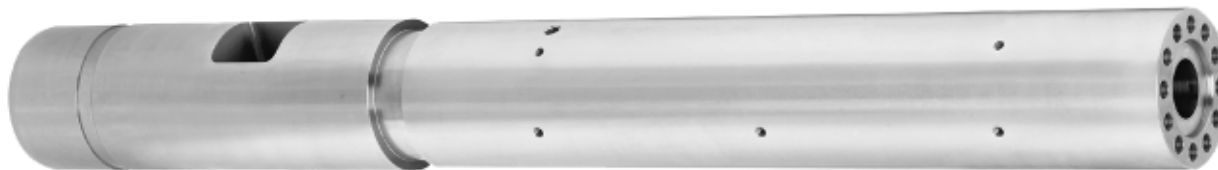


Barrel Services Available:

- Complete Barrel Inspection
- Remove Broken Endcap Bolts
- Repair or Replace Water Jackets
- Upsizing and Downsizing
- Mounting Flanges Repaired or Replaced
- T/C or Transducer Holes Installed
- Full and Partial Sleeves Installed
- Repair Cracked Barrels
- Pressure Sleeves Installed
- Barrels Shortened or Lengthened
- Special O.D. Modifications
- Feedports Installed or Modified

BMS can also repair Extruder Feed Housings



Barrel Inspection Procedure

1. Ship your barrel to BMS in a reusable crate freight prepaid. Barrels should be free of all plastic.
2. Barrel inspection begins with a visual inspection of the O.D. of the barrel. All threaded holes and O.D. threads are checked for damage and cracks. Endcap mounting face is checked for flatness and damage. If applicable, water jackets are inspected for cracks and pressure tested for leaks. Barrel I.D. should be free of plastic, however, if cleaning is required prior to I.D. inspection, there will be a charge for the time spent on cleaning. I.D. is visually checked for any wear, wear marks, screw deflection and cracks. A complete I.D. profile is performed to get a precise measurement of any wear and checked against OEM specifications.
3. All information gathered during inspection is recorded on an inspection report which will highlight all recommended O.D. and I.D. repairs. This report along with a quotation will be faxed or e-mailed.
4. To receive expedited deliveries on your barrel repair contact a BMS Customer Service Representative.

BMS can supply new as well as rebuilt barrels with the sleeving materials listed below. If you have questions regarding which sleeving material is correct for your processing needs, contact us and we will make the proper recommendation.

Tool Steels Sleeves

D-2: D-2 is a high carbon, high chromium tool steel with good wear resistance characteristics. D-2 is a very good general purpose sleeving material that will work well with low percentages of glass or mineral filled materials. Hardness range 56-58 Rc.

CPM 10V: CPM 10V is designed with a tough air hardening base analysis with added high carbon and vanadium for exceptionally good wear resistance, toughness and strength as needed in a barrel sleeving material. Hardness range 60-62 Rc.

CPM 15V: CPM 15V is BMS's highest vanadium, abrasion resistant tool steel. It contains 50% more hard vanadium carbide in its microstructure than CPM10V, to provide even higher wear resistance. A good tool steel for processing high glass and mineral filled resins. Hardness range 62-65 Rc.

CPM 420V: CPM 420V is the tool steel choice for corrosive applications found in resins such as PVC. The wear and corrosive resistance of CPM 420V make it an excellent choice to replace D-2 and CPM 10V or other tool steels in applications where improved corrosion resistance is also of benefit. Hardness range 58-60 Rc.

Bimetallic Sleeves

Standard Bimetallic: BMS Standard Bimetallic material is recommended for applications that process abrasive materials. It is a nickel-boron base iron with high hardness. It has excellent abrasion resistance and a low friction coefficient for prevention of screw galling. It provides a service life of at least four times that of nitrided barrels. Hardness range 60-65 Rc.

Carbide Bimetallic: Carbide Bimetallic is recommended for use where extremely abrasive and moderately corrosive conditions are encountered. It is a high tungsten-carbide content alloy with a matrix of a chromium-boron-nickel alloy. Tungsten carbide provides the primary wear resistance with the high chromium boride content matrix alloy providing additional wear and corrosion resistance. Hardness range 62-68 Rc.

Corrosion Resistant Bimetallic:

Corrosive Resistant Bimetallic sleeves are recommended for use where severe corrosive conditions are encountered. It is a cobalt-nickel base alloy with high chromium and boron content for excellent corrosion resistance against hydrochloric and other acids. It has over 10 times the service life of nitrided barrels in severely corrosive environments. Hardness range 50-55 Rc.