



Reconditioning Services:

In most cases, barrels can be resleeved at a considerable cost savings over replacement. Most standard resleeving can be estimated over the telephone; however, phone estimates are not firm until an inspection has been completed. Standard resleeving consists of measuring the barrel, determining length of sleeve necessary to return to OEM specifications, machining out the old liner, resleeving with the desired material, tapping all threads, and polishing. You will be contacted with a firm price, and **no work will be performed without your approval**. *There is NO CHARGE for inspection*. Depending on your application, your barrel can be resleeved with one of the following liners:

D-2 Tool Steel

Our most popular D-2 Tool Steel sleeve has been very successful in most molding applications including moderate concentrations of glass or mineral filled materials. One of the most wear resistant of the conventional tool steels, it is alloyed with 12% chromium and 1% vanadium which form very hard carbides. This high percentage of chromium gives it mild corrosion resisting properties in the hardened condition. D-2 Tool Steel is thru-hardened to maximize its wear life.

CPM®-10V Tool Steel

Crucible's CPM®-10V Tool Steel has proven itself for most difficult molding applications such as continuous use of glass, mineral, ceramic, calcium, & metal filled plastic materials. This extremely wear resistant tool steel is manufactured by the particle metallurgy process which makes it possible to alloy a high percentage (9.75%) of vanadium, which forms the hardest of the tool steel carbides.

CPM®-15V Tool Steel

Crucible's CPM®-15V Tool Steel is the newest in the family of high vanadium, highly abrasion resistant CPM® tool steels. It contains 50% more hard vanadium carbides (14.5%) in its microstructure than CPM®-10V, to provide even higher wear resistance. CPM®-15V is intended for applications requiring exceptional wear resistance and where CPM®-10V is successful, but even longer life is desired.

CPM®-420V Stainless Steel

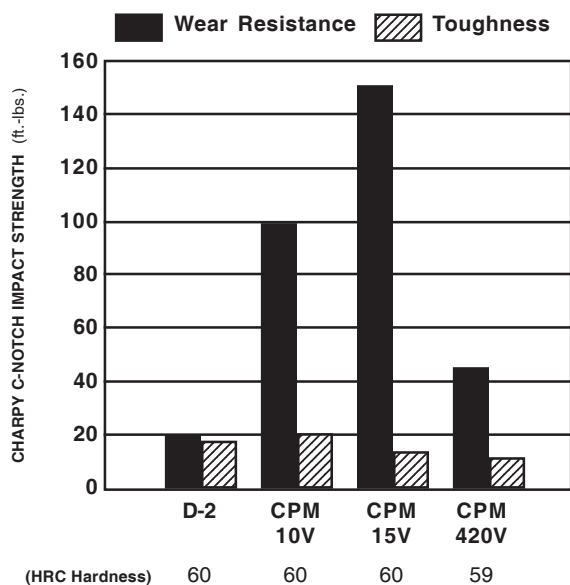
Crucible's CPM®-420V is a new stainless steel tool steel best suited for corrosion resistant applications. CPM®-420V is a higher performance upgrade for CPM®-440V. Corrosion resistance is significantly better than CPM®-440V, and wear resistance is about 25-50% better, due to the higher vanadium carbide content of the CPM®-420V (9% vanadium vs. 5.5-6% in CPM®-440V).

Other Services:

- We also repair bolt holes, threads, keyways, feed holes and ports.
- We specialize in super wear-resistant tool steel barrels, downsize/upsized conversions, and thermoplastic/thermoset conversions.
- We remove screws locked in barrels for a nominal fee. (A MSDS on the material being used when the machine seized MUST be supplied!)

See page 139 for additional information on sending parts to SFP for repair.

Steel Comparison Chart



Steel Hardness Chart

CORE	R _c	CASE	R _N
H-13 HT	44-46	NITRIDED	90 (61-63 Rc)
9-V HT	54-56	NITRIDED	90 (61-63 Rc)
420V	54-56		
17-4 PH SS	28-30		
D-2 HT	54-59	NITRIDED	90-93 (61-63 Rc)
CPM-10V HT	58-62		
CPM-15V HT	58-62		