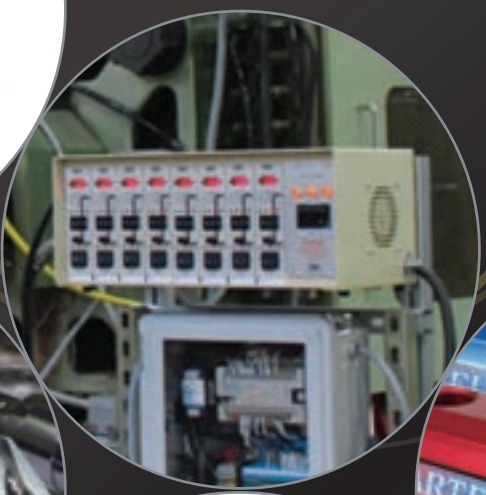
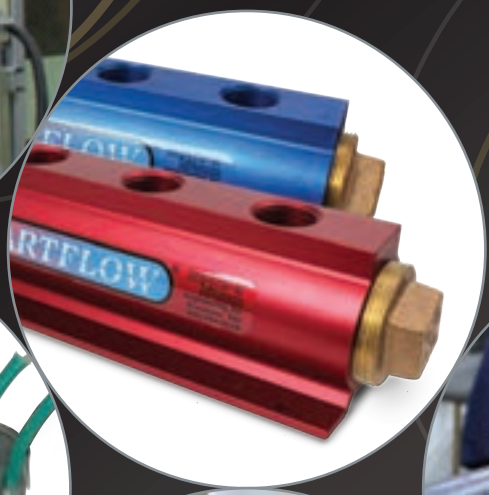
Since
1949

IMS Company

Everything You Need for the Plastics Processing Industry





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Did you know that IMS Company's Founder A. Reynolds "Ren" Morse was the designer of Van Dorn's very first injection molding machine?

A. Reynolds "Ren" Morse, Founder of IMS Company

In 1949, Mr. Morse started "Injection Molders Supply Co." Ever since those early days IMS Company has been an integral part in the development of the plastic injection molding industry. IMS assists molders by offering innovative process improving products with friendly service. We provide technical engineering expertise to help molders shorten shot cycle times, improve finished products, save set up time, reduce costs and solve difficult molding issues. We strive to continue to lead the molding community into the future.

IMS believes in being more than just a source for parts, supplies and equipment. We pride ourselves in offering well over 165 years of combined experience from our industry experts at no extra cost to our customers.

Choosing IMS Company to do business with is like choosing a molding partner that you can rely on, a partner that will be there for you when you need us most.

We welcome you to experience the IMS difference:

- QUALITY parts, supplies and equipment
- Dedicated technical help line 866-467-9001
- World Class friendly and courteous sales group available by phone or email – bilingual in English and Spanish
- Streamlined easy to navigate website with fast and simple ordering
- Full color catalog with recommendations and valuable information
- Same day shipping on most orders, same day delivery available
- Hassle free 30 days from date of purchase returns policy and a solid 2-year equipment warranty
- Trust and ethics, you can depend on IMS to be your honest and principled business partner

Behind the name IMS Company, we are a family owned business with a dedicated staff and a long-established history of satisfying the needs of our customers. Furthermore, Ren Morse believed in always taking care of the molder above all else. We are not about to change that approach – you have our word on it!

IMS Company, Industrial Molding Supplies, aka Injection Molders Supply Company, has been the most trusted source of supplies, auxiliary machinery and experienced technical service for the entire plastics processing industry. First in innovation, first in service.

Quality products to fit demanding needs, while making the most of your operating budget. Thousands of products shipped on time daily, from our fully stocked warehouse.

Since
1949

IMS Company

Everything for the Plastics Processing Industry

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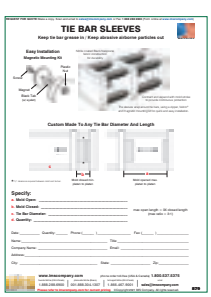

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70+ years Serving the Plastics Industry

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New From IMS!

Food Grade Loader Hose

Best Value, Food Grade PVC

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IMS Polyurethane Wired Hose

**Heavy Duty, Microbe Resistant,
with Ground Wire –Food Grade & Anti-Static**

Page 413-414

OHAUS Electronic Scales

**For fast, accurate weighing of small parts
(also for dry-color and additives)**

2,200 gram capacity

Item #173190

See Page 424

NEW Nozzle Leak Detector

Detect Nozzle Leaks Before They Cause Damage

Item #171707

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New From IMS!

Additive Feeder

High performance metering equipment of colorant, additives and regrind

Item #167017

See Pages 618-619

Resin Bin Loader Stand

Complete with Ratchet-Type Safety Stop

Item #173790

See Page 622

Shini Hopper Loader Systems

See Pages 669-671

Shini Screenless Granulators

See Page 785

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Featured Products

Chain Slings

Page 29

IMS Hoist Ring Rack™

Item #165874

Page 32-33

IMS Work Stations

- Available in 3 Styles to suit your needs

#168492

Design Allows User to Sit Comfortably while Working

Page 34-35

IMS Mold Setup Cart

Work surface included. Made for holding water line hoses, fittings, clamps, tools, cleaners, greases, tool boxes, small molds, reels of hose, tubing, wire, etc.

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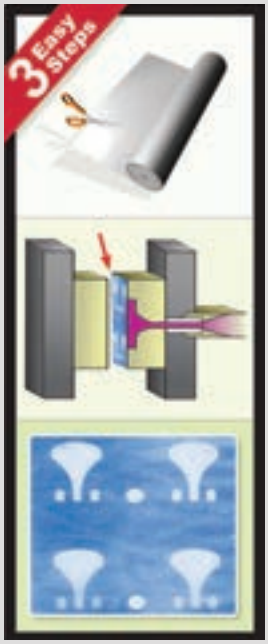
Featured Products

Mold-Align® Pressure Sensitive Mold and Die Aligning Paper



- Substantially Extend Life of Mold
- Very Economical
- Easy to Use
- Helps Reduce Flash and Improve Yield

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Mold Cycle Counters

Precisely monitor mold usage by tracking the activity for the life of the tool

- Parting Line or External Mount
- Up to 10 Million Cycles
- Completely Mechanical (No Batteries Needed)
- Non-Resetable

Page 76

90° Pneumatic Die Grinder Kit

Item #166174

Kit includes:

- ¼" collet
- ⅛" collet
- Five ¼" grinding wheels
- Five ⅛" grinding wheels
- 2 collet wrenches
- ¼" industrial plug
- Plastic case

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Bronze Sprue Puller Tools

Page 88-89

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Featured Products

Magnetic Pickup Tools & Inspection Mirrors

Page 94

Speed Mist PLUS™

Non-Flammable Mold Releases / Alternatives to EPA-Banned Formulas

#165731 Blue Label #165729 Paintable Mist

#165730 3% Silicone

Pages 118, 121, 133

CALL TODAY FOR YOUR

FREE SAMPLE*

*Offer valid for qualified industrial users

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Mini IR Non-Contact Thermometer

Precise Temperature Measurement on Difficult to Reach Surfaces

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Featured Products

IMS Brand Thermocouples

- Type J & K
- Flex Leads with Stainless Steel Braid
- Grounded
- Spade Lug Terminals

*** 5 Styles**

Pages 222-223

Hot Runner Diagnostics

>Mold X Checker™<

- Check for Opens
- Check for Shorts
- Check Heater Health

*** Eliminate Downtime**

>Cable X Checker™<

- Check Pin and Wire Continuity
- Check for Shorts
- Check Wired Connectors

Page 237-240

Super Gate Cutters

- Large Variety to Suit Your Needs
- Highest Quality and Comfort Available
- Lowest Cost per Cut on the Market

*** Expanded Listing**

More Sizes & Head Styles Than Ever Before

Pages 268-273

Knives

Break-Away/Snap-Off Knives

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Ceramic Utility Knife

Item #165846

Page 323

Plastic Safety Knife

Item #165820

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Featured Products

Mini Ball Valves

- Perfect for use when space is limited
- Chrome plated brass body and ball
- NPT taper ANSI B1.20.1 threads
- 450 PSI working pressure

Pages 373

BernzOMatic® Torch Heads

Item #168507
Model TS4000

BernzOMatic® Torch Head Assembly

CYLINDER HOLSTER for hands free convenience

Page 374

Page 375

Item #168509

Two-Way Valved Mold Coolant Couplers and Plugs

* Avoid Downtime

- Automatic Shut-Off at mold minimizes mold coolant leaks
- For use with Water/Glycol (-90° F to 400° F)

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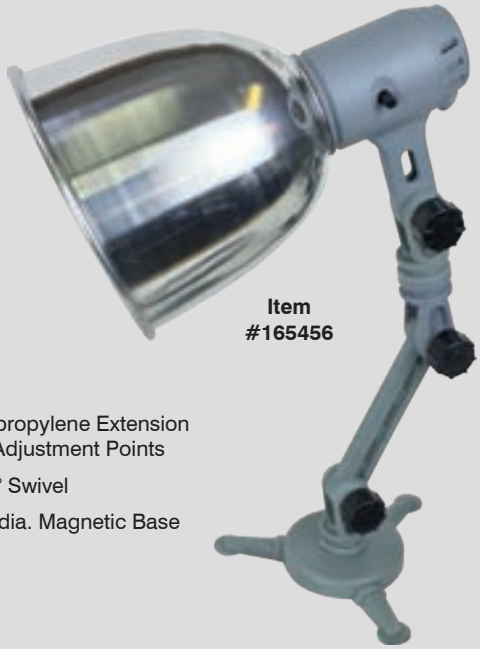
Worklight



Item #165456

- Tough Polypropylene Extension Arm with 3 Adjustment Points
- Unique 360° Swivel
- Strong 2¾" dia. Magnetic Base

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Process Trouble-Shooting Guidelines				
Problem	CRYSTALLINE MATERIALS		AMORPHOUS MATERIALS	
	Lower/Reduce	Raise/Increase	Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

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Featured Products

IMS Mini-Tumbler with Timer & Optional Guard Enclosure

- **Corner-over-corner design -** efficiently blends dry or liquid materials
- **Blending of ordinary pails -** reduces spills and prevents messy cleanups

See Page 640

Lo-Profile Drum Caddy

Item #163725

Handles up to 1,000 lbs.

See Page 648

IMS Series Stainless Steel Loaders

*** Now with No-Load Material Alarm**

5 SIZES and 2 STYLES to choose from!

See Pages 653

IMS Horizontal to Incline Conveyors

- Direct drive / No belts or chains
- Powder coated steel frame
- Up to 30' per minute
- Discharge chute included

See Page 776-782

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Featured Products

Portable Dew Point Meter/Monitor

Item #172020

Monitor and spot check the performance of your desiccant style drying equipment

See Page 698-699

SHINI Drying Hoppers

- Stainless steel construction on all contact surfaces
- PID microprocessor controller
- Unique hot air inlet design
- Insulated blower

See Page 706-707

Hydra EQ & NQ Series Chillers

- Upgraded components
- Sophisticated controls
- Environmentally friendly
- Up to 31 Tons

See Pages 754-755

IMS Hydra Pressurized Mold Temperature Controller

NOW up to 70% More Flow
<u>without</u> increased pump size!

- Maximum Performance
- Reliability
- Ease of Use

See Pages 740-741

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Engineering & Fabricating Services

Many of the products in this catalog were brought to us by molders. In an effort to maintain their machines or solve problems, they find a solution that works.

If this solution works for one it many work for someone else as well.

Bring your ideas to IMS – we welcome them! We will work with you to from development to implementation to engineer a solution.

Call or email us to discuss your needs:

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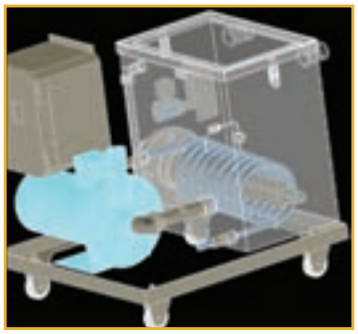
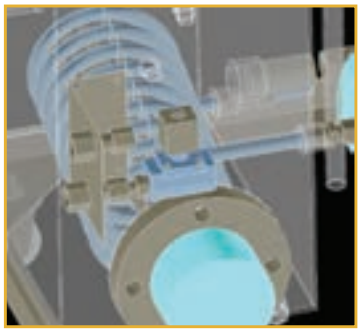
Email: ems@imscompany.com

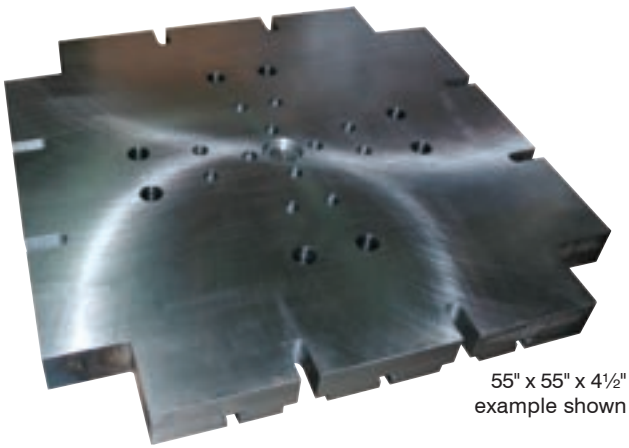




Custom Replacement Parts Capabilities

Molds and Mold Components

Molds and mold components can be built to any size or specification out of various materials. (Giant Spacer Plate shown)



55" x 55" x 4½"
example shown

Manifolds

Manifolds can be built to any custom size out of several material options with multiple ports and internal designs.

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Engineering & Fabricating Services

Custom Replacement Parts Capabilities (continued)

Air Take-Off Boxes

Air take-off boxes can be fabricated to any dimensions out of multiple materials with any number of ports. Additional design features include adjustable air flow and custom mounting.

Mobile Blending Station

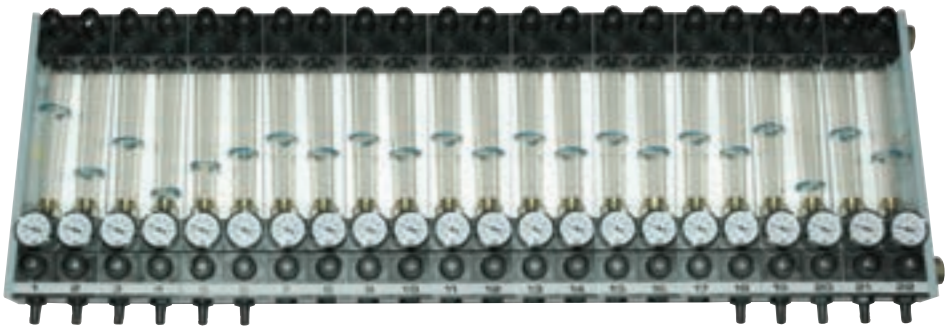
Portable unit allows blending of multiple materials on site, with easy access for conveying.

Hoppers

- Height
- Taper or Logarithmic Spiral
- Sight Glass
- Drain
- Hopper Slides
- Loader Mounts
- Extensions
- Slide Gates
- Capacity

Flow Regulators

Flow regulators can be made for any number of zones and flow rates.



There's Are Just a Few Examples of Our Capabilities – Call Us With Your Needs!

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IMS®

Industrial

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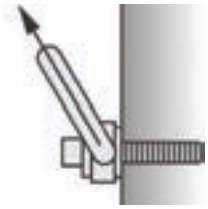
Heavy Duty Hoist Rings

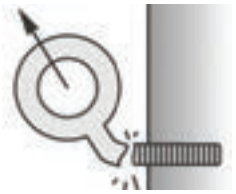
Use In Place Of Conventional Eyebolts To Maximize Lifting Safety

Pivot & Swivel to compensate for shifting and swaying loads



Hoist Rings retain their full rated load capacity regardless of lift angle!

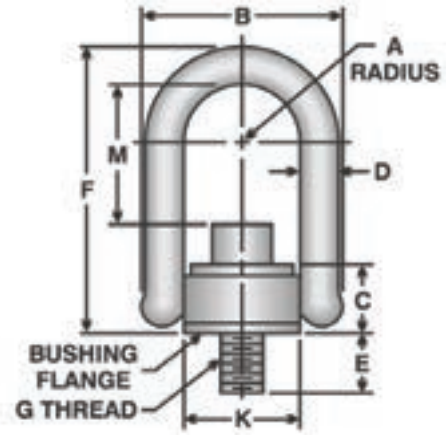
A side load applied to a Hoist Ring is well distributed to the screw and the bottom of the hoist ring assembly.



Side or angular pulling forces stress conventional eyebolts. They weaken, can twist, bend or even break!

The load concentrates shear stress on a small portion of a conventional eyebolt.

1 & 2 Standard and Metric Size Hoist Rings



Help prevent costly damage and injuries.

Pivot 180°

Swivel 360°

Minimum Safety Factor 5:1

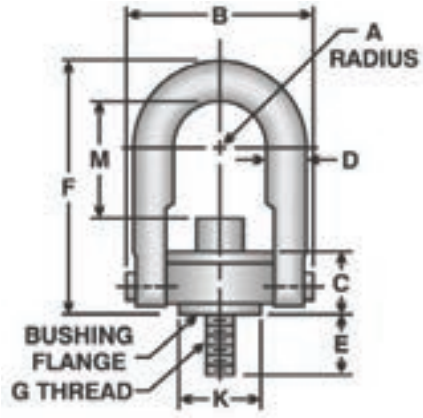
- Meet OSHA Standards
- Meets Military Standards MIL-STD1365 (11) or MIL-STD209C
- Specified and used in Nuclear Energy Equipment
- Destructive testing by outside independent laboratories

Material

- 4140 Aircraft Quality, High Strength Alloy Steel with Minimum Tensile Strength of 180,000 PSI
- Certified Heat Treatment
- 100% Magnetic Particle Inspected
- Black Oxide Finish

U.S. Patent No.s 3,297,293 / 4,570,987 / 4,641,986 / 4,705,422 / 5,405,210 / Other patents pending

3 & 4 Standard and Metric Size Safety Engineered Hoist Rings



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1. Standard Size Hoist Rings (See drawing on previous page)

Item #	Rated Load (lbs.)	A (in.)	B (in.)	C (in.)	D (in.)	E (in.)	F (in.)	G	K (in.)	M (in.)	TL* (ft-lbs.)
115925	800	0.65	2.29	0.96	0.44	0.56	3.32	5/16" - 18	1.25	1.51	7
115924	1000							3/8" - 16		1.45	12
115932	2500	1.00	3.50	1.50	0.75	1.00	5.31	1/2" - 13	1.89	2.56	28
115931						1.25					
115927	4000	1.00	3.50	1.50	0.75	1.00	5.31	5/8" - 11	1.89	2.44	60
115953						1.25					
115949	5000	1.00	3.50	1.50	0.75	1.00	5.31	3/4" - 10	1.89	2.31	100
115943						1.50					
115941	7000	1.40	5.10	2.05	1.00	1.20	7.00	3/4" - 10	2.81	3.20	100
115946	8000					1.20		7/8" - 9		3.07	160
115935	10,000	1.40	5.10	2.05	1.00	1.45	7.00	1" - 8	2.81	2.95	230
115963						1.20					
115944	15,000	2.00	6.75	2.87	1.25	2.63	9.22	1 1/4"-7	3.88	3.74	470
115940	24,000							1 1/2"-6		3.49	800

2. Metric Size Hoist Rings (See drawing on previous page)

Item #	Rated Load (kg.)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G	K (mm)	M (mm)	TL* (N-m)
115951	400	16.5	58.2	24.4	11.1	16	82.0	M8 x 1.25	31.8	38.5	9.5
115948						21					
115942	450	16.5	58.2	24.4	11.1	16	82.0	M10 x 1.5	31.8	36.5	16.0
115937						26					
115955	1,050	25.4	88.9	38.1	19.1	25	134.9	M12 x 1.75	48.0	65.0	37.0
115950						32					
115945	1,900	25.4	88.9	38.1	19.1	25	134.9	M16 x 2.0	48.0	62.0	80.0
115934						32					
115962	2,200	25.4	88.9	38.1	19.1	25	134.9	M20 x 2.5	48.0	58.7	135.0
115957						38					
115938	4,200	35.6	129.5	52.1	25.4	28	177.8	M24 x 3.0	71.4	76.3	311.0
115966						38					
115961	4,500	35.6	129.5	52.1	25.4	38	177.8	M30 x 3.5	71.4	70.3	311.0
115956						48					
115964	7,000	50.8	171.5	72.9	31.8	67	234.2	M30 x 3.5	73.2	95.0	637.2
115959	11,000							M36 x 4.0		88.6	1085.5

*Recommended torque load

Other Sizes Available — Inquire

continued on next page

Tech Tips

Useful Conversion Data (Approximation)			
	To Convert From	To	Multiply By
Length	Millimeter (mm)	Inch (in)	0.03973
Force	Newton (N)	Pound-Force (lb)	0.22481
Stress	Newton/mm2	Pound/Inch2	145.04
Torque	Newton-Meter (Nm)	Pound-Foot (lbs-ft)	0.7376
Weight	Kilogram (Kg)	Pound (lb)	2.204

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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3. Standard Size Safety Engineered Hoist Rings (See drawing on page 22)

IMS also carries Safety Engineered Hoist Rings with larger threads, a bigger radius and a pivot pin that goes completely through the head. Use this larger hoist ring to safely lift heavy loads.

Item #	Rated Load (lbs.)	A (in.)	B (in.)	C (in.)	D (in.)	E (in.)	F (in.)	G	K (in.)	M (in.)	TL* (ft-lbs.)
162009	550	0.43	1.84	0.71	0.375	0.54	2.67	¼" - 20	0.75	1.33	5
162010	800	0.43	1.84	0.71	0.375	0.29	2.67	5/16" - 18	0.75	1.27	7
162011						0.54					
128230	1,000	0.43	1.84	0.71	0.375	0.54	2.67	⅜" - 16	0.75	1.21	12
162012	2,500	0.70	2.58	0.93	0.5	1.07	3.77	½" - 13	1.25	1.84	28
127381		0.88	3.52	1.22	0.75	0.78	4.78	½" - 13	1.50	2.31	28
162013						1.03					
162014						1.28					
162015	4,000	0.88	3.52	1.22	0.75	0.78	4.78	5/8" - 11	1.50	2.18	60
127388						1.03					
162016						1.28					
127391	5,000	0.88	3.52	1.22	0.75	1.03	4.78	¾" - 10	1.50	2.06	100
162017						1.53					
162018	7,000	1.40	5.14	1.71	1.00	1.04	6.52	¾" - 10	2.37	3.06	100
162019						1.54					
162020	8,000	1.40	5.14	1.71	1.00	1.04	6.52	7/8" - 9	2.37	2.93	160
162021	10,000	1.40	5.14	1.71	1.00	1.29	6.52	1" - 8	2.37	2.81	230
127390						1.54					
162022						2.29					
162023								1⅛" - 8			
162024	15,000	1.75	6.50	2.11	1.25	1.89	8.73	1¼" - 8	3.20	4.12	470
162025	24,000	2.25	8.55	2.81	1.75	2.70	12.47	1½" - 8	4.20	6.14	800
127389	15,000	1.75	6.50	2.11	1.25	1.89	8.73	1¼" - 7	3.20	4.12	470
128217	24,000	2.25	8.55	2.81	1.75	2.70	12.47	1½" - 6	4.20	6.14	800
115958	30,000	2.25	8.55	2.81	1.75	2.96	12.47	2" - 4½	4.20	6.14	1100

4. Metric Size Safety Engineered Hoist Rings (See drawing on page 22)

Item #	Rated Load (kg.)	A (mm)	B (mm)	C (mm)	D (mm)	E (mm)	F (mm)	G	K (mm)	M (mm)	TL* (N-m)
162026	400	10.9	46.7	18	9.5	17	67.8	M8 x 1.25	19.1	32.1	9.5
162027	450							M10 x 1.5		30.2	16
162028	1,050	22.4	89.4	31	19	19	121.4	M12 x 1.75	38	59.4	37
162029	1,900					24		M16 x 2.0		55.4	80
162030	2.200					30		M20 x 2.5		51.4	135
162031	3,000	35.6	130.5	43.4	25.4	29	165.8	M20 x 2.5	58.7	77	135
162032	4,200					34		M24 x 3.0		73	311
162033	4,500					54		M30 x 3.5		67	311
162034	7,000	44.5	165.1	53.6	31.8	46	221.7	M30 x 3.5	81.3	106.3	637.2
162035	11,000	57.2	217.2	71.4	44.5	69	316.7	M36 x 4.0	106.7	164.8	1085.5
162036**	12,500					79		M42 x 4.5		158.8	
162037**	13,500					79		M48 x 5.0		152.8	
162038**	22,000	76.2	296.4	104	57.2	102	428.5	M64 x 6.0	146.1	203.3	2847.5
162039**	31,500	95.25	368.3	133.9	69.85	132	495.3	M72 x 6.0	184.15	215.39	5670

*Recommended torque load **Includes stud and nut to safely lift heavier loads

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Hoist Ring Bolt Kits

Each Kit includes Bolt and Retaining Clip

Standard Heavy Duty Hoist Ring Bolt

Bolt Kit Item #	For Use With Hoist Ring #	Thread Size
167540	**115925**	5/16"-18
133172	**115924**	3/8"-16
118055	**115932**	1/2"-13
142732	**115931**	1/2"-13
123224	**115927**	5/8"-11
122841	**115953**	5/8"-11
157730	**115949**	3/4"-10
123072	**115941**	3/4"-10
125101	**115943**	3/4”-10
167538	**115946**	7/8"-9
121745	**115963**	1"-8
122761	**115935**	1"-8
121519	**115944**	1 1/4"-7
167541	**115940**	1 1/2"-6

Metric Heavy Duty Hoist Ring Bolt

Bolt Kit Item #	For Use With Hoist Ring #	Thread Size
123408	**115951**	M8 x 1.25
167539	**115942**	M10 x 1.5
123174	**115937**	M10 x 1.5
147544	**115955**	M12 x 1.75
122861	**115950**	M12 x 1.75
167563	**115945**	M16 x 2.0
123278	**115934**	M16 x 2.0
167566	**115962**	M20 x 2.5
122810	**115957**	M20 x 2.5
167567	**115938**	M24 x 3.0
123067	**115966**	M24 x 3.0
167568	**115961**	M30 x 3.5
122916	**115956**	M30 x 3.5
167569	**115964**	M30 x 3.5

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Safety Engineered Hoist Ring Bolt Kits Available — Inquire

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Forged Steel Eyebolts

Notice

Load ratings are for vertical lifting only,with thread fully engaged

•

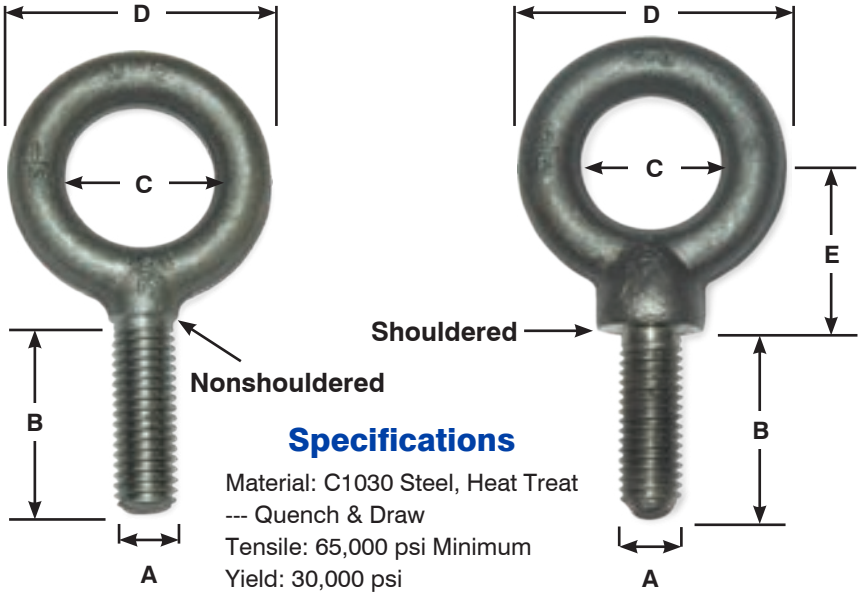
At 45° angle, load rating drops to 25% of listed rate

•

Do not use at an angle greater than 45°

Discard immediately if twisted, bent or otherwise damaged.

For safer lifting at any angle see Heavy Duty Hoist Rings on pages 22-24



Specifications

Material: C1030 Steel, Heat Treat --- Quench & Draw
Tensile: 65,000 psi Minimum
Yield: 30,000 psi

Item #	(A) Thread Size	(B) Shank Length	(C) Eye I.D.	(D) Eye O.D.	(E) Center Eye to Shoulder	Straight lift Capacity (lbs.)
Standard Size (Nonshouldered)						
142207	¼" - 20	1"	¾"	1 3/16"	N/A	500
142208	5/16" - 18	1 1/8"	7/8"	1 7/16"		900
101417	3/8" - 16	1¼"	1"	1 11/16"		1,300
101415	7/16" - 14	1 3/8"	1 1/16"	1 13/16"		1,800
101423	½" - 13	1½"	1 3/16"	2 1/8"		2,400
142209	9/16" - 12	1 5/8"	1 9/32"	2 9/32"		3.200
101420	5/8" - 11	1¾"	1 3/8"	2 9/16"		4,000
101419	¾" - 10	2"	1½"	2 13/16"		5,000
101425	7/8" - 9	2¼"	1 5/8"	3 3/16"		7,000
101422	1" - 8	2½"	1¾"	3 9/16"		9,000
101421	1 1/8" - 7	2¾"	2"	4"		12,000
107961	1¼" - 7	3"	2 3/16"	4 7/16"		15,000
142210	1½" - 6	3½"	2½"	5 3/16"		21,000
142211	1¾" - 5	3¾"	2 7/8"	6"		28,000
142212	2" - 4½	4"	3¼"	6 7/8"		38,000
142213	2½" - 4	5"	4"	8½"		56,000
Standard Size (Shouldered)						
142214	¼" - 20	1"	¾"	1 3/16"	¾"	500
142215	5/16" - 18	1 1/8"	7/8"	1 7/16"	15/16"	900
138068	3/8" - 16	1¼"	1"	1 11/16"	1 1/8"	1,300
142216	7/16" - 14	1 3/8"	1 1/16"	1 13/16"	1¼"	1,800
109787	½" - 13	1½"	1 3/16"	2 1/8"	1 3/8"	2,400
142217	9/16" - 12	1¾"	1 3/8"	2 9/16"	1 21/32"	3,200
109781	5/8" - 11	1¾"	1 3/8"	2 9/16"	1 21/32"	4,000
109794	¾" - 10	2"	1½"	2 13/16"	1 13/16"	5,000

continued on next page

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Forged Steel Eyebolts (continued)

Item #	A Thread Size	B Shank Size	C Eye I.D.	D Eye O.D.	E Center Eye to Shoulder	Straight lift Capacity (lbs.)
Standard Size (Shouldered)						
138069	7/8" - 9	2 1/4"	1 5/8"	3 3/16"	2 1/8"	7,000
135690	1" - 8	2 1/2"	1 3/4"	3 9/16"	2 5/16"	9,000
142218	1 1/8" - 7	2 3/4"	2"	4"	2 11/16"	12,000
137974	1 1/4" - 7	3"	2 13/16"	4 7/16"	2 15/16"	15,000
138829	1 1/2" - 6	3 1/2"	2 1/2"	5 3/16"	3 5/16"	21,000
142219	1 3/4" - 5	3 3/4"	2 7/8"	6"	4"	28,000
138064	2" - 4 1/2	4"	3 1/4"	6 7/8"	4 3/8"	38,000
Metric Size (Shouldered)						
	mm	**mm**	**mm**	**mm**	**mm**	**kg**
142220	M6 x 1.0	12	19	30	18.5	210
142221	M7 x 1.0	14	22	36.5	23.2	370
107516	M8 x 1.25	16	25	43	27.8	500
107521	M10 x 1.5	20	27	46	30.9	740
107520	M12 x 1.75	24	30	54	34	1,030
142222	M14 x 2.0	28	33	58	40.9	1,600
106724	M16 x 2.0	32	35	65	40.9	1,600
106723	M18 x 2.5	36	38	71.5	44.7	2,140
106720	M20 x 2.5	40	41	81	52.5	2,860
106718	M24 x 3.0	48	45	90.4	57.1	3,850
142223	M27 x 3.0	48	51	103	66.5	5,200
108500	M30 x 3.5	60	55	112.7	72.7	6,400
142224	M36 x 4.0	72	63	131.8	81.8	8,970
142225	M42 x 4.5	84	73	152.4	101.6	11,960
142226	M45 x 4.5	84	73	152.4	101.6	12,720
140636	M48 x 5.0	96	82	174.6	111.0	16,400

Other Styles and Sizes Available — Inquire

Notice

Load ratings are for vertical lifting only,with thread fully engaged

•

At 45° angle, load rating drops to 25% of listed rate

•

Do not use at an angle greater than 45°

Discard immediately if twisted, bent or otherwise damaged.

For safer lifting at any angle see Heavy Duty Hoist Rings on pages 22-24

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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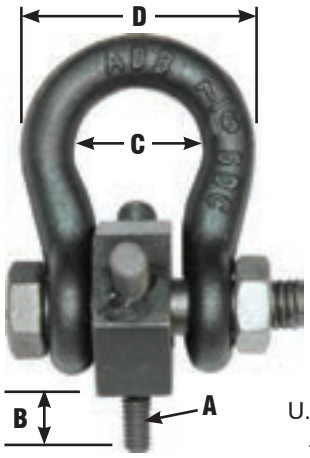
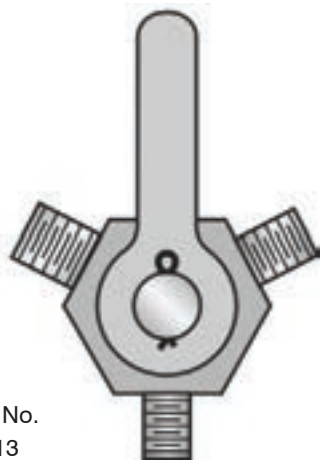
Universal Lift Rings

Stronger, Safer, More Versatile

More economical than conventional eyebolts





U.S. Patent No. #4,557,513

Two Different Size Rings, each with 3 selectable thread sizes

Item #	(A) Thread Size	(B) Shank Length	(C) Eye I.D.	(D) Eye O.D.	Straight Lift Capacity (lbs.)
115939	¼" - 20 5/16" - 18 ⅜" - 16	½"	1¼"	2⅛"	400 800 1,400
115967	½" - 13 ⅝" - 11 ¾" - 10	¾"	1¾"	3"	2,600 4,000 6,000

Hi-Strength Lifting Eye

- Maintain load ratings at lift angles of 90°
- Load ratings of 9,000 lbs to 15,000 lbs
- Safety Factor 5:1
- Made of Forged Carbon Steel

Purchasers also order:

- Heavy Duty Hoist Rings, pages 22-24
- Chain Slings, page 29
- Heavy Duty Lifting Slings, page 30
- Mold Handling Latches, page 31
- Copper Flake Thread Lube, page 521

Item #	Thread Size	Thread Length	Eye I.D.	Eye O.D.	Clevis	Capacity at 90°
121852	1" - 8	1⅞"	1¾"	3¾"	4 27/32"	9,000 lbs
121849	1¼" - 7	1¾"	2½"	5¼"	6⅝"	10,000 lbs
121847	1½" - 6	2"	2½"	5¼"	6⅝"	15,000 lbs

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Chain Slings

For More Versatile Help With Heavy Duty Lifting Applications

Made in the U.S.A

- **Made of Grade 100 Alloy Steel -** for maximum abrasion and corrosion resistance
- **Meets ASME B30.9 OSHA & NACM Standards**
- Grade 100 has 25% greater work load limit than grade 80
- User can experience more work load limit with a smaller diameter chain based on the application
- Grade 100 reduces overall wear on the links and extends the life of the chain

Specifications

Chain	SINGLE LEG Working Load Limit	2 LEG Working Load Limit at 60° Angle	3 LEG Working Load Limit at 60° Angle	4 LEG Working Load Limit at 60° Angle
9/32"	4,300 lbs	7,400 lbs	11,200 lbs	11,200 lbs
3/8"	8,800 lbs	15,200 lbs	22,900 lbs	22,900 lbs
1/2"	15,000 lbs	26,000 lbs	39,000 lbs	39,000 lbs
5/8"	22,600 lbs	39,100 lbs	58,700 lbs	58,700 lbs

Spare Latch Kits Available — See Kit section below*

Chain Size	Lgth.	Single Leg - SOS Safety Latch Without	Single Leg - SOS Safety Latch With	2 Leg - DOS Safety Latch Without	2 Leg - DOS Safety Latch With	3 Leg - TOS Safety Latch Without	3 Leg - TOS Safety Latch With	4 Leg - QOS Safety Latch Without	4 Leg - QOS Safety Latch With
9/32"	2'	170224	170225	170241	163922	170258	170259	170282	170283
	3'	170226	170227	170242	165295	170260	170261	161786	163214
	4'	170228	170229	170243	170244	170262	170263	170284	170285
3/8"	2'	159667	170219	159668	170245	170264	170265	170286	170287
	3'	170220	170221	170246	169057	170266	170267	170288	160747
	4'	170222	170223	170247	170248	170268	170269	170289	170290
1/2"	2'	170230	170232	138528	170249	170270	170271	170291	170292
	3'	161383	170233	170250	157726	170272	170273	170293	170294
	4'	170231	170234	159664	170251	170274	170275	170295	170296
5/8"	2'	170235	170236	170252	170253	170276	170277	170297	170298
	3'	170237	170238	170254	170255	170278	170279	170299	170300
	4'	170239	170240	170256	170257	170280	170281	170301	170302

*Spare Latch Kits include Latch, Pin and Spring	
#170303	9/32" Chain Safety Latch Kit
#170304	3/8" Chain Safety Latch Kit
#170305	1/2" Chain Safety Latch Kit
#170306	5/8" Chain Safety Latch Kit

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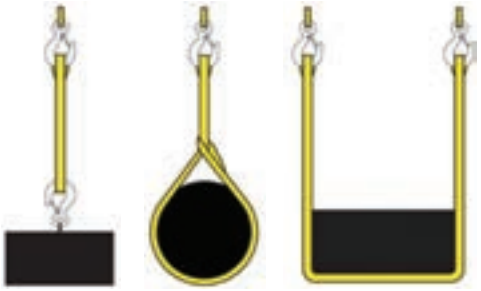
Heavy Duty Mold Lifting Slings

Avoid Damage to Molds, Barrels and Feed Screws From Chains and Cables

Rugged, Sewn, Woven Nylon Web, Double Ply Construction

Vertical Lift Capacity	
Sling Width	**Holds Up To**
1"	3,200 lbs
2"	6,400 lbs
3"	8,800 lbs
4"	11,500 lbs

Hitch Configurations



Vertical Hitch | Choker Hitch | Vertical Basket Hitch

Eye Bolts sold separately

- **Strength** - Various sizes to handle maximum load
- **Convenience** - Can conform to any shape
- **Safety** - Adjusts to the load for a tight, non-slip grip
- **Load Protection** - Will not mar, deface, or scratch
- **Economy** - Low cost / Long life
- **Long Life** - Unaffected by mildew, rot, or bacteria / Excellent abrasion resistance
- **Shock Absorbency** - Can absorb heavy shocks without damage
- **Temperature Resistance** - Unaffected up to 180°F

Meets OSHA Standards

- Sling is marked with rated capacities for vertical, choker and vertical basket hitch types
- Synthetic webbing is of uniform thickness and width

Note: Only use fittings with a minimum breaking strength equal to that of the sling.

Refer to OSHA Standards for proper usage.

Item #	Width	Length	- Working Load Limit (lbs) - Vertical	Choker	V.Basket
170815	1"	3 ft.	3200	2560	6400
170392		4 ft.			
170393		6 ft.			
170394		8 ft.			
170395		12 ft.			
170816	2"	3 ft.	6400	5120	12800
170396		4 ft.			
170397		6 ft.			
170398		8 ft.			
170399		12 ft.			
170400	3"	4 ft.	8800	7040	17600
170717		6 ft.			
170718		8 ft.			
170720		14 ft.			
170721	4"	4 ft.	11500	9200	23000
170722		6 ft.			
170723		8 ft.			
170724		10 ft.			
170725		14 ft.			

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Mold Handling Latch (G.A.I.M. T.O.I.™)

(Pronounced Game Toy) T.O.I.™ (Tool Opening Interrupter) by G.A.I.M. Engineering

GREEN Products

Keeps Mold Halves Together For Safe Handling

- Avoid costly damage to your molds during installation, removal, transporting or storage
- Cost much less than conventional, custom strapping systems
- Can be moved from one mold to another

How It Works

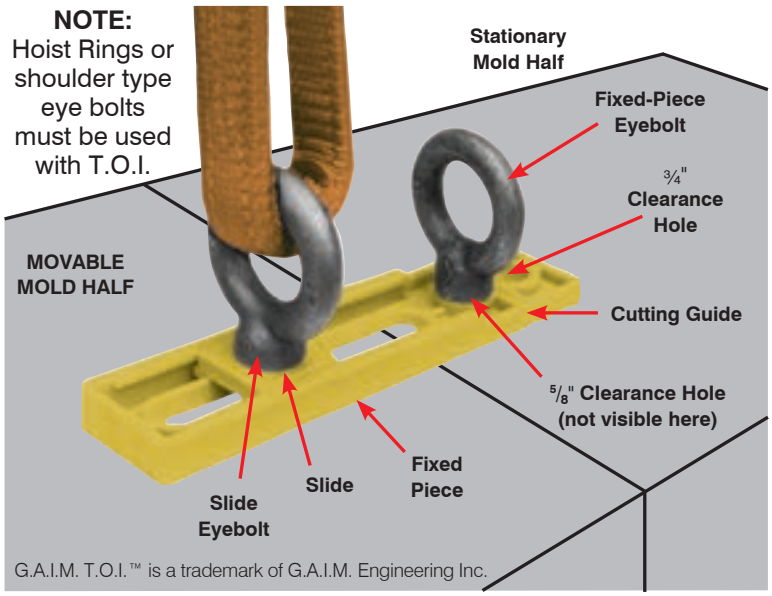
The T.O.I.™ holds the mold closed for transporting, setup, teardown or storage. It consists of a fixed piece that bolts to the stationary mold half, and a slide that moves within a track on the fixed piece. The slide bolts to the movable mold half. As the mold is lifted, the slide wedges tightly to the fixed piece, preventing the mold from opening.

To prevent damage to the tooling and machine, if the installer forgets to remove the T.O.I.™ after installing the mold on the machine, the latch is designed to safely break apart when the machine opens the mold.

Item #109330

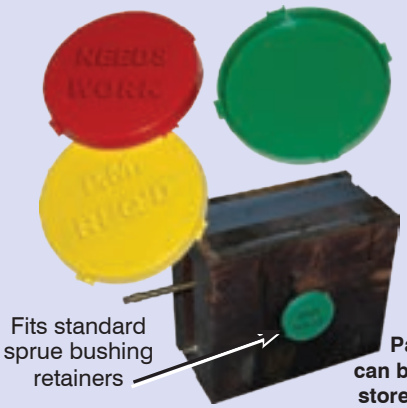
9" Long

NOTE: Hoist Rings or shoulder type eye bolts must be used with T.O.I.



Made of 100% Recycled Reinforced Nylon

No tools necessary to install!



The Original Snap-On SMART CAPS™

A quick, easy way to:

- Indicate a mold's status — ready to mold/needs work/P.M. required
- Attach work-orders, notes etc. to mold (under cap)

Help eliminate unnecessary downtime and confusion!

#137145	(Green: ready to mold)
#137146	(Red: needs work)
#137147	(Yellow: P.M. req'd)

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IMS Select® Hoist Ring Rack™

Convenient Storage and Portability!

The IMS Select® Hoist Ring Rack is ready when you are. Whether it's before, during or after the job, this handy rack will keep your commonly used Hoist Rings, Eyebolts and Lifting Chains organized and transportable.

- **Mobile**
- **Versatile**
- **Space Saving**
- **Durable**

IMS Exclusive Product!
(Other Items Sold Separately)

Reduce Mold Setup Time!

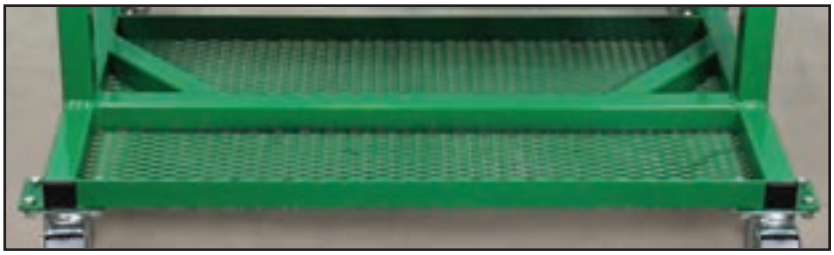
Tech Tips

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

It is a good idea to keep the most common rigging products you use on this cart. You may want to affix user installed labels on your cart to be sure products are returned to their proper location.

Push Bar Grips

5" Locking Swivel Casters



Reinforced Mesh Utility Trays

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Hoist Ring Rack™ (continued)

Item No. 165874

- **2' long Push Bar with Grips**
  - enables you to guide cart with ease

- **25 Heavy Duty Steel Posts**
  - allows a sturdy method to safely organize tools and rigging products

9 Top (Front) Rack Posts:
(2) 12" x 1"
(5) 8" x ¾"
(2) 6" x ½"

3 Top (Back) Rack Posts:
(2) 6" x ½"
(1) 6" x ¾"

5 Middle Rack Posts:
(5) 12" x 1"

8 Bottom Rack Posts:
(4) 8" x ¾"
(4) 6" x ½"

- **2 Reinforced Mesh Tool Trays**
  - provides quick access to tools and accessories that do not require hanging (32" x 6¾" usable area per tray)

- **Four 5" Locking Swivel Casters**
  - allows for mobility and control

Accommodates a Wide Variety of: Hoist Rings, Eyebolts, Mold Clamps, Lifting Straps, Chain Slings and Much More

Specifications	
Dimensions	37"W x 24"L x 40"H
Cart Structure	3" and 4" steel channel 14 and 16 gauge steel tube
Weight Capacity	975 lbs
Shipping Weight (Class 150 - must ship truck)	175 lbs
Crated Dimensions	44"W x 38"L x 47"H

Heavy Duty Welded Steel Construction

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Made in the U.S.A

IMS Select Workstation

Made Expressly For Injection Machine Operators

The ideal solution when the molder is looking for a heavy duty work table that has options and adjustments to suit several applications throughout the shop. Whether it is beside the press, in the tool room, or for the general maintenance area, the IMS Workstation offers quality and strength in even the most demanding environments. Built to last and priced within the molders budget.

- **Spacious** – 60" x 28" Workspace Top
- **Sturdy** – Rugged Welded-Steel Construction
- **Versatile** – Table Top Height Adjustable (30" to 40")
- **Clean Look** – Easy to clean durable polyester powder coating
- **Customizable** – Several upgrades and options to choose from to fit your shop needs

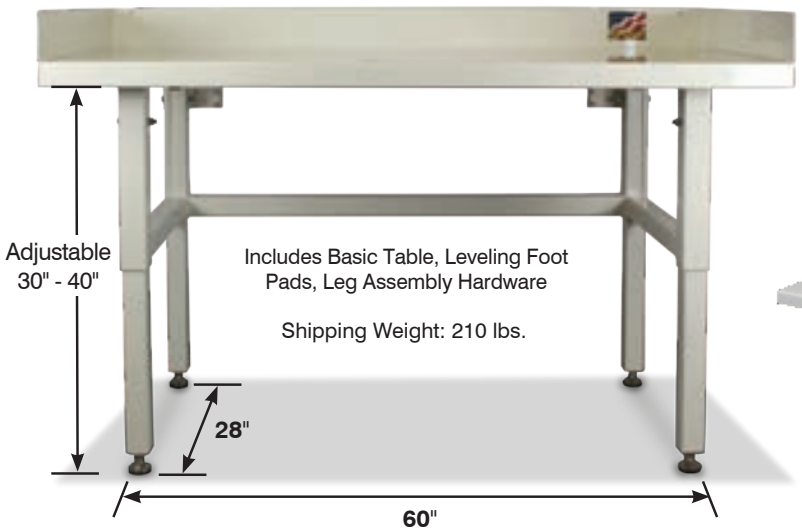
New Design Allows User to Sit Comfortably While Working

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

IMS Exclusive Product!

Deluxe Workstation #168492

Basic Workstation #168111



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IMS Select Workstation

Made in the U.S.A

Pro Workstation #168493

Includes: Basic Table with Leveling Foot Pads, Lighting Kit and Leg Assembly Hardware

Hinged Sides (Both Ends)

Large, Versatile Steel Work Surface For Multiple Tasks

Item #	Description
168492	Deluxe Workstation - Includes Lighting Kit, Box Shelf and Caster Kit
168493	Pro Workstation - Includes Lighting Kit, Leveling Foot Pads
168111	Basic Workstation - Leveling Foot Pads
Optional Accessories	
168113	Complete Lighting Kit for IMS Workstation
168112	Light Post Kit for IMS Workstation, Use your own light fixture*
167418	Part Boxing/Utility Shelf for IMS Workstation (18¼" x 23")
168494	Caster Kit - Includes (4) Swivel Locking Casters
175781	4', LED Light Fixture Only

* Requires 38¾" Distance Between Mounting Brackets

#168113
Optional Lighting Kit
Includes Light Fixture, Light Posts, Light Post Mounting Brackets and Hardware

#167418
Optional Part Boxing/Utility Shelf

#168494
Optional Lockable Swivel Casters
Set of 4 (Adds 4" to height)

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Made in the U.S.A

IMS Select Mold Setup Cart

Easy Access To All Your Maintenance Products

Item No. 163630

IMS Exclusive Product!

(Other Items Sold Separately)

Made expressly for holding water line hoses, fittings, clamps, tools, cleaners, greases, tool boxes, small molds, reels of hose, tubing, wire, etc.

Every Maintenance Department Needs This Cart!

Workspace Table

5S: SORT, SET, SHINE, STANDARDIZE, SUSTAIN

Specifications	
Tray Sizes:	
Upper (3):	14"W x 30"L x 2"D
Workspace Table:	14"W x 30"L x 2"D
Lower:	30"W x 30"L x 2½"D
Dimensions:	30"W x 30"L x 64"H
Cart Structure:	11 gauge steel
Weight Capacity:	350 lbs
Shipping Weight (must ship truck):	150 lbs

Tech Tips

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Have a mobile mold setup cart with every tool, hose, and clamp necessary that is brought to the machine. This avoids hunting for stuff and wasting time.

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Quick Mold Change

Using a video camera, record at least two mold (more preferably) changeovers made by different technicians. Have a meeting with your team, discuss and list what procedures works the best. (Everyone has a trick or two up their sleeve that can be passed on.)

Here are but a few suggestions for discussion:

1. What can be done while the mold that is coming out is still running
2. List the steps to be done as soon as the order comes for the mold change
3. List the steps to be done as soon as the machine is shut down
4. What has nothing to do with the changeover such as coffee and bathroom breaks that could be taken care of before starting the changeover
5. Who's going to troubleshoot running machines while the changeover is in process

Examine the list. One third of the set up time can be saved in preparation.

Here are a few examples of places to shave some time off your set up time:

1. Have the mold being set ready at the machine before shutting down
2. Install FasTie Couplers on your ejector rods
3. Install Quick Change or Push On waterline fittings
4. Preheat the mold off line with a spare thermolator
5. Pre Dry your material in a Mobile Drying Hopper
6. Have an IMS Mobile Set Up Cart stocked and ready to go with eyebolts, straps, bolts, water fittings, etc.

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IMS MAXX™ Mold Clamps

Quick Reference Price Chart

MAXX FC Forged, Closed-Toe Mold Clamps					
Description	**Length**	**Width**	**Wide Slot**	**Item #**	**Page #**
FC3	4 1/16"	1 1/4"	21/32"	103908	40
FC4	5 1/4"	2"	25/32"	103896	41
FC5	5 1/2"	2"	25/32"	103884	42
FC6	6 1/2"	2"	25/32"	103869	43
FC7	7"	2 1/4"	25/32"	103839	44
FC8	7"	2"	1 1/16"	103903	45
FC9	9"	3 1/4"	1 5/16"	104122	46
MAXX FO Forged, Open-Toe Mold Clamps					
Description	**Length**	**Width**	**Wide Slot**	**Item #**	**Page #**
FO5	5"	2"	25/32"	103875	48
FO7	7"	2"	25/32"	103859	49

Tech Tips

Molding Safety Checklist

Inspection

Inspect the press and surrounding areas including all auxiliary equipment for the following:

- Is the area clean and free of all potential hazards?
- Is other electrical equipment that could be hazardous during the operation locked out?
- Are the correct mold straps used to strap the mold together?
- Did you perform the daily inspection on the hoist/crane?

Holes in Platens

- Are the holes in the platen in good condition? Will they be able to hold the mold?

Mold Clamps

- Are the clamps the correct size for the mold?
- Are the clamps cracked or bent?
- How many clamps are needed to hold the mold?
- Are the clamps spaced evenly? It is essential that the clamps are placed properly.

Clamp Installation

- Make sure the bolts for the clamps are the correct size and grade.
- Make sure you are using the proper grade of bolts.
- Are the bolts in good condition?
- Check the manufacturer's torque information to see how much torque needs to be placed on the bolts.
- Don't rely on air pressure to torque bolts properly!

*** It is NOT recommended to re-use bolts from a previous application**

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FC Forged, Closed-Toe Mold Clamps

Closed Toe for Maximum Holding Strength

Look For "MAXX" If You Want The Very Best!

Clamps

- Closed toes provide maximum holding strength
- Made from durable forged 4140 tool steel
- Heat treated throughout, not just on the surface, optimizing tensile strength
- Large slots for easy mold positioning
- Black oxide, noncorrosive surface

Clamp bolts

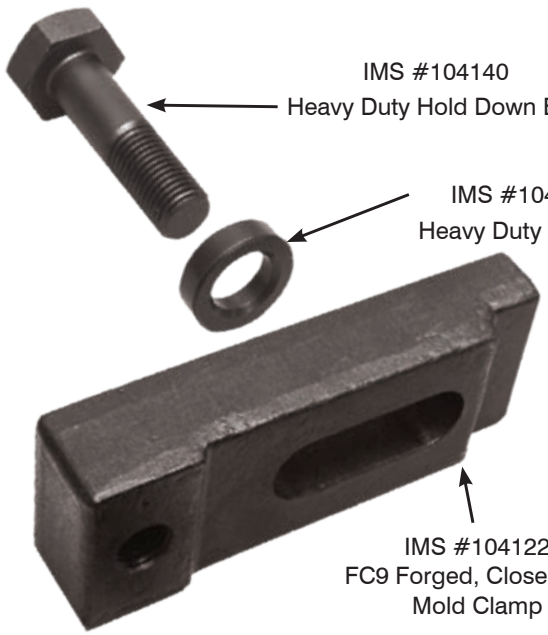
- Made from durable forged 4140 tool steel
- Oversized hex head prevents stripping of bolt head
- Extra large fillet under bolt heads
- Strong rolled threads prevents pull out
- Heat treated for maximum tensile strength

Washers

- Extra thick hardened steel to prevent deformation under a heavy load
- Black oxide, noncorrosive surface

MAXX™ is a trademark of IMS Company

Only from IMS!



Tech Tips

For basic applications use mold clamps that have a slot to accept the bolt. They never fall off the bolt.

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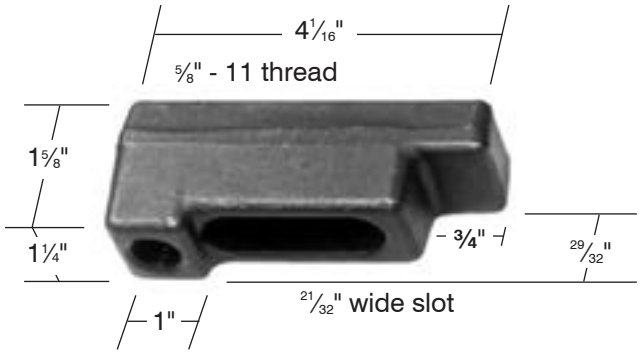
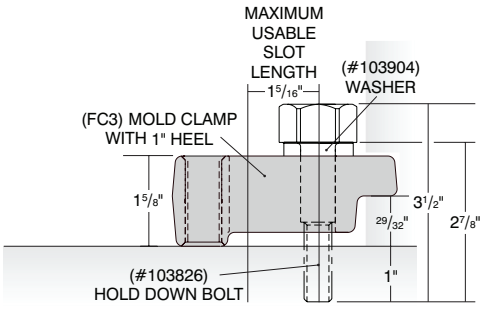
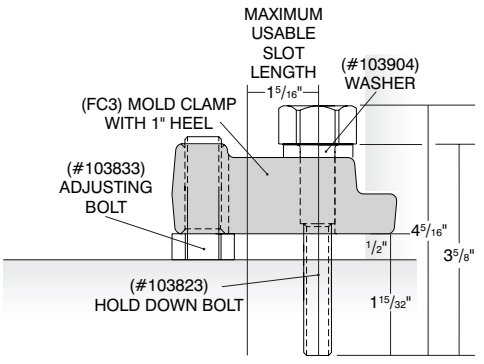
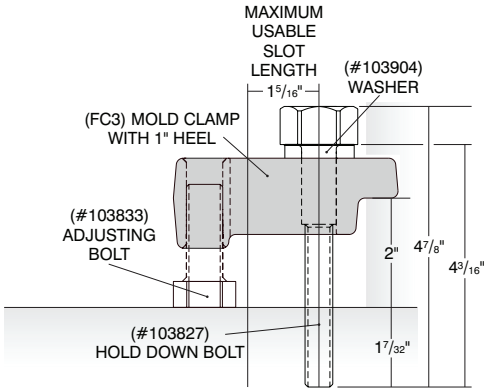
IMS MAXX™ FC3 Mold Clamps, Washers and Bolts



Specifications and Prices







For 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103908	FC3 Mold Clamp	4 1/16"L x 1 1/4"W x 21/32" wide slot
103904	Washer	1 1/4" O.D., 21/32" I.D. x 1/4"
103826	Hold down bolt	5/8" - 11 THD, 2 7/8"L

For 1/2"- 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103908	FC3 Mold Clamp	4 1/16"L x 1 1/4"W x 21/32" wide slot
103904	Washer	1 1/4" O.D., 21/32" I.D. x 1/4"
103833	Adjusting bolt	5/8" - 11 THD, 1 3/4"L
103823	Hold down bolt	5/8" - 11 THD, 3 5/8"L

For 1 13/32"-2" Mold Flanges (requires one of each item)

Item #	Description	Size
103908	FC3 Mold Clamp	4 1/16"L x 1 1/4"W x 21/32" wide slot
103904	Washer	1 1/4" O.D., 21/32" I.D. x 1/4"
103833	Adjusting bolt	5/8" - 11 THD, 1 3/4"L
103827	Hold down bolt	5/8" - 11 THD, 4 3/16"L

Don't see what you need?
Call and ask a tech today: 866.467.9001

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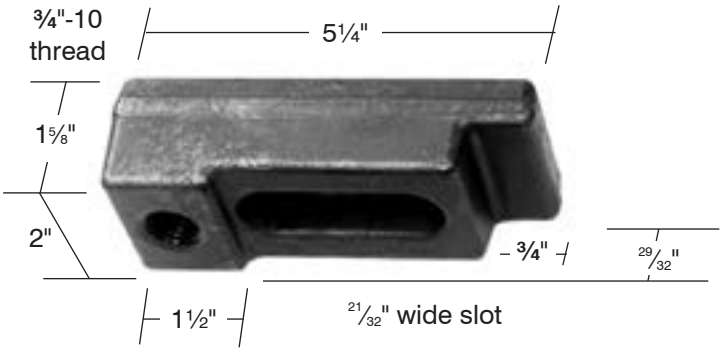
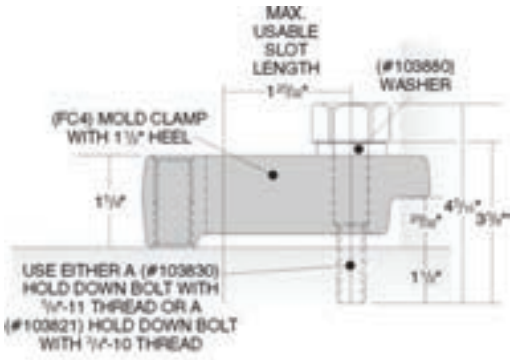
IMS MAXX™ FC4 Mold Clamps, Washers and Bolts

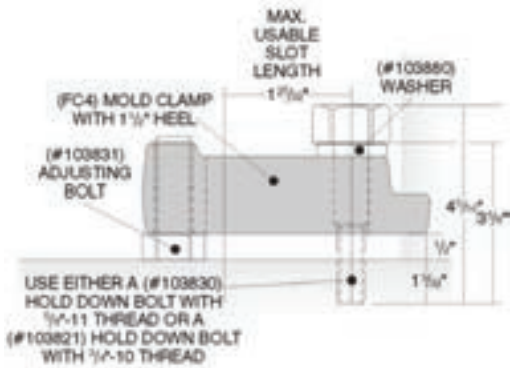


Specifications and Prices



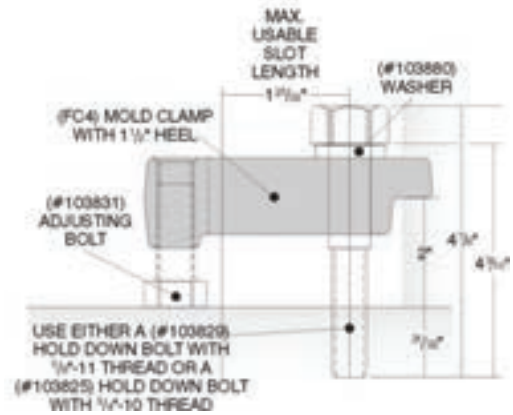
For 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103896	FC4 Mold Clamp	5¼"L x 2"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L



For ½"- 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103896	FC4 Mold Clamp	5¼"L x 2"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L



For 1 13/32"-2" Mold Flanges (requires one of each item)

Item #	Description	Size
103896	FC4 Mold Clamp	5¼"L x 2"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103829 or 103825	Hold down bolt	⅝" - 11 THD, 4 3/16"L ¾" - 10 THD, 4 3/16"L

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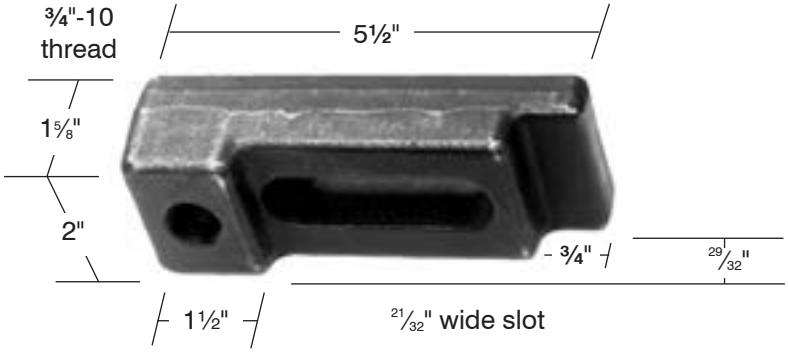
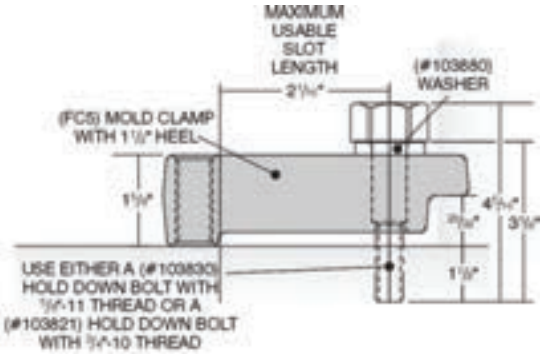
IMS MAXX™ FC5 Mold Clamps, Washers and Bolts

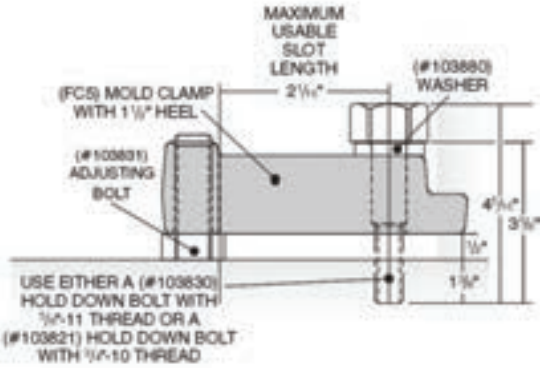


Specifications and Prices



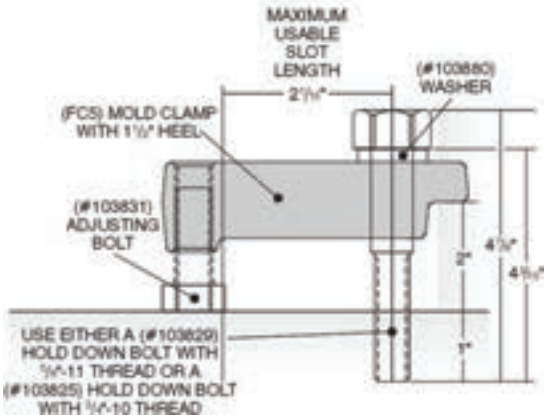
For 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103884	FC5 Mold Clamp	5½"L x 2"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L



For ½" - 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103884	FC5 Mold Clamp	5½"L x 2"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L



For 1 13/32"-2" Mold Flanges (requires one of each item)

Item #	Description	Size
103884	FC5 Mold Clamp	5½"L x 2"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103829 or 103825	Hold down bolt	⅝" - 11 THD, 4 3/16"L ¾" - 10 THD, 4 3/16"L

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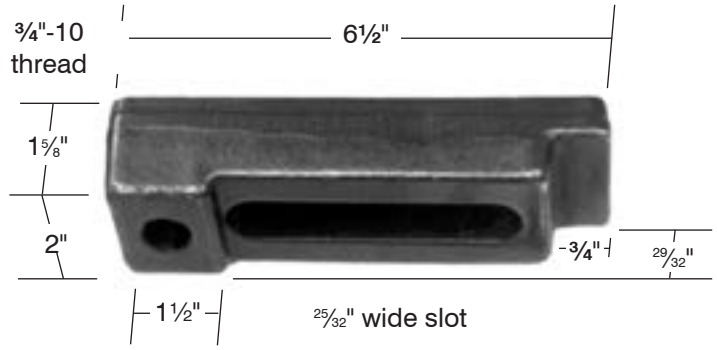
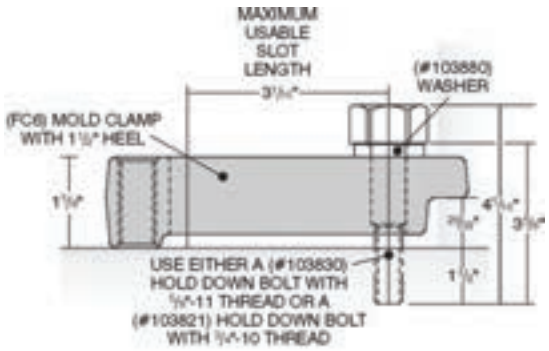
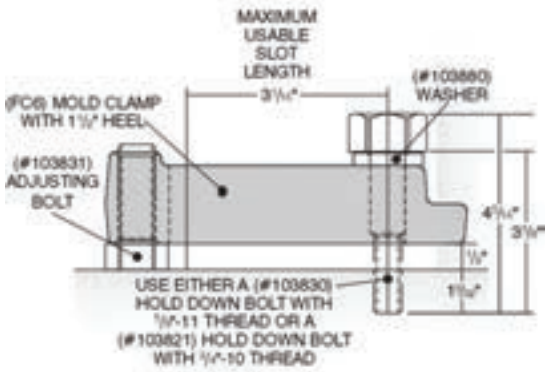
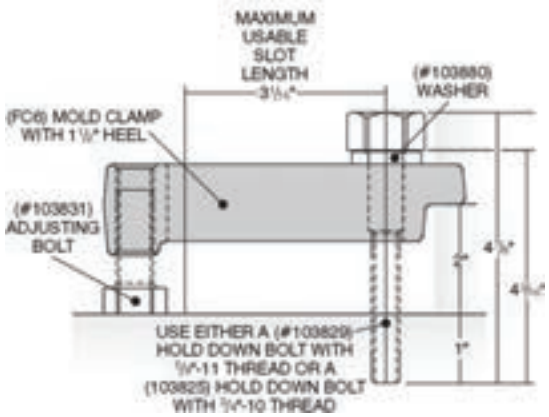
IMS MAXX™ FC6 Mold Clamps, Washers and Bolts



Specifications and Prices







For 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103869	FC6 Mold Clamp	6½"L x 2"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L

For ½"- 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103869	FC6 Mold Clamp	6½"L x 2"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L

For 1 13/32"-2" Mold Flanges (requires one of each item)

Item #	Description	Size
103869	FC6 Mold Clamp	6½"L x 2"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103829 or 103825	Hold down bolt	⅝" - 11 THD, 4 3/16"L ¾" - 10 THD, 4 3/16"L

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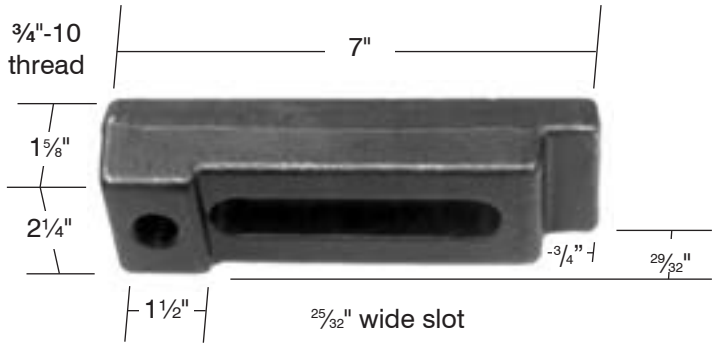
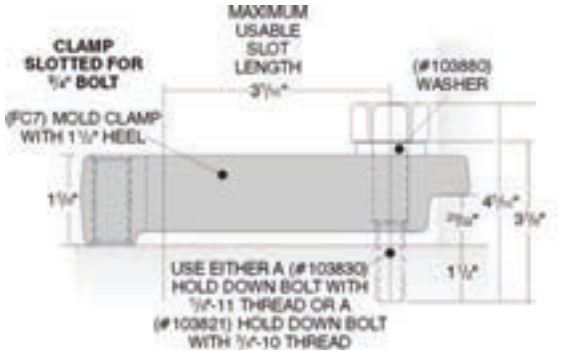
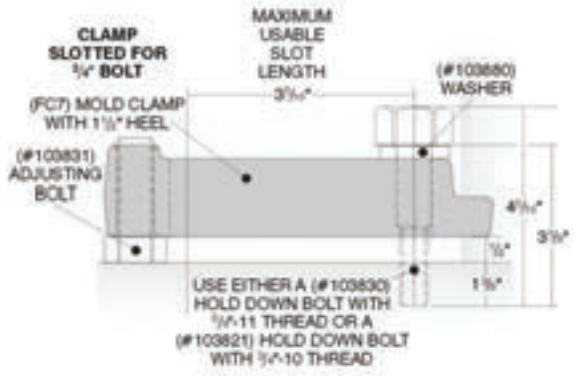
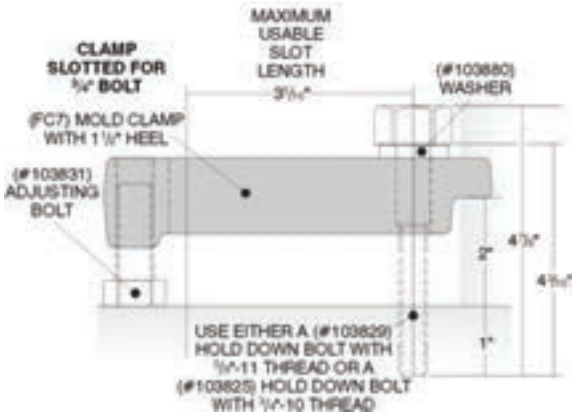
IMS MAXX™ FC7 Mold Clamps, Washers and Bolts



Specifications and Prices







For 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103839	FC7 Mold Clamp	7"L x 2¼"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L

For ½"- 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103839	FC7 Mold Clamp	7"L x 2¼"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L

For 1 13/32"-2" Mold Flanges (requires one of each item)

Item #	Description	Size
103839	FC7 Mold Clamp	7"L x 2¼"W x 25/32" wide slot
103880	Washer	1½" O.D., 13/16" I.D. x ½"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103829 or 103825	Hold down bolt	⅝" - 11 THD, 4 3/16"L ¾" - 10 THD, 4 3/16"L

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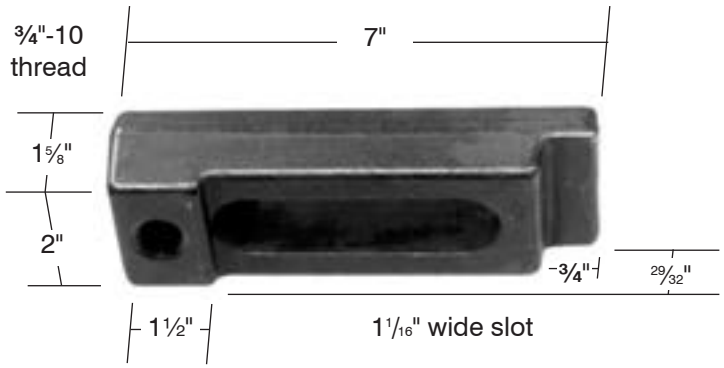
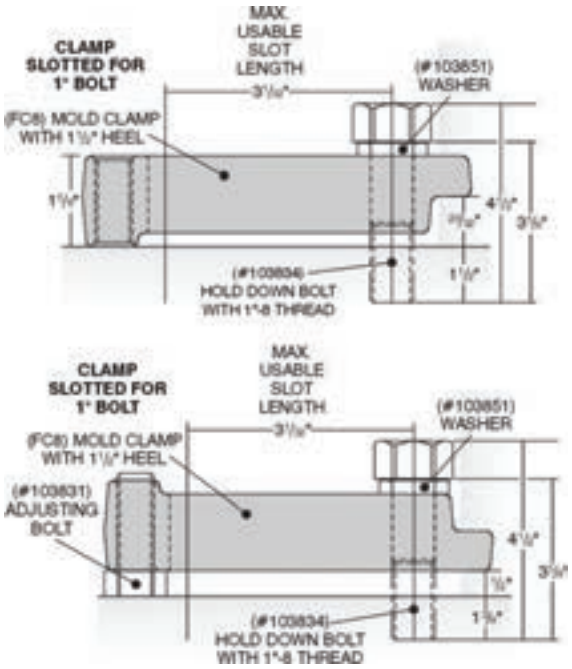
IMS MAXX™ FC8 Mold Clamps, Washers and Bolts



Specifications and Prices



For 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103903	FC8 Mold Clamp	7"L x 2"W x 1 1/16" wide slot
103851	Washer	2" O.D., 1 1/16" I.D. x ½"
103834	Hold down bolt	1" - 8 THD, 3⅝"L

For ½"- 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103903	FC8 Mold Clamp	7"L x 2"W x 1 1/16" wide slot
103851	Washer	2" O.D., 1 1/16" I.D. x ½"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103834	Hold down bolt	1" - 8 THD, 3⅝"L

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Tech Tips

Avoid "All-Purpose" Bolts and Washers. The most costly mistake you can make, is to use a bolt that is too short and strip the threads in a platen hole. Check clamp bolt engagement. It should enter the die plate at least 1¼ (preferably 1½) times the bolt diameter. Commercial bolts, socket head screws and soft steel washers require frequent, costly replacement, as bolt heads are too small and conventional washers bend when used on injection molds. You can avoid damage to your mold, cut your setup time and save money wasted on makeshifts by using bolts and washers made expressly for injection plants.

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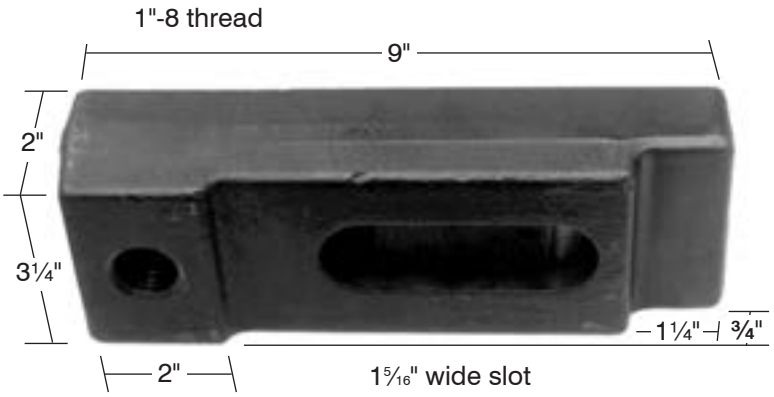
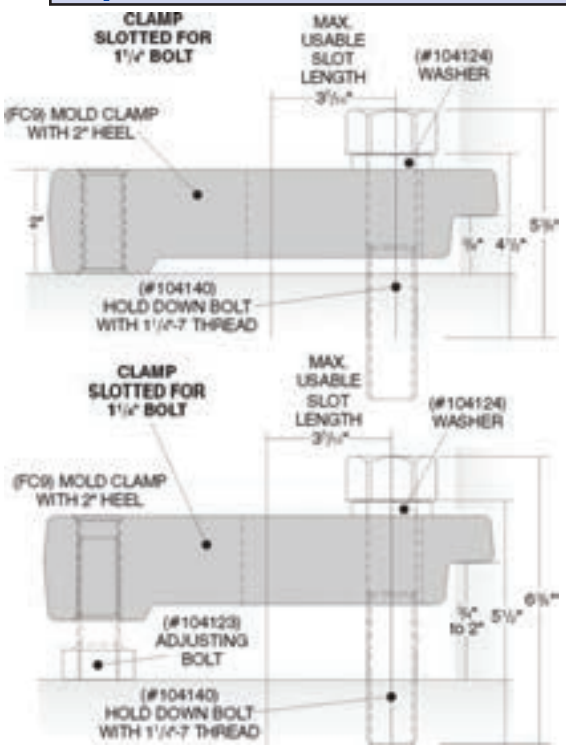
IMS MAXX™ FC9 Mold Clamps, Washers and Bolts



Specifications and Prices



For ¾" Mold Flanges (requires one of each item)

Item #	Description	Size
104122	FC9 Mold Clamp	9"L x 3¼"W x 1⁵⁄₁₆" wide slot
104124	Washer	2¼" O.D., 1⁵⁄₁₆" I.D. x ⁷⁄₁₆"
104140	Hold down bolt	1¼" - 7 THD, 5½"L

For ¾" - 2" Mold Flanges (requires one of each item)

Item #	Description	Size
104122	FC9 Mold Clamp	9"L x 3¼"W x 1⁵⁄₁₆" wide slot
104124	Washer	2¼" O.D., 1⁵⁄₁₆" I.D. x ⁷⁄₁₆"
104123	Adjusting bolt	1" - 8 THD, 2"L
104140	Hold down bolt	1¼" - 7 THD, 5½"L

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MAXX FO Forged, Open-Toe Mold Clamps

Open-Toe for maximum positioning flexibility

Only from IMS!

Clamps

- Open toes provide maximum positioning flexibility
- Made from durable forged 4140 tool steel
- Heat treated throughout, not just on the surface, optimizing tensile strength
- Black oxide, noncorrosive surface

Clamp bolts

- Made from durable forged 4140 tool steel
- Oversized hex head maximizes holding power
- Extra large fillet under bolt heads
- Strong rolled threads prevents pull out
- Heat treated for maximum tensile strength

Washers

- Extra thick hardened steel to prevent deformation under a heavy load
- Black oxide, noncorrosive surface

Custom Clamps Not A Problem for IMS!

Tech Tips

Take great care when handling open-ended clamps. They may slip and fall to the floor or down the chute when the tech is trying to bolt it in.

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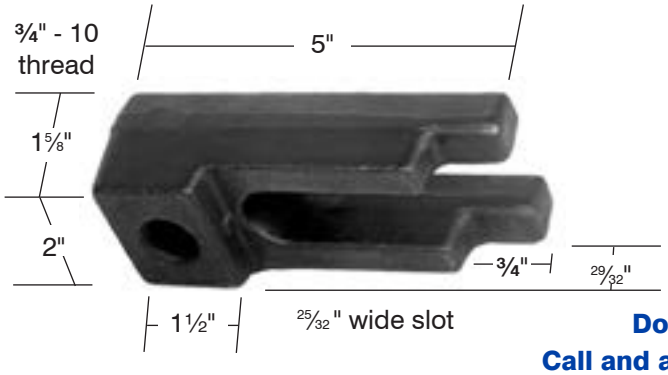
IMS MAXX™ FO5 Mold Clamps, Washers and Bolts



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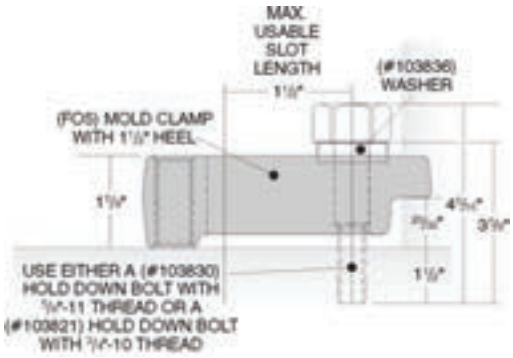
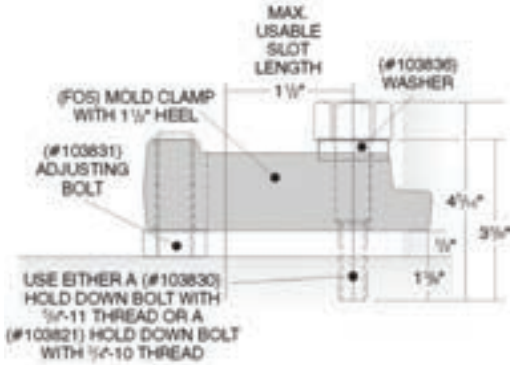
Specifications and Prices



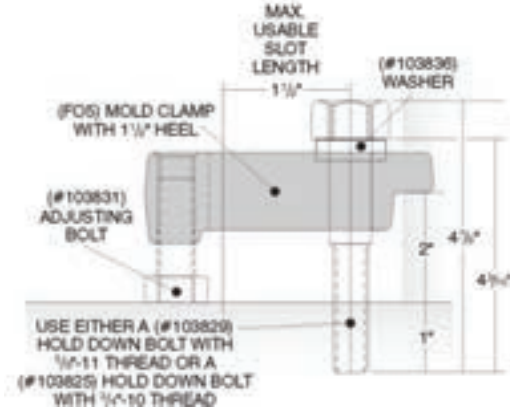
For 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103875	F05 Mold Clamp	5"L x 2"W x 25/32" wide slot
103836	Washer	25/32" I.D. x 7/16"
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L



For ½"- 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103875	F05 Mold Clamp	5"L x 2"W x 25/32" wide slot
103836	Washer	25/32" I.D. x 7/16"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L



For 1 13/32"-2" Mold Flanges (requires one of each item)

Item #	Description	Size
103875	F05 Mold Clamp	5"L x 2"W x 25/32" wide slot
103836	Washer	25/32" I.D. x 7/16"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103829 or 103825	Hold down bolt	⅝" - 11 THD, 4 3/16"L ¾" - 10 THD, 4 3/16"L

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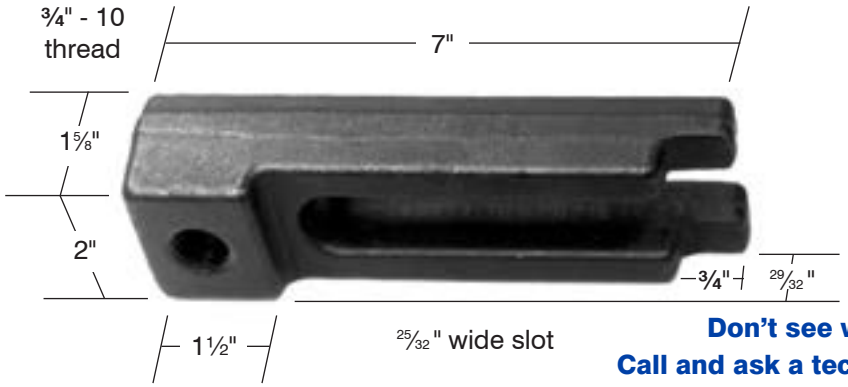
IMS MAXX™ FO7 Mold Clamps, Washers and Bolts



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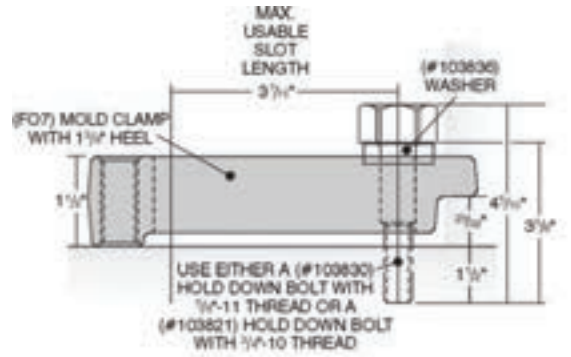
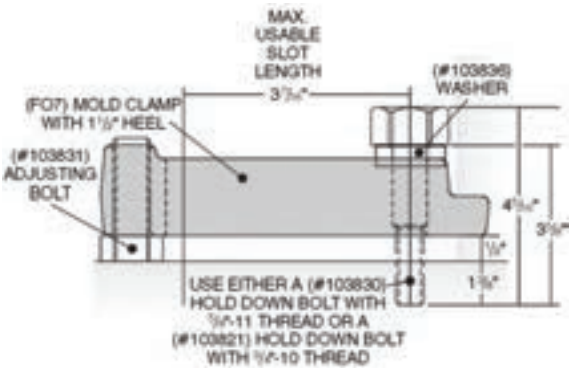


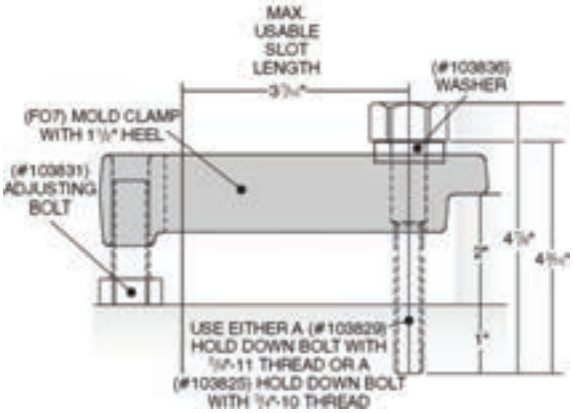
For 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103859	F07 Mold Clamp	7"L x 2"W x 25/32" wide slot
103836	Washer	25/32" I.D. x 7/16"
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L



For ½"- 29/32" Mold Flanges (requires one of each item)

Item #	Description	Size
103859	F07 Mold Clamp	7"L x 2"W x 25/32" wide slot
103836	Washer	25/32" I.D. x 7/16"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103830 or 103821	Hold down bolt	⅝" - 11 THD, 3⅝"L ¾" - 10 THD, 3⅝"L



For 1 13/32"-2" Mold Flanges (requires one of each item)

Item #	Description	Size
103859	F07 Mold Clamp	7"L x 2"W x 25/32" wide slot
103836	Washer	25/32" I.D. x 7/16"
103831	Adjusting bolt	¾" - 10 THD, 1¾"L
103829 or 103825	Hold down bolt	⅝" - 11 THD, 4 3/16"L ¾" - 10 THD, 4 3/16"L

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Machined Mold Clamps

Heat Treated Premium Quality Steel

- Carburized .020/.025 deep
- Black oxide finish
- Available in both open and closed design

NOTE: No Turn washers recommended with open toe clamps

Type	Item #	Length	Width	Thickness	Slot Length	Bolt Diameter	Adjusting Bolt Size
Closed Toe	141652	6"	1¾"	1¼"	2⅝"	⅝"	⅝"-11
	160989	7½"	1¾"	1¼"	3⅝"	⅝"	⅝"-11
	160990	6½"	2"	1½"	2¾"	¾"	¾"-10
	160991	8"	2"	1½"	3¾"	¾"	¾"-10
	138051	8"	2½"	1¾"	3"	1"	1"-8
	142932	9½"	2"	1½"	4¾"	¾"	¾"-10
	142392	11"	2½"	1¾"	5"	1"	1"-8
	138054	13"	3"	1¾"	5½"	1¼"	1½"-6
	161967	13½"	3½"	1¾"	5¾"	1½"	1½"-6
Open Toe	147811	4"	1¾"	1"	2¾"	⅝"	⅝"-11
	160977	5"	1¾"	1"	3¼"	⅝"	⅝"-11
	160980	5"	2"	1¼"	3⅜"	¾"	¾"-10
	160978	6"	1¾"	1"	3¾"	⅝"	⅝"-11
	160981	6"	2"	1¼"	3⅞"	¾"	¾"-10
	160983	6"	1¾"	1¼"	3⅝"	⅝"	⅝"-11
	160985	6½"	2"	1½"	4"	¾"	¾"-10
	160979	7"	1¾"	1"	4¼"	⅝"	⅝"-11
	145665	7"	2"	1¼"	4⅜"	¾"	¾"-10
	160984	7½"	1¾"	1¼"	4⅝"	⅝"	⅝"-11
	160986	8"	2"	1½"	5"	¾"	¾"-10
	160982	8"	2"	1¼"	5⅜"	¾"	¾"-10
	160987	8"	2½"	1¾"	4⅜"	1"	1"-8
	142835	9½"	2"	1½"	6"	¾"	¾"-10
	145661	10"	2½"	1½"	6"	1"	1"-8
	160988	11"	2½"	1¾"	6⅜"	1"	1"-8
	143016	13"	3"	1¾"	7¼"	1¼"	1½"-6

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Standard Grade 5 Mold Clamp Adjustment Bolts

Lower Cost Alternative to Grade 8 Adjusting Bolts

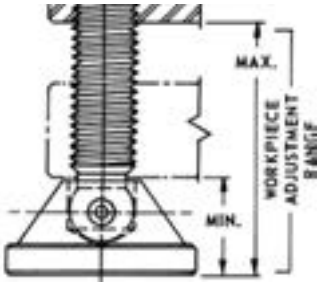
- Black oxide finish

Item #	Thread Size	Length	Hex Head	Head Thickness
148769	½"-13	2½"	¾"	5/16"
141653	⅝"-11	2½"	⅞"	7/16"
138534	¾"-10	2½"	1⅛"	½"
143019	1"-8	2½"	1½"	⅝"

Swivel Head Adjusting Bolts

Firm Footing When Clamp Angle is an Issue

- Heat treated premium steel
- Black oxide finish



Item #	Thread Size	Length	Hex Head	Head Thickness
141722	⅝"-11	3"	1¾"	⅞"
141721	¾"-10	3½"	2"	⅞"
137693	1"-8	3½"	2½"	1 5/16"
137692	1½"-6	5⅝"	3"	1⅝"

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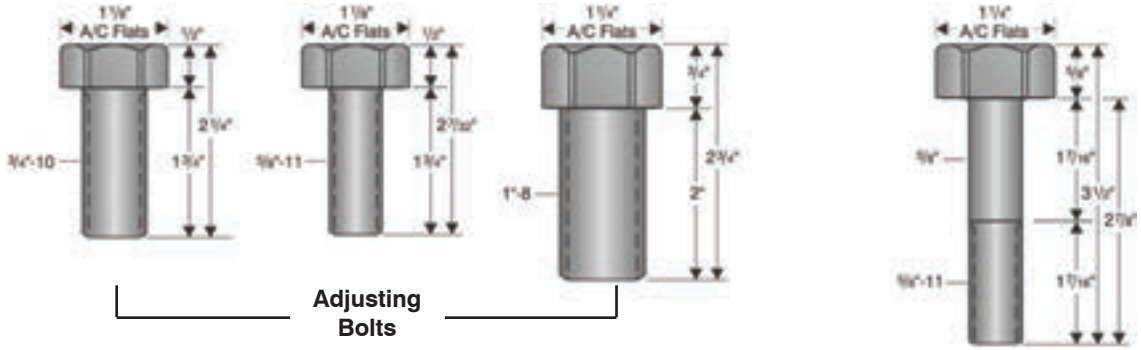
IMS MAXX™ Mold Clamp Bolts

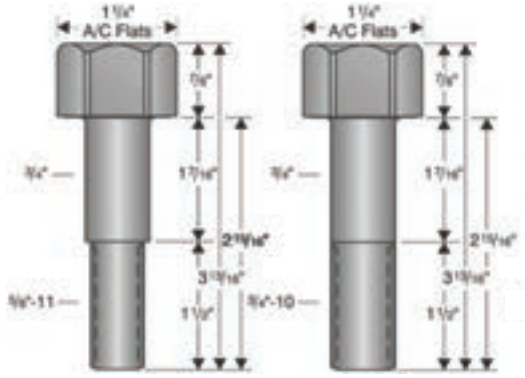
Specially designed for mold clamp use

- Made from durable forged 4140 tool steel
- Oversized hex head maximizes holding power
- Extra large fillet under bolt heads
- Heat treated for maximum tensile strength

Specifications and Prices (Unit Price = Each)



Item #	Item #	Item #	Item #
103831	103833	104123	103826



Item #	Item #
103824	103822

Suggested Maximum Torque Value for IMS Heavy Duty Clamp Bolts		
Bolt Number	Torque	Thread
#103833, #103826, #103824, #103830, #103823, #103829, #103827	245 ft./lb.	5/8"-11
#103831, #103822, #103821, #103825	425 ft./lb.	3/4"-10
#104123, #103834	591 ft./lb.	1"-8
#104140	800 ft./lb.	1¼"-7

continued on next page

Wrenches Available — See page 57 for details

Tech Tips

Check out www.imscompany.com for articles on proper bolt length and installation.

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IMS MAXX™ Mold Clamp Bolts

(continued)

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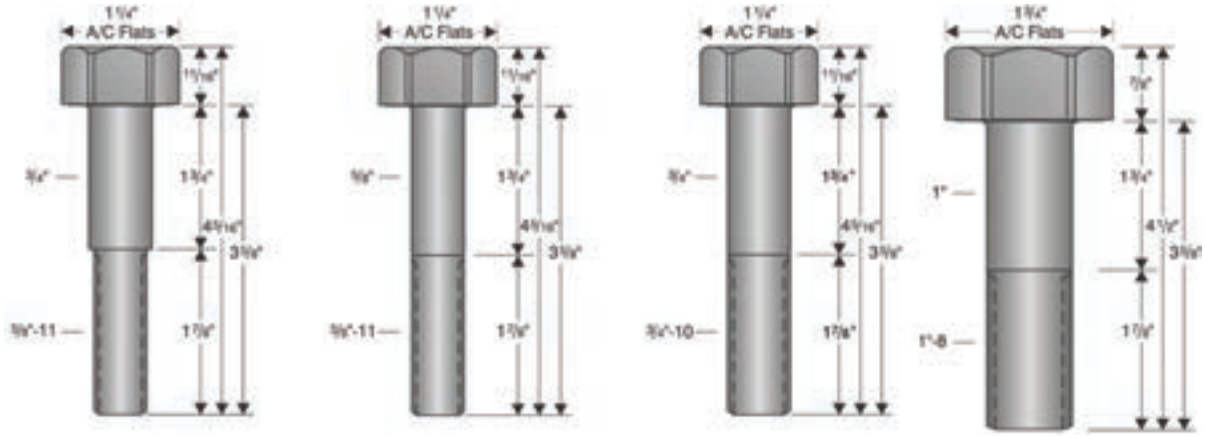
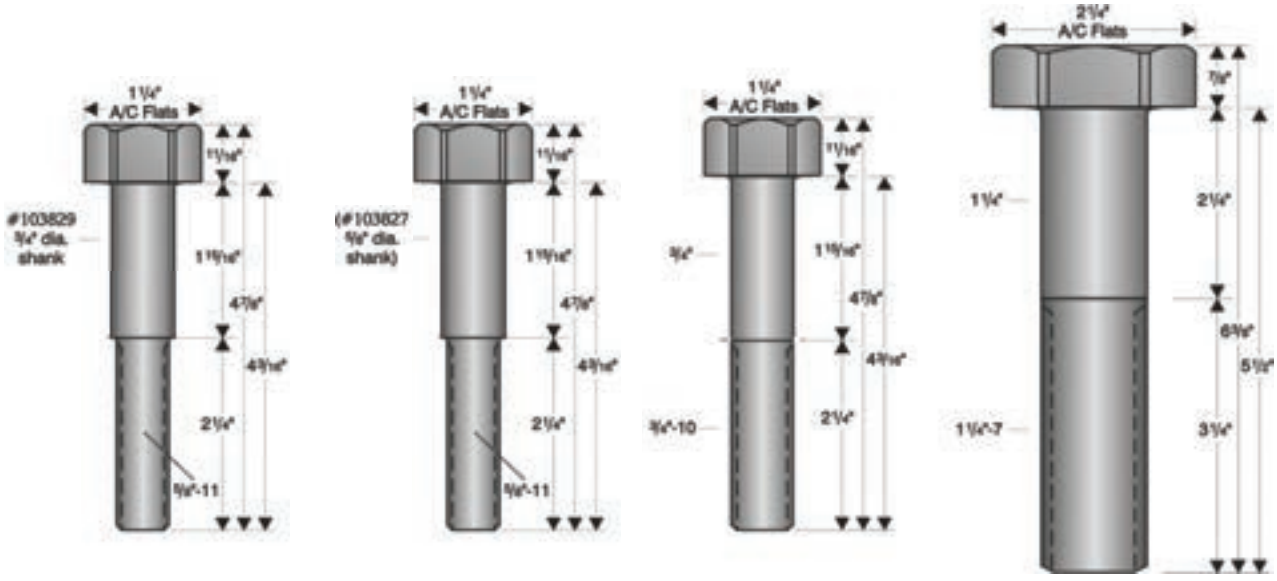
Specifications and Prices (Unit Price = Each)



Item #	Item #	Item #	Item #
103830	103823	103821	103834



Item #	Item #	Item #	Item #
103829	103827	103825	104140

Wrenches see page 57

MAXX Washers see page 56 - 57

Tape Measures see page 462-463

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Made in the U.S.A

Mold Clamp Bolts — Grade 8 Steel

- Hex head eases installation and inhibits stripping
- Tensile Strength: 150,000 psi (base steel)
- Specials available upon request

Purchasers also order:

- Washers, page 56-57
- Platen Hole Savers, page 60
- Copper Flake Thread Lube, page 521

Item #	Thread Size	Under Head Length	Thread Length	Hex Head	Shank Diameter
Standard Size					
103902	½"-13	2½"	1¼"	¾"	½"
103890		3½"			
103862	⅝"-11	3"	1⅝"	15/16"	⅝"
103847		3½"			
103925		4"	1½"		
103912		4½"			
103900		5"			
142306		6"			
103888	¾"-10	3½"	1⅞"	1⅛"	¾"
106340		1¾"	1¾"		NA
103874		4"	1⅞"		¾"
103858		4½"			
103844		5"			
103922	1"-8	4"	2¼"	1½"	1"
103909		4½"			
103897		5"			
131306		6"	2½"	1½"	1"
Metric Size					
103855	M-12 x 1.75	2⅜"	1 3/16"	19 mm	½"
103841		3½"			
103881	M-16 x 2.0	3½"	1½"	24 mm	⅝"
103893		4⅜"			
103852	M-20 x 2.5	2¾"	1 13/16"	30 mm	¾"
103867		4"			

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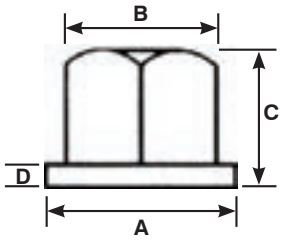
T-Slot Head Style High Strength Bolts

Made in the U.S.A

- AISI 1045
- Unified coarse threads
- Heads sized to fit in table slot giving more bearing surface

Item #	Thread Size	Length	Thread Length	Head Diameter	Shank Diameter	Hex Nut
147164	5/8"-11	4"	2"	1 3/32" x 1 5/16"	5/8"	159980
159972		5"				
148608		6"				
159974	3/4"-10	4"	2"	1 1/4" x 1 1/2"	3/4"	159981
137697		5"				
140372		6"				
159975		8"	2 1/2"			
159976	1"-8	4"	2"	1 3/4" x 2"	1"	150359
159977		5"				
137603		6"				
150358		8"	2 1/2"			

Flanged Hex Nuts for T-Slot Bolts



Item #	A	B	C	D	Thread Size
159979	1 1/8"	7/8"	11/16"	5/32"	1/2"-13
159980	1 3/8"	1 1/16"	13/16"	3/16"	5/8"-11
159981	1 5/8"	1 1/4"	1"	1/4"	3/4"-10
150359	2"	1 5/8"	1 1/4"	1/4"	1"-8

Optional Accessory

T-Slot Cleaner

Eliminates the danger of removing chips with air or by hand
Item No. 159978 ..... **$2.30**

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Made in the U.S.A

IMS MAXX™ Mold Clamp Washers

Specially Designed For Mold Clamp Use

- Extra thick hardened steel to prevent deformation under a heavy load
- Black oxide, noncorrosive surface*

Only from IMS!

NOTE: IMS Hardened Steel Injection Mold Clamp Washers are 2 to 3 times thicker than ordinary washers; select bolts to make sure length of thread engagement is 1 to 1½ times the bolt diameter. Washers made expressly for heavy duty mold clamping will outlast commercial types many times and cost you much less in the long run.

Specifications and Prices

Item #	Item #	Item #	Item #
103904	132419	103880	103866

Item #	Item #	Item #
103851	104124	162632*

*162632 is not black oxide coated

Maxx™ Mold Clamp Washer Quantity Discounts
Order 11-49 – Deduct 5% Order 50+ – Deduct 10%

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Washers and Nuts

#103870

#136374

#144181

Item #	I.D.	O.D.	Thickness
C1010 Steel Washers			
103870	9/16"	1 1/16"	1/4"
103854	21/32"	1 5/16"	1/4"
103840	25/32"	1 1/2"	1/4"
103918	1 1/32"	1 3/4"	1/4"
Black Oxide Washers			
160012	1/2"	1 1/2"	1/2"
141655	5/8"	1 1/4"	1/4"
144136	5/8"	1 3/4"	1/2"
137695	3/4"	2"	1/2"
136374	25/32"	1 1/2"	1/4"
144133	1"	2"	5/16"
137734	1"	2 1/2"	5/8"
137694	1 1/4"	3"	5/8"
No Turn/Rectangular Washers			
160906	1/2"	2 1/4" Long (1 3/4" between legs)	3/4"
141654	5/8"	2 1/4" Long (1 3/4" between legs)	3/4"
144180	3/4"	2 1/2" Long (2" between legs)	3/4"
103836 (forged)	25/32"	2 5/16" Long (1 29/32" between legs)	7/16"
144181	1"	3" Long (2 1/2" between legs)	1"
165551	1 1/4"	3 1/2" Long (3" between legs)	1"

Combination Wrenches

Heat Treated Chrome Vanadium Alloy Steel

Purchasers also order:

- Low Cost Mold Clamp Bolts, page 54

The Right Tool For Installing Nozzles, Mold Clamp Bolts and More

Item #	Fits Hex Size	Nominal OAL	Box	Weight
109151	7/8"	11"	12 point	9 oz.
149120	1 1/4"	16"	12 point	1.6 lbs.

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Plastic Locating Ring

The LOCATOR™ Ensures Proper Mold Installation

GREEN Products
Made from 100% Recycled Material!

Prevent costly damage to molds and platens!

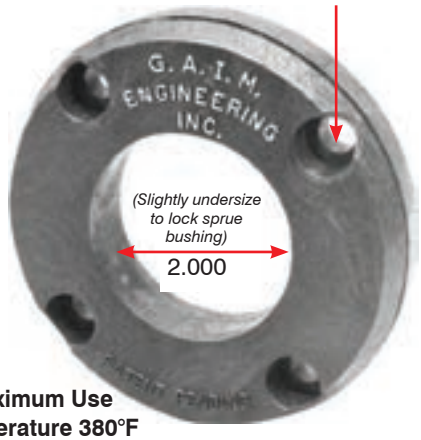
When installing a mold, the mold setter seldom knows anything is off center until he hears the sound of steel being crushed. By that time, the damage is done. Once damaged, a mold or platen is not serviced easily, and can prove very costly to repair.

The "LOCATOR™", with its unique micro-cellular structure, is forgiving. The sound of the thermoplastic ring cracking can alert setters to a misaligned mold before any damage is done to either the mold or the platens.

Features

- Reduce mold setup and tear down costs
- Form-fits to worn platens
- Leaking plastic from nozzle & sprue bushing easily peels right off – won't stick
- Costs much less than tapered, steel locator rings
- Mounting hole patterns are D-M-E® or National Tool standards

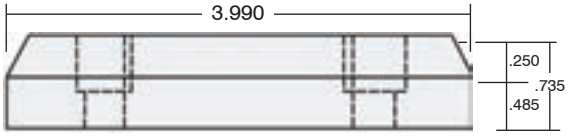
Drilled & counterbored for 5/16" dia. socket head cap screw



Maximum Use Temperature 380°F

Item #	Description
107960	Plastic Locating Ring

Designed & made by a molder for molders



Steel Locating Rings Available Upon Request

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Injection Mold Alignment Paper

Mold-Align® Pressure Sensitive Mold and Die Aligning Paper

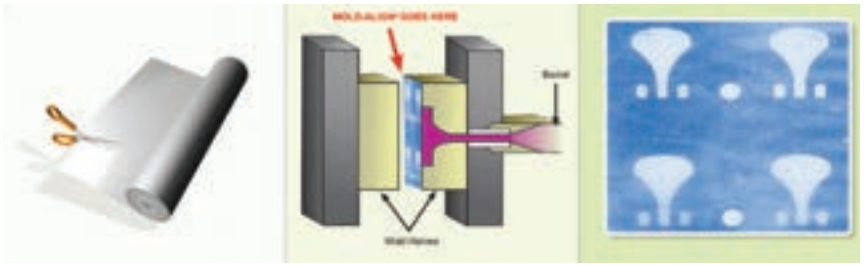
A unique, affordable and easy to use tool that reveals pressure distribution between mold platens

Benefits

- Substantially extend the life of your mold
- Very economical
- No training is required and extremely easy to use
- Helps reduce flash and also improve yield
- Can be incorporated into your quality system for reference and control to verify mold alignment changes

Example of how to use Mold-Align® in 3 steps:

1. Comes on a roll - cut to size.
2. Place Mold-Align® between the two mold/die halve surfaces.
3. Clamp-up mold/un clamp mold and remove Mold-Align® from between the mold/die haves to visually observe the color tone based on pressure.



Specifications

Thickness:	4 Mils	**Pressure Range:**	1,000 – 6,000 PSI (70-422 kg/cm2)
Usable Humidity Range:	10-90% RH	**Temperature Limit:**	200°F (93°C)

Style	Size	Quantity	Item #
Rolls	30" x 50' (76.2cm x 15.2m)	1 Roll	165698

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Made in the U.S.A

IMS Soft Steel Hole Savers

For easy repair of stripped platen holes

IMS Platen Hole Savers are made expressly for injection molders. There are many types of thread repair inserts offered for general use; many are hardened steel and are themselves NOT replaceable. When you damage those commercial inserts, you can't drill them out and repair them easily on the press.

Some molders repair stripped platen holes by drilling them out and making them larger. But then they need an odd size bolt, which means lost time at mold setups.

Stripped platen holes result from too-short or too-tight bolts, especially with adjustable clamps. Damaged platen holes waste hours of mold setup time and lead to bad mold-clamping habits.

If you have a stripped platen hole, repair it now with a soft steel Platen Hole Saver that is replaceable if the I.D. thread is damaged. Keep your mold clamps standardized. Avoid makeshift mold clamp setups, and save on mold-change costs.

How To Install

Drill and tap out new hole. Install hole saver with hex at bottom of hole using appropriate size Allen Wrench. Peen the hole saver in place or drill through threads with a 1/8" drill and drive in a soft steel pin.

Specifications and Prices

Bolt Thread Size	Drill Size	Hole Depth	Tap Size	Allen Wrench Size
1/2"-13	21/32"	1 1/2"	3/4"-10	7/16"
5/8"-11	7/8"	1 1/2"	1"-8	1/2"
3/4"-10	1 3/23"	1 1/2"	1 1/4"-7	5/8"
1"-8	1 13/23"	1 1/2"	1 1/2"-12	3/4" square key
1 1/4"-7	1 5/8"	1 1/2"	1 3/4"-8	1 1/8"
12 mm-1.75 mm	21/23"	1 1/2"	3/4"-10	3/8"
16 mm-2 mm	7/8"	1 1/2"	1"-8	1/2"
20 mm-2.5 mm	1 3/23"	1 1/2"	1 1/4"-7	5/8"
24 mm-3.0 mm	1 13/23"	1.80"	1 1/2"-12	3/4"

Standard Sizes		Metric Sizes	
Item #	**Size**	**Item #**	**Size**
103863	1/2" - 13	109836	12 mm-1.75 mm
103848	5/8" - 11	109833	16 mm-2 mm
103926	3/4" - 10	109827	20 mm-2.5 mm
103913	1" - 8	113147	24 mm-3.0 mm
137883	1 1/4" - 7		

Optional Accessories

Drills*			Taps	
Item #	**Bit Size**	**Shank Size**	**Item #**	**Size**
113048	21/32"	1/2"	113069	3/4" - 10
113067	7/8"	1/2"	113066	1" - 8
113063	1 3/32"	1/2"	113061	1 1/4" - 7
113058	1 13/32"	1/2"	113055	1 1/2" - 12
163375	1 5/8"	3/4"	137884	1 3/4" - 8

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5-Piece Long Folding Hex Key Set

- Tip Sizes: 3/16", 7/32", 1/4", 5/16" and 3/8"
- Overall Length: 2 7/16" min and 3 1/4" max
- Handle Length: 5 1/4"
- Material: Steel
- Finish: Black oxide with chrome plated handle

Made in the U.S.A

Item #	Description
162710	Long Folding Hex Key Set

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SMARTFLOW

FasTie® Quick Ejector Tie-In System

In an injection molding press, the FasTie system quickly "ties-in" the mold ejector plate to the press ejection system, dramatically reducing mold change time. The greatest time savings are realized in presses where space is limited and the ejector system is difficult to tie in using solid knock-out bars.

The FasTie coupler may be permanently mounted to the press ejector plate. The quick-connect locking mechanism in the coupler snaps mechanically onto the mold-mounted stud during mold installation.

To release the ejectors, apply shop air to the coupler. The coupler opens to release the stud, disconnecting the press and tooling ejector plates. The coupler remains in the open position, ready for a new mold to be set.

For multiple ejector locations, an air manifold is recommended to release all couplers simultaneously. See inside catalog pages for installation examples.

Three FasTie models are available: 1-inch original model for presses 500 tons and under, 1-inch High Strength FasTie for center knock-out and high speed ejection, and 2-inch model for presses larger than 500 tons.

Allow Faster Mold Change

1-Inch Original

FasTie Couplers

U.S. Patent No. 6,379,072

FasTie Studs

Includes Air Fitting

- FasTie installs easily into existing tapped holes, no additional machining is required.
- FasTie reduces mold setting time by quickly uncoupling, plus there are no loose parts to stow.
- FasTie remains coupled during mold cycling for increased "tie-in" reliability and reduced wear.

High Strength vs Original Coupler and Stud

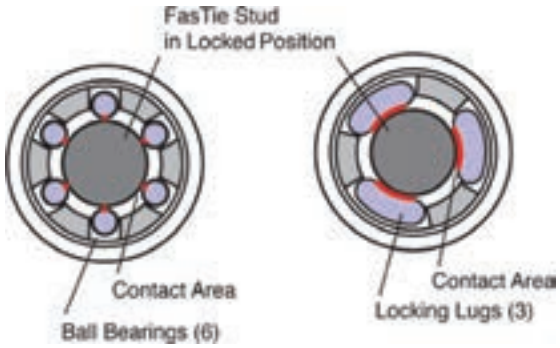
High Strength FasTie works the same as the original FasTie. The difference is in the load-bearing surface area inside the coupler. Instead of six ball bearings to hold the FasTie stud, there are three locking lugs to distribute the load more evenly. See below. Contact area is increased dramatically.

When coupler and stud are connected, the High Strength FasTie assembled length is .10" (2.5mm) longer than the original version. The outside diameters are the same.

Mating High Strength Components must have "HS" stamped on the hex body. Production parts will have knurling on both components for easy identification. The new design significantly improves coupler life in demanding applications such as center knock-out.

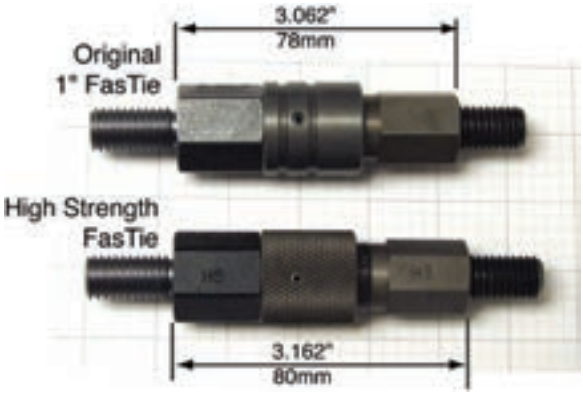
High Strength couplers and studs must NOT be used with the original FasTie. Slight dimensional differences will cause malfunction if the versions are mixed in an installation. Standard Ejector Bars, Center Adapters and Air Manifolds may be used with the High Strength FasTies.

High Strength FasTie End View



Original 1" FasTie — High Strength FasTie

High Strength FasTie Length Comparison



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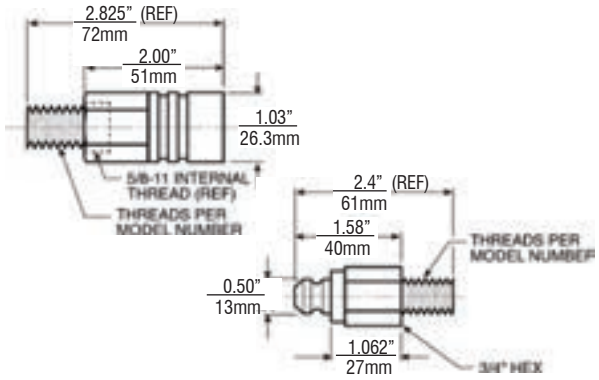
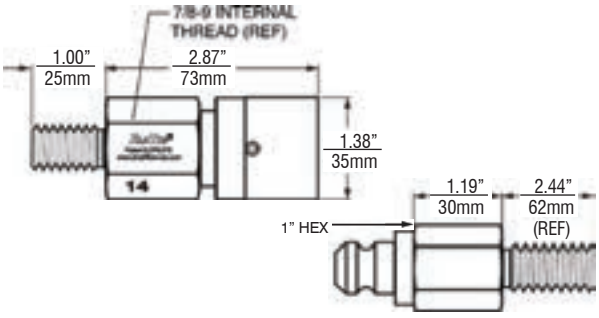
FasTie® Quick Ejector Tie-In System

For presses 500 tons and under





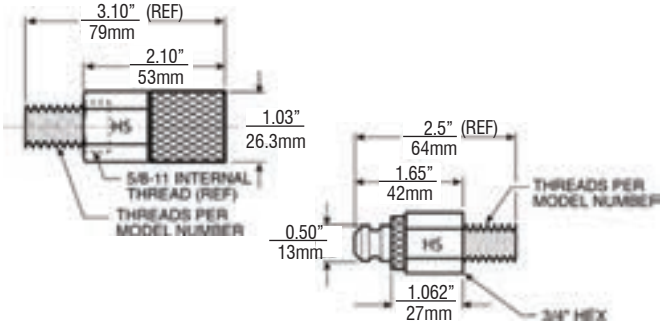
1" and 1⅜" Series Couplers & Studs

Original FASTIE® 1" Couplers and Studs		
Item #	**Model #**	**Thread Size**
Coupler ONLY		
143507	FTF-50	½" - 13
143509	FTF-63	⅝" - 11
147536	FTF-M12	M12 x 1.75
147537	FTF-M16	M16 x 2
Studs ONLY		
143531	FTM-38	⅜" - 16
143508	FTM-50	½" - 13
143510	FTM-63	⅝" - 11
143532	FTM-M12	M12 x 1.75
143533	FTM-M16	M16 x 2
147535	FTM-M20	M20 x 2.5
Original FASTIE® 1⅜" Couplers and Studs		
Item #	**Model #**	**Thread Size**
Coupler ONLY		
161395	FTF1.4-63	⅝" - 11
161401	FTF1.4-75	¾" - 10
173424	FTF1.4-88x	⅞" - 9 Female
161402	FTF1.4-M16	M16 x 2
161403	FTF1.4-M20	M20 x 2.5
Studs ONLY		
161396	FTM1.4-63	⅝" - 11
161398	FTM1.4-75	¾" - 10
161399	FTM1.4-M16	M16 x 2
161400	FTM1.4-M20	M20 x 2.5

High Strength FasTie Couplers & Studs

Do not use HS FasTie Couplers in combination with original version (above). Damage to couplers will result.

Center knock-out, multiple and high speed ejection indicate the need for High Strength FasTie Couplers and Studs. High Strength Couplers and Studs are longer than the original parts (see above), and are not to be used in combination with Original Couplers and Studs. All Accessories are compatible with both styles of Couplers and Studs.



High Strength FASTIE® 1" Couplers and Stud		
Item #	**Model #**	**Thread Size**
Coupler ONLY		
143511	FTFHS-50	½" - 13
143513	FTFHS-63	⅝" - 11
170636	FTFHS-63X	⅝" - 11 Female
147539	FTFHS-M12	M12 x 1.75
147540	FTFHS-M16	M16 x 2
172188	FTFHS-M20	M20 x 2.5
Studs ONLY		
143534	FTMHS-38	⅜" - 16
143512	FTMHS-50	½" - 13
143514	FTMHS-63	⅝" - 11
143535	FTMHS-M12	M12 x 1.75
143536	FTMHS-M16	M16 x 2
147538	FTMHS-M20	M20 x 2.5

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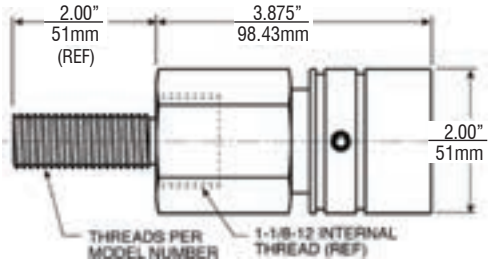
FasTie® Quick Ejector Tie-In System

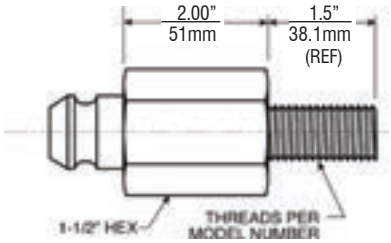
2" Couplers and Studs
For presses larger than 500 tons

U.S. Patent No. 6,379,072

2" Series

Allow Faster Mold Change





- Couples mechanically
- Disconnects with shop air
- Simplifies mold changes
- Adaptable to different types of machines and molds
- Made from hardened steel
- Installs without mold modification
- Saves up to 15-20 minutes per mold change
- Stays coupled during cycles

FASTIE® 2" Couplers and Studs			
Item #	**Model #**	**Thread Size**	**Unit Price**
Coupler ONLY			
147523	FTF2-63	5/8" - 11	**$488.00**
144856	FTF2-75	3/4" - 10	**488.00**
173576	FTF2-M20	M20 x 2.5	**543.00**
175037	FTF2-113X	1 1/8" - 12 Female	**470.00**
Studs ONLY			
147524	FTM2-63	5/8" - 11	**$112.00**
144855	FTM2-75	3/4" - 10	**112.00**
147541	FTM2-M16	M16 x 2	**134.00**
173577	FTM2-M20	M20 x 2.5	**134.00**
147525	FTM2-M24	M24 x 3.0	**Inquire**

FasTie® Quick Ejector Tie-In System Specifications

Allowable press tonnage: 1-inch ..... ≤ 500 tons
2-inch ..... ≥ 500 tons
Maximum operating temp ..... 300°F (149°C)
Air pressure range ..... 80 - 100 psi
Stud material ..... Hardened Steel (58-62 Rc)
Ejector bar and coupler material ..... High Strength Steel
Threaded Studs ..... B7 Alloy or Comparable
Air manifold material ..... Aluminum
Air tubing material ..... 1/8" OD Nylon

Press requirements:

	Coupler Size	
	1-inch	2-inch
Platen thru hole min.	ø1.063" ø27mm	ø2.063" ø52.4mm
Ejector plate thru hole min.	ø0.512" ø14mm	ø0.765" ø19.4mm
Ejector force per coupler max.	2.5 tons	7.5 tons

See FasTie Accessories on Page 66 - 67

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Process Trouble-Shooting Guidelines				
Problem	CRYSTALLINE MATERIALS Lower/Reduce	Raise/Increase	AMORPHOUS MATERIALS Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

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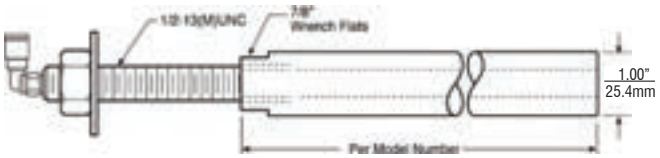
SMARTFLOW

FasTie® Accessories

Fixed Length Ejector Bar

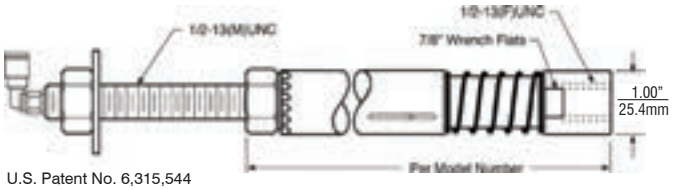


For use with 1" Series ONLY

Ejector Bars for 2" FasTie are special orders – INQUIRE

See next page to "Determine Ejector Bar Length"

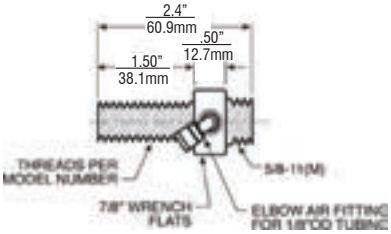
SpeedBar Adjustable Length Ejector Bar



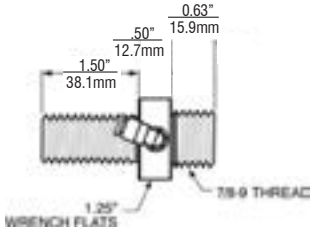
U.S. Patent No. 6,315,544

Ask about Special Thread Sizes for Ejector Bars and Center Adapters

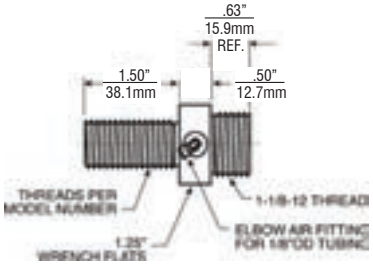
1" Center Adapter for 1" Series



1⅜" Center Adapter for 1⅜" Series



2" Center Adapter for 2" Series



- **Fixed Length Ejector Bar** also provides an air passage through to the back of the press ejector plate. Several lengths are stocked with one blank end for on-site finishing.

Fixed Length Ejector Bar (½"-13 threads)		
Item #	**Model #**	**Length**
147526	FTBB-50-8	8"
147527	FTBB-50-10	10"
147528	FTBB-50-12	12"
147529	FTBB-50-14	14"

- **SpeedBar Adjustable Length Ejector Bar***
  Adjustment sleeve is rotated without tools to shorten or lengthen the bar up to ½" in increments of 0.006". Once the desired length is set, the spring-loaded sleeve securely locks the adjustment. Provides air passage through the bar for air hook-up at the back of the press ejector plate.
  * 1-inch, ½-13 threaded only

SPEEDBAR Adjustable Ejector Bar (½"-13 threads)		
Item #	**Model #**	**Length**
143522	SBAB-50-6	5.5" to 6.5"
143523	SBAB-50-7	6.5" to 7.5"
143524	SBAB-50-8	7.5" to 8.5"
143525	SBAB-50-9	8.5" to 9.5"
143526	SBAB-50-10	9.5" to 10.5"
143527	SBAB-50-11	10.5" to 11.5"
143528	SBAB-50-12	11.5" to 12.5"
143529	SBAB-50-13	12.5" to 13.5"
143530	SBAB-50-14	13.5" to 14.5"

1" Center Adapter		
Item #	**Model #**	**Thread Size**
143645	FTCA-63	⅝"-11 male
147532	FTCA-M16	M16 x 2 male
147542	FTCA-M20	M20 x 2.5 male

1⅜" Center Adapter		
Item #	**Model #**	**Thread Size**
161397	FTCA1.4-63	⅝"-11 male
161404	FTCA1.4-75	¾"-10 male
161405	FTCA1.4-M16	M16 x 2 male
161406	FTCA1.4-M20	M20 x 2.5 male

2" Center Adapter		
Item #	**Model #**	**Thread Size**
147533	FTCA2-75	¾"-10 male
147534	FTCA2-M16	M16 x 2 male
143538	FTCA2-M20	M20 x 2.5 male

continued on next page

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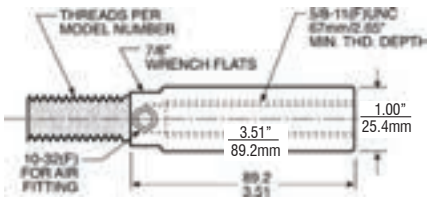
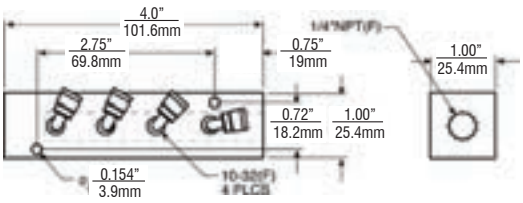
FasTie® Accessories (continued)



(use with FTF-63 or FTFHS-63 only)
see page 63

- Center Ejector Bar and Center Adapter provide an air passage in front of the press ejector plate for center knockout. These can also be used for multiple knockouts.

Center Bar		
Item #	**Model #**	**Thread Size**
147530	FTCA-63-63	5/8"-11
147531	FTCA-M16-63	M16 x 2



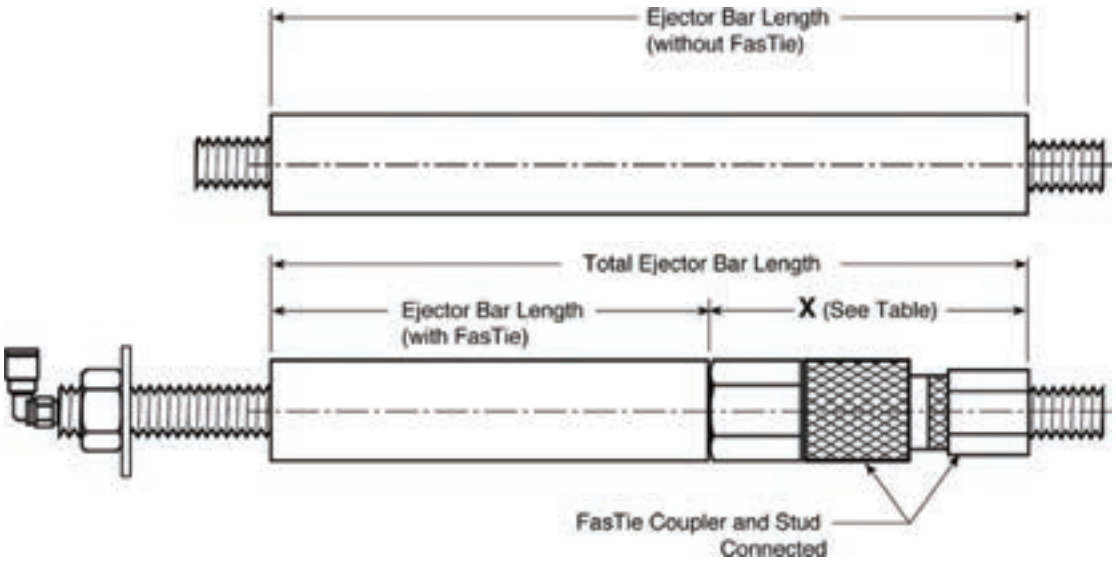
- Air Manifold splits single air supply into four circuits to aid air connection. Comes with 1/8" diameter tubing and pneumatic connectors.

Air Manifold Assembly	
Item #	**Model #**
143537	FTAM-100
148823	90° Air Fitting with 10-32 thd (for FTAM-100)
149469	1/8" O.D. Nylon Tubing (for FTAM-100)

Determine Ejector Bar Length

- Determine length of Solid Ejector Bar
- Select Connected FasTie Length from table
- Subtract Connected FasTie Length from Solid Ejector Bar Length
- Subtract Center Adapter Length if needed
- Result is FasTie Ejector Bar Length

Connected FasTie Lengths		
Description	**Part Numbers**	**"X" Length**
Original 1" FasTie	FTF-xx and FTM-xx	3.062"/77.8mm
High Strength 1" FasTie	FTFHS-xx and FTMHS-xx	3.162"/80.3mm
2" FasTie	FTF2-xx and FTM2-xx	5.875"/149.2mm



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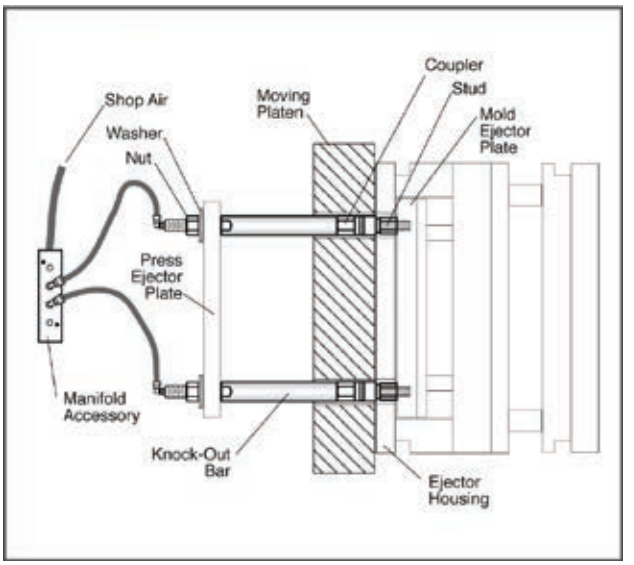
FasTie® Installation Examples

Typical Application for 2 or 4 Ejector Positions

- **This setup is designed for captive molders, or shops with tools using a standard thickness ejector housing.**



Couplers are located at the end of the ejector bars mounted to the press ejector plate.

Studs are mounted to each mold in storage. Ejector connection is made without changing ejector bars. Ejector housing shown is 1.062" thick.

Air Manifold supplies compressed air to the end of each ejector bar for simultaneous coupler release. Fixed length bars are finished on site, cut to length and tapped with ½-13 female thread.

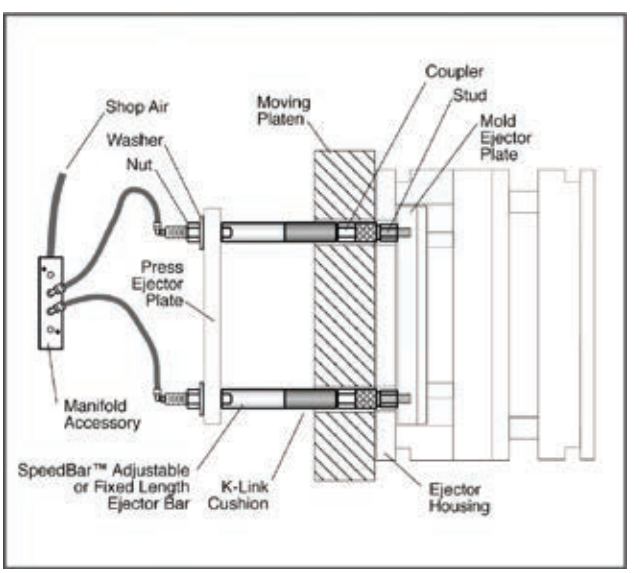
Parts List

qty.	Part
2 or 4	FasTie Stud
2 or 4	FasTie Coupler
2 or 4	Fixed Length Ejector Bars or SpeedBar® Adjustable Length Bars
1	Air Manifold with tubing

Fixed Length Ejector Bar

Alternate Application for 2 or 4 Ejector Positions

- **This setup is designed for custom molders who use a variety of injection molds with different ejector patterns and ejector housing thicknesses.**



Couplers are installed next to the Press Ejector Plate. Studs are placed at the end of the mold-mounted ejector bars for easy removal. Molds are changed quickly without accessing the back of the Press Ejector Plate.

For example, a press with 4 ejector positions may be running molds using only the horizontal positions, but the next mold may need the 2 vertical ejector positions. Ejector housing shown is 1.062" thick.

Air Manifold supplies air to the end of each ejector bar for simultaneous coupler release.

Parts List

qty.	Part
2 or 4	FasTie Stud
2 or 4	FasTie Coupler
2 or 4	Fixed Length Ejector Bars or SpeedBar® Adjustable Length Bars
1	Air Manifold with tubing

Air Manifold

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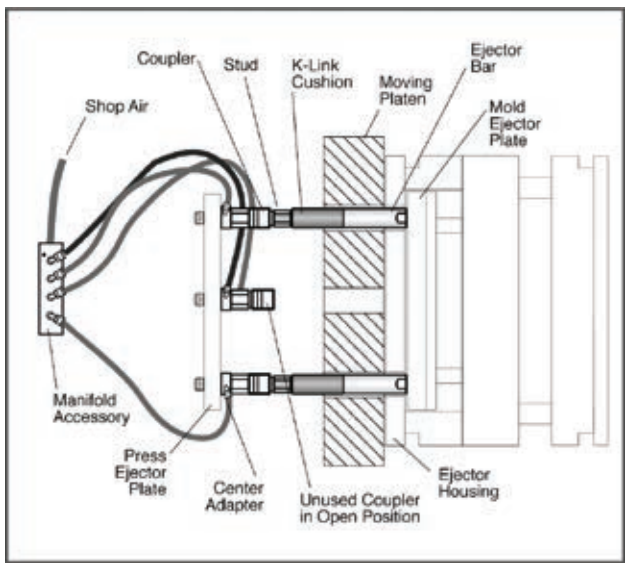
FasTie® Installation Examples

Alternate Application for 2 or 4 Ejector Positions

- **This setup is used where there is limited access to the back of the Press Ejector Plate. Custom molders using smaller presses will benefit from this application.**



Couplers are installed next to the Press Ejector Plate. Studs are placed at the end of the mold-mounted ejector bars for easy removal. Molds are changed quickly without accessing the back of the Press Ejector Plate.

For example, a press with 4 ejector positions may be running molds using only the horizontal positions, but the next mold may need the 2 vertical ejector positions. Ejector housing shown is 1.062" thick.

Air Manifold supplies air to the mold side of the Press Ejector Plate with the use of adapters.

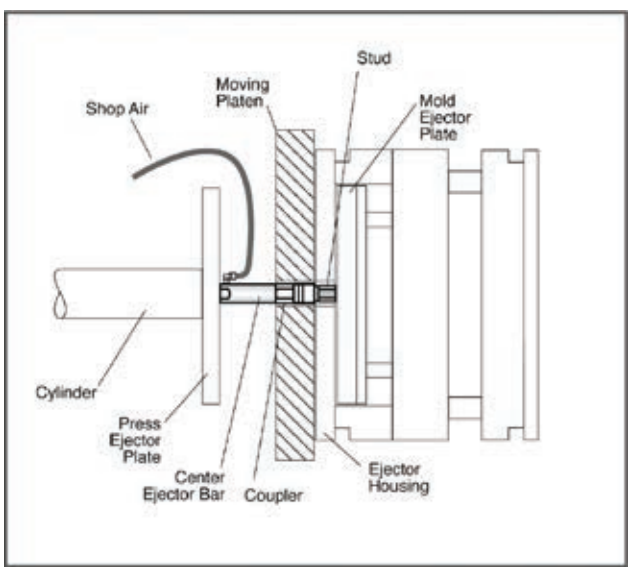
Parts List

qty.	Part
2 or 4	FasTie Stud
2 or 4	FasTie Coupler
2 or 4	Center Adapters
2 or 4	Fixed Length Ejector Bars or SpeedBar® Adjustable Length Bars
1	Air Manifold with tubing

Center Adapter

Center Ejector Position

- **For small presses with a center ejector, replace the cylinder bolt with a Center Ejector Bar and FasTie coupler.**



Center Ejector Bar and Coupler are installed into the Press Ejector Plate, with the Coupler attached to the end. Stud is installed in the Mold Ejector Plate. Molds are changed quickly without accessing the back of the Press Ejector Plate. Ejector housing shown is 1.062" thick.

Shop air is supplied to the side of the center adapter. No Air Manifold is needed. Fully threaded Center Ejector Bar may be shortened to proper length on-site. In many small machines, there may not be room for an ejector bar.

Parts List

qty.	Part
1	FasTie Stud
1	FasTie Coupler
1	Center Ejector Bar

Center Ejector Bar

High Strength Couplers and Studs are recommended for 1" applications.

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Tie Bar Sleeves

Inexpensive Method to Reduce Contamination of Molded Parts While Extending the Life of Tie Bars And Bushings

Shown In Extended Mold Open Position

Shown In Mold Closed Position

MAX Use Temp: 240° F

- Prevent tie bar grease from contacting molded parts
- Protect tie bars and bushings from abrasive airborne particles
- Opens and closes with mold stroke to provide continuous protection
- Provides a cleaner, more professional appearance at the press
- Constructed of Neoprene Coated Nylon
- Custom made to any tie bar diameter and length
- Sized to the molding press, not individual molds

Tabs with Eyelets

Used with the magnetic mounting kit to connect to the mold

Air Vent

Allows air flow while mold is closing

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Tie Bar Sleeves

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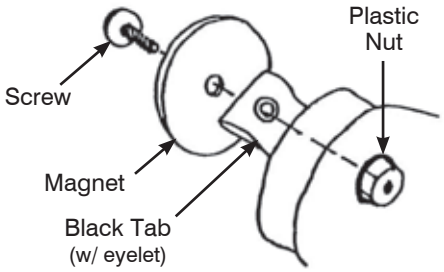
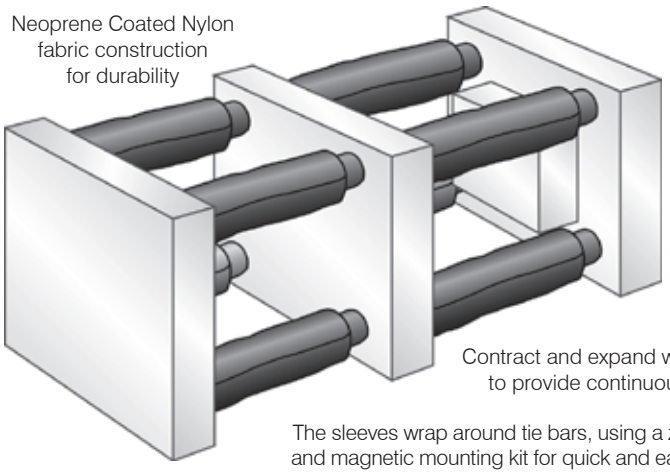
Keep Tie Bar Grease In / Keep Abrasive Airborne Particles Out

Easy Installation

Magnetic Mounting Kit



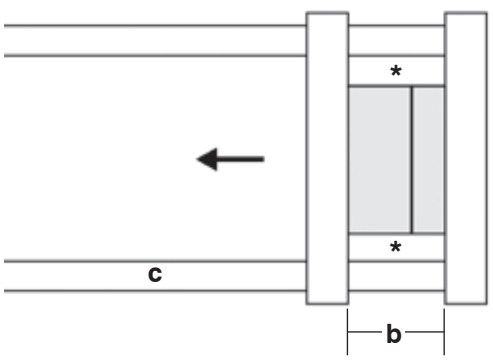
Neoprene Coated Nylon fabric construction for durability



Contract and expand with mold stroke to provide continuous protection

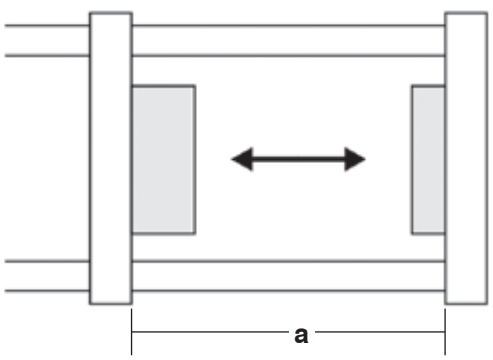
The sleeves wrap around tie bars, using a zipper, Velcro® and magnetic mounting kit for quick and easy installation.

Custom Made To Any Tie Bar Diameter And Length



*1½" clearance required between mold and tie bar.

Mold closed min. platen to platen



Mold opened max. platen to platen

Specify:

a. Mold Open: _____

b. Mold Closed: _____

max open length = 3X closed length (max ratio = 3:1)

c. Tie Bar Diameter: _____

d. Quantity: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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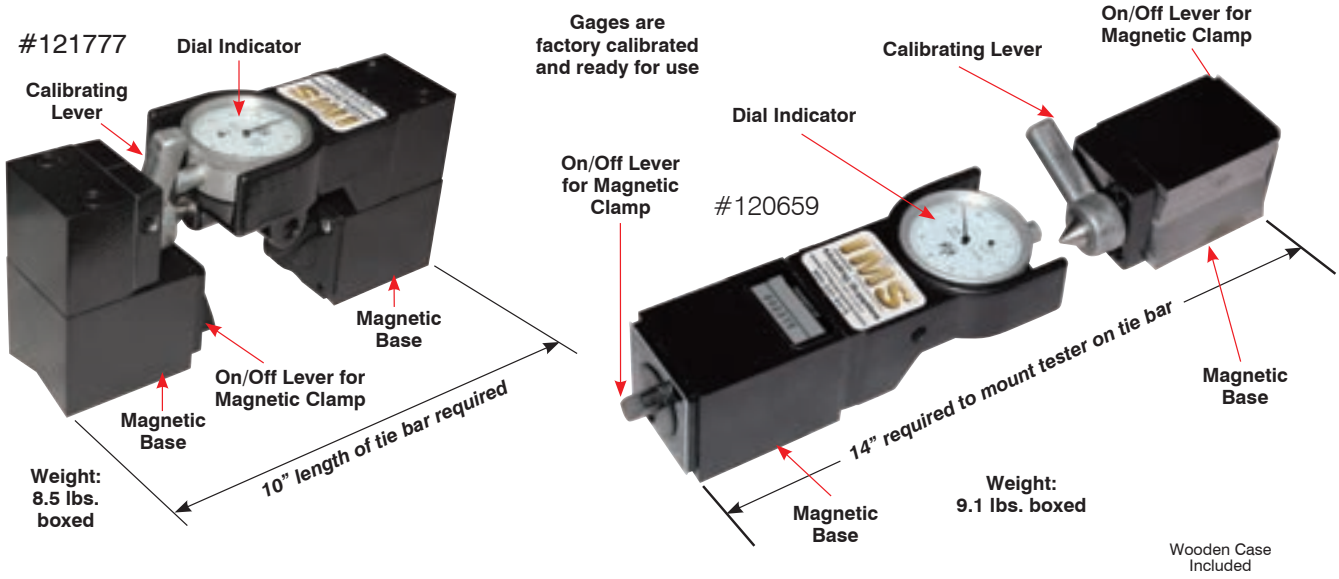
Injection Machine Tie Bar Strain Gages

Help You Obtain Maximum, Uniform Press Clamping Pressure Without Overloading Toggles Or Tie Bars



1 Year Warranty

Avoid tie bar failures and cracked pins • Extend bushing life

Features

- Two super-power on-off magnets allow strain gage to be quickly moved to each tie bar
- Magnetic face angles designed for maximum grip on tie bars up to 2" (small gage), over 2" (large gage)
- Calibrating lever lets you set dial indicator to zero
- Ruggedly constructed for injection plant use
- Chart inside case translates .001 of tie bar stretch on dial into tonnage of clamp pressure — Without Calculations

These Unique Instruments Let You:

1.) Check for equal pressure on tie bars, eliminating breakage

2.) Verify actual tonnage your press is delivering

(Old presses may not meet rating. Newer presses can exceed rating and should NOT be operated at higher than rated clamp or you will wear out your toggles prematurely!)

For Small Presses 25 To 100 Ton

Item No 121777

Call For Pricing

For Large Presses 125 Ton & Up

Item No 120659

Call For Pricing

Calibration and Repair Service available — Inquire

IMS can provide NIST Certification in both long and short form:

Long Form Calibration entails measuring and recording the tie bar gage performance at several different pressure settings as received. After disassembly, inspection, repair and calibration the gage is re-tested at those same pressure settings and the readings recorded.

Our standard Short Form Calibration skips the initial testing procedure and the performance is tested after completion at one pressure setting only.

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phone order toll-free (USA & Canada) 1.800.537.5375
fax order toll-free (USA & Canada) 1.888.288.6900
phone order toll-free (Mexico) 001.888.304.1307
tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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SMARTFLOW

Made in the U.S.A

VersaSwitch™ Limit Switch

Prevents Premature Movements of Machine Components

Smartflow VersaSwitch Limit Switches

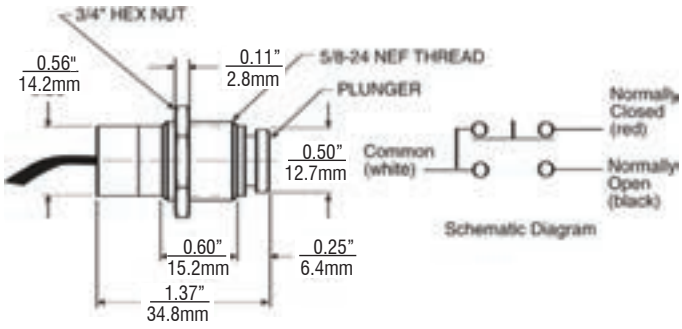
- Over 1 million cycle life provides dependable service.
- 180°F (82°C) standard temperature rating allows installation into most molding applications.
- Adjustable operating point provides custom installation.
- In stock to provide same-day delivery.
- Stripped and tinned 6ft. wire leads make the switch ready to install without modification.
- Included mounting hardware installs the Versaswitch limit switch easily.

Smartflow® VersaSwitch™ Limit Switch installs into an injection mold to prevent premature movement of your machine components. By using the VersaSwitch to indicate location of the core the switch prevents equipment damage. The VersaSwitch limit switch also protects your profits by limiting downtime and loss of productivity.

The VersaSwitch® Limit Switch is easily installed into a 5/8"-24 female thread. The switch actuates when 3.5 lbs of force is applied to the plunger. Actuation height is adjusted by threading the switch to the correct position in the installation. The switch is held in place via a lockwasher and hex nut. SPDT snap action switch provides a simple, positive indication of the mold or core location.

Prevent Equipment Damage and Accidents

Shown Actual Size



The VersaSwitch™ Limit Switch is designed for use in very low power mold protection control circuits. It is not intended to switch heavy loads in power applications.

Specifications

Electrical	240VAC 5 Amps Resistive 3 Amps Inductive
Operating Temperature	180°F max. (82°C max.)
Switching	SPDT
Operating Force	3.5 lbs (1.605 kg)
Pre-travel to operating point	0.06" (1.5mm)
Overtravel	0.01" (.25mm)
Enclosure	Watertight per IP68S
Materials	
Body	Anodized Aluminum/ Epoxy
Plunger	Stainless Steel
Lockwasher and Nut	Stainless Steel
Wire Leads	22ga stranded, 3-conductor, shielded cable, 6 ft. (1.8m) long, ends stripped and tinned

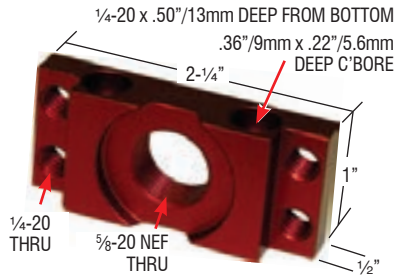
VERSASWITCH™ Limit Switch

INCLUDES: Switch, Lockwasher and Nut

Item #	Model #
144416	V-222

Optional Aluminum Mounting Bracket

The mounting bracket attaches to a mold with conveniently-located, threaded holes. The red anodized finish provides effective corrosion-protection.



Item #	Model #
144417	VB-222

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VERSASWITCH is a trademark of Burger & Brown Engineering, Inc.

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Made in the U.S.A

SMARTFLOW

ThinSwitch® Limit Switch

Verify Ejector Plate Return Before Closing The Mold

SmartFlow ThinSwitch Limit Switches

- Over 10 million cycle life
- 175°F (79.4°C) standard temperature rating
- 250°F (121°C) high temperature unit for higher temperature needs
- Adjustable actuation between .187" and .250" from the mold base.
- 3/16" thick design fits snugly behind the ejector plate between the rest buttons
- Stripped and tinned 6 ft. wire leads
- Mounting screws and wire clips included

SmartFlow® ThinSwitch® is designed to verify ejector plate return. The ThinSwitch helps prevent accidental mold close in injection molding applications by providing a position switch that is tied to the injection molding machine control.

The ThinSwitch has been tested for reliability over 10 million cycles without failure. Two switches can be used in series for larger molds to ensure the ejector plate return, preventing costly mold damage.

Shown Actual Size
(.18" Thick)

U.S. Patent No. 5,446,252 and 6,982,392

Drill and tap #10-24 x 3/8" deep to accept #10 button head screws included with ThinSwitch® Limit Switch

Specifications

Electrical
250VAC ..... 5 Amps resistive / 4 Amps inductive
28VDC (sea level) ..... 5 Amps resistive / 4 Amps inductive

Operating Temperature
Standard Models ..... 175°F max. (79.4°C max.)
High Temp Models ..... 250°F max. (121°C max.)

Mount inside ejector housing and wire to machine controls. Use for core slides or any place where space is limited.

The Thinswitch® Limit Switch is designed for use in very low power mold protection control circuits. It is not intended to switch heavy loads in power applications such as relay or solenoid coils.

Rated Current vs. Steel Temperature

Standard Models			High Temp Models		
Amps	°F	°C	Amps	°F	°C
5.0	85	29.4	5.0	100	37.7
4.0	120	49.0	4.5	155	68.3
3.0	155	68.3	4.0	210	98.8
2.0	175	79.4	3.5	250	121.1

Switching ..... SPDT

Materials

Body ..... Fiberglass-reinforced nylon
Dome ..... Polyurethane
Back Cover ..... Polyester film
Wire Leads ..... 22ga stranded, 3-conductor, shielded cable, 6 ft. (1.8m) long, ends stripped and tinned

ThinSwitch® Limit Switches
Includes: Switch, Wire Clips, Screws and Allen Wrench for adjustment

Item #	Model #
143446	**Standard Model (175° F Max)** T-222
143448	**Standard Model (250° F Max)** HT-291
143447	**Liquid Resistant Model (175° F Max)** T-222-LR
143521	**Liquid Resistant Model (250° F Max)** HT-291-LR

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tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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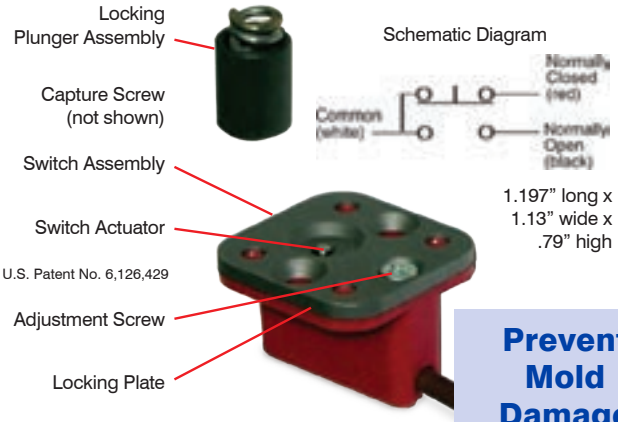
SmartLock® Slide Retainer and Limit Switch

Made in the U.S.A

Prevents Premature Slide Movement During Part Injection

SmartFlow SmartLock Limit Switches

- Over 10 million cycle life provides dependable service.
- 17 - 27 pounds holding force, adjustable
- Capture screw holds plunger in place to prevent loss.
- 175°F (79.4°C) standard temperature rating allows installation into most molding applications.
- 250°F (121°C) high temperature unit provides additional application flexibility.
- Superior flush mount switch is protected by mounting inside a milled pocket.
- Stripped and tinned 6 ft. wire leads make the switch ready to install without modification.



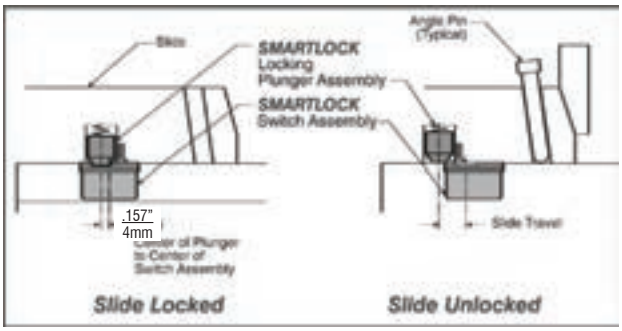
Prevent Mold Damage and Accidents

The SmartLock switch is designed for use in very low power mold protection control circuits. It is not intended to switch heavy loads in power applications.

SmartFlow SMARTLOCK slide retainer and limit switch is designed for injection molders to provide switching and a slide detent in one unique package. The SMARTLOCK locking function prevents premature slide movement during molded part ejection while the SPDT switch is simultaneously actuated.

The SMARTLOCK slide retainer and limit switch has been tested for reliability over 10 million cycles without failure. Two or more switches may be used for larger molds, or molds with multiple slides.

Increased safety and prevention of mold damage result when the SMARTLOCK slide retainer and limit switch is installed in a mold. A capture screw holds the plunger in the slide to prevent loss.



Installed in the slide, the plunger moves into a recess in the locking plate of the switch assembly, which is installed in the mold plate. The switch actuator, located in the bottom of the recess, closes the normally open switch contacts when the plunger is seated in the locking plate recess. When the break away force is applied to the slide, the lock is released, and the switch returns to its normal state.

Specifications

Electrical ..... 250VAC / 28VDC
4 Amps Inductive / 5 Amps Resistive

Operating Temperature
Standard Models ..... 175°F (79.4°C) max.
High Temp Models ..... 250°F (121°C) max.

Rated Current vs. Steel Temperature					
Standard Models			High Temp Models		
Amps	°F	°C	Amps	°F	°C
5.0	85	29.4	5.0	100	37.7
4.0	120	49.0	4.5	155	68.3
3.0	155	68.3	4.0	210	98.8
2.0	175	79.4	3.5	250	121.1

Switching ..... SPDT

Break Away Force* ..... 17 to 27 lbs. (Adjustable)

Materials

Switch Body ..... Glass-reinforced nylon
Locking Plate ..... Hardened Steel
Locking Plunger ..... Hardened Steel
Wire Leads ..... 22ga stranded, 3-conductor, shielded cable, 6 ft. (1.8m) long, ends stripped and tinned

SmartLock® Slide Retainer and Limit Switches Includes: Switch, Wire Clips and Screws	
Item #	**Model #**
144412	**With Captive Plunger (175°F Max)** SL-222-S-C
144413	**With Captive Plunger (250°F Max)** SL-291-S-C
144414	**With Small Plunger (175°F Max)** SL-222-S-S
144415	**With Small Plunger (250°F Max)** SL-291-S-S

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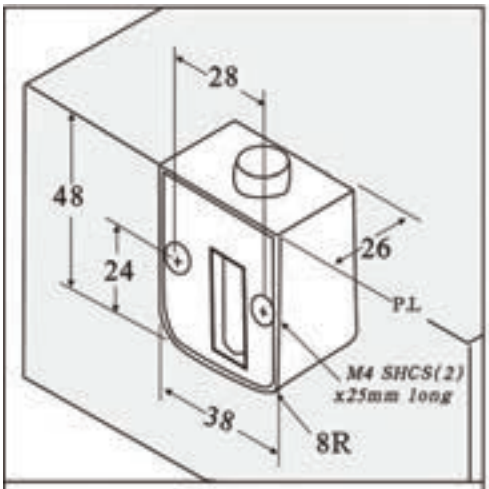
Mechanical Mold Cycle Counters

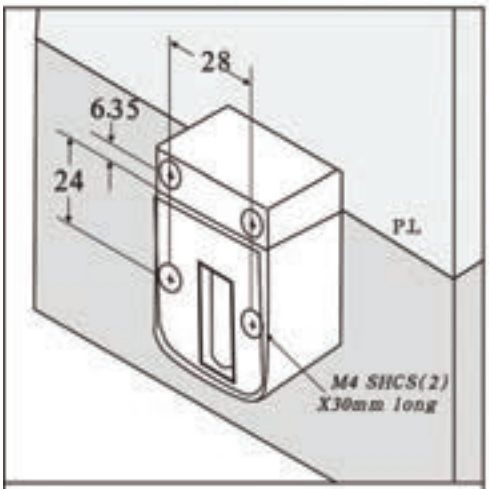
Precisely Monitor Mold Usage by Tracking The Activity For the Life of the Tool

Available in two mounting styles to accommodate your needs

Dimensional Diagrams:



#168511
Parting Line Mount



#168512
External Mount

- Helps overall mold maintenance
- Choose from Parting Line or External Mount
- Non resettable
- 7 Digit completely mechanical (No batteries to replace)
- Counts up to 10 Million Cycles
- Industry standard size
- Made from Durable Glass Filled Nylon with Stainless Steel Internal Parts
- Includes mounting screws

Item #168511
Parting Line Mount Cycle Counter

—

Item #168512
External Mount Cycle Counter

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fax order toll-free (USA & Canada) 1.888.288.6900
phone order toll-free (Mexico) 001.888.304.1307
tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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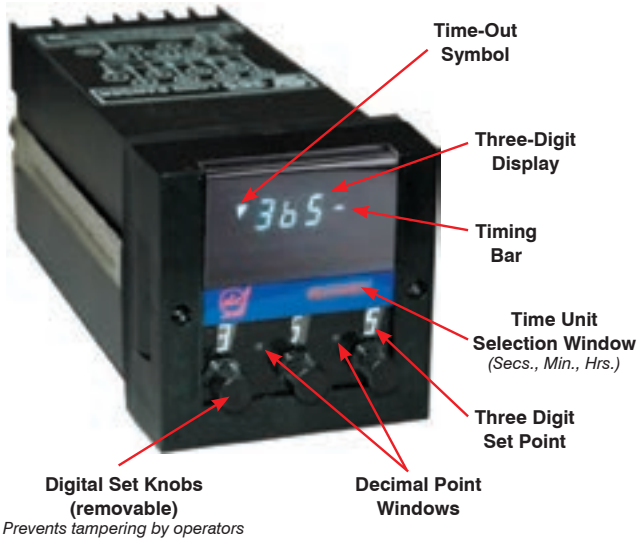
Microprocessor Based Digital Timer

Help Older Presses with Less Accurate Mechanized Timers Perform Like Newer Solid-State Machines!



More Precise, Repeatable, Consistent Cycles

Means Improved Production and Part Quality

Replaces:

EAGLE HP-5 Cycle Flex, 12-terminal model reset on power interruption.

EAGLE HP-5 Cycle Flex, 15-terminal model reset on power interruption.

EAGLE CE-500 Analog if timing from closed start.

EAGLE CD-360 Digital Timer if timing from closed start.

EAGLE CT-530/531 if timing from closed start; also if last two digits of model ends in 00.
Example: CT 5312A600.
Also: ATC 305, 325 and 335 timers.

Microprocessor-Based, Digital Timers are the ultimate in accuracy and repeatability. They are designed to replace many old-style, mechanical EAGLE SIGNAL® and ATC Timers, which are less accurate and costly to maintain.

Every $\frac{1}{10}^{th}$ of a second variation in your press timers represents both lost profits and changes in your molded part quality.

No other retrofit product can touch this Digital Timer in speed of pay-back. And part quality improves because cycles are now 100% repeatable with every shot.

Every press user can gain immediate benefits from consistent, reliable press timer performance. Update all your old presses now! Save time and money!

Specifications

RANGES:
Switch-selectable ranges of 0-9.99, 0-99.9 and 0-999 sec, min. or hrs.

REPEAT ACCURACY:
AC ±0.01 sec on all ranges, synced to AC line.

TIMING MODES:
SINGLE CYCLE: Interval or delayed.
REPEAT CYCLE: Pulse-clocked at 60 ms to 80 ms (will be constant for a given unit).

DISPLAY:
CYCLE PROGRESS:
3-digit display, 0.3 inch, high intensity, blue, programmable: DOWN and STOP, DOWN and GO, UP and STOP or UP and GO.

TIME-OUT: - display (left); energized at time-out.

TIMING BAR: - display (right); blinks once per second during cycle, rapidly after time-out.

TEMPERATURE RATING:
32-140° F (0 to 60° C).

LOAD RELAYS:
NUMBER: one instantaneous and one delayed.

TYPE: DPDT, Form C.

CONTACT RATINGS:
7A at 120, 240 or 24V AC, 1/6 HP.
3A at 24V DC, 1.5A at 48V DC,
500mA at 125V DC.

LIFE: 100 million operations (no load).

POWER REQUIREMENTS:

— *STANDARD* —

120V AC: 95-132V AC, 50 or 60 HZ.
Inrush — 300mA.
Running — 60mA at 120V AC.

— *OPTIONAL* —

240V AC: 190-264V AC, 50 or 60 HZ.
Inrush — 150mA.
Running — 30mA at 240V AC.

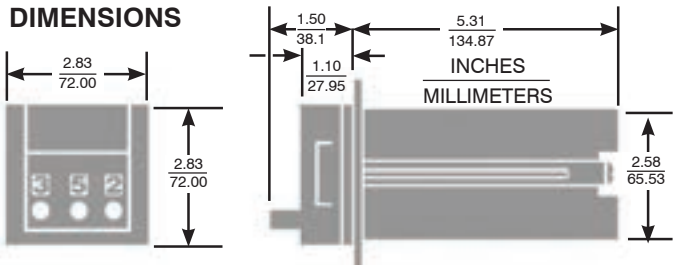
24V AC: 19.2-26.4V AC, 50 or 60 HZ.
Inrush — 1A.
Running — 250mA at 24V AC.

24V DC: 19.2-26.4V DC, 5% ripple
Running — 120mA at 24V DC.

Easy To Install

This timer requires only that you file out a slight clearance for the corners of the square casing. Easy to follow instructions and template are included. Simple rewiring to numbered posts is necessary and takes just a few minutes!

DIMENSIONS



Cut-out opening: 2.64" sq. / **Minimum spacing between timers:** 3.63" o/c

Item #104313 120 VOLT

Retrofit Kit #104229
(Required when replacing ATC Timers 305, 325 and 335 plus Eagle Signal® Flex HP-5 Timers) — **Inquire**

Other Voltages Available — **Inquire**

EAGLE SIGNAL® is a registered trademark of Danaher Controls

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Process Trouble-Shooting Guidelines				
Problem	CRYSTALLINE MATERIALS		AMORPHOUS MATERIALS	
	Lower/Reduce	Raise/Increase	Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

Process Trouble-Shooting Guidelines				
Problem	CRYSTALLINE MATERIALS Lower/Reduce	Raise/Increase	AMORPHOUS MATERIALS Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

Pneumatic Die Grinder Kit

Great For Quick, Easy Mold Surface Enhancements

¼"-18 Industrial Plug

Made of durable alloy heat-treated steel and cast iron

Rear exhaust directs air away from the work surface

¼" Collet

Safety Latch helps prevent inadvertent actuation

⅛" Collet

Five ⅛" and five ¼" grinding wheels

Price includes plastic storage carrying case

Specifications

Speed:	22,000 rpm
Collet Size:	¼" and ⅛"
Air Inlet Size:	¼" N.P.T.
Working Pressure:	90 psi
Overall Dimensions:	7" long x 1⅝" dia.
Overall Weight:	1.2 lbs.

Item No. 134156

Kit includes ¼" collet, five ¼" grinding wheels, ⅛" collet, five ⅛" grinding wheels, 2 collet wrenches, ¼" industrial plug & a plastic case

See next page for Optional Accessories

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Please refer to imscompany.com for current pricing

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90° Pneumatic Die Grinder Kit

Ruggedly Built To Quickly Remove Stock

Made of durable alloy heat-treated steel and cast iron

¼"-18 Industrial Plug

Rear exhaust directs air away from the work surface

Safety Latch helps prevent inadvertent actuation

¼" Collet

⅛" Collet

Five ⅛" and five ¼" grinding wheels

Price includes plastic storage carrying case

Specifications

Speed:	25,000 rpm
Collet Size:	¼" and ⅛"
Air Inlet Size:	¼" N.P.T.
Working Pressure:	90 psi max
Overall Dimensions:	6¼" long x 1⅝" dia.
Overall Weight:	1 lb.

Item No. 166174

Kit includes ¼" collet, five ¼" grinding wheels, ⅛" collet, five ⅛" grinding wheels, 2 collet wrenches, ¼" industrial plug & a plastic case

Optional Accessories for use on Grinder #134156 and #166174

3" Cut-Off Wheel for metal (3" dia. x 1/16" thick)

40 grit aluminum oxide / ⅜" arbor / 20,000 rpm MAX

Item No. 145547 ..... $3.21ea

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Soft Hammers

Make Mold Setup And Maintenance Quicker, Safer

Eliminate Scratching And Denting — Non-Sparking

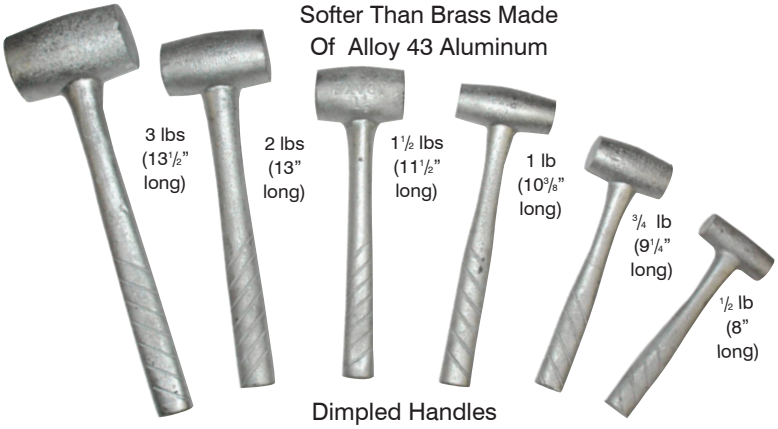
Shock-absorbing
Fiberglass Handles

Brass

Item #	Weight	Handle Type	Handle Length
174775	1 lb.	Fiberglass	12"
174776	2 lb.	Fiberglass	14"

*Wooden handle hammers available only while supplies last

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.



Softer Than Brass Made Of Alloy 43 Aluminum

Dimpled Handles

Aluminum

Low Cost. Less Than Comparable Brass Hammers.

Item #	Weight
101010	½ lb.
101125	¾ lb.
101070	1 lb.
101042	1½ lb.
100978	2 lb.
100946	3 lb.

Warning: Protect your eyes. Wear safety goggles.

Caution: These soft hammers are meant only for light activities such as driving pins and positioning tight-fitting mold components.

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Brass Mold Hole Cleaning Brushes

Made in the U.S.A

Use these brass bristle brushes to effectively remove scale, rust, and plastic residue within small-bore metal tubing and drilled orifices. They eliminate need for corrosive liquid cleaners and are available in a variety of sizes. Brass bristle brushes are perfect for reaching into areas such as condenser tubes, cartridge heater holes, ejector pin holes, mold cavity holes and mold coolant passages.

Brass Bristle Tube Brushes

- Sturdy, twisted wire handles
- Finger loops for comfortable grip
- Easily apply reaming pressure to clean tubes
- 16 brush diameters available
- Available in kit form

Power-Driven (Single Spiral) Brushes

- Closely packed brass bristles
- Effective mounted in power drill
- Five brush diameters available
- Available in kit form

Power-Driven (Double Spiral) Brushes

- Smooth, double stranded, heavy gauge wire for easy gripping
- Stronger shaft for use in power drills and drill presses
- Five brush diameters available
- Available in kit form

Condenser Cleaning Brushes

- Stiffer brass bristles for maximum cleaning power
- Five brush diameters available
- Extensions and T-handle available
- Available in kit form
- 5/16"-18 female thread x 1/8" NPT male thread

Brass Bristle Tube Brushes

Item #	Brush Dia.	Overall Length	Wire Size	Item #	Brush Dia.	Overall Length	Wire Size
101006	1/16"	6"	.003	100990	5/8"	9"	.005
101038	1/8"			101137	11/16"		
101119	3/16"	7"	.003	101104	3/4"		
101088	1/4"			101045	13/16"	10"	.005
101029	5/16"		.004	100983	15/16"		
100998	3/8"	8"	.006	100974	1"		
100934	7/16"			101014	7/8"	13½"	.005
101081	1/2"			112368	All 16 brushes		
101023	9/16"	9"	.005				

Power Driven (Single Spiral)

101059	1/4"	12"	.005	100958	5/8"	12"	.008
100967	3/8"			101073	3/4"		
101053	1/2"		.006	112381	All 5 brushes		

Power Driven (Double Spiral)

100951	1/4"	12"	.003	101066	5/8"	12"	.005
101129	3/8"			101037	3/4"		
101097	1/2"		.004	112370	All 5 brushes		

Condenser Cleaning Brushes

Item #	Brush Dia.	Brush Length	Overall Length	Item #	Description
101015	3/8"	4½"	7½"	101128	Extension (15/16"-18 thread 24" length)
100984	1/2"			101095	Extension (15/16"-18 thread 36" length)
100952	5/8"			101064	T-handle only
101130	3/4"				
101306	1"				

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Brass Brushes

For Tough Spot Cleaning Without Scratching

Heavy Duty Models

Item #	Description
100973	1" bristle length; 13" long overall
101087	½" bristle length; 7⅞" long overall

Hard, Maplewood Handles

Many Molding Shop Uses – Ideal For Cleaning Threads

100973

101087

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Please refer to imscompany.com for current pricing

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Brass Mold Surface Cleaning Brushes

Designed to Operate at High Speeds, These Brass Brushes Effectively Clean Large Mold Surfaces, Producing Polished Results.

Item #	Description
Brass Utility Cup Brushes Spindle: ¼" dia. RPM: 13,000	
101044	2" dia.
101013	2½" dia.
Brass Conflare Brushes Spindle: ¼" dia. RPM: 20,000	
101282	2" dia.
101234	3" dia
Brass Copper Center Brushes RPM: 20,000	
101237	2" dia.; ½" arbor hole
101217	3" dia.; ½" arbor hole
101300	4" dia.; ⅝" arbor hole
101221	¼" driver with 1" thread length; fits ½" arbor hole
Brass Pencil End Brushes RPM: 8,000	
101418	5/16" dia.
Brass Circular Flared End Brushes Spindle: ¼" dia. RPM: up to 20,000	
100933	1¼" dia.
101111	1½" dia.
101080	2¾" dia.
101052	3" dia.
Brass Solid End Brushes Spindle: ¼" dia. RPM: 20,000	
101136	¾" dia.
101311	1" dia.
Heavy Duty Brass Wheel (use with bench mounted grinder) RPM: 6,000	
101065	6" dia.; ⅝" arbor hole

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Made in the U.S.A

HYDE Low Cost Brass Scrapers

For Removing Stuck Plastic Parts From The Mold!

• Non Scratching • Non Sparking • Non Magnetic

Sharpened Front Edges

5 in 1 Scraper

- Scraper
- Putty Knife
- Spreader
- Rounded Paint Roller Cleaner
- Pointed Crack Opener

Tough Nylon Handles and Brass Grommets

Solid .057" Spring-Tempered Brass Blades

	Item #	Description	Length Overall	Blade Length
1	128196	1¼" Wide Scraper	7¾"	3⅝"
2	128201	1⁵⁄₁₆" Wide, Long Handle Scraper	11¾"	3⅝"
3	128197	2" Wide Scraper	7¾"	3⅝"
4	128199	2½" Wide, 5 in 1 Scraper	7¼"	4⅝"
5	128198	3" Wide Scraper	8"	4⅝"
6	128200	3" Wide, Long Handle Scraper	12½"	4¼"

Order Today!

Heavy Duty and Bent Style Scrapers also available — see next page

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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IMS Heavy Duty Brass Scrapers

For Removing Even The Most Stubborn Plastic Parts From The Mold!

Non-Scratching • Non-Sparking • 0.125" Thick

Item #	Length	Blade Width
Flat Scraper (handle not included)		
106476	4"	1"
106469	8"	1"
127272	18"	1"
Bent Scraper (handle not included)		
106463	7"	1"
Flat, Wide Scraper (handle not included)		
106460	4"	2"
Bent, Wide Scraper (handle not included)		
106456	3"	2"
Plastic Handle		
173944	5"L x 1"W x ¾" thick, 2" blade slot, dark green	
108006	5"L x 1"W x ¾" thick, 2" blade slot, dark green, includes 2 brass screws	
113749	Screw only: ¼"-20 countersunk, ¾"L, brass	
Specially Priced Short Set Kit		
117110	Includes #106476, #106463, #106460, #106456 and #108006 (plastic handle with 2 brass screws)	
Flat Scraper (includes handle and 2 brass screws)		
128193	7"	1"
128192	11"	1"
128191	21"	1"
Bent Scraper (includes handle and 2 brass screws)		
128190	10"	1"
Flat, Wide Scraper (includes handle and 2 brass screws)		
128189	7"	2"
Bent, Wide Scraper (includes handle and 2 brass screws)		
128188	6"	2"

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Made in the U.S.A

IMS Select

Bronze Sprue Puller Tools

Allow Quick, Safe Sprue And Part Removal.
Specially Designed To Preserve Fine Mold Surfaces.

An Absolute Must For Every Machine Operator, Maintenance Person and Mold Maker

The Superior Bronze Tool

- Made of polished, forged bronze (24 Rc Hardness)
- Long-levered ergonomic handles
- Pre-lapped joints ensures long life and smooth operation
- Extra thick, anti-static foam handle covers

Specifications and Prices

	Item #	Description	
Serrated Tip; 60° Needle Nose —**#108636**; 1⅝"; 6⅞"; 8½"	108636	Standard Duty 60° Needle Nose (CNB-7)	
Serrated Tip; 60° Rounded Nose —**#108634**; 1 13/16"; 6 13/16"; 8⅝"	108634	Heavy Duty 60° Rounded Nose (CNBG-7)	Angled 60° for leverage
Straight, Needle Nose —**#108631**; 2⅛"; 6⅞"; 9"	108631	Straight, Needle Nose (LNB-7)	
Flat Back —**#108632**; Serrated Jaw Edge; 1¼"; 6 15/16"; 7 13/16"	108632	15° Flat Back (BDS8)	
Straight, Snub Nose —**#116584**; Ridged Jaw Edge and Tip; 1¼"; 6¾"; 8"	116584	Straight, Snub Nose (BG791E)	
Rounded Back —**#108042**; Serrated Jaw Edge; 1⅛"; 6 13/16"; 7 15/16"	108042	15° Rounded Back (BG8)	
Straight, Pointed Nose —**#108625**; Serrated Tip; 1⅛"; 6 13/16"; 7 15/16"	108625	Straight, Pointed Nose (BG831G)	
		Ask about custom designs	

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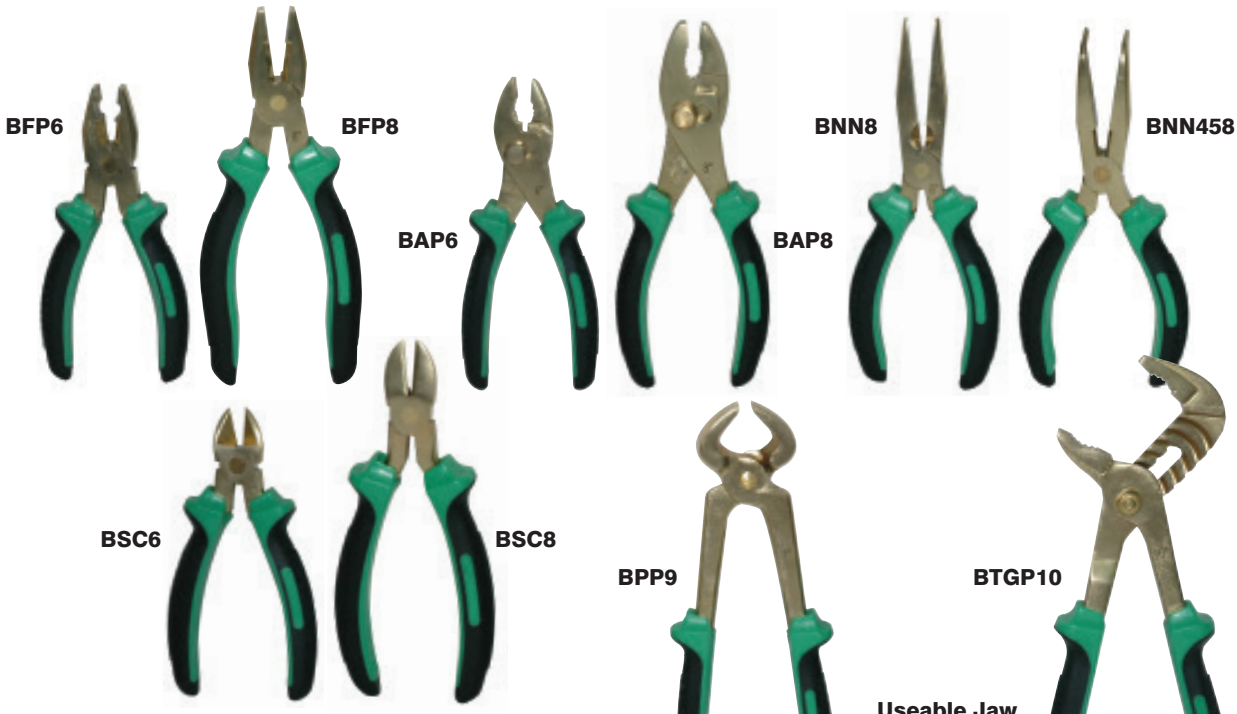
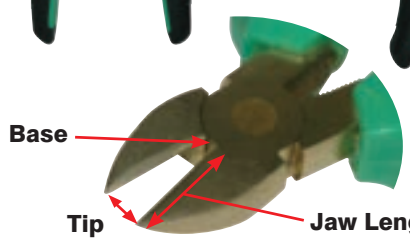
Economy Bronze Sprue Puller Tools

Good Quality Specialty Hand Tools For Use Around The Mold Or Areas Where Scratching And Sparking Are Concerns.



Every Maintenance Tool Box Should Have These Tools!

- Variety of styles and sizes to fit your application
- Durable solid bronze – 24 HRC
- Comfortable contoured grips with anti-slip texture
- Stronger than brass, but soft enough they won't scratch



Item #	Model #	Description	Jaw Opening at Tip	Jaw Opening at Base	Jaw Length
165788	BFP6	6" Bronze Non-Adjustable Plier	1"	1/4"	1 1/8"
165789	BFP8	8" Bronze Non-Adjustable Plier	1 3/8"	5/16"	1 3/8"
165680	BAP6	6" Bronze Adjustable Plier	1 1/4"	3/4"	7/8"
165681	BAP8	8" Bronze Adjustable Plier	1 1/2"	1"	1"
165682	BNN8	8" Bronze Needle Nose Plier	2 1/4"	1/4"	2 3/4"
165683	BNN458	8" Bronze Needle Nose 45° Plier	2 1/8"	1/4"	2 1/2"
165685	BSC6	6" Bronze Side Cutter	5/8"	3/16"	7/8"
165686	BSC8	8" Bronze Side Cutter	1"	1/4	1 1/8"
165684	BPP9	9" Bronze Pincer Plier	3/4"	N/A	3/4"*
165687	BTGP10	10" Bronze Tongue and Groove Plier	1 1/4"	N/A	1 3/16"
165790	BSPK10	10 Piece Bronze Sprue Puller Kit (Includes one each above - save $29)			

*Width

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Soft Aluminum Part Removal Tools

Make Stuck Part Removal Quick, Safe And Easy!

- Lightweight, durable construction
- Spring opened design
- Protect mold and operator

Won't Scratch Molds!

Item Number	Description
110189	7" Lightweight, duckbill plier 2½" jaw length; 2 oz.
110186	8¼" Heavy duty, duckbill plier 2¾" jaw length; 4 oz.
110198	10½" Duckbill plier with finger guard loops on both handles 3" jaw length; 6 oz.
110194	10⅜" Heavy duty, right angle nose with finger guard loops ⅝" jaw length; 9 oz.
110605	Specially Priced Kit One of each above

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Top Quality Brass Rods

For Use On All Molds, Dies, Nozzles And Sprue Bushings

Made in the U.S.A

Safe! Won't Scratch Molds!

Speeds removal of stuck sprues & runners

Oversized Plastic Grips For Easier Handling

	Item Number	Description	Length Overall
1	101144	⅛" dia. straight with point	13¾"
2	100965	⅛" dia. 90° bend with point	11"
3	101078	3/16" dia. straight with point	13¾"
4	101109	3/16" dia. 90° bend with point	11¼"
5	101020	⅜" dia. straight with point	13¾"
6	101050	⅜" dia. straight with flat head	13¾"

Brass Rod Kit

Includes one each of all six rods shown above.
#100988

Brass Screwdriver

#141788 ⅜" dia., straight with flared tip

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IMS Sprue Pullers (with Replacement Brass Screws)

Expressly Made for the Injection Molder

All-Brass Replaceable Screws, Aluminum Grips - Won't Damage Your Mold

Item #	Description
103980	Small Sprue Puller (2”)
103968	Large Sprue Puller (2½”)
Spare Parts	
103964	Extra screw (small)
103958	Extra screw (large)
103954	Extra set screw (small)
103948	Extra set screw (large)

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Needle Nose Pliers

- Pull small parts out of confined areas
- Multiple uses

Specifications and Prices

Item Number:	103938
Overall Length:	6"
Blade Length:	1 11/16"
Max. Opening at Tip:	2½"
Max. Opening at Base:	⅜"
Spring Type:	stainless steel twin leaf
Weight:	3 oz.

Purchasers also order:

- Bronze Sprue Puller Tools, pages 86 - 87

Item #	Description
103938	Needle Nose Pliers

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Heavy Duty Leveling Mounts

For Use With Any Injection Press

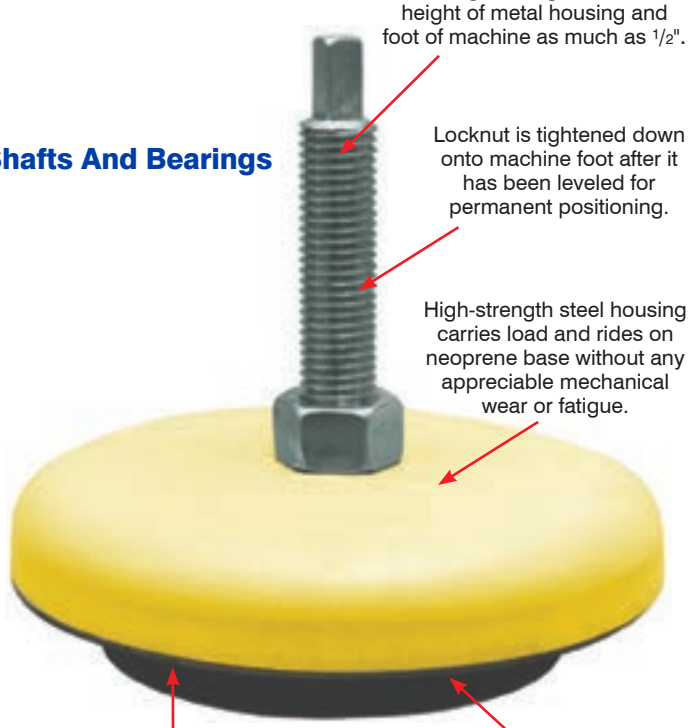
Simplify Installation

Reduce Noise

Control Vibration

Minimize Mechanical Stress To Floor, Machine Shafts And Bearings

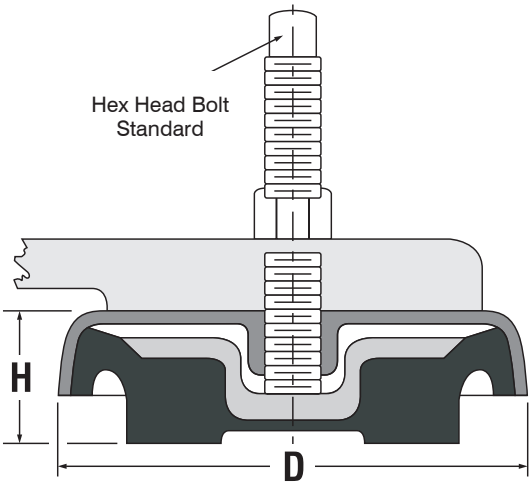
- Meet OSHA Safety Standard for anchorage
- Will not walk or creep (no lagging required)
- Unaffected by oil or water



How To Order

Total Machine Weight
÷ Number of Mounting Points
= Mount Capacity
(Refer to chart at right for maximum load capacity)

NOTE: Natural frequency is approximately 12 Hertz at maximum load.



Designed for long-life!

Heavy duty leveling mounts

Item Number	Min. Load	Max. Load	Bolt Size & Length	Dimensions D	H
109828	30 lbs	150 lbs	3/8"-16 x 3"	3 1/8"	1 1/2"
109820	100 lbs	500 lbs	3/8"-16 x 3"	3 1/8"	1 1/2"
109838	400 lbs	1000 lbs	1/2"-13 x 5"	4 3/4"	1 1/2"
109835	500 lbs	4500 lbs	3/4"-10 x 5"	6 1/4"	1 5/8"
112701*	4000 lbs	13000 lbs	1"-14 x 8"	9"	2 1/4"

*Square head bolt

Other head styles and bolt sizes available — Inquire

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Magnetic Pickup Tools and Inspection Mirrors

Handy and versatile tools for a variety of uses. These handy tools can be helpful to reach hard to see areas when inspecting parts, machines, tools and more.

- 3 lb Pull Pocket Magnetic Pickup Tool
- 7 lb Pull Pocket Magnetic Pickup Tool
- Circular Pocket Inspection Mirror
- Circular Inspection Mirror
- Rectangular Inspection Mirror
- “LED” Lighted Circular Inspection Mirror
- “LED” Lighted Rectangular Inspection Mirror

#165420 #165421 #165407 #165410 #165408 #165411 #165409

Pocket Magnetic Pickup Tools are great for grabbing dropped magnetic objects in hard to reach areas such as nuts, bolts, wrenches, sockets, etc.

- Choose from 3 or 7 pound lifting strength
- Permanent neodymium magnetic ends
- Telescoping handles with convenient pocket clips

Inspection Mirrors are perfect for checking resin levels in hoppers from the shop floor or finding missing bolts that might have been dropped.

- Choose from Circular or Rectangular Designs
- Lighted and Non-Lighted
- Comfortable Telescoping Handles (except pocket version #165407)
- Full 360 Degree Swivel Double Ball Joint Heads
- Shatter resistant mirrors
- Lighted mirrors feature 2 extra bright LEDs (Batteries Included)
- A must for any Molding Shop

Item #	Description
Magnetic Pickup Tools	
165420	3 lb Pull Pocket Magnetic Pickup Tool with 25” Telescoping Handle
165421	7 lb Pull Pocket Magnetic Pickup Tool with 23” Telescoping Handle
Inspection Mirrors	
165407	Circular Pocket Inspection Mirror - 1¼" Diameter with 8" Fixed Handle
165410	Circular Inspection Mirror 2¼" Diameter with 11½" to 16” Telescoping Handle
165408	Rectangular Inspection Mirror 3½" x 2⅛", 11¼" to 15¼" Telescoping Handle
165411	“LED” Lighted Circular Inspection Mirror 1⅞" Diameter with 12" to 33" Telescoping Handle
165409	“LED” Lighted Rectangular Inspection Mirror 3½" x 2" with 12" to 33" Telescoping Handle

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Process Trouble-Shooting Guidelines				
Problem	CRYSTALLINE MATERIALS		AMORPHOUS MATERIALS	
	Lower/Reduce	Raise/Increase	Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

Magnetic Surface Thermometers

Measure the temperature on almost any surface! (Manifolds, platens, piping etc.)

Sample temperature anyplace, anytime – pinpoint hot or cold spots

No holes to drill or tap

Aluminum Case with Optically Clear Crystal

Easy to Read Analog Dial (Blue marks on white background)

Specifications and Prices

Sensing element: precision calibrated bi-metal coil
Accuracy: within 2% of full scale
Response Time: approx. 1 minute
Mounting: 2 alnico magnets on back
Size: 2" diameter dial x ½" thick
Weight: 2 oz.

Item #	Description
109647	Magnetic Surface Thermometer — 0° to 150° F (-20° to 65° C)
109645	Magnetic Surface Thermometer — 0° to 250° F (-20° to 120° C)
109643	Magnetic Surface Thermometer — 0° to 500° F (-20° to 260° C)
109640	Magnetic Surface Thermometer — 50° to 750° F (10° to 400° C)

Check Out These Other Useful IMS Products!

Heat Resistant Gloves

- Reinforced sewn knuckle straps
- Band topped cuff
- One size fits all

24 oz
Hot Mill Gloves

Item No. 136369

- Reinforced sewn knuckle straps
- Band topped cuff
- One size fits all

30 oz
Hot Mill Gloves

Item No. 136370

see page 447 for more info

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Digital Electronic Multimeter

Aids in troubleshooting

The Digital Electronic Multimeter will help you troubleshoot heaters and reduce downtime by quickly checking your electrical systems. Compact and portable, it has an easy-to-read backlit LCD screen with large 1" characters.

- Measurement functions include AC/DC voltage and current, resistance, diode, continuity and transistor
- Type K thermometer built-in for temperature measurements
- Low current capability: measure down to 0.1μA
- Input fuse protection and mis-connection warnings
- Comes with a protective rubber boot
- Automatically shuts off if unused
- Complete with battery and test leads
- Includes tilt stand and velcro strap for ease of use

Specifications and Prices			
Display:	1" backlit	Dimensions:	7.4" x 3.2" x 2" (187 mm x 81 mm x 50 mm)
Fuse Protection:	2A (A socket), 10A range not fused	Weight:	0.75 lbs (342 g)
Power Supply:	9V battery		
Temperature:	-4° F to 1382° F (-20° C to 750° C)		

Item #	Description
147976	Digital Electronic Multimeter complete with CAT III test leads, tilt stand, velcro strap, bead wire temp. probe, 9 volt battery and protective rubber boot

Check Out These Other Useful IMS Products!

White Board Mold Insulation

See Page 204 For More Information

UniVest Barrel Insulation System

See Page 199 - 202 For More Information

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True RMS Multimeter
with Infrared Thermometer

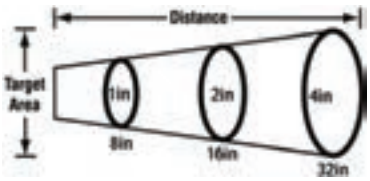
Two Useful Instruments In One Compact Case At One Great Price!

1) It's a true RMS Multimeter

- Provides highly accurate voltage and current measurements
- Advanced Functions include:
  - Frequency
  - Capacitance
  - Type K Temperature measurement

2) It's a Non Contact, Thermometer

- Built-in Laser Pointer helps ensure quick, safe and accurate surface temperature measurement.
- 8:1 distance to target ratio allows for measurements in areas that are normally difficult or unsafe to reach. Fixed emissivity 0.95.



Specifications	
Display:	400 Counts Backlit
Basic Accuracy:	±0.3% (VDC)
DC/AC Voltage:	0.1mV to 600V
DC/AC Current:	0.1μA to 20A
Resistance:	0.1W to 40MW
Capacitance:	0.01nF to 100μF
Frequency:	0.001Hz to 10MHz
Temperature (Type K):	-4°F to 1382°F (-20°C to 750°C)
Temperature (IR with Laser):	-4°F to 518°F (-20°C to 270°C)
Diode/Continuity:	Yes
Size:	7.36"L x 3.2"W x 2.0"D
Weight:	0.753 lbs

CAT III - 600V

Item #132602

Includes: Meter, Test Leads, Type K Temperature Probe, Protective Holster, 9V Battery and Three Year Limited Warranty

Velcro® is a registered trademark of Velcro Companies

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Combination Mini Digital MultiMeter
with Built-in, Non-contact AC Voltage Detector

Two Useful Instruments In One Compact Case At One Great Price!

1) It's a Multimeter

Functions include:

- AC and DC Voltage Measurements
- AC/DC Current Measurements
- Resistance Measurements
- Continuity Check
- Diode Test
- Capacitance Measurements
- Frequency Measurements
- % Duty Cycle
- Contact Temp. Measurements (°F/°C switchable)
- Relative Mode

2) It's a Non Contact AC Voltage Detector

Lets you safely check for the presence of AC Voltage before testing

- If voltage is present, indicator will flash a bright orange and an audible warning will sound

Specifications	
Display Counts:	4000
Basic Accuracy:	0.5%
NC Voltage Detector:	100 to 600VAC
DC Voltage:	0.1mV to 600V
AC Voltage:	0.1mV to 600V
AC/DC Current:	0.1μA to 10A
Resistance:	0.1W to 40MW
Capacitance:	0.001nF to 200μF
Frequency:	0.001Hz to 10MHz
Temperature (Type K):	4°F to 1382°F (-20°C to 750°C)
Duty Cycle:	0.1 to 99.9%
Diode/Continuity:	Yes
Size (including holster)	5.8"L x 2.9"W x 1.6"D (147 x 76 x 42mm)
Weight (including holster)	9.17oz (260g)

Item #141779

Includes: Meter, Test Leads, Bead Wire Temperature Probe, Protective Holster with Stand, two AAA Batteries and One Year Limited Warranty

Also available with NIST Certification - Inquire

IMS also stocks many other Thermometers, MultiMeters and Voltage/Current Detectors - INQUIRE

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Process Trouble-Shooting Guidelines				
Problem	CRYSTALLINE MATERIALS		AMORPHOUS MATERIALS	
	Lower/Reduce	Raise/Increase	Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

Non-Contact AC Voltage and Current Detector

Great for detecting "live" circuits through shielded wires, conduits and metal junction boxes

The ONLY 2-in-1 voltage/current detector designed for electrical testing

Used it to:

- Trace concealed wires in walls and floors
- Identify "HOT" conductors and terminals
- Trace current flow behind walls, in conduit etc. where voltage detectors do not work
- Sensitivity high enough to trip on low voltage HVAC or similar signal levels

Safer To Use

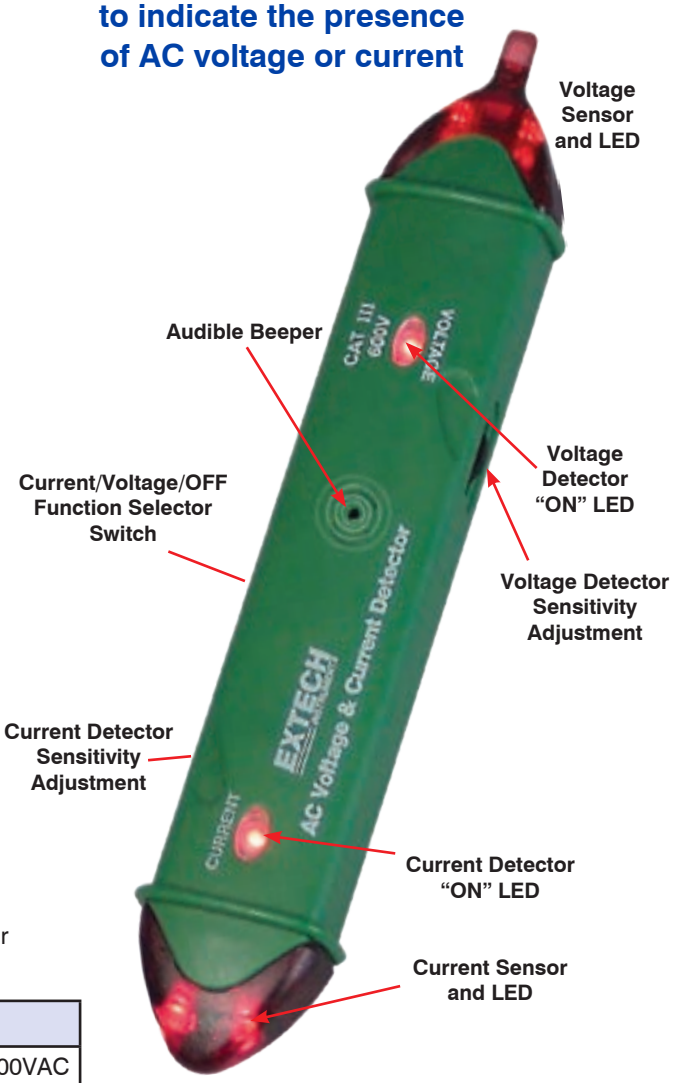
No need to touch probe to wiring

Lightweight, Compact — fits in your pocket

Great for use in tight spaces

(Even if you can't see it, you can hear it!)

"Lights up" and "Beeps" to indicate the presence of AC voltage or current



CAT III - 600V

Note

Sensitivity can be adjusted to increase or reduce sensor trigger threshold — to "hone in" on conductors.

Specifications	
Voltage Detection:	12V to 600VAC
Current Detection:	200mA to 1,000A
Current Sensitivity:	200mA (.2A) AC at .2"
(Detects current flow at much greater distances for larger current flows)	
Audible Indication:	Beeper (Voltage and Current)
Visual Indication:	Flashing LED (Voltage and Current)
Frequency Range:	50 to 500HZ
Operating Temperature:	14°F to 122°F (-10°C to 50°C)
Operating Humidity:	<80% RH
Altitude:	<2000m
Power Supply:	Four LR44 batteries or equivalent
Dimensions:	7.6"L x 1.2"W x 0.9"D(192 x 31 x 24 mm)
Weight	2.1 oz. (60g)

Item #133295

Includes: Four LR44 batteries and pocket clip and 1 Year Warranty

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SuperHeat Psychrometer

Measures Dew Point (-90.4° to +122°F)PLUS Wet Bulb, Humidity, Air Temperature and Differential Temperature

All In One Compact, Low Cost Instrument

Perfect For*:

1. Differential measurements
2. Trend analysis of zone temperatures
3. Evaluating duct losses
4. Monitoring wet bulb, dew point, humidity and temperature
5. Mold prevention programs
6. Humidity monitoring in manufacturing or storage area

*NOT for use with hot air dryers

Unique sensor cap design twists to closed position for protection during storage

Lightweight / Portable / Easy to Use

(Eliminates the need for expensive chart recorders)

Specifications

Function	Range & Resolution	Accuracy
Humidity	0.0 to 100.0% RH	±3% RH (10 to 90%) @ 23°C
Temperature (air)	-4.0 to 122.0°F (-20 to 50°C)	±1.8°F (±1°C)
Temperature	-328 to 2,250°F	±0.3% rdg or
(external) T1, T2	(-200 to 1,370°C)	±(1.8°F)1°C
Display	Triple LCD	
Sensor Type	Humidity: Precision capacitance sensor Internal Temperature: Thermistor External Temperature: Type K Thermometer	
Response Time	60 seconds typical	
Dew Point	-90.4 to 122.0°F (-68 to 50°C) (calculatedfrom RH and air temperature measurements)	
Wet Bulb	-6.88 to 122.0°F (-21.6 to 50°C) (calculated from RH and air temperature measurements	
Low Battery Indicator	Yes	
Power Supply	4 x 1.5V 'AAA' Batteries	
Dimensions	9 x 2.2 x 1.7" (230 x 57 x 44mm)	
Weight	5.3 oz. (153g)	

Item #150232

Includes: Meter, two Type K Bead Wire Temperature Probes, 4 AAA Batteries and 1 Year Warranty

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Made in the U.S.A

Date Code Insert

Run at up to 350°F, these inserts are not affected by heat or mold releases

Made from pre-hardened 416 Stainless Steel

Meet your regulatory traceability requirements without costly secondary operations.

Easy Operation Without The Hassles

Standard Outer Styles

- Blank
- Qtr/Yr
- Shift
- Custom
- Month/Yr
- Year
- Material

Standard Inner Styles

- Blank
- Arrow
- Arrow/Year

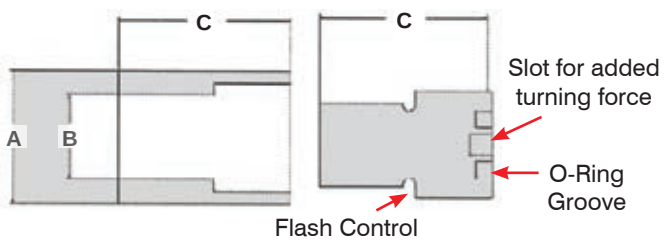
Attention rubber molders: You can make use of the rotating insert style. Flash is controlled and the insert is cleanable for less overall cost.

- Flash control for rubber and thermoset molders
- Turns with screwdriver in the arrow
- Rear screwdriver slot for greater turning torque
- O-ring slot for turning resistance for plastic molders
- Precision clearances to give a seamless look
- Multiple materials, lots, dates, etc. can be put on the outer ring to eliminate the need for any removals of center inserts. This saves time and money.
- Engraving options are tailored to your needs.

Easy Installation

Drill and bore hole in mold to diameter (A) +0.0000"/-0.0004" and a depth of (C). Rear access holes at insert as follows: 4-6 mm inserts 0.057" diameter 8-20 mm inserts 0.125" diameter.

No O-ring groove on 4 or 6 mm styles.



Specifications and Prices

	Diameter "A"	Diameter "B"	Height "C"	Unit Price	Replacement Inserts
DAB-4	4mm (0.1575")	0.0709"	0.2360"	Call For Pricing	Call For Pricing
DAB-6	6mm (0.3262")	0.1417"	0.3150"		
DAB-8	8mm (0.3150")	0.1969"	0.3937"		
DAB-10	10mm (0.3937")	0.2530"	0.4724"		
DAB-12	12mm (0.4724")	0.2992"	0.4724"		
DAB-16	16mm (0.6300")	0.3930"	0.5510"		
DAB-20	20mm (0.7847")	0.5197"	0.6300"		

Check Out These Other Useful IMS Products!

Part Chute Guideskirts

Page 770

Drum and Gaylord Covers

Page 645 - 646

Gaylord Liners

Page 644

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Rupture Disks Extruder Burst Plugs

Instantaneously rupture at a predetermined pressure

Provide emergency relief in applications where pressure build-up can be so rapid that the response time of relief valves is inadequate.

Features

- All stainless steel body
- Inconel disk
- Low installation and maintenance costs

Specifications

- Burst Pressures: 1,500 to 15,000 psi
- Burst Pressure Accuracy: ± 5%
- Maximum Melt Temperature: 750° F

½"-20 UNF mounting thread Standard

Other thread sizes available (⅝"-11, ¾"-16 NC)

Shown: Models RD3H and RD6H with hex head

Shown: Model RD2 with slotted head

Specifications and Prices

Item #	Mounting Thread	Length	Head Style	Burst Pressure at 600˚F (psi) ***
140390	½"-20 UNF	1.82" *	Slotted	1,500
140391				2,500
140392				3,500
140393				4,500
140394				5,500
140395				6,500
140396				7,500
140397				8,500
140398				9,500
140399				10,000
140400				12,500
140402	½"-20 UNF	3" **	Hex	1,500
140403				2,500
140404				3,500
140405				4,500
140406				5,500
140407				6,500
140408				7,500
140409				8,500
140410				9,500
140411				10,000
140412				12,500
140414	½"-20 UNF	4" **	Hex	1,500
140415				2,500
140416				3,500
140417				4,500
140418				5,500
140419				6,500
140420				7,500
140421				8,500

* Thread dependent ** Length is defined as length below the hex head *** For burst pressures not listed, Inquire

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Item #	Mounting Thread	Length	Head Style	Burst Pressure at 600˚F (psi)*
140422	½"-20 UNF	4" **	Hex	9,500
140423				10,000
140424				12,500
140426	½"-20 UNF	6" **	Hex	1,500
140427				2,500
140428				3,500
140429				4,500
140430				5,500
140431				6,500
140432				7,500
140433				8,500
140434				9,500
140435				10,000
140436				12,500
140438	½"-20 UNF	7" **	Hex	1,500
140439				2,500
140440				3,500
140441				4,500
140442				5,500
140443				6,500
140444				7,500
140445				8,500
140446				9,500
140447				10,000
140448				12,500
140450	½"-20 UNF	9" **	Hex	1,500
140451				2,500
140452				3,500
140453				4,500
140454				5,500
140455				6,500
140456				7,500
140457				8,500
140458				9,500
140459				10,000
140460				12,500
140462	½"-20 UNF	12" **	Hex	1,500
140463				2,500
140464				3,500
140465				4,500
140466				5,500
140467				6,500
140468				7,500
140469				8,500
140470				9,500
140471				10,000
140472				12,500

Alternate Mounting Threads	
-⅝	⅝"-11 NC (For RD4H and RD6H only)
-¾S	¾"-16 UNF 2A short thread
-¾	¾"-16 UNF 2A full thread
-M18	M18 x 1.5 (RD6H only)
Optional Discharge Connection Threads	
-¼ NPT	¼"-18 NPT
-½ NPT	½"-20 NPT

* Length is defined as length below the hex head *** For burst pressures not listed, INQUIRE Custom Form on Next Page

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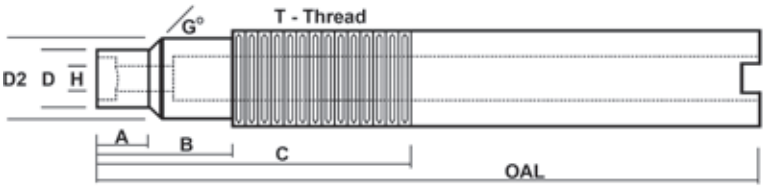
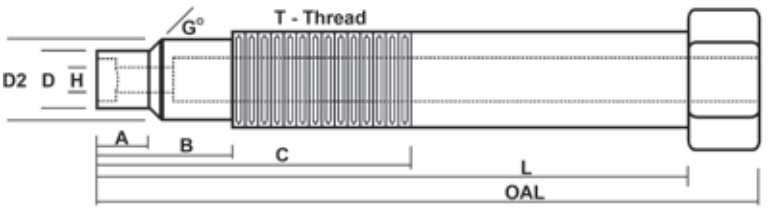
REQUEST FOR QUOTE: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

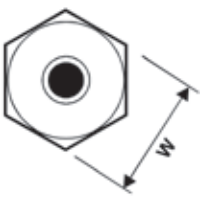
Custom Melt Pressure Extruder Rupture Disk Quote Form

Screwdriver slot style

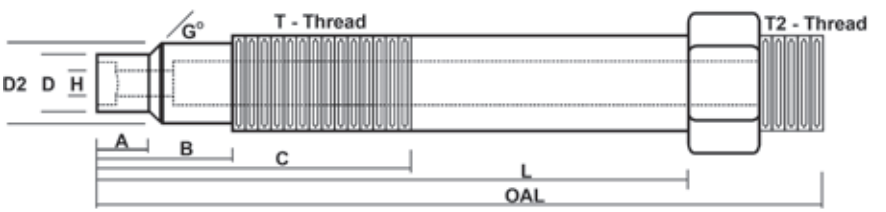


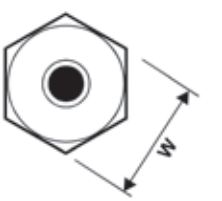
Hex head style



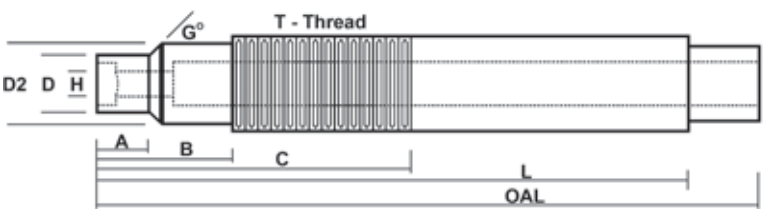


NPT thread style





Flat end style



Specify

1. Style: ❑ Screwdriver Slot ❑ Hex Head ❑ NPT Thread ❑ Flat End

2. Body Material: ❑ 304 Stainless Steel ❑ Other _____

3. Disc Material: ❑ Inconel ❑ Other _____

4. Pressure Rating: _____ PSIG @ _____ °F

5. Dimensions:

H _____ D _____ D2 _____ A _____ B _____ C _____

L _____ OAL _____ W _____ G _____ T _____ T2 _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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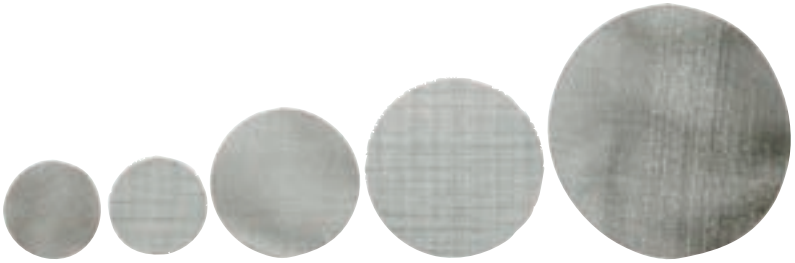
Extrusion Screens and Screen Packs

Now available from IMS!

Extruder Screens of any shape and size available in any mesh size.



Stainless Steel

Diameter	10 Mesh	20 Mesh	40 Mesh	60 Mesh	80 Mesh	100 Mesh	120 Mesh
1"	RFQ*	148649	148650	148651	148652	148653	148654
1¼"		159934	159935	159936	148395	159937	159938
1⅜"		159939	159940	144731	159941	159942	159943
1½"		144583	144584	144585	144586	159944	159945
2"		148092	148093	148094	143715	143716	159946
2¼"		159947	159948	145054	159949	159950	159951
2⅜"		159952	150641	150642	150643	159953	159954
2½"		143707	143708	143709	150640	143717	159955
2¾"		144587	144588	144589	143633	159956	159957
3"		143712	143713	143714	159958	159959	159960
3¼"		150446	150447	150602	150448	150449	159961
3⅜"		159982	159983	159984	159985	159913	159986
3½"		148484	148485	148486	148487	159962	159963
3¾"		150457	150458	150459	150460	150461	159964
4"		144590	144591	144592	144593	148558	159965
4⅛"		150452	150453	150454	150455	150456	159966
4½"		150444	150445	150441	150442	150443	159967
4¾"		147878	147879	159968	159969	159970	159971

Plain Steel

Diameter	10 Mesh	20 Mesh	40 Mesh	60 Mesh	80 Mesh	100 Mesh	120 Mesh
2"	RFQ*	148163	RFQ*	148164	148165	RFQ*	RFQ*
2½"		148166		148167	148168		
4½"	160598	148169		148170	148171		
6"	RFQ*	148172		RFQ*	148173		

*Request for quote

Made to order Extruder Screen Packs available in any size or combination of meshes

Inquire for more details

Quantity Based Pricing Available - Call or Email to Inquire!

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Melt Pressure Transducers & Transmitters

Rapidly Becoming the Preferred Choice of Cost Conscious Plastic Processors!

Deliver Exceptional

- Functionality
- Accuracy
- Repeatability
- Reliability

Incorporate a tried and proven liquid filled capillary design which:

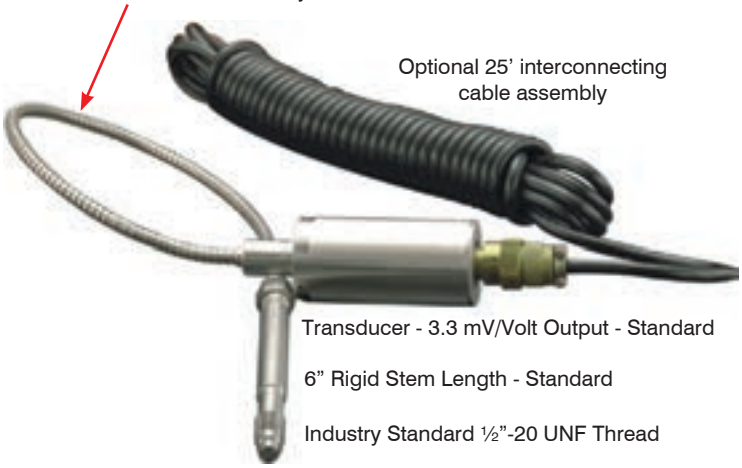
- Provides an electronic signal which is proportional to the measured pressure
- Allows the transducer to operate at process temperatures up to 750°F (400°C)

Fully compatible (without rewiring) with:

- Industry standard wiring pattern and color coding
- Existing transducers utilizing a 6 pin bayonet connector
- Industry standard 80% output calibration

Mecury Free Sodium Potassium Filled

18" long armor-encased capillary allows electronics to be mounted away from heat and vibration



Optional 25' interconnecting cable assembly

Transducer - 3.3 mV/Volt Output - Standard

6" Rigid Stem Length - Standard

Industry Standard ½"-20 UNF Thread

Standard Unit Specifications

Mechanical	
Pressure Ranges:	0-15,000 psi
Mounting:	½"-20 UNF thread
Mounting Torque:	150 - 500 in-lbs max.
Diaphragm Material:	Inconel
Overload Capacity:	2 times Full Scale
Temperature Ratings:	Diaphragm 1000°F Electronics 250°F
Accuracy:	General Purpose <.5% FSO
Repeatability:	+/- 0.2%
Electrical	
Type:	Bonded Strain Gage, 4 Leg Wheatstone Bridge
Bridge Resistance:	350 ohm
Connector:	6 pin Bendix Style Bayonet
Output:	3.3mV/Volt
Excitation Voltage:	mV/Volt-10VDC 4-20mA-24VDC 0-10VDC-24VDC
Internal Calibration:	80% of Full Scale Output

Two Styles

Rigid Style is the same as the Classic, minus the capillary

Classic Style features a 6" rigid stem with 18" flex armor capillary

Stainless Steel Sealed Construction

Classic Style Transducer with thermocouple option

See next page for Standard Unit Prices, Options and Accessories

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tech support toll-free (USA & Canada) **1.866.467.9001**

e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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Item #	Style	Rigid Stem Length	Output Type	Pressure Range	Thermocouple
174900	Rigid	6" Stem	Transducer 3.3mV/ Volt	0-3,000	–
174901				0-5,000	
174902				0-7,500	
174903				0-10,000	
174904				0-15,000	
174905	Classic	6" Stem + 18" Flex Hose	Transducer 3.3mV/ Volt	0-3,000	–
174906				0-5,000	
174907				0-7,500	
174908				0-10,000	
174909				0-15,000	
174910	Classic	6" Stem + 18" Flex Hose	Transmitter 4-20 mA	0-3,000	–
174911				0-5,000	
174912				0-7,500	
174913				0-10,000	
174914				0-15,000	
174915	Classic	6" Stem + 18" Flex Hose	Transmitter 0-10 VDC	0-3,000	–
174916				0-5,000	
174917				0-7,500	
174918				0-10,000	
174919				0-15,000	
174920	Classic	6" Stem + 18" Flex Hose	Transducer 3.3mV/ Volt	0-3,000	Type J
174921				0-5,000	
174922				0-7,500	
174923				0-10,000	
174924				0-15,000	
174925	Classic	6" Stem + 18" Flex Hose	Transmitter 4-20 mA	0-3,000	Type J
174926				0-5,000	
174927				0-7,500	
174928				0-10,000	
174929				0-15,000	
174930	Classic	6" Stem + 18" Flex Hose	Transmitter 0-10 VDC	0-3,000	Type J
174931				0-5,000	
174932				0-7,500	
174933				0-10,000	
174934				0-15,000	
Accessories					
132027	25' Extension Cable with Mating Connector, 6 pin				
132028	50' Extension Cable with Mating Connector, 6 pin				

Special Order Options Available - Inquire for pricing

Connectors: 6 Pin screw, 8 Pin screw
Threads: M18 x 1.5, M10 x 1.0
Stem Lengths: 3", 4", 9", 12", 81"
Flex Hose Capillary Lengths: 24", 30", 60"
Diaphragms: Hastelloy, Titanium Aluminum Nitride

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GREEN Products

Air Wipe™

Provides a Uniform, 360° Stream of Air

Perfect for non-contact blow-off, cleaning, drying and cooling of extruded shapes, pipe, cable, hose etc.

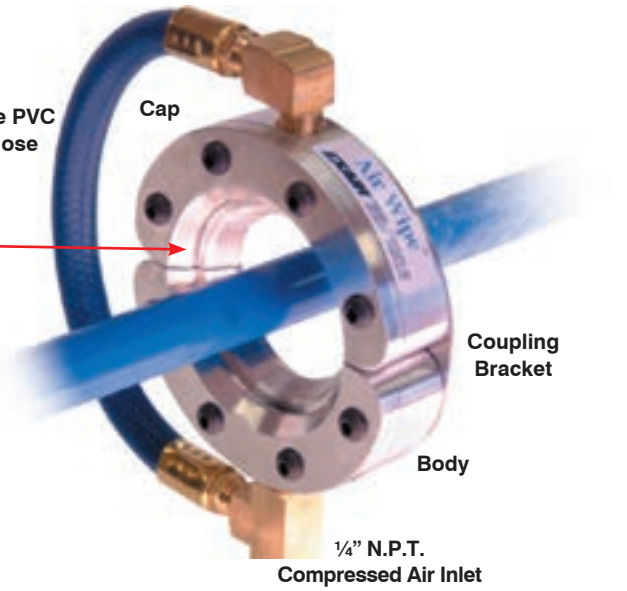
Performs better, runs quieter and is much more efficient than conventional air nozzles in such applications

Helps reduce production costs

Use to:

- Blow-off dust and dirt
- Remove excess coatings
- Dry after printing or plating
- Cool hot, extruded shapes

5 Year Warranty



Variable Velocity

Thickness of Plastic Shim between cap and body (.002" standard) determines force and flow of air stream. Thicker and thinner Shims (sets available below) can be used to increase or decrease airflow.

A pressure regulator on the compressed air supply provides infinite control of flow, force and air consumption.
NOTE: Use of an Air Filter Separator is essential for proper operation.

Circular Styling

Directs a consistent flow of air over the entire surface

Quiet

Meets or exceeds OSHA noise requirements

Split Design

Allows easy installation around the surface of the material moving through it

Low Air Consumption

Helps reduce production costs

Can be supported by the compressed air supply pipe. Tapped holes (¼"-20) on the bottom of the body can also be used for mounting.

2 Styles to Match Any Application

Standard Air Wipe

- The best in non-corrosive environments
- Designed to work where temperatures do not exceed 150°F (66°C)
- Complete package including a general purpose PVC hose sized up to 4" (120mm)

Super Air Wipe

- Ideal choice for corrosive environments
- Choose from Aluminum models rated up to 400°F (204°C) or Stainless Steel models rated to 800°F (427°C) depending on your operating temperatures
- Constructed with high quality stainless steel screws, shims along with stainless steel wire braided coupling hose sizes up to 4" (120mm)

Perfect for Hundreds of Applications:

- Drying after paint, cleaning, plating or coating
- Cool hot extruded shapes
- Dry extruded profiles, rod & medical tubing
- Blow excess water off auto door gaskets
- Dry tube, hose, wire, & fiber optics
- Clean paint gun tips
- Clean strips or ribbons
- Blowoff of dust and contaminates
- Uniformly wipe surfaces
- Eliminate solution carryover - stop contamination
- Remove excess coatings, water and oil
- Minimize solution loss due to drag-out
- Dry screen printed or in jetted surfaces

Air Wipe™ *is a Trademark of EXAIR Corp.*

continued on next page

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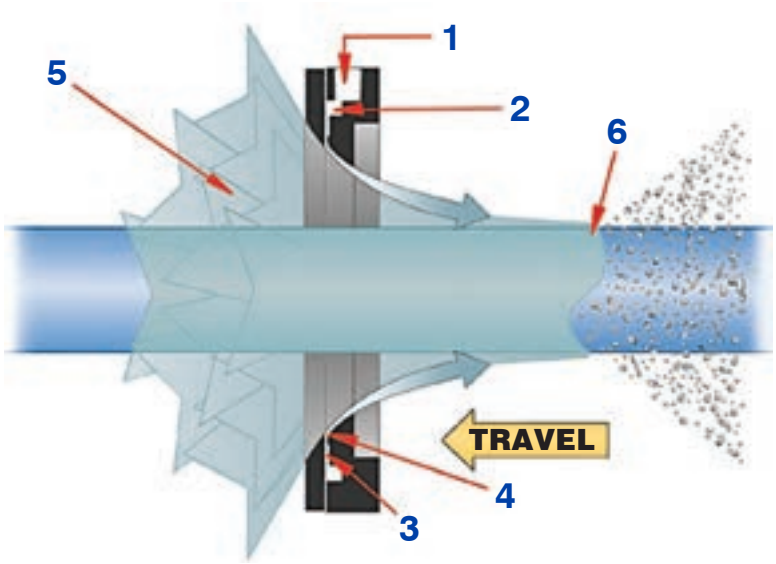
How Does it Work?



Compressed air flows through an inlet (1) of the Air Wipe into an annular chamber. (2) It is then throttled through a small ring nozzle (3) at high velocity. This primary airstream adheres to the coanda profile (4), which directs it down the angled surface of the Air Wipe. A low pressure area is created at the center (5) inducing a high volume flow of surrounding air into the primary airstream. As the airflow leaves the Air Wipe, it creates a conical 360° ring of air that attaches itself to the surface of the material running through it (6), uniformly wiping the entire surface with the high velocity airflow.

No Moving Parts — Nothing to Wear Out or Break!

Air Wipe Includes: .002" thick plastic shim

	Standard Air Wipe		Aluminum Super Air Wipe		Stainless Steel Air Wipe	
ID	Wipe Only	Shim Kit*	Wipe Only	Shim Kit*	Wipe Only	Shim Kit*
½"	RFQ	RFQ	147567	147568	N/A	N/A
1"	133926	134255	144361	144383	144379	144383
2"	133927	134256	144362	144371	144380	144371
3"	133928	134257	144363	144372	144381	144372
4"	133929	134258	144364	144373	144382	144373
5"	144351	144661	144365	144374		
6"	144352	144662	144366	144375		
7"	144353	144663	144367	144376		
9"	144354	144664	144368	144377		
11"	144660	144665	144369	144378		

*Kit Includes: 1", 3" and 4" thick plastic shims - 1 of each

Optional Accessories			
Pressure Regulator		Auto Drain Filter Separator	
104451	¼" N.P.T.	104454	⅜" N.P.T.
134259	½" N.P.T.	134260	½" N.P.T.
104448	¾" N.P.T.	104452	¾" N.P.T.

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Air-Chilling Cold Gun™

Ideal For Spot Cooling of Mold Cores, Cavities and Molded Parts

Reduce cycle time by effectively cooling precise points of heat build-up where water and other cooling media can't reach or are undesirable.

In the molding room:

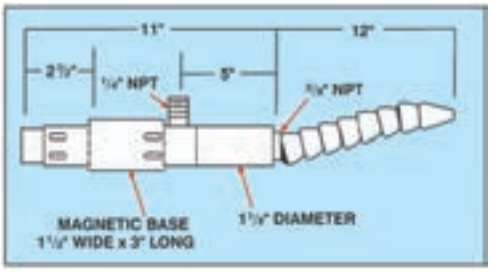
- Stabilize Molded Part Dimensions
- Faster Cooling Often Means Stronger Plastic Parts
- Minimize Sink Marks By Faster Cooling Of Thick Sections
- Freeze Off A Nozzle Fast
- Stop Drooling At Nozzle Changes

In the tool room:

- Keep Cutting Edges Cool
- Lengthen Tool Life
- Grind Faster

Specifications

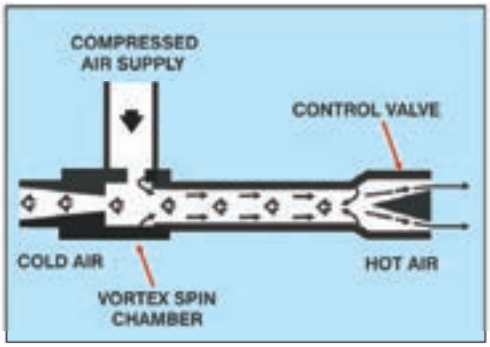
- Air consumption: 15 scfm at 100 psig inlet air pressure (3-4 hp compressor on continuous use)
- Temperature Drop: 50° from compressed air temperature at 100 psig.



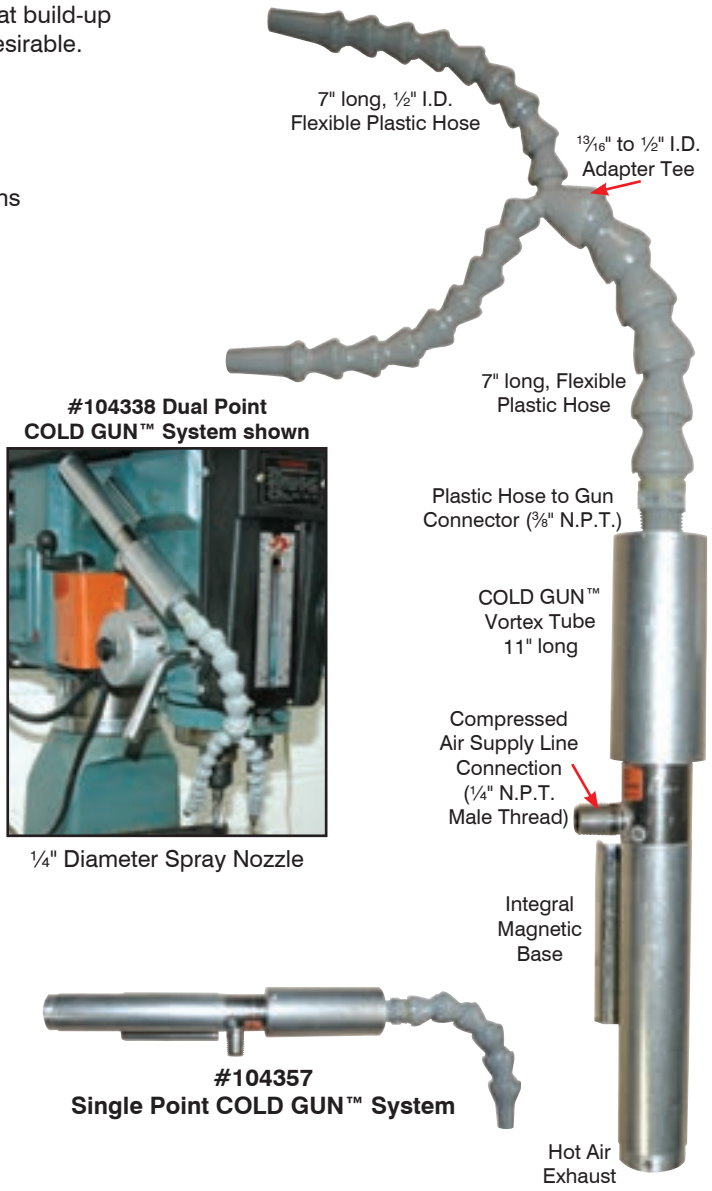
With its integral magnetic base, the COLD GUN™ is easily mounted to any machine, requiring only a source of compressed air.

How It Works

The COLD GUN™ works by spirally separating cold molecules of slower moving air from faster moving hot ones, found in all compressed air. Long a technical curiosity, the COLD GUN™ allows you to direct chilled air right to the cutting edge of a tool. Or in a mold core, it can chill a fountain far better than water.



COLD GUN™ is a trademark of EXAIR Corp.



#104338 Dual Point COLD GUN™ System shown

¼" Diameter Spray Nozzle

#104357 Single Point COLD GUN™ System

#104357 Single Point COLD GUN™ System Includes: Gun, Single Point Hose Kit, Filter Separator and Instructions.	
#104338 Dual Point COLD GUN™ System Includes: Gun, Dual Point Hose Kit, Filter Separator and Instructions.	
Optional Accessories	
#104356 Single Point Hose Kit Includes: (1) Hose to Gun Connector, (1) 11" long, 13/16" I.D. Flex Hose, (1) ⅜" dia. Spray Nozzle and (1) 1¼" wide Fan Nozzle.	
#104337 Dual Point Hose Kit Includes: (1) Hose to Gun Connector, (1) 7" long, 13/16" I.D. Flex Hose, (1) 13/16" I.D. to ½" I.D. Adapter Tee, (2) 7" long, ½" I.D. Flex Hoses, (2) ¼" dia. Spray Nozzles and (2) 1" wide Fan Nozzles.	

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1949

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Molding Supplies

Mold Release & Maintenance Products

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Mold Cleaners
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Mold Rust Preventives
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Mold Polishes
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Material Lubricants
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Spray Systems
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Most Items In Stock For Same Day Shipment

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Mold Release Products

High-quality products with a focus on safety

IMS Company offers a selection of mold release products for a variety of applications. All are made from the purest, highest quality ingredients available.

Our focus is on worker safety. We go out of our way to find the least toxic options when we formulate our mold releases. Our labels list all significant ingredients. Our MSDS sheets fully disclose all ingredients and give detailed safety information. We respect you enough to tell you what we're selling you. You and your workers deserve nothing less. We've even changed to bilingual English/Spanish labels on many of our most common products, for added protection for Spanish-speaking workers.

Material safety data sheets

We include an SDS in every chemical shipment. Our SDS sheets are also available online at www.imscompany.com, or by calling us.

Nonflammable mold releases

For applications where non-flammability is needed, we offer a full line of Nonflammable mold releases in aerosol cans and aerosol tanks. All of our aerosol tanks are Nonflammable as a complete formula, and all contain no flammable gases. *NOTE ON NON-FLAMMABILITY: Beware of dimethyl ether in an aerosol tank (cylinder). It is a flammable gas — even if the final product is technically Nonflammable — and we do not believe it is legal to use in the so-called DOT-39 tanks used for mold release. We also believe the danger would be too great if there were an uncontrolled release due to the hose breaking or a solenoid valve sticking.

Aerosol tanks

We now offer two formulas. Our inexpensive A4 Series has been available since 2004, and it is working very well for many molders. Our high-end Speed Mist Plus formula contains no trichloro-ethylene, no dimethyl ether and no other flammable gas. Evaporation is much faster than trichloro-ethylene. The Speed Mist Plus formula is also very low toxicity.

Blanket order plans

Blanket orders let you set pricing based on your annual usage, to take advantage of the highest level of quantity discount available. They also provide a measure of price stability. Ask about blanket pricing for your large-volume chemical purchases.

Free samples

Often, the best way to determine which formula is best for your application is to sample various sprays. Free sample cans are available upon request. Simply contact the IMS Supplies Team at 1-800-537-5375 or sales@imscompany.com.

Bulk mold releases

IMS stocks several formulas of undiluted bulk mold release. Bulk releases offer money savings in applications where aerosol-thin applications are not strictly required

Spray systems

IMS stocks spray systems to enable automated application of mold release. Those systems are available for aerosol application using aerosol tanks or for bulk application.

Note: Prices are subject to change without notice.

Note: Warranties are not offered on application of mold release materials. All mold releases should be pretested on your material and mold.

Recognized under the component program of Underwriters Laboratories Inc.

Several stock mold releases have earned UL 94 approval indicating that they do not alter non-flammability of the plastics onto which they are applied.

OVERVIEW

IMS Company

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Aerosol Mold Release Selection Guide

See individual product page for pricing, as well as more economical size aerosol tanks and bulk packaging
(Review our website for the most up-to-date information on any product we sell)

- This list is a general guide based on reported results from our customers. It is not a guarantee of safety or effectiveness. Test the mold release with your mold and material before use.
- These products are intended for application to metal molds as a mold release. Some of these products contain solvents that are aggressive against some plastics. Do not apply directly to plastics without pretesting or without the recommendation of the manufacturer of the plastic. Allow full evaporation of the solvent before injection.

Description	1% Silicone Mist	3% Silicone	Speed Mist PLUS 3% Silicone	Economy Silicone	Economy Silicone-50	Nonflammable Silicone	S-6, 15% & Super 33% Silicone	Blue Label	Gold Label	Paintable Mist	Speed Mist PLUS Paintable Mist	Economy Paintable	Economy Paintable-50	Nonflammable Paintable Mist	Neutral Oil A4	Organic Oil A4 & L-6 Lecithin	Ester Spray	Dry Spray A4 with PTFE	DRY-21 Paintable PTFE Powder	Mold Release with DryFilm	Zinc Stearate A4
ABS	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Acetal	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Acrylic PMMA	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Epoxy															•	•	•	•	•	•	•
Nylon	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Polycarbonate	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Polyester		•	•				•	•	•	•	•	•	•		•	•	•	•	•	•	•
Polyethylene	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Polypropylene	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Polystyrene	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Polysulfone	•	•	•	•	•	•	•	•	•	•	•	•	•		•	•	•	•	•	•	•
Polyurethane															•	•	•	•	•	•	•
PPO (Noryl)	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
PVC								•	•									•	•	•	•
Rubber	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•	•
Paintable										•	•	•	•	•	•	•	•	•	•	•	•
FDA Approved	•	•	•	•	•	•	•								•	•	•		•		•
UL	•[1]	•[1]		•						•[1]		•			•		•[1]				

[1]Aerosol cans and A4-series aerosol tanks approved for this product. Mist tanks are not UL approved.

Rating relative to other mold release products, 1=most favorable, 2=moderately favorable, 3=least favorable

Evaporation	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
Toxicity to Workers	2	2	1	2	3	1	2	2	2	2	1	2	3	1	2	2	2	2	2	2	2
Flammability	2	2	1	2	3	1	2	2	2	2	1	2	3	1	2	2	2	2	2	2	2
Solvent-Sensitive*	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
Cost	2	2	3	2	1	3	2	3	3	2	3	2	1	3	2	2	2	3	2	3	2

*Compatibility with Solvent-Sensitive Plastics

Tech Tips

Wonder which mold release to use? Start with a silicone — unless there is a reason not to. The next most effective release is paintable mist.

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Made in the U.S.A

IMS 1% Silicone Mist Mold Release

Low Residue Formula

Silicone Mist is our driest silicone release, for use where low residue is critical.

- **Approved for food packaging: FDA 21 CFR 181.28**
- Low Toxicity
- Recognized under the component program of Underwriters Laboratories Inc.

Effective with:

ABS	Nylon	Polypropylene	PPHOX
Acetal	Polycarbonate	Polystyrene	PPO
Acrylic PMMA	Polyethylene	Polysulfone	Rubber

Item #	Description	Quantity (Packaged 12 Cans Per Case)
113659	1% Silicone Mist Mold Release (12 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

Purchasing in bulk? Call to inquire for more quantity discounts.

E94408 (N)

- Misting tip
- Moderate flammability

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IMS 3% Silicone Spray Mold Release

Our Most Popular Silicone Spray

Made in the U.S.A

Silicone Spray is the ideal general-purpose mold release. Its 3% concentration forms a long-lasting film on the mold, yet is dry enough to leave little residue on the part.

- **Approved for food packaging: FDA 21 CFR 181.28**
- Low Toxicity
- Recognized under the component program of Underwriters Laboratories Inc.

E94408 (N)

- Moderate flammability

Effective with:

ABS	Polycarbonate	Polystyrene	Rubber
Acetal	Polyester	Polysulfone	
Acrylic PMMA	Polyethylene	PPHOX	
Nylon	Polypropylene	PPO	

Item #	Description	Quantity (Packaged 12 Cans Per Case)
113646	3% Silicone Mist Mold Release (9¼ oz. fill)	1-71
		72-143 (save 5%)
		144+ (save 10%)
113653	3% Silicone Mist Mold Release (12 oz. fill)	1-71
		72-143 (save 5%)
		144+ (save 10%)

Purchasing in bulk? Call to inquire for more quantity discounts.

E94408 (N)

- Moderate flammability

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Made in the U.S.A

IMS 3% Silicone Spray Mold Release

Continued

Speed Mist PLUS™

- Extremely fast evaporating
- Very low toxicity
- No flammable ingredients
- The industry's safest

Speed Mist™/Speed Mist PLUS™ are a trademarks of IMS Company

Speed Up Cycle Times

Item #	Description
165730	Speed Mist 3% Silicone Spray Mold Release (Tank) (30 lb. / 21 lb. fill)

Note: IMS Aerosol Tanks are not refillable and must be properly disposed of when empty.

For Tank Spray Systems and Accessories — see pages 150-157

Ask About Larger Sizes

Note: Always pre-test before using any mold release. Be sure to test it thoroughly for compatibility with your molding materials and post-molding processes like painting or plating. Check for crazing, stress cracking and marking to be sure you have selected the right mold release for your plastic.

Check Out These Other Useful IMS Products!

IMS Automatic Bulk Spray System Item # 121983

- Helps maintain consistent cycle times
- Eliminates wasteful over-spray
- Reduces health and accident claims

Save Money!
Uses Bulk Releases & Compressed Air

See Page 156 For More Details

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6% S-6 Silicone Spray Mold Release

Moderate Percentage Of Silicone

Made in the U.S.A

- Fast evaporating
- Low toxicity
- Moderate flammability
- **Approved for food packaging: FDA 21 CFR 181.28**

Effective with:

ABS	Polycarbonate	Polystyrene	Rubber
Acetal	Polyester	Polysulfone	
Acrylic PMMA	Polyethylene	PPHOX	
Nylon	Polypropylene	PPO	

Item #	Description	Quantity (Packaged 12 Cans Per Case)
131968	S-6 Silicone Spray Mold Release (11 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

Purchasing in bulk? Call to inquire for more quantity discounts.

Economy Silicone Mist Mold Release

Low Cost

Made in the U.S.A

- General purpose, low cost spray
- **Approved for food packaging: FDA 21 CFR 181.28**

Effective with:

ABS	Polycarbonate	Polystyrene	Rubber
Acetal	Polyester	Polysulfone	
Acrylic PMMA	Polyethylene	PPHOX	
Nylon	Polypropylene	PPO	

Item #	Description	Quantity (Packaged 12 Cans Per Case)
113718	Economy Silicone Mist Mold Release (12 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

E94408 (N)

- Low cost
- Moderate flammability
- Low toxicity

123491	Economy Silicone-50 Mist Mold (9 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

Purchasing in bulk? Call to inquire for more quantity discounts.

- Lowest cost

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Made in the U.S.A

IMS 15% Silicone Mold Release

Formulated For Tough Jobs

15% Silicone Spray is a general purpose release for low-draft molds. Higher concentration of silicone allows for more releases between sprays.

- **Approved for food packaging: FDA 21 CFR 181.28**
- Low toxicity

Effective with:

ABS	Nylon	Polyethylene	Polysulfone	Rubber
Acetal	Polycarbonate	Polypropylene	PPHOX	
Acrylic PMMA	Polyester	Polystyrene	PPO	

Item #	Description	Quantity (Packaged 12 Cans Per Case)
113717	15% Silicone Spray Mold Release (9¼ oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

Purchasing in bulk? Call to inquire for more quantity discounts.

Made in the U.S.A

IMS Super 33% Silicone Spray Mold Release

Formulated For Tougher Jobs

Super 33% Silicone Spray Mold Release contains 33% silicone fluid for tough molding jobs.

- **Approved for food packaging: FDA 21 CFR 181.28**
- Low toxicity

Effective with:

ABS	Nylon	Polyethylene	Polysulfone	Rubber
Acetal	Polycarbonate	Polypropylene	PPHOX	
Acrylic PMMA	Polyester	Polystyrene	PPO	

Item #	Description	Quantity (Packaged 12 Cans Per Case)
113712	Super 33% Silicone Spray Mold Release (9¼ oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

Purchasing in bulk? Call to inquire for more quantity discounts.

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Please refer to imscompany.com for current pricing

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IMS Blue Label Silicone Spray Mold Release

More Releases Per Spray — Long Lasting

Made in the U.S.A

Developed by IMS, Blue Label Silicone is an exclusive blend of two different types of silicone. It forms a thin, tough film on the mold surface. It is the best spray anywhere for new molds.

Effective with:

ABS	Polycarbonate	Polystyrene	Rubber
Acetal	Polyester	Polysulfone	
Acrylic PMMA	Polyethylene	PPO	
Nylon	Polypropylene	PVC	

Note: Blue Label Silicone Spray can cause a film buildup on warm molds if used too heavily. The buildup is easy to remove with a soft cloth and any IMS Mold Cleaner.

Item #	Description	Quantity (Packaged 12 Cans Per Case)
113719	Blue Label Silicone Spray Mold Release (9¼ oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

Purchasing in bulk? Call to inquire for more quantity discounts.

Speed Mist PLUS™

Lets You Run Jobs Others Can't

- Extremely fast evaporating
- Very low toxicity
- No flammable ingredients
- The industry's safest

Item #	Description
165731	Speed Mist™ Blue Label Silicone Spray Mold Release (Tank) (30 lb./21 lb. fill)

Note: IMS Aerosol tanks are not refillable and must be properly disposed of when empty.

Speed Mist™/Speed Mist PLUS™ are a trademarks of IMS Company

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Made in the U.S.A

Gold Label Silicone Spray Mold Release

Formulated for the toughest jobs

Gold Label Silicone is a proprietary blend of 4 viscosities of polydimethylsiloxane. It offers the advantages of the heavier silicones without the greasiness.

- Better coverage with minimal part marking
- More releases per spray

Blended to Handle the Toughest Jobs

Effective with:

ABS	Polycarbonate	Polystyrene	Rubber
Acetal	Polyester	Polysulfone	
Acrylic PMMA	Polyethylene	PPO	
Nylon	Polypropylene	PVC	

Item #	Description	Quantity (Packaged 12 Cans Per Case)
113716	Gold Label Silicone Spray Mold Release (9¼ oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

Made in the U.S.A

IMS Pure Silicone Mold Release

- General-purpose mold release
- 350 centistokes viscosity
- Highest quality silicone
- **Approved for food packaging: FDA 21 CFR 181.28**

Effective with:

ABS	Nylon	Polystyrene
Acetal	Polycarbonate	Polysulfone
Acrylic PMMA	Polyethylene	Rubber

Item #	Description
	Pure Silicone Mold Release (Bulk)
100579	(1-gal. can)
100536	(5-gal. can)

For Tank Spray Systems and Accessories — see pages 150 - 157

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ECONO-CUBE™ - Silicone Mold Release

For use with the IMS ECONO-CUBE™ Spray System

Made in the U.S.A

- 100% pure silicone
- Nontoxic
- No VOCs
- One-minute cube replacement time
- Minimal packaging disposal

Item #	Description
111967	Silicone Mold Release Econo-Cube™ (1 quart/956ml)
115348	Silicone Mist Mold Release Econo-Cube™ (1 quart/ 956ml) Thinner Viscosity
	NOTE: ECONO-CUBE™ Silicones are not FDA approved.

For Tank Spray Systems and Accessories — see pages 150 - 157

For ECONO-CUBE™ - Paintable Mold Release — See page 155

Use Bulk to Save Money

ECONO-CUBE™ is a trademark of IMS Company

IMS Water-Emulsion Silicone Mold Release

For Rubber and Other Hot Molds

Made in the U.S.A

Water-Emulsion Silicone contains 35% Pure Silicone Solids. This 1,000-centistoke-viscosity, pure silicone suspension is excellent for rubber molding. Dilute from 3 to 500 parts water to 1 part water-emulsion silicone depending on your application. It's best used for processes with mold temperature above 200°F.

- Effective as an assembly lubricant
- No VOCs, non-toxic

Effective with: Polyethylene and Rubber

Item #	Description
	Water-Emulsion Type Silicone Mold Release
148854	(1-gal. jug)
148855	(5-gal. pail)

NOTE: NOT FDA approved.

For Tank Spray Systems and Accessories — see pages 150 - 157

Note: Always pre-test before using any mold release. Be sure to test it thoroughly for compatibility with your molding materials and post-molding processes like painting or plating. Check for crazing, stress cracking and marking to be sure you have selected the right mold release for your plastic.

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Made in the U.S.A

IMS Paintable Mist Mold Release

Low residue buildup

Use wherever molded parts are to be painted, plated, printed or stamped. Also use Paintable Releases if these processes will be done near the press, because any mold release can get into the air and deposit on parts even many feet away.

- For molded parts to be painted, plated, printed, or ink stamped
- Wide range of applications
- Misting tip
- Recognized under the component program of Underwriters Laboratories Inc. (except Speed Mist)

E94408 (N)

- Moderate flammability

Effective with:

ABS	Nylon	Polypropylene	PPO
Acetal	Polycarbonate	Polystyrene	Rubber
Acrylic PMMA	Polyester	Polysulfone	
Epoxy	Polyethylene	PPHOX	

Item #	Description	Quantity (Packaged 12 Cans Per Case)
113658	Paintable Mist Mold Release (9¼ oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)
113649	Paintable Mist Mold Release (12 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

- Moderate flammability

E94408 (N)

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Please refer to imscompany.com for current pricing

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Paintable Mist Mold Release

Continued

Made in the U.S.A

Evaporates Fast — Run Faster Cycles

Speed Mist PLUS™

- Extremely fast evaporating
- Nonflammable
- No flammable ingredients
- No dimethyl ether

Item #	Description
165729	Speed Mist™ Paintable Mist Mold Release (Tank) (30 lb./21 lb. fill)

Note: IMS Aerosol Tanks are not refillable and must be properly disposed of when empty.

For Tank Spray Systems and Accessories — see pages 150 - 157
Ask about larger sizes

Replaces IMS Item Numbers 113962, 113993 and 134308

IMS Economy Paintable Mold Release

Made in the U.S.A

- For molded parts to be painted, plated, printed, or ink stamped
- Formulated with high grade paintable fluid

Effective with:

ABS	Nylon	Polypropylene	PPO
Acetal	Polycarbonate	Polystyrene	Rubber
Acrylic PMMA	Polyester	Polysulfone	
Epoxy	Polyethylene	PPHOX	

Item #	Description	Quantity (Packaged 12 Cans Per Case)
113711	Economy Paintable Mold Release (12 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)
123492	Economy Paintable-50 Mold Release (9 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

E94408 (N)

Speed Mist™ is a trademark of IMS Company

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Made in the U.S.A

ECONO-CUBE™ - Paintable Mold Release

For use with the IMS ECONO-CUBE™ Spray System

Go Bulk and Save Money

- 100% nonsilicone mineral oil
- Minimal packaging disposal
- One-minute cube replacement time

Item #	Description
113133	Paintable Mold Release ECONO-CUBE™ (1quart/956 ml)

For ECONO-CUBE™ Spray Systems and Accessories — See page 154-155
For ECONO-CUBE™ - Silicone Mold Release — See page 123

ECONO-CUBE™ is a trademark of IMS Company

Made in the U.S.A

IMS Paintable Neutral Oil Mold Release

Ideal for Polyethylene and Polypropylene

Neutral Oil is for use with most plastics, but especially polyolefins. It avoids most of the environmental stress cracking and crazing caused by silicone-type lubricants.

- Formulated with mineral oil
- For molded parts to be painted, plated, printed, or ink stamped
- Recognized under the component program of Underwriters Laboratories Inc.
- **Approved for food packaging: FDA 21 CFR 178.3620**

Effective with:

ABS	Polycarbonate	Polyurethane
Acetal	Polyethylene	PPHOX
Epoxy	Polypropylene	PPO
Nylon	Polystyrene	Rubber

E94408 (N)

Item #	Description	Quantity (Packaged 12 Cans Per Case)
131393	Paintable Neutral Oil A4 Mold Release (11 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

Note: Always pre-test before using any mold release. Be sure to test it thoroughly for compatibility with your molding materials and post-molding processes like painting or plating. Check for crazing, stress cracking and marking to be sure you have selected the right mold release for your plastic.

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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IMS Paintable Organic Oil A4 Mold Release

Made in the U.S.A

Heavier Lecithin in a Low-Concentration Spray

High-viscosity, vegetable-based release forms a thin, tough layer of mold release that lasts for many cycles. Many jobs respond well to this high-viscosity lecithin. Often used for epoxy resins. Minimizes environmental stress cracking and crazing on polyethylene.

- For molded parts to be painted, plated, printed, or ink stamped
- **Approved for food packaging: FDA 21 CFR 184.1400 GRAS**

Effective with:

ABS	Nylon	Polypropylene	PPHOX
Acetal	Polycarbonate	Polystyrene	PPO
Acrylic PMMA	Polyester	Polysulfone	Rubber
Epoxy	Polyethylene	Polyurethane	

Item #	Description	Quantity (Packaged 12 Cans Per Case)
131395	Paintable Organic Oil A4 Mold Release (11 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

L-6 Paintable Lecithin Mold Release

Made in the U.S.A

Lighter Lecithin in a Medium-Concentration Spray

Thinner, oily lecithin spray provides best release for many jobs. Use where painting, plating, stamping or printing are done.

- Use where parts are to be painted, plated, printed or hot-stamped
- Fast evaporating
- Low toxicity
- **Approved for food packaging: FDA 21 CFR 184.1400, also GRAS**

Effective with:

ABS	Nylon	Polypropylene	PPHOX
Acetal	Polycarbonate	Polystyrene	PPO
Acrylic PMMA	Polyester	Polysulfone	Rubber
Epoxy	Polyethylene	Polyurethane	

Item #	Description	Quantity (Packaged 12 Cans Per Case)
131969	L-6 Paintable Lecithin Mold Release (11 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

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Made in the U.S.A

IMS Paintable Ester Spray A4 Mold Release

Water Washable, Non-Conductive Lecithin

Ester Spray is an excellent all purpose mold release. Our heaviest lecithin — also our biggest selling lecithin.

- Non-conductive
- Easily washed off with warm water or diluted detergent solution
- For molded parts to be painted, plated, printed, or ink stamped
- Highly effective for most materials
- Recognized under the component program of Underwriters Laboratories Inc.
- **Approved for food packaging: FDA 21 CFR 184.1400**

Effective with:

ABS	Epoxy	Polyethylene	Polyurethane
Acetal	Nylon	Polypropylene	PPHOX
Acrylic PMMA	Polycarbonate	Polystyrene	PPO
Alkyd	Polyester	Polysulfone	Rubber

Item #	Description	Quantity (Packaged 12 Cans Per Case)
131400	Paintable Ester Spray A4 Mold Release (11 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

E94408 (N)

Note: Use sparingly. Mold buildup may occur if applied too liberally. Remove with IMS Mold Cleaner.

Item #	Description
131397	Paintable Ester Spray A4 Mold Release (Tank) (30 lb./21 lb. fill)

Note: IMS Aerosol Tanks are not refillable and must be properly disposed of when empty.

Note: May react with aluminum. Use White 2000 Mold Cleaner ONLY with Brass Spray Gun. See page 150

For Tank Spray Systems and Accessories — see pages 150 - 157

continues on next page

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

E94408 (N)

- No flammable gases
- Nonflammable

ReleasaGen® is a registered trademark of ReleasaGen Mfg. Inc.

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IMS Paintable Dry Spray A4 Mold Release with PTFE

Made in the U.S.A

This mold release spray combines PTFE fluoropolymer resin — with its superior anti-stick properties — with a tough bonding agent formulated to keep the powder in place so its lubricating properties can be fully used.

- Inert dry powder with tough bonding agent
- High fusion point
- For molded parts to be painted, plated, printed, or ink stamped
- Useful as multi-purpose lubricant

Effective with:

ABS	Epoxy	Polyethylene	Polyurethane
Acetal	Nylon	Polypropylene	PPO
Acrylic PMMA	Polycarbonate	Polystyrene	PVC
Alkyd	Polyester	Polysulfone	Rubber

Item #	Description	Quantity (Packaged 12 Cans Per Case)
131399	Paintable Dry Spray A4 Mold Release with PTFE (10 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Made in the U.S.A

IMS Paintable Mold Release with DryFilm

DryFilm is a waxy, short-chain telomer of tetrafluoroethylene. Developed by DuPont, it shows excellent properties as a parting agent. It can be used on thermosets as well as thermoplastics.

- For molded parts to be painted, plated, printed, or ink stamped
- Fluorocarbon base
- Excellent for acrylics and other engineered materials

Effective with:

ABS	Epoxy	Polyethylene	Polyurethane
Acetal	Nylon	Polypropylene	PPO
Acrylic PMMA	Polycarbonate	Polystyrene	PVC
Alkyd	Polyester	Polysulfone	Rubber

Item #	Description	Quantity (Packaged 12 Cans Per Case)
131410	Paintable A4 Mold Release with DryFilm (10 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Made in the U.S.A

IMS Zinc Stearate Paintable Mold Release

Dry Powder — Safe for Food Industry Applications

This Zinc Stearate aerosol is an ideal applicator for a time-proven lubricant. It puts powder right where it's needed, without waste. It is long-lasting and non-marking, quick, clean and handy.

- For molded parts to be painted, plated, printed, or ink stamped
- Long lasting, non-marking
- **Approved for food packaging: FDA 21 CFR 182.5994**

Effective with:

ABS	Epoxy	Polyethylene	Polyurethane
Acetal	Nylon	Polypropylene	PPO
Acrylic PMMA	Polycarbonate	Polystyrene	PVC
Alkyd	Polyester	Polysulfone	Rubber

Item #	Description	Quantity (Packaged 12 Cans Per Case)
131398	Paintable Zinc Stearate A4 Mold Release (9¼ oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

Zinc Stearate can also be used as a material lubricant — See page 148

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Note: To clean residue, wash parts in a mild household detergent. Avoid excessive usage which could cause wear of mold pins and machine parts. Buildup can be removed with IMS Mold Cleaner.

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Please refer to imscompany.com for current pricing

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Aerosol Mold Cleaner Selection Guide

See website for pricing and economical size aerosol tanks and bulk packaging
(Review our website for the most up-to-date information on any product we sell)

	Red 2000 #118310	White 25 #176000	Formula A-P #118313	Citrus #111598	Citrus-50 #169732	SafeKlean #126674	C-Foam #168232
Evaporation	Very Fast	Very Fast	Slow but Complete	Needs to be Wiped	Needs to be Wiped	Needs to be Wiped	Needs to be Wiped
Toxicity (relative to other aerosal cleaners)	Favorable	Least Favorable	Favorable	Most Favorable	Favorable	Most Favorable	Favorable
Flammability	Extremely Flammable	**Not Flammable**	Flammable	Highly Flammable	Flammable	Flammable	Not Flammable†
Cleaning Ability	Good	Better	Good	Best	Better	Best	Better
Environmental Friendliness (relative to other aerosal cleaners)	Moderate	Least Favorable	Moderate	Favorable	Moderate	Most Favorable	Favorable
Base	Hydrocarbon	Halogenated Solvent	Hydrocarbon	Citrus	Citrus	Citrus	Citrus
Scent	Moderate Petroleum	Mild, Ether-Like	Very Mild Petroleum	Strong Orange	Mild Orange	Strong Orange	Mild Orange

† not flammable while spraying, but foam is flammable

Aerosol Rust Preventive Selection Guide

See website for pricing, as well as more economical size aerosol tanks and bulk packaging
(Review our website for the most up-to-date information on any product we sell)

	Safeseal #124644	Night Coat #142877	Clear Coat #137083	Step Two #142939	Heavy Coat #145220
Duartion	Overnight to 24 months or more	Overnight to 1 week	Overnight to 4 months or more	Up to 1 year	Up to 2 years
Indoor/Outdoor	Indoor	Indoor	Indoor	Indoor/Outdoor	Indoor/Outdoor
Deposited Product Texture	Buttery / Gel	Very Light Oil	Petroleum Jelly	Light Wax	Heavy Wax
Removal	Removed w/startup shots - if applied heavily, might need to wipe first	Removed w/startup shots - if applied heavily, might need to wipe first	Removed w/startup shots - if applied heavily, might need to wipe first	Solvent Required to Remove	Solvent Required to Remove
Penetrates – Runs	No	Yes	No	No	No
Neutralizes Acid	No	Yes	No	No	No
Displaces Moisture	Yes	Yes	Yes	No	No
Toxicity to Operator (relative to other aerosal rust preventatives)	Favorable	Average	Better Than Average	Average	Average

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Made in the U.S.A

NEW IMS Nonflammable White 25 Mold Cleaner

Our Best Heavy Duty Solvent For Use at The Press

White 25 is a heavy duty, **nonflammable**, solvent offering excellent cleaning properties and **extremely fast evaporation**.

- Powerful Cleaner & Degreaser
- Removes: Silicone, Oils, Waxes, Inks, Lubricants
- Leaves no film behind to interfere with molding
- Non-Chlorinated
- Does Not Contain Ozone Depleting Propellants
- Does Not Contain Trichloroethylene

Cleans Without Wiping

Item #	Description	Quantity (Packaged 12 Cans Per Case)
176000	Nonflammable White 25 Mold Cleaner (14 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Made in the U.S.A

IMS Nonflammable White 2000 Mold Cleaner

Our Best Heavy Duty Solvent For Use at The Press

IMS White 2000 Mold Cleaner is a heavy duty, nonflammable, chlorinated solvent offering excellent cleaning properties and very fast evaporation.

Cleans Without Wiping

Referred to as a power wash in a can.

This item is discontinued - See White 25 or Red 2000 for replacement

Item #	Description	Quantity (Packaged 12 Cans Per Case)
118308	Nonflammable White 2000 Mold Cleaner (16 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

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IMS Red 2000 Mold Cleaner

Low-Toxicity For The Tooling Maintenance Area

Made in the U.S.A

Hydrocarbon-based Red 2000 Mold Cleaner provides very good solvent properties, very fast evaporation and moderate toxicity.

- Low cost
- Moderate toxicity
- Cleans with little or no wiping
- Fastest evaporation

Item #	Description	Quantity (Packaged 12 Cans Per Case)
118310	Red 2000 Mold Cleaner (10 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

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Made in the U.S.A

Citrus Spray Mold Cleaner

A Natural, Biodegradable Degreaser

IMS Citrus Spray is a pure, all-natural cleaner with good solvent ability, a natural orange scent and low toxicity. It contains no water and no detergents.

- **FDA rated GRAS — 21 CFR 182.60**
- Cleans with minimal wiping, saves labor time
- Accepted for electrical and electronics cleaning
- Non-conductive to 43,000 volts

Item #	Description	Quantity (Packaged 12 Cans Per Case)
111598	Biodegradable Citrus Spray Mold Cleaner (12 oz. fill)	1-71
		72-143 (save 5%)
		144 or more (save 10%)

NOTE: Citrus cleaner pricing is directly affected by citrus fruit-crop conditions in Florida and Brazil

Item #	Description
	Citrus Mold Cleaner (Bulk)
112075	(1-gal. can)
112082	(5-gal. can)
112083	(55-gal. drum)

IMS Citrus-50 PLUS is a unique blend of our proven, natural citrus solvent and an FDA grade petroleum-based solvent.

- **NOW FDA rated 21 CFR 172.884 and 178.3650**
- Takes advantage of the synergy of two different solvent types
- Helps avoid the price fluctuations that can be found in pure citrus cleaners
- Cleans with minimal wiping, saves labor time

Item #	Description	Quantity (Packaged 12 Cans Per Case)
169732	Citrus-50 PLUS Mold Cleaner (12 oz. fill)	1-71
		72-143 (save 5%)
		144+ (save 10%)

- Low flammability

www.imscompany.com
phone order toll-free (USA & Canada) 1.800.537.5375
fax order toll-free (USA & Canada) 1.888.288.6900
phone order toll-free (Mexico) 001.888.304.1307
tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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IMS SafeKlean™ Mold Cleaner

A Natural, Biodegradable Degreaser

Made in the U.S.A

- **FDA rated GRAS — 21 CFR 182.60**
- Cleans with minimal wiping, saves labor time
- Accepted for electrical and electronics cleaning
- Non-conductive to 43,000 volts

Packaged with a 2-way spray nozzle and optional tube

Most Environmentally Friendly Mold Cleaner!

Item #	Description	Quantity (Packaged 12 Cans Per Case)
126674	SafeKlean™ Mold Cleaner (Less Flammable Citrus Cleaner) (12 oz. fill)	1-71
		72-143 (save 5%)
		144 or more (save 10%)

NOTE: Citrus cleaner pricing is directly affected by citrus fruit-crop conditions in Florida and Brazil

IMS All-Purpose Formula A-P Mold Cleaner

A Low Cost, Worker-Friendly Cleaner

Made in the U.S.A

Formula A-P Mold Cleaner is a hydrocarbon-based solvent offering low toxicity, moderate flammability, moderate evaporation and good solvent properties.

- **FDA rated GRAS — 21 CFR 172.884; 178.3650**
- Ideal for warm molds
- Cleans with little or no wiping
- Leaves little residue

Our Safest Cleaner!

Item #	Description	Quantity (Packaged 12 Cans Per Case)
118313	All-Purpose Formula A-P Mold Cleaner (10 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

Item #	Description
	Formula A-P Mold Cleaner (Bulk)
119888	(1-gal. can)
119882	(5-gal. can)
119884	(55-gal. drum)

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Made in the U.S.A

IMS C-FOAM Foaming Citrus Mold Cleaner

Strong Cleaning From a Drip-Resistant Foam

Aggressive foam stays in place longer to clean better.

- Biodegradable
- Not flammable as sprayed
- Low toxicity
- Low VOC / No California Prop 65

Item #	Description	Quantity (Packaged 12 Cans Per Case)
168232	C-FOAM Foaming Citrus Mold Cleaner (16 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)

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e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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IMS SAFESEAL™ Premium Tool Steel Protectant

For Short or Long Term Mold Storage (12 Months or More)

Made in the U.S.A

Can be used on molds up to 350°F (speeds change-over time)

- Quick, easy removal saves money.
- Foaming/spreading action ensures coverage of even the smallest, hidden areas (One 11 oz. can will cover approximately 31 sq. ft. when applied between .01" and .015" thickness.)
- Grass green color lets you see when the mold is covered — and when it's clear.

SAFESEAL™ is a unique blending of a polymer into a vegetable-based oil to provide long lasting, heavy duty rust prevention in a non-toxic formula. It protects the most finely polished mold finishes, preventing downtime and mold refinishing expenses.

SAFESEAL'S green coloring lets workers see what surfaces are covered and what aren't. Nothing gets missed or over sprayed. SAFESEAL'S foaming action helps spread the material evenly - for total protection.

The base material in SAFESEAL™ is safe for application at temperatures as high as 350˚F, so the mold does not have to be cooled before application (when there are no sources of ignition present.) Mold changeovers are quicker and more profitable.

SAFESEAL™ is easily removed without solvents - simply wipe with dry paper towels or cloths, then allow the startup shots to finish the job - saving money in downtime and mold cleaner expense.

Item #	Description	Quantity (Packaged 12 Cans Per Case)
124644	SAFESEAL™ Premium Tool Steel Protectant (11 oz. fill)	1-71
		72-143 (save 5%)

Reduces Usage

- Formula is compatible with all common old steels and polymers
- Meets or exceeds 72 hour ASTM B-117 specifications for corrosion protection

The Best Steel Protector – Only From IMS

SAFESEAL™ is a trademark of DeNOVUS

CLEAR COAT³ Rust Preventive Spray

For Overnight and Short-Term Use — Tested at More Than 4 Months*

Made in the U.S.A

- Forms a clear barrier against rust
- Chemically prevents rust*
- Displaces moisture**
- Developed for Injection Molds. Great for any metal surface.
- "Dry" — does not penetrate into pins and bushings. Won't bleed out.
- Stays soft and buttery — does not get waxy.
- Easily removed by wiping or startup shots.

There's nothing else like it!

No Chlorinated Solvents • No TCE • Low Oder • Low Cost

Item #	Description	Quantity (Packaged 12 Cans Per Case)
137083	Clear Coat3 Rust Preventive Spray (11 oz. fill)	1-71
		72-143 (save 5%)

* Tested to ASTM D-1748 Rust Prevention specs
** Tested to Mil-C-16173E Fingerprint Suppression specs

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Made in the U.S.A

IMS Night Coat™ Rust Preventive and Acid Neutralizer

Stops Corrosion During Short or Long-Term Shut-Downs

IMS Night Coat is Excellent:

1) As an overnight or short-term rust preventive

Just spray it on at shut-down. Penetrates and quickly wets out across the mold, displacing moisture and neutralizing acid from fingertip perspiration. Easily removed by start-up shots or with standard solvent

2) As an acid-neutralizing surface preparation for longer-term rust preventives

(A must when molding PVC or CPVC, where out-gassed hydrochloric gas combines with moisture to create corrosive hydrochloric acid.)

Just spray it on and wipe away any puddles. Then apply IMS Step 2 Heavy Coat or any other longer-term protector

Item #	Description	Quantity (Packaged 12 Cans Per Case)
142877	Night Coat Rust Preventive and Acid Neutralizer (10 oz. fill)	1-71
		72-143 (save 5%)

Bilingual Label
(English & Spanish)

- Helps protect and preserve the value of your molds
- Helps reduce downtime and mold maintenance costs
- Helps decrease your costs and inventory of mold care products

Night Coat™ is a trademark of IMS Company

Made in the U.S.A

IMS Step Two Rust Stopper

Part of a Two-Step Process for Mold Surface Protection for PVC and CPVC Molding

Use our Two-Step System to protect even the most highly polished tooling when you process PVC or CPVC.

1) The first step is to clean the mold with IMS Night Coat. Wipe up any puddles.

2) Next apply Improved IMS Step Two to chemically prevent rust and provide a tough barrier against future exposure to moisture and acid.

Improved Step Two is also a great, general-purpose rust preventive for indoor or outdoor mold storage.

Item #	Description	Quantity (Packaged 12 Cans Per Case)
142939	Step Two Rust Stopper (11 oz. fill)	1-71
		72-143 (save 5%)

Bilingual Label
(English & Spanish)

Now an even better Rust Stopper

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phone order toll-free (Mexico) 001.888.304.1307
tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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IMS Heavy Coat Mold Surface Protector

Made in the U.S.A

For Long-Term Mold Storage – Indoors or Outdoors

- Leaves a heavy, waxy coating plus chemical rust preventives
- Easily removed with any IMS mold cleaner

Item #	Description	Quantity (Packaged 12 Cans Per Case)
145220	Heavy Coat Mold Surface Protector (11 oz. fill)	1-71
		72-143 (save 5%)

Want even better assurance of maximum protection? Before applying Heavy Coat, pre-treat the steel with Night Coat #142877 (page 138) to displace moisture and neutralize acids.

Bilingual Label
(English & Spanish)

Improved by latest chemical technology

Replaces #111547

IMS Foaming Mold Water Passage Rust Inhibitor and Cleaner

Made in the U.S.A

Mold water passage rust preventive and cleaner

Protect water passages during mold storage. Reusable hose, clamp, and fitting sold separately.

- Displaces moisture from mold passages
- Prevents rust
- Easily dissolved into water system at start-up

Item #	Description	Quantity (Packaged 12 Cans Per Case)
103776	Foaming Mold Water Passage Rust Inhibitor and Cleaner (16 oz. fill)	1-71
		72-143 (save 5%)
		144-863 (save 10%)
Optional Accessory		
101549	1' hose, ¼" N.P.T. fitting and clamp	

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Reusable hose, clamp and fitting sold separately as item #101549

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Made in the U.S.A

Old Purple® Mold Polish

3rd Generation Formula — The Best Yet

An Essential Molding Shop Accessory!

- Cleans Tough Jobs - Doesn't Scratch
- Polishes mold hang-up areas and reduces the need for mold release
- Quickly cleans stubborn mold stains
- Easily removes burn deposits without scratching fine mold finishes
- Dries Faster For Easier Removal

Old Purple™ is a registered trademark of IMS Company

Item #	Description
149045	Old Purple® — 16 oz. plastic squeeze bottle

GREEN Products

Wiping & Polishing Rags

For General Molding Shop Use

Perfect for Cleaning and Polishing Presses, Tools, etc

- Made of recycled cotton material
- Super soft
- Washable
- Low lint
- Mixed colors and sizes

See Page 420 for More Information

Take advantage of quantity breaks to lower your cost!

Punchout Hole (perforated) for easy rag removal

Carton Clips sold separately

149055

Carton Clips

Many Molding Shop Uses

Great For Holding Gaylord Liners in Place – See Page 420 For More Information

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Please refer to imscompany.com for current pricing

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Advanced Mold Polishing Diamond Compounds

Made in the U.S.A

Oil Soluble Type

IMS brings you the very best synthetic diamond compound to produce the best results. All IMS diamond compounds provide the best polish in the least time required in polishing.

IMS diamond compounds are excellent for molds, but also work great for die and tool polishing, initial charging of lapping plates and discs, polishing to final tolerance of ceramic parts, various tool-room use, and other processes that require high finish as well as close tolerance performance.

IMS Diamond Compound Advantages:

- Monocrystalline-type structure has a strong cubo-octahedral shape with pronounced multiple cutting edges.
- Resistant to breakdown or "frying" at high temperatures. If frying does occur, the crystal is fracture controlled to produce more cutting edges.
- Extremely efficient metal bond retention.
- Oil soluble carrier indefinitely suspends diamond particles uniformly without separating, provides the fastest polishing time.
- Non-toxic, easy to use and easy to clean.
- Impervious to contaminants on lapping surface.
- Withstands pressure and temperature during application.
- Sold in Syringe applicators to pinpoint areas to apply compound, eliminates contamination, and reduce wasteful overuse.
- Medium diamond concentrations for optimum polishing and value.

These oil-soluble compounds are effective on most applications; water-soluble versions are also available. Larger containers are also available. Call today for more information.

5 Gram

18 Gram

Recommended for:	US Bureau of Standards Micron Size	Micron Size Range	Mesh Size Equivalent	Color Code	5 Gram Syringe	18 Gram Syringe
Ultra Fine Finish	1	0 - 2	14,000	Ivory	120784	120793
Super Fine Finish	3	2 - 4	8,000	Yellow	120807	120781
	6	4 - 8	3,000	Orange	120796	120800
	9	6 - 12	1,800	Green	120782	120792
Fine Finish/ Prep-Lapping	15	10 - 12	1,200	Blue	120778	120787
	30	20 - 40	575	Red	120804	120809
Aggressive Removal/ Roughing	45	30 - 60	400	Brown	120798	120806
	60	50 - 70	270	Purple	120790	120797
Compound Kits - Save 10%	One Each of Above				120852	120847

Optional Accessories

Item #	Description	Diameter	Head Length	Shank Diameter	Bristle Texture
120758	Felt Polishing Bob	1"	1"	¼"	Soft
120755	Felt Polishing Bob	¾"	¾"	⅛"	Hard
120759	Felt Polishing Bob	¼"	¼"	⅛"	Medium
120786	Cup Polishing Brush	1"	17/32"	⅛"	Hard
120780	Cup Polishing Brush	½"	5/16"	3/32"	Hard

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Autosol® Metal and Mold Care

- German Engineered / Professional Grade Quality
- Award Winning / Tried and Tested / Renowned car makers trust Autosol® products
- Many products promise results, but end up disappointing. Autosol® delivers on all its claims
- More than 80 years of producing metal care products
- Stop wasting time and money on substandard metal care items. Don't risk using cheap inferior products on your expensive molds, choose the product with the Guarantee*, choose Autosol® from IMS.

Autosol® Mold/Metal Polish (Rated NSF A7)

For all Ferrous metal surface types. cleans and removes plastic build up, dirt, and surface rust. Provides a brilliant high gloss finish.

Item #	Description
165794	Tube 2.5 oz (75 ml)

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Please refer to imscompany.com for current pricing

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Autosol® Metal and Mold Care

- German Engineered / Professional Grade Quality
- Award Winning / Tried and Tested / Renowned car makers trust Autosol® products
- Many products promise results, but end up disappointing. Autosol® delivers on all its claims
- More than 80 years of producing metal care products
- Stop wasting time and money on substandard metal care items. Don't risk using cheap inferior products on your expensive molds, choose the product with the Guarantee*, choose Autosol® from IMS.

Autosol® Liquid Metal Polish

Ideal for brass and copper alloys - contains no ammonia. Cleans and removes plastic build up, dirt, and corrosion. Provides a brilliant high gloss finish.

Item #	Description
165802	Bottle 8.4 oz (250 ml)

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Made in the U.S.A

Check Out These Other Useful IMS Products!

GREEN Products

IMS Lime Buster III™ Water-Passage Descaler

Keeps Mold Productivity Up And Press Operating Costs Down!

The Problem:

Water circulators provide mold temperature control, but water can leave deposits that insulate the mold from the circulating water; as little as 1/64" can reduce heat transfer 40%. Full temperature change takes longer. Cycle times and electricity use go up as part quality goes down.

The Solution:

The IMS Lime Buster circulates a mild acid through your mold water passages, dissolving mineral deposits and flushing them away. Circulating water can then have direct contact with the metal in the mold, restoring heat transfer. You'll see shorter cycles and better parts.

See Page 759 - 763 For More Information

Sealants

Keep fasteners and pipe joints tight! Help prevent costly down time!

Pipe Thread Sealant Compound

- Contains PTFE
- Non-hardening
- Non-toxic
- Positive seal
- Prevents corrosion
- Withstands hydraulic pressures up to 10,000 psi

Thread Sealant Tape with PTFE

- Mil-Spec # MIL-T-27730A
- Meets USDA and FDA requirements
- Seals against gas, air, oil and water
- Resists chemicals, corrosives, caustics and solvents
- Prevents leakage
- Resists high heat
- Seals effectively in 2 or 3 wraps
- Withstands hydraulic pressures up to 10,000 psi

See 397 for Specifications and Pricing

IMS Paintable Ejector Pin Lube L T

Made For Use on Knock-Out Pins in Forward Position

Made in the U.S.A

IMS Paintable Ejector Pin Lube LT is a clean, paintable, load-bearing lubricant designed for spraying on close-fitting knockout pins. The lubricant produces minimal part marking, won't bleed out and can be used in a -65°F to +350°F temperature range.

Item #	Description
140171	Paintable Ejector Pin Lube LT (9¼" oz. fill)

No Chlorinated Solvents

IMS White Lithium Lubricant Spray

Ideal For Injection Molds and Most Other Industrial Applications

Made in the U.S.A

- Sprays Like a Fluid – to Penetrate Into Tight Passages
- Thickens Into Grease – to Lubricate
- Medium-bodied Grease
- Moisture Proof, and Resists Most Chemicals and Acids
- Long Lasting – Resists Wiping Off
- For Slides, Stripper Plates, Cams and Guide Pin Bushings
- Minimizes Galling
- Resists Heat to 275˚F
- Useful at Temps as cold as -10˚F

Specifications	
NLGI Number:	1
Worked Penetration Range @ 77˚F:	310/340
ASTM Dropping Point:	380˚F
Mineral Oil Viscosity (SUS @ 100˚F):	750
(CSt @ 40˚C):	135

Item #	Description
145221	White Lithium Lubricant Spray (11 oz. fill)

Replaces #127364

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Made in the U.S.A

Original Formula® Mold Grease

Long Lasting Lubricant with PTFE — Good to 500° F

Forms an adherent, but slippery film. Won't wipe off through tight bushings.

- Superior strength and load bearing ability
- Superior lubricity -40°F to +500°F
- Waterproof
- Anticorrosive
- Non-melting
- Non-silicone
- NSF listed

The Original and Still the Best!™

NSF

Item #	Container	Net Weight
107320	2 oz. jar	2 oz. (57 g)
107439	14 oz. cartridge	14 oz. (397 g)
105998	16 oz. jar	1 lb. (454 g)
107526	1-gal. pail	8 lbs. (3.63 kg)
107433	5-gal. pail	42 lbs. (19 kg)

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Please refer to imscompany.com for current pricing

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WD-40® The Original Multipurpose Spray

Use on Molds, Machinery and All Around Your Shop

- Frees rusted metal parts
- Provides positive rust protection
- Non conductive
- 50-state VOC Compliant

Specifications	
Appearance:	Clear or slightly cloudy
Color:	Light amber
Odor:	Mild Petroleum Odor
Flash Point:	110° F open cup (min.)
Boiling Point:	300° F (min.)

Bulk Liquid

Item #	Description
105341	WD-40® (1-gal. container)

Aerosol Spray with Smart Straw™

- Never lose another nozzle extension tube
- Smart Straw permanently attached
- 50-state VOC Compliant

Item #	Description
137084	WD-40® (12 oz. spray)

Smart Straw™ are a trademarks of WD-40 Company WD-40® is a registered trademark of WD-40 Company

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Zinc Stearate Material Lubricant

Zinc Stearate is an internal lubricant for thermoplastic resins (especially styrenes) to ease material passage through the barrel.

- Often eliminates the need for mold release agents — acts as a paintable mold release
- Often improves cycle time
- Melt Point: 249.8°F

Item #	
104464	Zinc Stearate Bulk Plastic Lubricant (25-lb. bag)

Acrawax® C Material Lubricant

Acrawax® C Material Lubricant is an excellent internal lubricant for Nylon, PVC and Polyurethane. When properly proportioned*, Acrawax® C often:

- Improves color dispersion
- Speeds machine cycle times
- Eliminates the need for mold release agents
- Imparts antistatic properties to molded parts
- Melt Point: 285.8° F

* Typically .25% to 5.00% by weight.
With Nylon and PVC, .25% to 3.00% by weight.
With Polyurethane .40% by weight.

Often reduces static problems and color separation in the hopper and material feed system.

104460

Item #	
104460	Acrawax® C Material Lubricant (50-lb. bag - powdered form)
127431	Acrawax® C Material Lubricant (50-lb. bag - pellet form)

Plastic Resin Scoops

#132787

#132788

#146497

Item #	Size	Style	Color
132787	32 oz	Flat Bottom	White
132788	82 oz.		
146497	128 oz.		

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e-mail sales@imscompany.com

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IMS Spray Can Holders

Hold Cans Securely Within Reach but Not in the Way

- Stop fumbling for cans
- Help reduce valve breakage
- Dress up your presses
- Mount on walls, injection presses, cabinets, etc.
- Pay for themselves many times over!

Heavy Duty Stainless Steel Can Holder

Item No. 100588

Multi-Can Holder

- Two pre-drilled holes for easy mounting
- Generally large enough for most 12 oz., 16 oz. or 20 oz. cans
- Steel holder with powder-coated finish

Item No. 123490

Sprays (shown) sold separately

Spray Can Handle

Turns Spray Cans Into Spray Guns!

Made in the U.S.A

There Is Only One CAN-GUN®

- It's a Quick Snap On/Off
- Eliminates painful finger fatigue
- Provides accurate and comfortable spray control
- Color: Black
- Made of: Recycled Plastic
- Weight: Less than 1 oz.

Item No. 135048

Firmly snaps on most spray cans

Exclusize V-Notch™
Locking Nose Piece

Photo shows Can-Gun® attached to can of IMS Red 2000 Mold Cleaner

Patented Arthritis-Friendly Design

MEMBER TESTED AND RECOMMENDED HANDYMAN

CAN-GUN® and V-Notch™ are trademarks of SafeWorld International, Inc.

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IMS Spray Gun

Designed expressly for use with Aerosol Tanks or cylinders

Lightweight • Fast Acting • Changeable Valves

- Accepts any standard, 1" uncrimped aerosol valve. Lets you control discharge rate.
- Lets you choose the spray valve best suited to your application.

PATENT No. 3,592,390

Item #	Description
100650	Brass Spray Gun Assembly includes 167910 Spray Valve
100554	Brass Spray Gun Assembly with 8' Hose & Fittings and 167910 Spray Valve
100509	Brass Spray Gun Assembly with 12' Hose & Fittings and 167910 Spray Valve
Brass spray guns are required for products with chlorinated solvents such as IMS White 2000 and in IMS A4-series Mold Release Tanks. They can be used with any aerosol tank.	
100662	Aluminum Spray Gun Assembly includes 167911 Spray Valve
100565	Aluminum Spray Gun Assembly with 8' Hose & Fittings and 167911 Spray Valve
100520	Aluminum Spray Gun Assembly with 12' Hose & Fittings and 167911 Spray Valve

Aluminum Spray Gun Assembly

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Accessories and Replacement Parts

Item #	Description
170084	Magnetic Spray Gun Holder for use with IMS Aerosol Tank Spray Guns
100597	Threaded, Aluminum Gun Cap
100641	Threaded, Aluminum Gun Body
100606	O-Ring Gun Gasket
167911	Medium Spray Valve (Standard)
167909	Medium Spray Valve
167910	Coarse Spray Valve
100590	8-ft. Hose with Fittings
100587	12-ft. Hose with Fittings

Any length hose to special order

170084

Spray Valve
#167911 shown

Cap O-Ring Body

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fax order toll-free (USA & Canada) 1.888.288.6900
phone order toll-free (Mexico) 001.888.304.1307
tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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SURE SHOT® Refillable Compressed Air Sprayers

GREEN Products

Now Less Expensive And Lighter Weight Than The Old Model

- Easier to buy and easier to use
- Save money; help save the environment
- Eliminate can, propellant, labeling and packaging costs of throw-away aerosols
- Take full advantage of lower-cost bulk material
- For Mold Releases, Mold Cleaners and Rust Preventives*
- Heavy Duty, 16-oz. Aluminum Canister with Electroless-Nickel Plating Inside and Out — includes Interchangeable Valves and Nozzles

Compressed Air Sprayer Assembly

Safe for most non-acidic industrial chemicals

Item No. 142862

Contains: 16 oz. Electroless-Nickel Plated Aluminum Sprayer with Brushed Finish/Chrome-Plated Brass Valve Body

(2) General-Purpose Spray Valves with Dip Tube Includes Viton O-Ring #110455

(2) General-Purpose Regular Spray Nozzles

(1) Pin-Stream Nozzle with 6" Snorkel Tube

(5 each) Labels and Clear Label Covers

— Nozzles, Valves and O-Rings —	
109736	General-Purpose Valves (pkg. of 6) Does not include #110455 O-Ring
108626	General-Purpose Regular Spray Nozzles (pkg. of 6)
108630	Pin-Stream Nozzles with 6" Snorkel Tube (pkg. of 6)
110455	Viton® O-Ring for General Purpose Spray Valve (1)
108628	Fine-Mist Nozzles (pkg. of 6)

Other size canisters and different styles are available — Inquire

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

*Note: Thicker solutions may need to be diluted for proper operation.

Viton® is a registered trademark of E. I. du Pont de Nemours and Company or its affiliates
SURE SHOT® is a registered trademark of Milwaukee Sprayer Mfg. Co., Inc.

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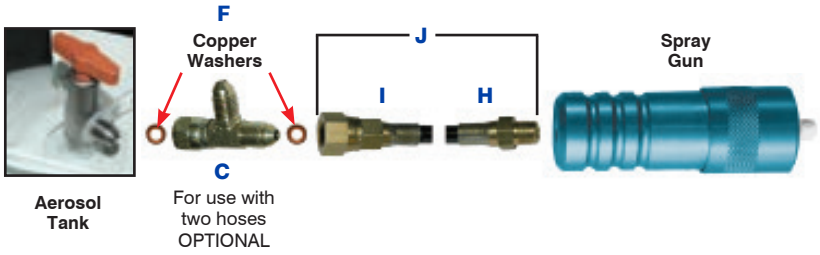
Aerosol Tank Setup Hardware

3 Ways to Use!

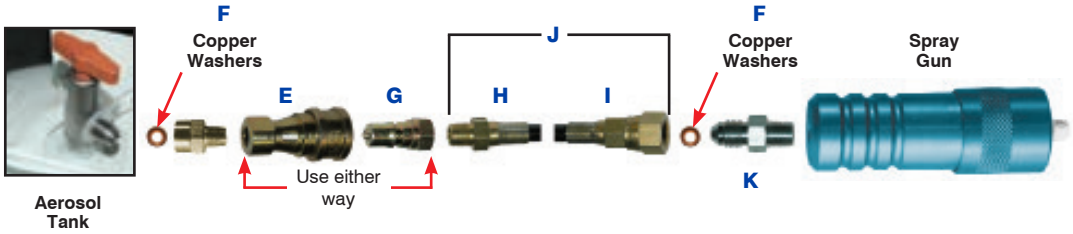
Speed Bulk Tank Changes

1 Standard hook-up to IMS Spray Gun for manual spraying



For Spray Guns see page 150

2 Quick disconnect hook-up to IMS Spray Gun for manual spraying



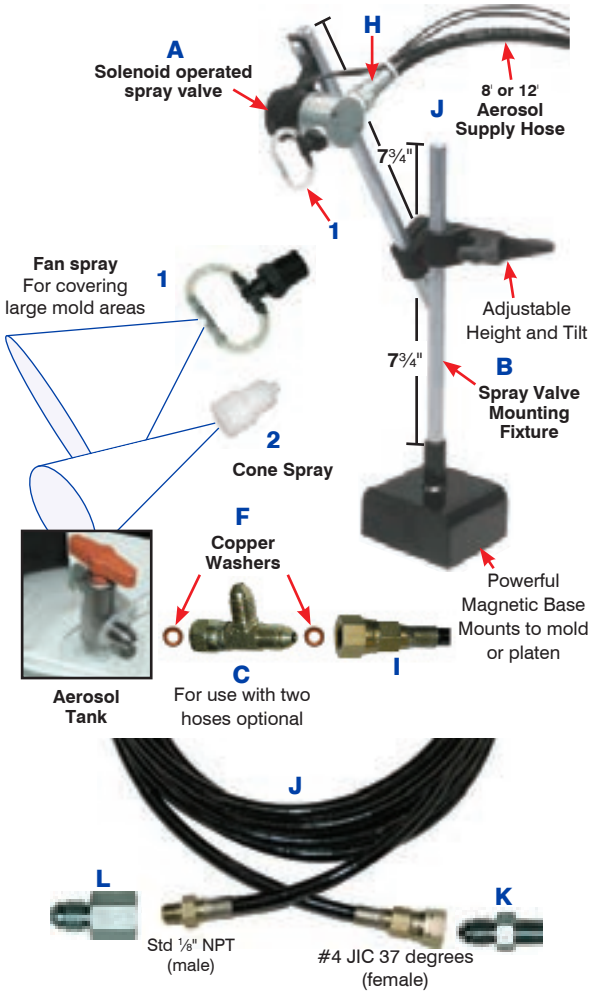
3 Mountable hook-up to Solenoid Operated Spray Valve for automatic spraying (using IMS Spray Controller)

Item #	Description
Spray Valve and Nozzle	
A 112160	Solenoid Operated Spray Valve
1 114706	Swivel Loop, Fan Spray Nozzle
2 114707	Cone Spray Nozzle
Spray Assembly Mounting Fixture	
B 114343	Adjustable Spray Valve Mounting Fixture
Aerosol Tank End Fittings & Hose	
C 100625	Optional "T" Connector for Attaching two hoses
D 100612	Spray Gun Adapter, Quick Connect, Adapts 1/4" Female Flare To 1/8" NPT Male
E 163302	Quick Disconnect Coupler
F 100605	Copper Flare Washers, use with C & D
Hose to Spray Gun End	
G 163307	Quick Disconnect Nipple for use with E
H 100646	1/8" Male NPT Thd Hose Crimp Fitting
I 100636	#4 Female JIC 37° Thd Hose Crimp Fitting
J 100590	8' Aerosol Supply Hose Assembly with Fittings
100587	12' Aerosol Supply Hose Assembly with Fittings
Coupler & Hose Extension Adaptors	
K 142859	JIC Male Adaptor 1/8" NPT x 7/16" JIC 37 Deg
L 142860	JIC Female Adaptor 1/8" NPT x 7/16" JIC 37 Deg

Note

Adaptors (**K**) and (**L**) can be used to connect multiple hoses for larger lengths. Use with copper washer (**F**).

Two Spray Nozzles Suit Most Applications



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Spray/Robot Controller for Aerosol Tanks

Allows Faster, More Consistent and Safer Mold Release Application

Based on Fully Programmable PLC Technology

Automate for Smooth, Consistent Coverage

Cycle Count
24VDC output to dry contact on the press for "mold open"

Spray Start
24 VDC output to spray solenoid

Sweep Start
24 VDC output to robot

Displayed Parameters	
Cycle count	(0 to 9999)*
Cycles per robot	(0 to 9999)*
Robot per spray	(0 to 9999)*
Spray delay	(0 to 999.9 Seconds)*
Spray time	(0 to 999.9 Seconds)*
Robot delay	(0 to 999.9 Seconds)*

(*denotes user-selectable values)

Unit Price

Item No. 173243

Complete with three, 10 foot pigtails with female Jones Plugs.

Electrical Requirements: 115 VAC

Dimensions: 8"H x 10"W x 6"D

Weight: (Boxed) 18½ lbs.
(Unboxed) 16 lbs.

Available Only from IMS!

IMS can also customize this controller to more specific applications — Inquire

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GREEN Products

IMS Select ECONO-CUBE™ Mold Release Spray-System

Helps You Beat the Ever-Increasing Costs and Regulations of Aerosols

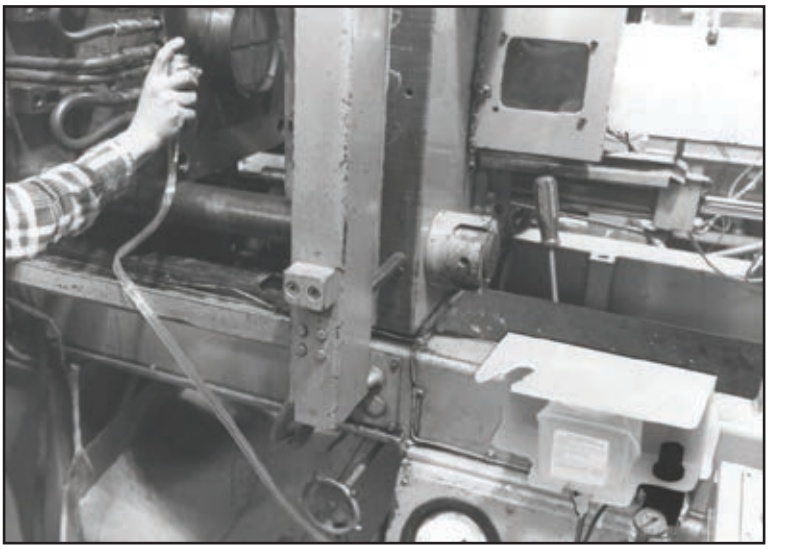
Environmentally safer
Compressed-air operated — no questionable chemicals

Effective
High-tech spray gun provides smooth, consistent mold release application

Convenient
Entire assembly mounts directly on or near press

Economical
Unique ECONO-CUBES™ eliminate can and propellant costs

Go Bulk to Save Money



Mounted within operator reach, the ECONO-CUBE™ Spray System is easy to use and gives excellent mold-release coverage.

Lets You Apply Mold Release Without CFC's or Cans!

The IMS ECONO-CUBE™ Spray System uses only inexpensive bulk mold release and compressed air. That saves you the expense and inconvenience of aerosol cans, solvents and propellants.

You get the most even and finely atomized bulk spray available — almost as good as aerosol cans.

The ECONO-CUBE™ spray gun mounts conveniently at the press, on a rugged, easy to install, polypropylene holder. Connect the air, install the ECONO-CUBE™ and you're ready to spray. Total changeover time is about one minute.

And using the ECONO-CUBE™ is even easier. Slide the spray gun off the holder, spray the mold, and slide the spray gun back onto the holder.

The ECONO-CUBE™ gives you maximum mold coverage with minimum use of material.

EPA Regulations and the ECONO-CUBE™

Continuing changes in aerosol regulations have made the ECONO-CUBE™ the best choice for applications where non-flammability and worker exposure are critical issues.

The ECONO-CUBE™ eliminates the headaches of EPA regulations and questionable chemicals altogether because it uses only bulk mold release and compressed air. Highly economical, effective and convenient, the ECONO-CUBE™ is a smart choice.

Each ECONO-CUBE™ contains as much mold release as 88, 12 oz. aerosol cans!

Sprays only air & mold release – No CFC's

ECONO-CUBE™ is a Trademark of IMS Company

IMS Company

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IMS Select ECONO-CUBE™ Mold Release Spray-System

Excellent for Die Casters or Investment Casting

Compact combination cube base/gun holder
Mounts anywhere on or near press
(welded polypropylene construction)

Easy Pressure Adjustment gives you full control of spray

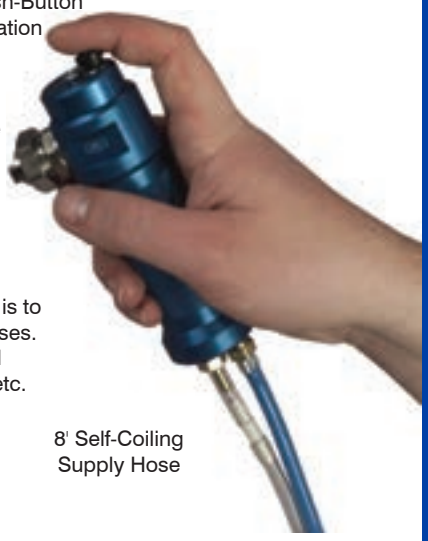
Quick-Change ECONO-CUBE™
Provides a long lasting, continuous supply of mold release

Air Filter/Regulator provides clean, dry air

Unique Aluminum Spray Gun

Easy, Push-Button Operation

Interchangeable High and Low Volume Spray Nozzle options



Note: This unique atomizer is to be used only for mold releases. Not recommended for mold cleaners, rust preventives, etc.

8' Self-Coiling Supply Hose

Note: Pure mold release spray is hard to see, unlike an aerosol where you can see the carrier. Test-spray on a smooth surface to determine coverage.

Standard Spray Gun Assembly Item #111971
Includes: Aluminum Spray Gun with Fan-Spray Nozzle, 8' Air/Fluid Supply Hose, Base/Holder, Filter/Regulator and Fluid Connector
Low Volume Spray Gun Assembly Item #116364
Same as above but with #112931 Low Volume Round-Spray Nozzle
High Volume Spray Gun Assembly Item #118906
Same as above but with #112947 High Volume Fan-Spray Nozzle
Optional Spray Nozzles **Low Volume Spray Nozzle Kit** Item #112931
Includes: #112878 Fluid Cap and #112877 Air Cap
High Volume Spray Nozzle Kit Item #112947
Includes: #112876 Fluid Cap and #112872 Air Cap

Air Pressure: 30-100 psi
Gun Body: Anodized, 6061 Aluminum
Spray Nozzle: Nickel-Plated Brass
Cartridge Valve: Brass with Buna-N Seals
Hose: Coiled, Clear PVC (8' uncoiled)
Holder: Welded Polypropylene

Specially Priced Kits Include:

- A Cube of Specified Mold Release (Silicone or Paintable).
- Aluminum Spray Gun with Eight Foot Air/Fluid Supply Hose, Base/Holder, Filter/Regulator and Fluid Connector.
- Fan-Spray Nozzle.

111983	Silicone Kit
116369	Silicone Mist Kit
111969	Paintable Kit
Refills (1 quart/956 ml)	
111967	Silicone
115348	Silicone Mist
113133	Paintable

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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GREEN Products

IMS Select Automatic Bulk Spray System

Specially Designed for Use With Less Expensive Bulk Mold Releases

Automatic Programmed Spraying

Helps Maintain Consistent Cycle Times

The IMS Bulk Mold Release Spray System conveniently automates mold release applications using bulk materials. It quickly pays for itself in reduced operating and material costs.

Compressed air pressurizes the material tank and feeds the bulk mold release to the spray gun. Another compressed air line to the spray gun atomizes the fluid. PLC-controlled solenoids precisely control the flow of fluid and air to produce a finely-divided spray when it is needed and for as long as it's needed.

Settings include Sweep Delay, Spray Delay and Spray Time. A built-in delay shuts off the fluid slightly before air-shutoff to avoid drooling.

Two spray guns can be used with each controller.

Three spray head options are available to achieve different spray patterns. The cart sits on four lockable swivel casters for easy mobility and easy placement close to the press.

Environmentally-Friendly and Cost Effective

Selecting a bulk product presents financial, safety, environmental, training and regulatory advantages.

- Helps eliminate (Volatile Organic Compounds) VOCs
- Helps meet environmental regulation requirements

Spray Cart and Controller

Item #121983

Bulk Mold Release Spray System with bulk spray cart, single-press PLC-Type controller and instructions (spray gun not included). One required for every press that will have automatic spray control.

The Bulk Mold Release Spray System comes pre-assembled for easy installation and can be customized for your specific needs. Contact the IMS Supplies Team for additional details.

Save Money – Uses Bulk Releases & Compressed Air

Specifications

Compressed Air Requirements: 80-100 psi

Electrical Requirements (controller only): 2A at 115 VAC/60/1

Output: 2 A at 24 VDC

Dimensions: (controller only) 8"h x 10"w x 6"d
(entire assembly) 50"h x 19½"w x 21½"d

Weight: Controller: 16 lbs., 18½ lbs. boxed
Cart: 48 lbs., 59 lbs. boxed

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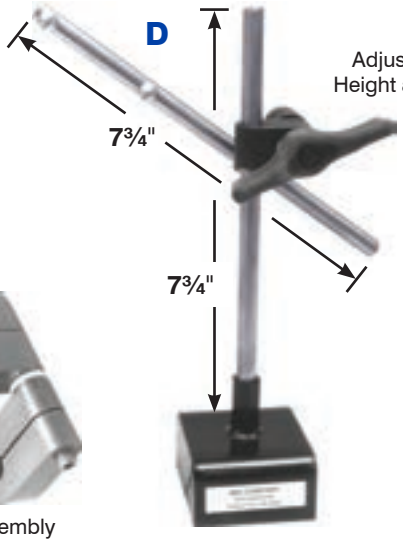
Automatic Bulk Spray System

Parts and Components

D



Adjustable Height and Tilt

Magnetic Base for use when mounting tomold or platen

E

Swivel Assembly for use with F

B Spray Controller

See Page 153 for more information

F

Spray Gun
Mount on robot or Magnetic Base

D

Spray Cart

C

G

Standard Fan Spray Nozzle Kit

Low Volume Round Spray Nozzle Kit

High Volume Fan Spray Nozzle Kit

H

Elbow Fitting #147305
(1 per gun)
⅛" NPT

I

Elbow Fitting #147306
(2 per gun)
¼" NPT

Split Lines At Cart

J

Tee Union
#147296

Split Lines At Gun

K

Tee Union
#147319 (1 per gun)
⅛" NPT

L

Tee Union
#147320 (2 per gun)
¼" NPT

Use when plumbing two or more guns together.

PLC Type Controller

8 ft. Grounded Power Cord

Three Air Solenoids start/stop flow of air and mold release to spray unit

Air Line Connection

A

Spray Cart and Controller

Three Quick Connects allow easy hook-up to:
1. Sweep Start
2. Spray Start
3. Cycle Count

Rugged but Lightweight, Aluminum Cart

1 gal. Pressurized Tank for mold release

Four lockable swivel casters for easy placement close to the press

Order Form on Next Page

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Spray System Worksheet

Select either entire assembly or select individual components that fit your application

A **Spray Cart and Controller** **Item #121983** ..... x _____ = _____

Bulk Mold Release Spray System with bulk spray cart, single-press PLC-Type controller and instructions (spray gun not included)
One required for every press that will have automatic spray control.

B **Spray Controller** **Item #173243** ..... x _____ = _____

PLC-based controller which mounts onto the spray cart.
One required for every press that will have automatic spray control.

C **Spray Cart** **Item #119814** ..... x _____ = _____

Aluminum frame assembly complete with casters, valves, pressurized tank, etc.
One required for every press that will have automatic spray control.

Use to position the spray units

D **Magnetic Base** **Item #114343** ..... x _____ = _____

One base (and associated swivel assembly) can support one spray gun; ensure that this base can be mounted close to the mold cavity to minimize overspray.

E **Swivel Assembly** **Item #122233** ..... x _____ = _____

One of these is required for every magnetic base.

Choose one or more depending on area to be sprayed

F **Spray Gun Only (automatic)** **Item #119020** ..... x _____ = _____

The size and shape of your mold cavity may require multiple spray guns for adequate spray coverage; nozzle kit must be ordered in addition to the gun.

Choose one per spray gun

G

Standard Fan Spray Nozzle Kit **Item #120480** ..... x _____ = _____

Low Volume Round Spray Nozzle Kit **Item #112931** ..... x _____ = _____

High Volume Fan Spray Nozzle Kit **Item #112947** ..... x _____ = _____

These are the most common nozzles that have been used in this application; others are available as a special order.

Purchase as needed

not shown **¼" O.D. Polyurethane Tubing** **Item #118052** ..... x _____ = _____

This tubing is recommended for connection between the spray cart valves and the spray guns; its blue color increases visibility, which aids in installation.

H **Elbow Fitting (1 per gun)** **Item #147305** ..... x _____ = _____

Male elbow, brass, tube to male pipe; joins ¼" O.D. tube to ⅛" N.P.T. thread.

I **Elbow Fitting (2 per gun)** **Item #147306** ..... x _____ = _____

Male elbow, brass, tube to male pipe; joins ¼" O.D. tube to ¼" N.P.T. thread.

Use when plumbing two guns

For split lines at cart:

J **Tee Union** **Item #147296** ..... x _____ = _____

Tee union, brass, tube to tube; joins ¼" O.D. tube to ¼" O.D. tube.

For split lines at guns:

K **Tee Union ⅛" NPT (1 per gun)** **Item #147319** ..... x _____ = _____

Tee union, brass, tube to tube; joins ¼" O.D. tube to ¼" O.D. tube.

L **Tee Union ¼" NPT (2 per gun)** **Item #147320** ..... x _____ = _____

Tee union, brass, tube to tube; joins ¼" O.D. tube to ¼" O.D. tube.

Bulk Mold Release: Products having a viscosity of 200 centiStokes or lower are recommended.

Total _____

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Since
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Industrial
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Heaters & Temperature Control

Heater Bands
160 – 189

Coil & Strip Heaters
190 – 193

Wire & Accessories
194 – 197

Barrel Insulation
199 – 205

Cartridge Heaters
206 – 212

Thermocouples
214 – 228

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Standard Mica Bands

Hot Sleeves*

Good Quality Bands at a Great Price

- Mica insulated
- 12" fiberglass braided leads
- Strap lockup (in most cases)
- Large variety available

See Pages 161-165

V Bands*

Better Quality at a Moderate Price

- Mica Insulated
- 12" fiberglass braided leads
- Heavier duty strap lockup
- Large variety available

See Pages 166-167

Metric Mica Bands

Metric Bands*

Made to Fit Exactly

No shimming, forming or stretching necessary

- Mica insulated
- 12" fiberglass braided leads
- Strap lockup
- Made to order

Ideal for metric sizes that do not closely correspond with an English measurement

See Page 184

Special Feature Bands

Key Lock Bands*

Designed for use in Tight Spaces

Low Profile, reverse-wedge design tightly clamps the band while maintaining a small outer diameter

- Mica Insulated
- 36" flex leads
- Large variety available

See Page 169

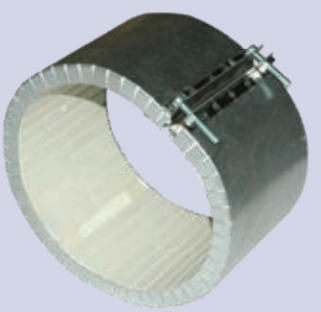
Hot Sleeves Big Bands*

Larger or Barrel Bands

Over 40 Sizes – 4" to 33" ID

- Mica or ceramic insulated
- 12" treated glass braid leads or post terminals
- Stainless steel clamp or flange lockup
- Large variety available

See Pages 174-181



S Bands – IMS Exclusive*

Patented Design Resists Melted Plastic

Less chance of electrical shorts

- Mica Insulated
- 10" fiberglass braided leads
- Heavier duty strap lockup
- Large variety available

See Page 168

Adjustable I.D. Mica Barrel-Heater Bands

Stock Alternative to Costly Bands from the Manufacturer

- Mica insulated, strap lockup
- Diameter adjustable within ½" or ¾" range (depending on size)
- Lower cost than custom bands
- Two-pieced design allows installation without removal of all bands on the barrel
- Large variety available

See Page 182

Hot Sleeves Xtreme*

Higher Wattage Heater Bands

Generates more heat than other mica bands of the same size

- Mica Insulated
- 36" stainless steel braided leads
- Strap lock or key lock
- Large variety available

Recommended where experience shows other mica bands cannot keep up with the heat load

See Pages 170-173

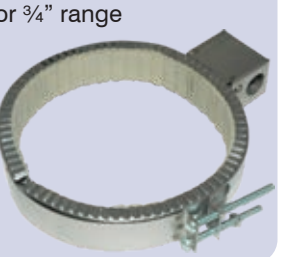
NOTE: High watt density bands require appropriate temperature control techniques to prevent them from overheating

Adjustable I.D. Ceramic Heater Bands

Stock Alternative to Costly Bands from the Manufacturer

- Diameter adjustable within ½" or ¾" range (depending on size of band)
- Lower cost than custom bands
- Highly flexible design allows installation without removal of all the other bands on the barrel
- Large variety available

See Page 183



*Custom bands made to order

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Hot Sleeves Heater Bands

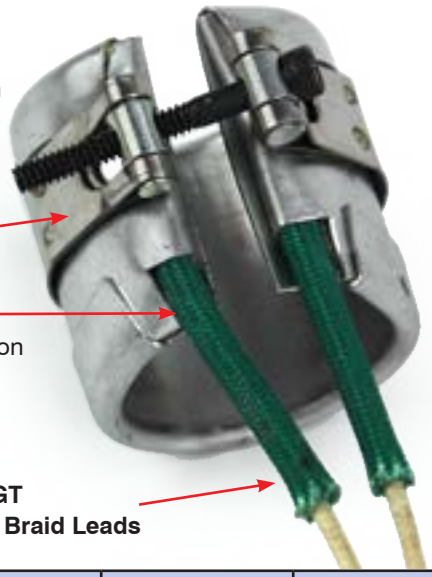
Good Bands at a Great Price

Made in the U.S.A

Mica Insulation

31-46 Watts per square inch (average)

Nickel-Chromium resistance wire element



I.D.	Width	Volts	Watts	Leads	Lock-Up-Style	Item #
3/4"	1"	120	80	12"	Strap	134660
		240				134599
7/8"	1"	120	100	12"	Strap	134600
		240				134601
	1 1/4"	120	90			134661
		240				134662
	1 1/2"	120	100			134663
		240				134664
1"	1"	120	125	12"	Strap	134602
		240				134603
		460	150			137758
	1 1/2"	120	100	12"	Strap	134604
		240				134605
	2"	120	200	12"	Strap	134606
		240				134607
		480	250	36"		137462
		240	300	12"		134665
	3"	120	300	12"	Strap	134608
		240				134609
	4"	120	400	12"	Strap	134666
		240				134667
	5"	120	475	12"	Strap	134668
		240				134610
1 3/16"	1 3/8"	120	150	12"	Strap	134669
		240				134611

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Hot Sleeve Heater Bands continued...

I.D.	Width	Volts	Watts	Leads	Lock-Up-Style	Item #
1¼"	1"	120	125	12"	Strap	134612
		240				134613
		120/240				134670
	1½"	120	200	12"	Strap	134671
		240				134672
	2"	120	250	12"	Strap	134673
		240				134674
	3"	240	150	12"	Strap	134675
		120	400			134676
		240				134677
1⅜"	1"	120	200	12"	Strap	134614
		240				134615
	1½"	120	200	12"	Strap	134678
		240				134679
	2"	120	300	12"	Strap	134680
		240				134681
1½"	¾"	120	150	12"	Strap	134682
		240				134616
	1"	120	150	12"	Strap	134617
		240				134618
		240		36"	Flange	137676
		120/240		12"	Strap	134683
		120	400			134684
	1½"	120	275	12"	Strap	138653
		230		24"		139923
		120	300	12"		134619
		240				134620
	1¾"	120	285	12"	Strap	134685
		240				134686
	2"	120	300	12"	Strap	134621
		240				134622
		120/240				134687
		120	375			134688
		230	400			135062
	2½"	120	400	12"	Strap	134623
		240				134624
	3"	120	450	12"	Strap	134625
		240				134626
		120/240				134689
	3½"	120	525	12"	Strap	134627
		240				134628

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continued on next page

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Hot Sleeve Heater Bands continued...

I.D.	Width	Volts	Watts	Leads	Lock-Up-Style	Item #
1½"	4"	120	550	12"	Strap	134629
		240				134630
	5"	240	500	12"	Strap	144300
		120	700			134631
		240				134632
	6"	240	500	12"	Strap	144301
		120	850			134690
		240				134691
	8"	120	1250	36"	Flange	137559
		240	1500	12"	Strap	138179
1¾"	1"	120	175	12"	Strap	134633
		240				134634
	1½"	120	300	12"	Strap	134635
		240				134636
	2"	120	350	12"	Strap	134692
		240				134637
	2½"	120	350	12"	Strap	134693
		240				134694
	3"	120	500	12"	Strap	134638
		240				134639
	3½"	120	500	12"	Strap	134695
		240				134696
	4"	120	700	12"	Strap	134697
		240				134698
	5"	120	750	12"	Strap	134699
		120	900	12"	Strap	134700
		240				134701
	6"	120	1000	12"	Strap	134702
		240				134703
1⅞"	1"	120	300	12"	Strap	134704
		240				134705
2"	1"	120	200	12"	Strap	134640
		240				134641
	1½"	120/240	300	12"	Strap	134706
		120	350			134642
		240				134643
	2"	120	400	12"	Strap	134644
		240				134645
	2½"	120	500	12"	Strap	134707
		240				134708
	3"	120	500	12"	Strap	134646
		240				134647
		120	600			134709
		240				134710

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continued on next page

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Hot Sleeve Heater Bands continued...

I.D.	Width	Volts	Watts	Leads	Lock-Up-Style	Item #
2"	4"	230	750	12"	Strap	134711
		120	800			134712
		240				134713
	5"	120	900	12"	Strap	134714
		240				134715
	6"	120	1200	12"	Strap	134716
		240				134717
2⅛"	1"	120	225	12"	Strap	134718
		240				134648
	1½"	120	300	12"	Strap	134719
		240				134720
	2"	240	300	12"	Strap	134721
			400			134722
	3"	120	600	12"	Strap	134723
		240				134724
2¼"	1"	120	225	12"	Strap	134649
		240				134650
	1¼"	240	327	12"	Strap	134725
	1½"	240	350	12"	Strap	134727
	2"	120	450	12"	Strap	134728
		240				134729
	2½"	120	600	12"	Strap	134730
		240				134731
	3"	120	700	12"	Strap	134732
		240				134733
	4"	120	900	12"	Strap	140474
		240				143073
			950	12"	Strap	134734
2⅜"	1"	120	250	12"	Strap	134735
		240				134651
	1½"	120	400	12"	Strap	134736
		240				134737
2½"	1"	120	300	12"	Strap	134652
		240				134653
	1¼"	120	350	36"	Flange	140176
		480	380	20'	Strap	137024
	1½"	120	350	12"	Strap	134654
		240				134655
		240	300	Posts		144864
	2"	120	500	12"	Strap	134739
		240				134740
	2½"	240	350	12"	Strap	135760
	3"	120	700	12"	Strap	134741
		240				134742

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I.D.	Width	Volts	Watts	Leads	Lock-Up-Style	Item #
2½"	4"	240	850	12"	Strap	134743
	5"	240	1150	12"	Strap	134744
	6"	240	1150	12"	Strap	139904
2¾"	1½"	120	400	12"	Strap	138658
		240				135081
	3"	240	750	12"	Strap	134745
2 7/16"	1⅜"	230	250	12"	Strap	134738
3"	1"	120	300	12"	Strap	134656
		240				134657
	1½"	120	500	12"	Strap	134658
		240				134659
	2"	120	600	12"	Strap	134746
		240				134747
	2½"	460	500	48" SS	Strap	140223
	3"	120	900	12"	Strap	134748
		240				134749
	3½"	240	665	12"	Strap	134750
3⅛"	1"	240	400	12"	Strap	134751
	1½"		500			134752
3½"	1½"	240	500	12"	Strap	134753
		240	600	Euro Plug	Flange	129751
	2"	120	500	Post	Strap	139939
		240	600	12"		134754
			650			134755
3¾"	1½"	240	500	12"	Strap	134758
			700			134759
	2"	250	300	12"	Strap	134760
	3"	120	600	12"	Strap	134761
3⅝"	1½"	240	625	12"	Strap	134756
		120/240	650			134757
3⅞"	3"	460	1500	12"	Strap	134762
4"	2½"	240	1250	36"	Strap	137009
4½"	1½"	240	700	Euro Plug	Flange	129750
8½"	1¼"	240	600	12"	Strap	140290

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V-Type Mica-Insulated Heater Bands

Heavier Duty For Improved Durability

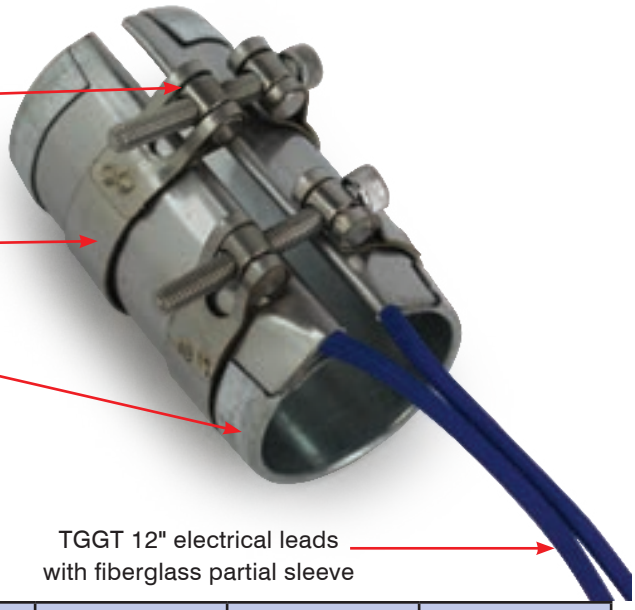
Mica insulation nichrome heating element

31-46 watts per square inch provides effective heating up to 800°F

Heavy Duty Strap Type Lock-Up with socket head screw

Aluminized impregnated steel shell resists rust and extends life

24 or 26 gauge shell thickness minimizes hotspot formation, extending heater life



TGGT 12" electrical leads with fiberglass partial sleeve

Heater Band Quantity Discounts*
Order 13-24 **DEDUCT 5%** Order 25 or more **DEDUCT 10%**

*Same item only

I.D.	Width	Volts	Watts	Leads	Lock-Up-Style	Item #
7/8"	1"	240	100	12"	Strap	101732
1"	1"	120	125	12"	Strap	101714
		240				101694
				36"		164040
	1 3/8"	240	150	12"	Strap	101657
	1½"	120	150	12"	Strap	101680
		240				101670
	2"	120	200	12"	Strap	101660
		240				101650
	3"	120	275	12"	Strap	101641
		240				101633
1¼"	1"	120	125	12"	Strap	101647
		240				101638
1 3/8"	1"	240	200	12"	Strap	101684
1½"	¾"	120	150	12"	Strap	101674
		240				101664
	1"	240	150	12"	Strap	101645
	1½"	120	250	12"	Strap	101636
		240				101628
	2"	120	300	12"	Strap	101682
		240				101672
	2½"	120	350	12"	Strap	101662
		240				101652
	3"	120	400	12"	Strap	101643
		240				101635

continued on next page

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V-Type Mica-Insulated Heater Bands

I.D.	Width	Volts	Watts	Leads	Lock-Up-Style	Item #
1½"	3½"	120	525	12"	Strap	101626
		240				101679
	4"	120	550	12"	Strap	101669
		240				101659
	5"	120	700	12"	Strap	101649
		240				101640
1¾"	1"	240	175	12"	Strap	101623
	1½"	120	250	12"	Strap	101676
		240				101666
	2"	240	350	12"	Strap	101646
2"	1"	240	200	12"	Strap	101673
	1½"	120	300	12"	Strap	101663
		240				101653
	2"	240	400	12"	Strap	101627
	3"	120	500	12"	Strap	101681
		240				101671
2⅛"	1"	240	225	12"	Strap	101651
2⅜"	1"	240	250	12"	Strap	101678
2½"	1"	120	300	12"	Strap	101668
		240				101658
	1½"	120	350	12"	Strap	101648
		240				101639
3"	1"	120	300	12"	Strap	101631
	1½"	240	450			101665
3⅛"	1"	240	350	12"	Strap	101655
	1½"	240	450	12"	Strap	102376

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S-Type Mica-Insulated Heater Bands

Patented shell-folding design resists melted plastic

Help prevent shorts — Less downtime / Save money

- 10" TGGT leads
- Mica insulation and nichrome heating element with 31-46 watts per square inch provide effective heating up to 800° F
- Stainless steel straps

Aluminized impregnated steel shell resists rust and extends life

24 or 26 gauge shell thickness minimizes hotspot formation, extending heater life

Only from IMS!

Heater Band Quantity Discounts*
Order 13-24 **deduct 5%** Order 25 or more **deduct 10%**

I.D.	Width	Volts	Watts	Leads	Lock-Up-Style	Item #
1"	1"	120	125	10"	Strap	117075
		240				117103
	2"	120	200	10"	Strap	117092
		240				117078
	3"	120	300	10"	Strap	117108
		240				117095
1½"	1"	120	150	10"	Strap	117082
		240				117071
	1½"	480	200	10"	Strap	117076
		120/240	275			117105
		120	300	10"	Strap	117093
		240				117079
	2"	120	300	10"	Strap	117109
		240				117096
	2½"	120	400	10"	Strap	117084
		240				117072
	3"	115	450	10"	Strap	117100
		240				117089
	4"	120	550	10"	Strap	117077
		240				117107
	5"	120	700	10"	Strap	117094
		240				117080
1¾"	1½"	240	250	10"	Strap	117097
2"	1"	120	200	10"	Strap	117086
		240				117074
	1½"	120	300	10"	Strap	117101

*Same item only

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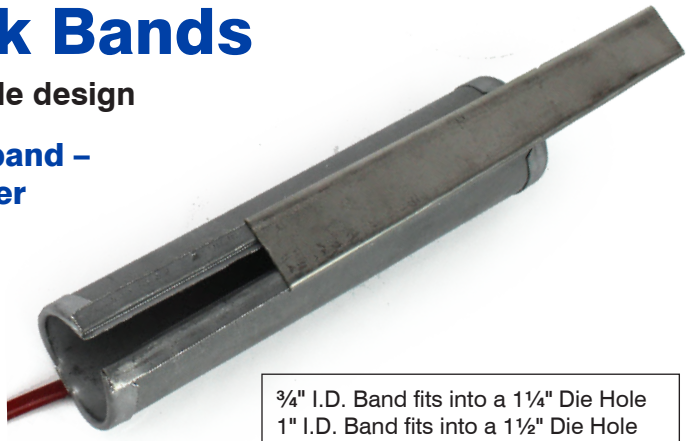
Key Lock Bands

Low profile design

Reverse-wedge design tightly clamps the band – while maintaining a small outer diameter

- 36" TGGT leads
- Mica insulation and nichrome element
- Rust-resistant sheath
- 25-40W per square inch



¾" I.D. Band fits into a 1¼" Die Hole
1" I.D. Band fits into a 1½" Die Hole
1¼" I.D. Band fits into a 1¾" Die Hole
1½" I.D. Band fits into a 2⅛" Die Hole

Heater Band Quantity Discounts*
Order 13-24 **deduct 5%** Order 25 or more **deduct 10%**

I.D.	Width	Volts	Watts	Leads	Item #
¾"	1"	120	75	36"	105241
		240			105239
1"	1"	120	125	36"	101824
		240			101801
	1½"	120	200	36"	101779
		240			101755
	2"	120	250	36"	101733
		240			101715
	2½"	120	275	36"	101695
		240			101817
	3"	120	300	36"	101794
		240			101747
1¼"	1"	240	150	36"	108883
	1½"	240	200	36"	108877
	2"	240	250	36"	108871
	3"	240	350	36"	108884
1½"	1"	120	150	36"	108882
		240			108879
	1½"	120	275	36"	101761
		240			101738
	2"	120	300	36"	101701
		240			101823
	3"	120	450	36"	101799
		240			101777
	3½"	120	525	36"	110049
		240			110046
	4"	120	575	36"	101713
		240			101693
	4½"	240	675	36"	110053
	5"	120	700	36"	101771
		240			101746
	5½"	240	800	36"	110042
	7½"	240	1100	36"	110055

*Same item only

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Hot Sleeves Xtreme Heater Bands

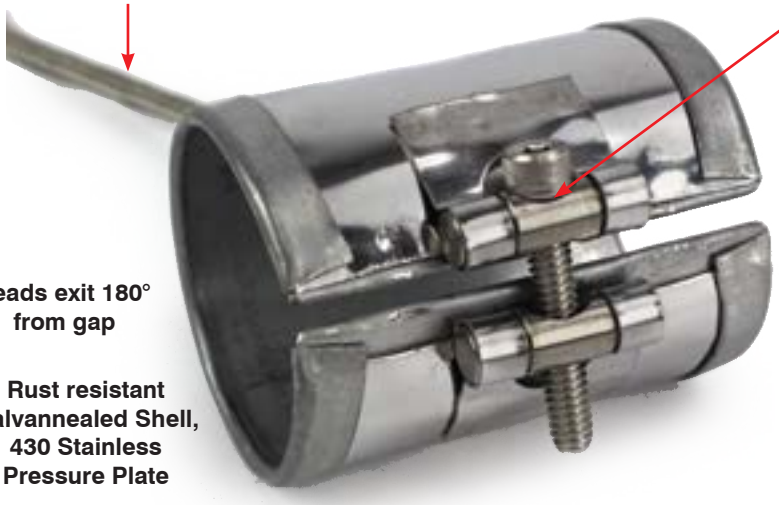
For use where other bands are not keeping up with the heat load

36" Stainless Steel Braided Leads with strain relief

70 Watts per square inch

Your choice of Lock-Up:
- Style 1 Barrel Nut Lock-Up
- Style 2 Key-Lock Style

Ideal where minimum clearance is necessary



Leads exit 180° from gap

Rust resistant Galvannealed Shell, 430 Stainless Pressure Plate

— NOTE —

Appropriate temperature control technique required to prevent overheat and burnout — see page 173

I.D.	Width	Volts	Watts	Leads	Lock-Up Style	Item #
1"	1"	120	220	36" SS	Barrel Nut	141797
		240			Strap	150975
		120			Key Lock	141911
		240			Key Lock	141912
	1½"	120	330	36" SS	Barrel Nut	141799
		240			Barrel Nut	141800
		120			Key Lock	141913
		240			Key Lock	141914
	2"	120	440	36" SS	Barrel Nut	141801
		240			Barrel Nut	141802
		120			Key Lock	141915
		240			Key Lock	141916
	3"	120	660	36" SS	Barrel Nut	141803
		240			Barrel Nut	141804
		120			Key Lock	141917
		240			Key Lock	141918
1¼"	1"	120	280	36" SS	Barrel Nut	141805
		240			Barrel Nut	141806
					Key Lock	141920
	1½"	120	420	36" SS	Barrel Nut	141807
		240			Barrel Nut	141808
		120			Key Lock	141921
		240			Key Lock	141928
	5"	240	1375	36" SS	Barrel Nut	141810
					Key Lock	141930

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Hot Sleeve Xtreme Heater Bands

I.D.	Width	Volts	Watts	Leads	Lock-Up Style	Item #
1½"	1"	120	330	36" SS	Barrel Nut	141811
		240			Barrel Nut	141812
		120			Key Lock	141931
		240			Key Lock	141932
	1½"	120	500	36" SS	Barrel Nut	141813
		240			Barrel Nut	141814
		120			Key Lock	141933
		240			Key Lock	141934
	2"	120	675	36" SS	Barrel Nut	141815
		240			Barrel Nut	141816
		120			Key Lock	141935
		240			Key Lock	141936
	2½"	120	825	36" SS	Barrel Nut	141817
		240			Barrel Nut	141818
					Key Lock	141938
	3"	120	1000	36" SS	Barrel Nut	141819
		240			Barrel Nut	141820
					Key Lock	141940
	3½"	240	1200	36" SS	Barrel Nut	141822
	4"	120	1300	36" SS	Barrel Nut	141823
		240			Key Lock	141944
	4½"	120	1500	36" SS	Barrel Nut	141825
		240			Barrel Nut	141826
					Key Lock	141946
	5"	120	1700	36" SS	Barrel Nut	141827
		240			Barrel Nut	141828
					Key Lock	141948
	5½"	120	1250	36" SS	Key Lock	141949
	6"	120	1350	36" SS	Barrel Nut	141831
		240	2000		Barrel Nut	141832
		120	1350		Key Lock	141951
		240	2000		Key Lock	141952
	6½"	120	1450	36" SS	Barrel Nut	141833
			1450		Key Lock	141953
	7"	120	1575	36" SS	Barrel Nut	141835
			1575		Key Lock	141955
	7½"	120	1700	36" SS	Barrel Nut	141837
			1700		Key Lock	141957
	8"	120	1800	36" SS	Barrel Nut	141839
			1800		Key Lock	141959
		240	2700		Key Lock	141960
	8½"	120	1900	36" SS	Barrel Nut	141841
		240	2800		Barrel Nut	141842
		120	1900		Key Lock	141961

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Hot Sleeve Xtreme Heater Bands continued...

I.D.	Width	Volts	Watts	Leads	Lock-Up Style	Item #
1¾"	1"	240	400	36" SS	Barrel Nut	141844
					Key Lock	141964
	1½"	120	600	36" SS	Barrel Nut	141845
		240			Barrel Nut	141846
		120			Key Lock	141965
		240			Key Lock	141966
	2½"	240	1000	36" SS	Barrel Nut	141848
	3"	120	1200	36" SS	Barrel Nut	141849
	3½"	120	1400	36" SS	Barrel Nut	141851
	5"	120	1300	36" SS	Barrel Nut	141853
		240	2000		Barrel Nut	141854
		120	1300		Key Lock	141973
		240	2000		Key Lock	141974
2"	1"	120	450	36" SS	Barrel Nut	141855
		240			Barrel Nut	141856
					Key Lock	141976
	1½"	120	700	36" SS	Barrel Nut	141857
		240			Barrel Nut	141858
					Key Lock	141978
	2"	240	750	36" SS	Barrel Nut	141714
	3"	240	1400	36" SS	Barrel Nut	141860
	4"	120	1200	36" SS	Barrel Nut	141861
	5"	120	1500	36" SS	Barrel Nut	141863
					Key Lock	141983
	6"	120	1800	36" SS	Barrel Nut	141865
		240	2300		Barrel Nut	141866
		120	1800		Key Lock	141985
2¼"	1½"	120	750	36" SS	Barrel Nut	141867
		240			Barrel Nut	141868
	2½"	240	1000		Barrel Nut	141923
2½"	1"	240	550	36" SS	Barrel Nut	141870
		120			Key Lock	141989
		240			Key Lock	141990
	1¼"	240	700	36" SS	Barrel Nut	141872
	1½"	120	825	36" SS	Barrel Nut	141873
		240			Barrel Nut	141874
					Key Lock	141994
2¾"	1½"	120	900	36" SS	Barrel Nut	141875
		240			Barrel Nut	141876
			700		Key Lock	158351
	5"	120	2000	36" SS	Barrel Nut	141877
					Key Lock	141997
3"	1½"	240	1000	36" SS	Barrel Nut	141880
3½"	1½"	240	1200	36" SS	Barrel Nut	141882
					Key Lock	142002
	2"	240	1600		Barrel Nut	141884
3¾"	1½"	240	1300	36" SS	Barrel Nut	141886
					Key Lock	142006

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Hot Sleeve Xtreme Heater Bands continued...

I.D.	Width	Volts	Watts	Leads	Lock-Up Style	Item #
4"	1"	120	900	36" SS	Barrel Nut	141887
		240			Barrel Nut	141888
	1½"	120	1400	36" SS	Barrel Nut	141889
		240			Barrel Nut	141890
		120			Key Lock	142009
		240			Key Lock	142010
	2"	120	1200	36" SS	Barrel Nut	141891
		240	1800		Barrel Nut	141892
	2½"	120	1500	36" SS	Barrel Nut	141893
		240	2200		Barrel Nut	141894
		120	1500		Key Lock	142013
5"	1½"	240	1700	36" SS	Barrel Nut	141896
		120			Key Lock	142015
		240			Key Lock	142016
5¼"	1½"	240	1700	36" SS	Barrel Nut	141898
5½"	1½"	120	1250	36" SS	Barrel Nut	141899
		240	1800		Barrel Nut	141900
6"	1½"	120	1350	36" SS	Barrel Nut	141901
		240	2000		Barrel Nut	141902
6½"	1½"	120	1475	36" SS	Barrel Nut	141903
					Key Lock	142023
6¾"	1½"	120	1500	36" SS	Barrel Nut	141905
		240	2300		Barrel Nut	141906
		120	1500		Key Lock	142025
7"	1½"	120	1575	36" SS	Barrel Nut	141907
					Key Lock	142027
8"	1½"	240	2700	36" SS	Barrel Nut	141909
		120	1800		Key Lock	142029

IMS Hot Sleeves Xtreme Heater Bands - Extra Power Requires Extra Attention

IMS Hot Sleeves Xtreme Heater Bands require extra attention during installation and use. Xtreme Bands have twice the watt-density of a normal heater band. They are capable of getting extremely hot extremely fast. That is good news, but you need to make sure that the band doesn't get hot faster than the nozzle can absorb the heat. If that happens, the band can burn itself out very quickly.

To ensure a successful application:

- Tighten the heater band well when installing. Metal-to-metal contact is needed – no air gaps. These bands cannot heat air.
- If there is an air gap, fill it with aluminum foil. (We do not recommend heat transfer compound on heater bands. It can melt off and cause electrical shorts.)
- If necessary, tap around the circumference of the band with a soft-face hammer to make the band as round as it can be.
- Always heat the band slowly to allow the nozzle to absorb the heat gradually. Use the controller's soft-start feature, or manually heat to 212°F (100°C) to drive off moisture, then 100° at a time until you reach temperature.
- Re-tighten the screws after a few heat-up and cool-down cycles – and occasionally after that.
- Avoid mixing Xtreme Bands with standard bands within a control circuit. If you must use the same control circuit, put the Xtreme Band nearest the thermocouple. The reason for this is:
  - The controller will select its power output based on the nozzle or barrel temperature directly under the thermocouple.
  - The controller sends the same voltage to both bands, but does not get the same results from both bands.
  - If the thermocouple is closer to the standard band, it will sense the temperature in the colder part of the nozzle. The controller will send enough power to heat the nozzle under the colder band, but that same power will overheat the Xtreme Band.
  - If the thermocouple is closer to the Xtreme Band, the thermocouple will sense the temperature in the hotter part of the nozzle and will quit sending power before the nozzle has come up to temperature under the colder band. You might leave the nozzle a little too cold at times, but you won't burn out the Xtreme Band.

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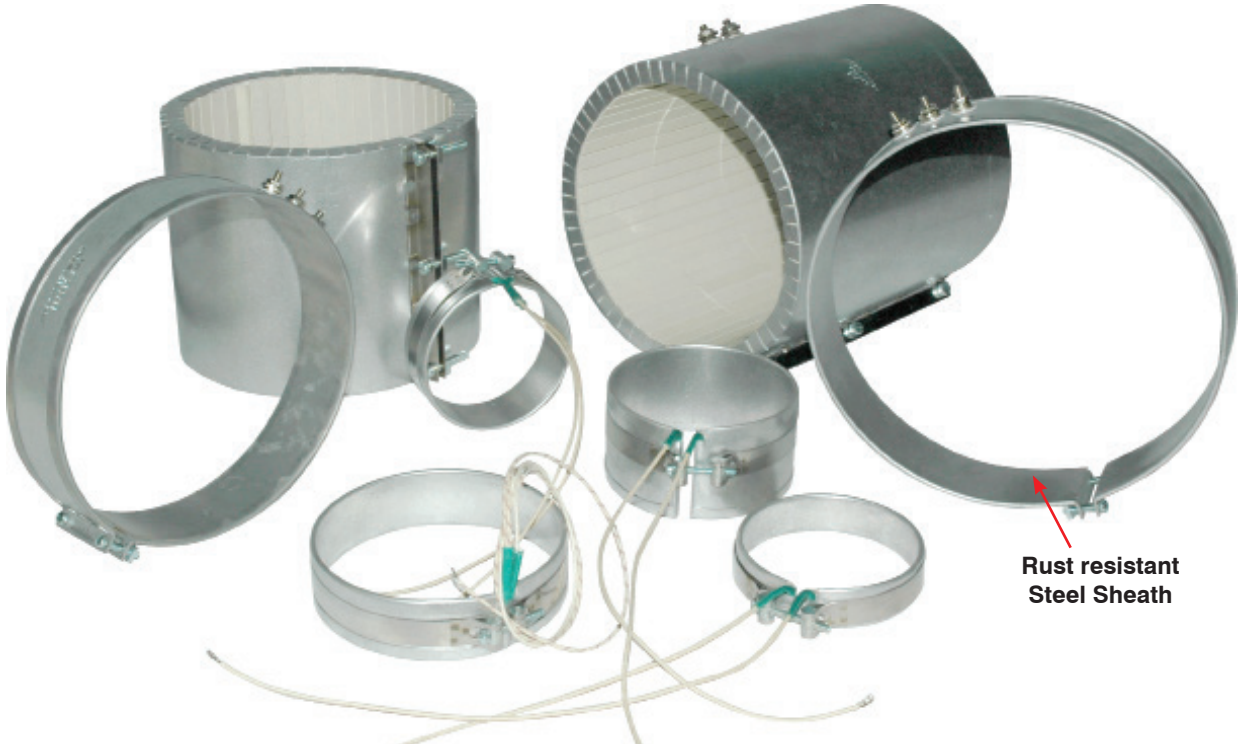
Hot Sleeves Big Bands

4" to 33" I.D.

Hundreds of Sizes and Types (Mica and Ceramic)



I.D.	Width	Volts	Watts	Terminals	Material	Lock-Up Style	Item #
4"	1"	240	625	12" Leads	Mica	Strap	134763
				24" Leads		Flange	138663
			700	12" Leads		Strap	134764
	1½"	230	400	12" Leads	Mica	Strap	134765
		240	550	Post	Ceramic	Flange	139947
			625	12" Leads	Mica	Strap	134768
		460					134769
		480	650	Post 180˚ from Gap		Flange	138664
		230	725	Post			139946*
		240	800	12" Leads		Strap	134770
	2"	240	600	12" Leads	Mica	Strap	134771
			800				134772
				Post 180˚ from Gap	Ceramic	Flange	138665
		230	1100	Post	Mica		139948*
	3"	230	500	48" Leads	Mica	Flange	139949
	3½"	230	1000	Post	Mica	Flange	139950*
			1800				139951*
	4¼"	240	1600	Post 180˚ from Gap	Mica	Flange	138666
4⅛"	4"	230	1000	Post	Mica	Flange	139952*
			1800				139953*

* 2 Piece

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Hot Sleeve Big Bands continued

I.D.	Width	Volts	Watts	Terminals	Material	Lock-Up Style	Item #
4¼"	2½"	120	1200	Post	Mica	Flange	139955
	4"	240	2650				134296*
4"	2"	240	600	24" Leads	Mica	Flange	139956
4½"	1½"	240	750	Post	Mica	Flange	131276
		480	650				138667
	2½"	230	600	Post	Mica	Flange	139957*
		240	1250	12" Leads		Strap	134773
	4"	120/240	1500	12" Leads	Mica	Strap	134774
		230					134775
	6½"	240	1000	12" Leads	Mica	Strap	134776
4¾"	1"	240	515	Post	Mica	Flange	144356
	1½"	240	650	Post	Mica	Flange	144357
	1¼"	240	400	18" Leads	Mica	Strap	133313
	5½"	230	1600	J screws	Mica	Strap	139959*
4 15/16"	4"	240/480	1200	Post 180˚ from Gap	Mica	Flange	138669
5"	1"	120	650	Post	Mica	Flange	139960
					Ceramic		139961
	1½"	240	500	12" Leads	Mica	Strap	134777
	1½"	240	700	Euro Plug	Mica	Flange	129747
		120/240	1000	12" Leads		Strap	134778
	2"	240	500	12" Leads	Mica	Strap	134779
	2½"	240/480	720	24" Leads	Mica	Flange	138668
		240	750	12" Leads		Strap	134780
	2¾"	230	860	72" Armor Leads	Mica	Flange	139962*
	3"	240/480	1200	36" Leads	Mica	Flange	137507
	4"	240	2100	Post	Ceramic	Flange	139963
	6½"	230	2760	Post 180˚ from Gap	Ceramic	Flange	138670
	9"	220	1900	12" Leads	Mica	Strap	134781
5¼"	1¼"	240	750	Post	Ceramic	Flange	139964
	1½"	240	800		Mica		139965
		240	825	12" Leads		Strap	134782
		120/240	1000				134783
	2½"	240	1300	Post w/Box	Mica	Flange	139967
	2¼"	230	1300	Post	Mica	Flange	139966*
	3"	230	850	Post	Mica	Flange	139968
		230	1200				139969*
		120/240	1700	12" Leads		Strap	134784
	4½"	230	1300	Post	Mica	Flange	139970
		120/240	2400	12" Leads		Strap	134786
	5"	240	1700	12" Leads	Mica	Strap	134787
5½"	1½"	120/240	1000	12" Leads	Mica	Strap	134788
	2¾"	480	800	60" SS	Mica	Flange	140198
	3"	220	1500	12" Leads	Mica	Strap	134789
	4"	220	1500	12" Leads	Mica	Strap	134790

* 2 Piece

continued on next page

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Hot Sleeve Big Bands continued...

I.D.	Width	Volts	Watts	Terminals	Material	Lock-Up Style	Item #
5¾"	3"	480	1200	Post 180˚ from Gap	Ceramic	Flange	138672
	4"	480	1200	Post 180˚ from Gap	Ceramic	Flange	138673
5⅞"	1¼"	240	1000	36" SS	Mica	Flange	134213
6"	1½"	240	600	Post	Mica	Flange	140073
			650	Euro Plug			129468
		240/480	675	24" Leads			138675
		240	1000	12" Leads		Strap	134791
		120/240					134792
	2"	240	650	Post	Mica	Flange	139971
		480	800		Ceramic		139972
	2½"	480	1450	Post w/Box	Mica	Strap	140530
	3"	480	1200	Post	Mica	Flange	136595
			1400			Strap	134794
			1800		Ceramic	Flange	139973
	4"	240	1200	Post	Mica	Flange	137360
	5"	480	3500	Post	Ceramic	Flange	140071
		240/480	4200				140070
	5¼"	240/480	2350	Post 180˚ from Gap	Mica	Flange	138676
6¼"	1½"	480	1000	Post	Mica	Flange	139975
	3"	230	2500	Post	Mica	Strap	140605
	4½"	230	2500	Post	Mica	Strap	140604
	5"	230	2600	Post 180˚ from Gap	Ceramic	Flange	138677
	7¼"	240	3900	Post	Mica	Flange w/ Springbolt	137355
6.33"	6"	230	3500	Post	Mica	Flange	139976*
6½"	1½"	240	900	Post	Mica	Strap	144865
	1"	240	500	12" Flex Leads	Mica	Strap	140293
				12" Armor Leads			140292
	1½"	240	500	12" Armor Leads	Mica	Strap	140291
			700	12" Leads			134795
				Euro Plug		Flange	129749
			950	12" Leads		Strap	134796
			1000			Flange	139977
	4"	460	1850	Post	Mica	Flange	137506
	5"	480	1675	48" SS	Mica	Flange	138678
	6"	480	2700	Post 180˚ from Gap	Mica	Strap	138680
	7"	480	1800	Post 180˚ from Gap	Mica	Flange	138681
	8"	480	2500	Post	Ceramic	Flange	139978
	9"	480	3800	Post 180˚ from Gap	Mica	Flange	138682
6¾"	1½"	240	290	Post	Mica	Flange	139979
			750	Post 180˚ from Gap			138683
		460	765	Post			139980
		240	815	Post 180˚ from Gap	Ceramic		138684
		120/240		12" Leads	Mica	Strap	134798
		240	1000	Post 180˚ from Gap	Ceramic	Flange	138685

* 2 Piece

continued on next page

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Hot Sleeve Big Bands continued...

I.D.	Width	Volts	Watts	Terminals	Material	Lock-Up Style	Item #
6¾"	1½"	120/240	1000	12" Leads	Mica	Strap	134799
	2"	240	1000	Post 180˚ from Gap	Ceramic	Flange	138687
	3"	240	1630	Post 180˚ from Gap	Ceramic	Flange	138686
	4"	480	2600	Post	Mica	Flange	138104
		120/240		12" Leads		Strap	134802
	5"	240	2600	Post 180˚ from Gap	Ceramic	Flange	138679
7"	1½"	240	1000	12" Leads	Mica	Strap	134803
		120/240	1250				134804
	3"	120/240	2000	12" Leads	Mica	Strap	134805
		480		Post	Ceramic	Flange	139982
	4½"	240	2100	Post	Mica	Flange	139983*
	5"	240	1500	Post	Ceramic	Flange	139984
			2000				139985
			2080		Mica		139986
		480	3700	Post 180˚ from Gap			138688
	5¾"	230/460	2000	Post	Ceramic	Flange	139987
	8½"	480	2500	Post	Ceramic	Flange	139988
7¼"	6"	230	3500	Post	Mica	Flange	139989*
	7½"	240	2200	Post	Mica	Flange	135263*
7½"	1"	240	750	12" Leads	Mica	Strap	134808
	1½"	240	500	Post	Mica	Flange	139991
		230	850				139990*
		240	1000	36" SS Leads			134214
		240/480	1000	Post			138691
				48" Leads			138690
		240	1100	Post		Barrel Nut	138692
		120/240	1500	12" Leads		Strap	134809
	2"	240	1250	Post 180˚ from Gap	Mica	Barrel Nut	138694
				Post			138693
	3½"	240	2290	Post	Mica	Flange	137280
			2325	Post 180˚ from Gap			138695
				Post	Ceramic		139993
			2350		Mica		139992*
			2600	Post 180˚ from Gap	Ceramic		138696
			3250	Post			139994
	5½"	240/480	2500	Post	Ceramic	Flange	139996
			3000				139997
	7"	480	5000	Post	Ceramic	Flange	138697
7¾"	1½"	230/460	1000	Post	Ceramic	Flange	139998
		240/480			Mica		139999
	5½"	230	2800	Post	Mica	Flange	140001*

* 2 Piece

continued on next page

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Hot Sleeve Big Bands continued...

I.D.	Width	Volts	Watts	Terminals	Material	Lock-Up Style	Item #
8"	1½"	240	850	Post 180˚ from Gap	Mica	Flange	138698
			950	12" Leads		Strap	134810
			1000	Post		Flange	140002
			1100	96" SS			135707
		120/240	1250	12" Leads		Strap	134811
	2"	240	1000	12" Leads	Mica	Strap	134812
				Euro Plug		Flange	129748
			1200	Post 180˚ from Gap		Strap	144863
		230/460	1400	Post 180˚ from Gap		Flange	138699
	3"	480	1500	12" Leads	Mica	Strap	134813
				Post		Flange	140003
	4½"	240/480	2000	Post 180˚ from Gap	Mica	Flange	138700
		240	2275				138701
	5"	480	2500	Post	Mica	Strap	135761
		240	3250			Flange	140004
	5½"	240/480	3800	Post 180˚ from Gap	Mica	Flange	138702
	7"	240	2000	Post	Ceramic	Flange	140013
	8¾"	460	4900	Post 180˚ from Gap	Ceramic	Flange	138703
	9"	480	4900	Post w/Box	Ceramic	Flange	138704
8½"	1½"	240/480	1300	Post	Mica	Flange	140007
		230	1400		Ceramic		140006
	4"	240/480	1700	Post	Mica	Flange	140009
		240	3400		Ceramic		140008
	4½"	240	3350	Post w/Box	Ceramic	Flange	138705
	5"	240	2500	Post	Ceramic	Flange	140010
			3250				140011
		480	3250	12" Leads	Mica	Strap	134814
				Post		Flange	140012
	8½"	240/480	6800	Post	Mica	Flange	140068
8¾"	1"	240	1200	36" SS Leads	Mica	Flange	138111*
	1½"	240	1000	36" SS Leads	Mica	Flange	134215
	5"	240	3250	Post	Ceramic	Flange	140014
9"	1"	240	1200	72" SS Leads	Mica	Flange	133093*
	1½"	240	500	Post	Mica	Flange	140015
			1450	Post 180˚ from Gap	Ceramic		138706
	2"	240	900	12" Leads	Mica	Strap	134816
	2½"	460	1791	12" Leads	Mica	Strap	134818
				Post	Ceramic	Flange	140017
	2¼"	240/480	800	Post	Mica	Flange	140016
	3½"	240/480	3000	Post	Ceramic	Flange	140018
	4"	240	2275	Post	Ceramic	Flange	140019
		460	2500	12" Leads	Mica	Strap	134819

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Hot Sleeve Big Bands continued...

I.D.	Width	Volts	Watts	Terminals	Material	Lock-Up Style	Item #
9¼"	2½"	480	2270	Post	Mica	Strap	140531
	3¾"	480	3800	Post 180˚ from Gap	Ceramic	Strap	138707
	4½"	240	3250	Post	Ceramic	Flange	140020
9 7/16"	3"	240/480	2300	Post	Mica	Flange	140074
	4 5/8"	240	3425	Post	Mica	Flange	140075
9½"	2"	240/480	1700	Post	Mica	Flange	140086
	2½"	460	2600	Post	Mica	Flange	140021*
	3"	480	2300	Post	Mica	Flange	138709
	3½"	240/480	3000	Post 180˚ from Gap	Mica	Flange	138710
	5"	240	1750	Post	Mica	Flange	140022
		230	5500				140069*
	8¼"	240/480	4740	Post	Ceramic	Flange	140023
9¾"	6"	480	4200	Post	Ceramic	Flange	135688
10"	1"	460	736	Post	Mica	Flange	140024*
	1½"	460	1100	Post	Mica	Flange	140025*
	2"	240/480	1500	12" Leads	Mica	Strap	134824
		240	1700	Post		Flange	138711
		240/480		Post 180˚ from Gap			141731
		460	1800	12" Leads		Strap	134823
		240	2000				134822
	3"	240	2000	Post	Ceramic	Flange	140026
	4"	230	3000	Post	Mica	Flange	140027*
	5"	240	1500	Post	Ceramic	Flange	140028
		480	3500				140029
	5½"	240	2500	Post	Ceramic	Flange	140072
	8"	460	5750	Post	Ceramic	Flange	140030
	8½"	240/480	8000	Post w/Box	Ceramic	Flange	138712
10¼"	2"	240/480	2000	Post	Mica	Flange	140031
10½"	2"	480	2250	Post w/Box	Mica	Flange	137267
	3"	240	1200	Post	Mica	Flange	140032
	3½"	120/240	3300	Post	Mica	Strap	134826
		240/480				Flange	140033
10.7"	2"	480	2000	Post	Ceramic	Flange	140034
11"	1"	460	1000	Post	Mica	Flange	140035*
	1½"	460	603	12" Leads	Mica	Strap	134827
			1000	Post		Flange	140036
		240/480	1750		Ceramic		140037
	4"	460	1400	Post	Mica	Flange	140039*
			3220				140038*
11 1/8"	3"	480	2190	Post	Mica	Flange	140040

* 2 Piece

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Hot Sleeve Big Bands continued...

I.D.	Width	Volts	Watts	Terminals	Material	Lock-Up Style	Item #
11¼"	5"	240/480	5100	12" Leads	Mica	Strap	134831
11½"	5"	480	4000	Post	Ceramic	Flange	140041
	5½"	240	5000	Post w/Box	Ceramic	Flange	138713
11 3/16"	2"	240/480	1800	Post	Mica	Flange	140067
12"	3"	480	1000	Post	Ceramic	Flange	140042
			2500		Mica	Strap	134832
					Ceramic	Flange	140043
			4000				140044
	7⅛"	480	4900	24" SS Leads	Mica	Flange	140046*
12½"	3"	480	3000	24" w/Box	Ceramic	Flange	138716
	3¼"	460	3900	Post 180˚ from Gap	Mica	Flange	138717
	3¾"	240	2400	Post	Mica	Flange	140047*
13"	1½"	460	1428	Post	Mica	Flange	140048*
	2"	460	2000	Post	Mica	Flange	140049*
		240	3800	Post 180˚ from Gap	Ceramic		138714
	2½"	460	2800	Post	Ceramic	Flange	140051
		240/480	3000	Post w/Box	Mica		138715
	2⅜"	460	2800	Post	Ceramic	Flange	140050
		480			Mica	Strap	134833
	3¾"	480	3900	Post	Mica	Flange	138718*
	4"	460	3710	Post	Mica	Flange	140052*
13¼"	1½"	460	1458	Post	Mica	Flange	140054*
	2½"	240/480	3000	Post	Mica	Flange	140055
14¾"	2"	460	2180	24" Leads	Mica	Flange w/ Springbolt	136179*
	3"	460	6744	Post	Ceramic	Flange	140056*
15½"	1½"	460	1724	Post	Mica	Flange	140057*
	2½"	460	2188	Post	Mica	Flange w/ Springbolt	135790*
			2250		Ceramic	Flange	140058
	3"	460	3640	Post	Mica	Flange	140059*
	4"	460	4600	Post	Mica	Flange	140060*
15¾"	3¾"	460	2400	Post	Mica	Flange	140061
17¾"	4"	460	5400	Post 90˚ from Gap	Ceramic	Flange w/ Springbolt	134878*
18½"	3"	230	4600	Post	Mica	Flange w/ Springbolt	135755*
19"	3"	460	4200	72" Fiberglass Leads	Mica	Flange w/ Springbolt	130961
19¾"	2"	460	1483	Post w/Box	Mica	Flange w/ Springbolt	130954*
	3"	460	3378	Post	Mica	Flange w/ Springbolt	130953*
	5"	460	7288	Post	Mica	Flange w/ Springbolt	130952

* 2 Piece

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Hot Sleeve Big Bands continued...

I.D.	Width	Volts	Watts	Terminals	Material	Lock-Up Style	Item #
20½"	2"	460	3200	Post	Ceramic	Flange w/ Springbolt	130957*
	3"	460	4500	Post w/Box	Mica	Flange w/ Springbolt	130956*
			4500			Springbolt	136861
	5"	460	7800	Post	Mica	Flange	140062*
21"	3"	460	4740	Post w/Box	Mica	Flange w/ Springbolt	135811*
22"	4"	240	6600	Post w/Box	Mica	Flange w/ Springbolt	135754*
23"	3"	460	5270	Post	Mica	Flange	140063*
24"	5"	230	12000	Post	Mica	Flange	140064*
25¾"	3"	460	5860	Post	Mica	Flange	140065*
30"	3"	460	6826	Post	Mica	Flange w/ Springbolt	130960*
33"	5"	460	12000	Post	Ceramic	Flange	140066*

* 2 Piece

Check Out These Other Useful IMS Products

IMS Select

SAFEKOTE 60™

Will Not Harden

An affordable, high heat compound for continuous use up to 600°F

INFRA-KOTE

Limited use heat transfer compound formulated for continuous use up to 350°F

These products consists of metal powders blended into a grease carrier to allow it to be applied. The grease carrier will break down at the temperature listed, but the products will continue to provide heat transfer up to the listed temperature limits of the metal powders.

Both excellent heat transfer compounds for use with cartridge heaters and heater bands.

Improve surface contact between heaters and equipment, extending heater life, providing better response times and reducing energy costs.

See Page 213 For Specifications and Pricing Information

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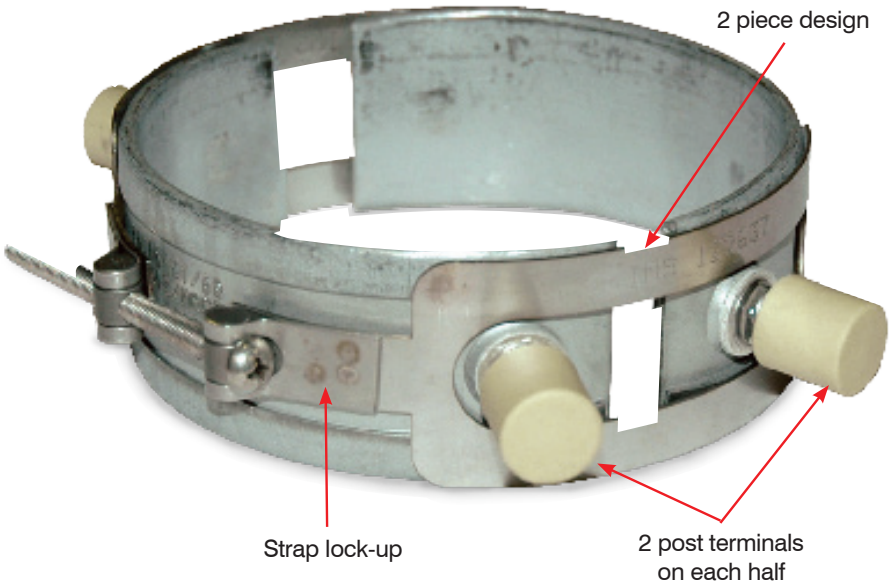
Adjustable I.D. Mica Barrel-Heater Bands

The Original Adjustable Band

- Mica type insulation
- 28-32 watts per sq. in.
- 900°F maximum use temperature
- Rust resistant, low expansion steel
- 20 gauge pressure plate
- Maximum conductivity
- 240 volts (Can be wired in series for 480 volts - see page 186-189)



I.D.	Width	Watts	Item #
4" to 4½"	1½"	500	122637
4½" to 5"		575	122638
5" to 5½"		650	122639
5½" to 6"		750	122640
6" to 6½"		850	122641
6½" to 7"		900	122642
7" to 7½"		950	122643
7½" to 8"		1000	122644
8" to 8½"		1100	122645
8½" to 9"		1200	122646
9" to 9¾"		1300	122647
9¾" to 10½"		1400	122648
10½" to 11¼"		1500	122635
11¼" to 12"		1600	122636
Ceramic Post Protector 10-32 Thread			108972

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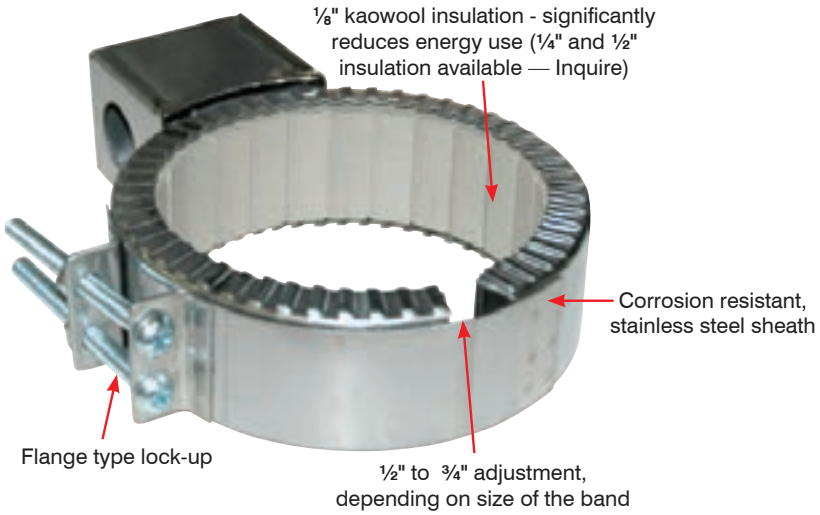
Adjustable I.D. Ceramic Heater Bands

End Long Waiting for Special OEM and Metric Bands

- 35 watts per sq. in.
- 1200°F maximum use temperature
- 1½" wide, 2 post terminals - 240 volts (Can be wired for 480 volts using two bands in a series - see page 187)
- 2½" wide, 3 post terminals - 240 volts (Can be wired for 480 volts - see page 186-189)



I.D.	Width	Volts	Watts	Item #
4" to 4½"	1½" 2½"	240 240/480	650 1100	101863 101854
4½" to 5"	1½" 2½"	240 240	700 1150	101844 101960
5" to 5½"	1½" 2½"	240 240	800 1150	101949 101941
5½" to 6"	1½" 2½"	240 240	850 1400	101931 101905
6" to 6½"	1½" 2½"	240 240/480	950 1600	101913 101888
6½" to 7"	2½"	240/480	1650	101868
7" to 7½"	1½" 2½"	240 240/480	1100 1850	101877 101849
7½" to 8"	1½" 2½"	240 240/480	1200 2000	101858 101954
8" to 8½"	1½" 2½"	240 240/480	1250 2000	101838 101935
8½" to 9"	2½"	240/480	2250	101917
9" to 9¾"	1½" 2½"	240 240/480	1450 2400	101927 101900
9¾" to 10½"	1½" 2½"	240 240/480	1550 2600	101909 101881
10½" to 11¼"	1½" 2½"	240 240/480	1650 2750	101901 101892
11¼" to 12"	1½" 2½"	240 240/480	1800 3000	101883 101873

Optional Accessory	
Ceramic Post Protector 10-32 Thread	108972

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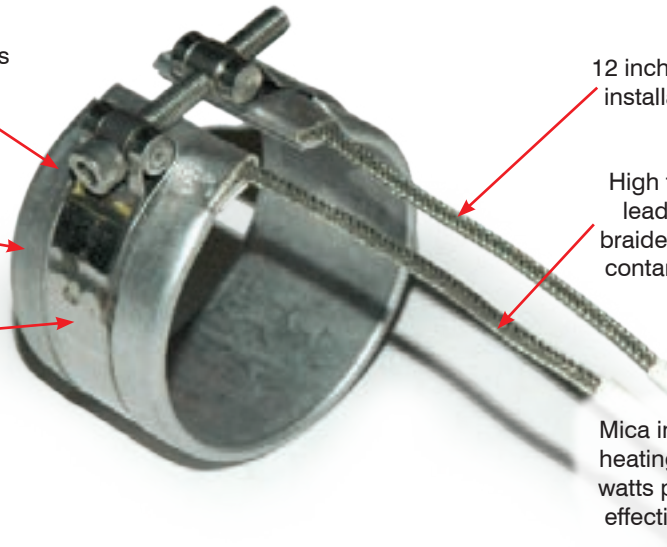
Metric Size Mica-Insulated Heater Bands

For The Proper Fit — Eliminate Shimming, Forming and Stretching



I.D. x Width (mm)	Volts	Watts	Leads	Lock-Up Style	Item #
30 x 30	240	100	12"	Strap	111242
30 x 38	240	130	12"	Strap	111231
35 x 16	240	60	12"	Strap	111254
35 x 22	120	85	12"	Strap	111250
	240				111245
35 x 25	240	100	12"	Strap	111235
45 x 30	240	250	12"	Strap	111249
48 x 22	120	220	12"	Strap	111244
	240				111239
50 x 27	480	220	12"	Strap	135143*
50 x 34	240	275	12"	Strap	111252
56 x 22	240	250	12"	Strap	111232
60 x 22	120	275	12"	Strap	111228
	240				111255
65 x 20	240	150	12"	Strap	111246
65 x 22	240	275	12"	Strap	111236

*12" Braided Fiberglass Leads

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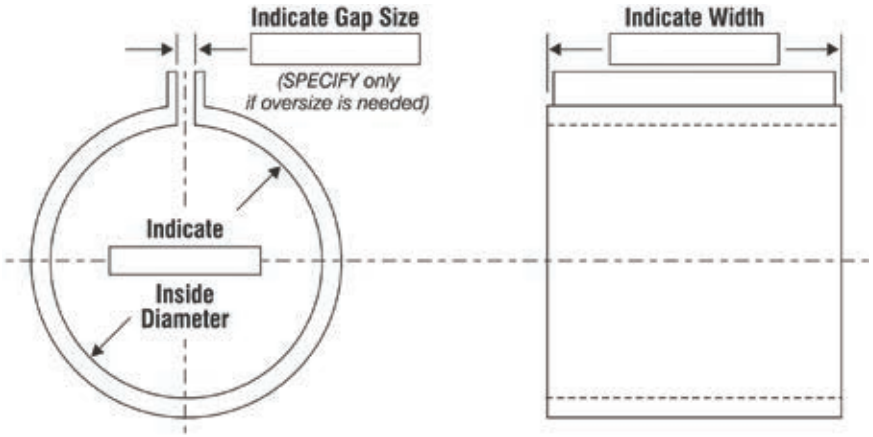
Non-Stock Heater Band Form

SPECIFY:



Tech Tips

A good rule of thumb for figuring the maximum available heater band wattage:
3.14 x band I.D. x band width x 35

Quantity: _____

Mfg. (if known): _____

Mfg. Part No. (if known): _____

Wattage: _____

Voltage: _____

Type: Nozzle Band ☐ Key Lock ☐

Construction

One-Piece ☐ Two-Piece ☐ Adjustable I.D. ☐

One-Piece Expandable Mica ☐

Other (describe): _____

_____

Insulation

Mica ☐ Compacted Mineral ☐ Ceramic ☐

Lock-up

Flange ☐* Strap ☐* Key (Wedge) ☐

Barrel Nut ☐ Spring Bolts ☐

Other (describe): _____

_____

_____

Electrical Connections/Terminations

Select One Only

NOTE: Illustrate location of connection on diagrams above.

Flex Leads: ☐ ____ long

Flex Leads with Armor Sleeving: ☐ ____ long

Flex Leads with Braided Wire Sleeving: ☐ ____ long

OR

Post Terminals: ☐

Post Terminals with Terminal Box: ☐

Post Terminals with Voltraps: ☐

Post Terminals with Terminal Caps: ☐

• • •

Plug Connector (Blade): ☐

Plug Connector (European): ☐

Expedited 24-48 Hour Service: ☐

Special

For holes, cut-outs and notches,
indicate size and location on drawings above.

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Variations of Ohm's Law

Tech Tips

VOLTS

$$\text{Volts} = \sqrt{\text{Watts} \times \text{Ohms}}$$

$$\text{Volts} = \frac{\text{Watts}}{\text{Amperes}}$$

$$\text{Volts} = \text{Amperes} \times \text{Ohms}$$

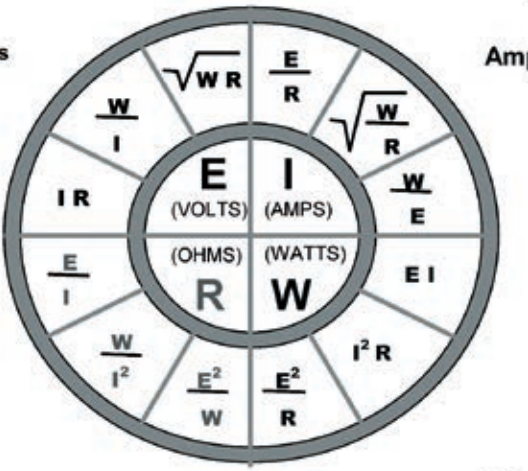
AMPERES

$$\text{Amperes} = \frac{\text{Volts}}{\text{Ohms}}$$

$$\text{Amperes} = \frac{\text{Watts}}{\text{Volts}}$$

$$\text{Amperes} = \sqrt{\frac{\text{Watts}}{\text{ohms}}}$$

OHM'S LAW



OHMS

$$\text{Ohms} = \frac{\text{Volts}}{\text{Amperes}}$$

$$\text{Ohms} = \frac{\text{Volts}^2}{\text{Watts}}$$

$$\text{Ohms} = \frac{\text{Watts}}{\text{Amperes}^2}$$

Wattage varies directly as ratio of voltage squared

$$W_2 = W_1 \times \left(\frac{E_2}{E_1}\right)^2$$

WATTS

$$\text{Watts} = \frac{\text{Volts}^2}{\text{Ohms}}$$

$$\text{Watts} = \text{Amperes}^2 \times \text{Ohms}$$

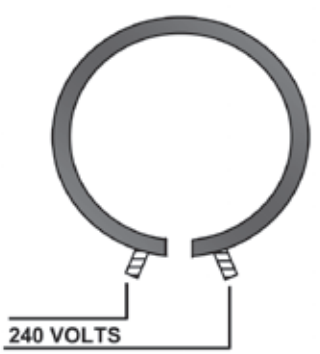
$$\text{Watts} = \text{Volts} \times \text{Amperes}$$

3 Phase Amperes $= \dfrac{\text{Total Watts}}{\text{Volts} \times 1.732}$

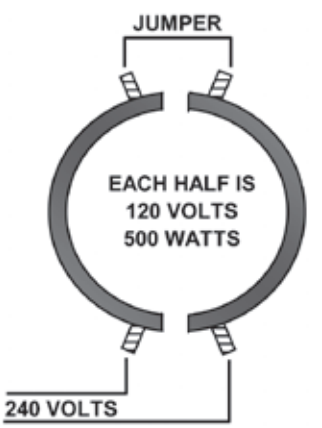
Heater Band Wiring

One Piece and Two Piece Bands:

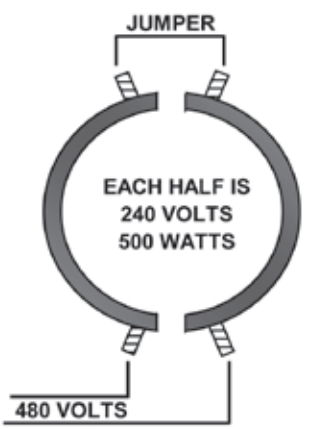
1 PIECE BAND RATED
240V / 1,000 WATTS



2 PIECE BAND RATED
240 VOLTS / 1,000 WATTS
EACH HALF IS 120 V / 500 W
WIRE EACH HALF IN SERIES



2 PIECE BAND RATED
480 VOLTS / 1,000 WATTS
EACH HALF IS 240 V / 500 W
WIRE EACH HALF IN SERIES



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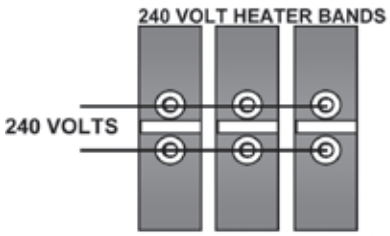
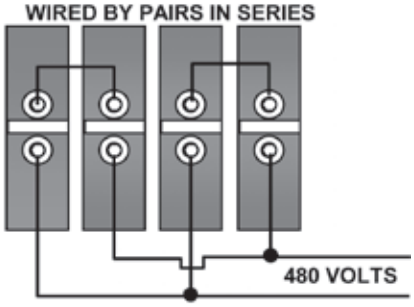
Heater Band Wiring (continued)

Parallel and Series Wiring

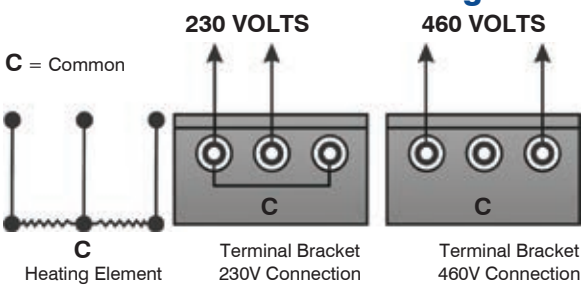
PARALLEL WIRING:
HEATER BANDS ARE NORMALLY WIRED IN PARALLEL BY ZONE



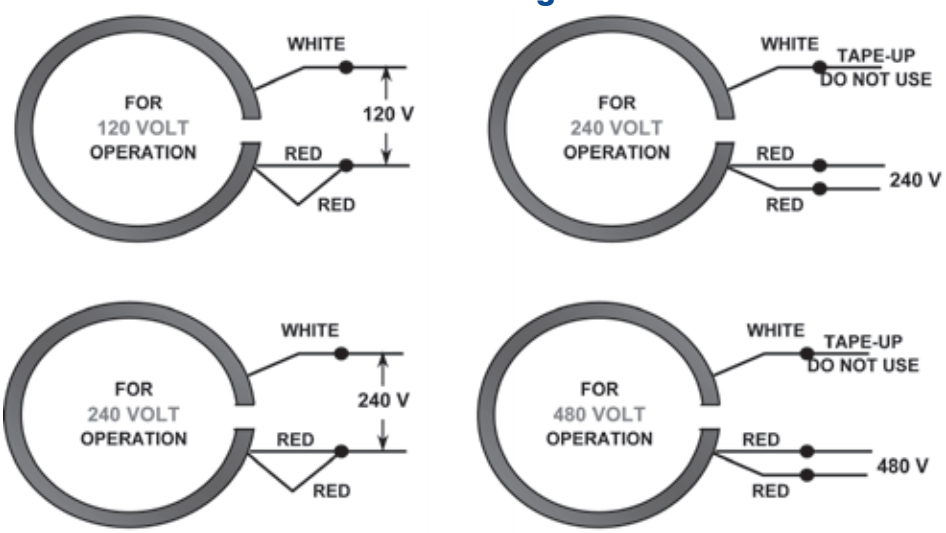
SERIES WIRING:
ILLUSTRATION SHOWS 240 VOLT BANDS WIRED TO ACCEPT 480 VOLTS
BANDS MUST BE OF EQUAL WATTAGE AND WIRED BY PAIRS IN SERIES



3 Post Terminal Wiring



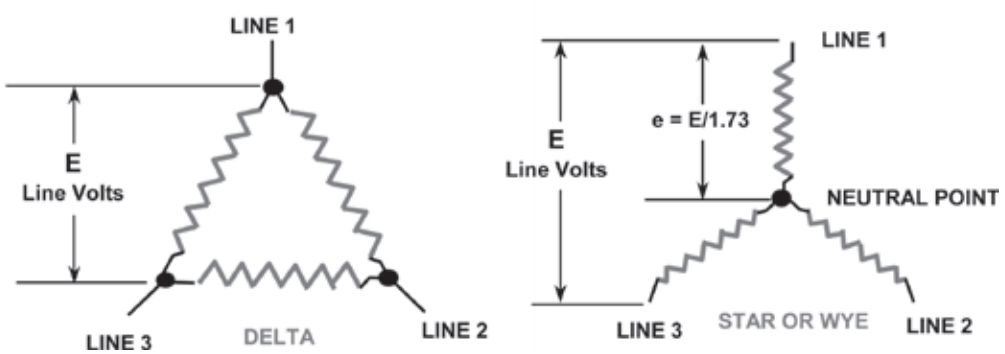
Dual Voltage



3 Phase

Element Resistance (Hot) = $\frac{1.731\ E}{I}$

Element Resistance (Hot) = $\frac{E}{1.731}$



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Heater Band Wiring (continued)

Tech Tips

CAUTION

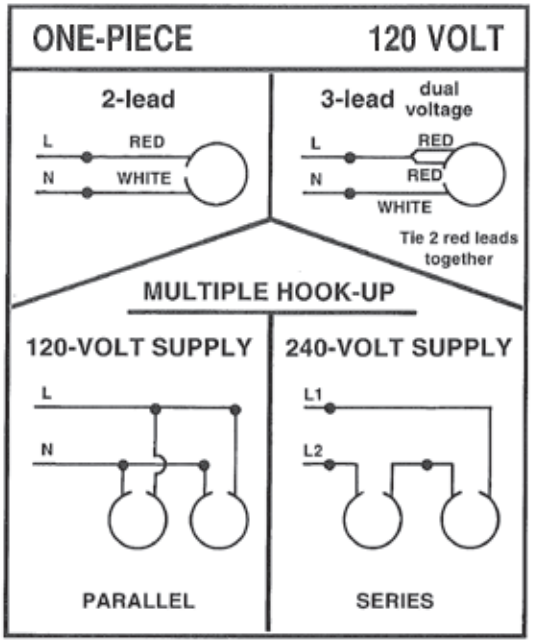
DO NOT EXCEED AMP RATING OF CONTROLLER. Consider number of heaters in circuit, and actual voltage of power supply. Have a qualified electrician approve wiring.

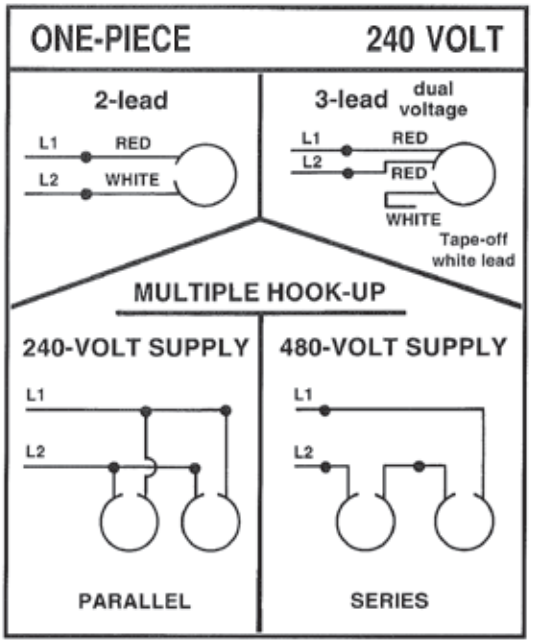
NOTES

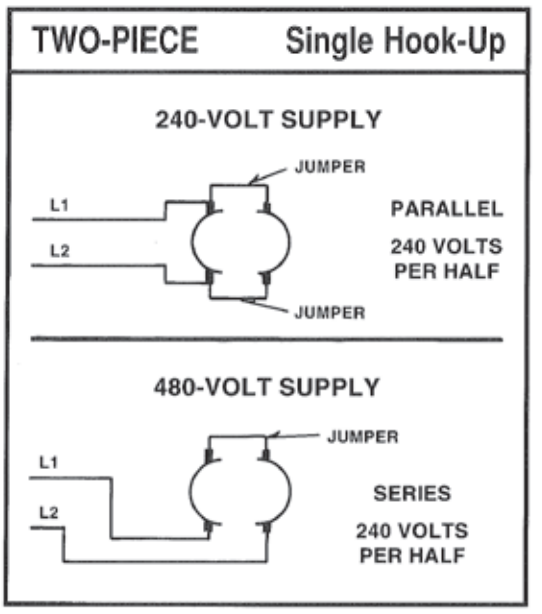
To extend heater life:

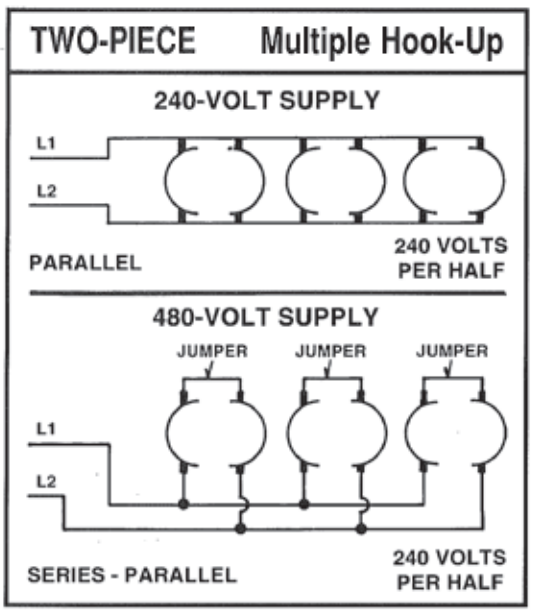
— Use a Heat-Transfer Compound such as IMS Infra-Kote on all types of heater bands except open-coil ceramic. It will improve heat transfer and save power.

— Preheat non-sealed heaters to 200° F at half power before applying full power. Many of today's solid state controllers have a soft start feature that automatically does this.









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Should You Connect Heaters in a “Series Circuit”

Tech Tips

This question arises when more than one heater is to be connected to electrical power.

Usually any number of heaters can be connected in a “Parallel Circuit”.

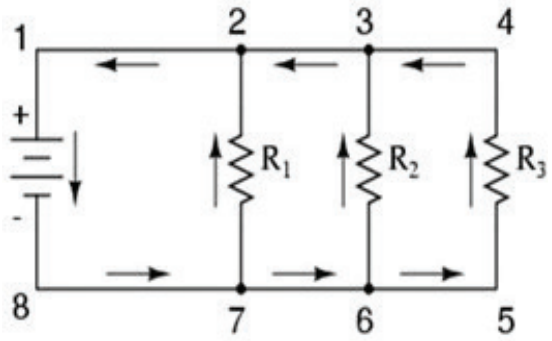
Usually only two heaters may be connected in a “Series Circuit” as it is much more complicated to do so.

The main disadvantage of a “Series Circuit” is that there is only one path in which the current can flow. Opening or breaking a Series Circuit at any point will cause the entire circuit to “open” or stop operating:

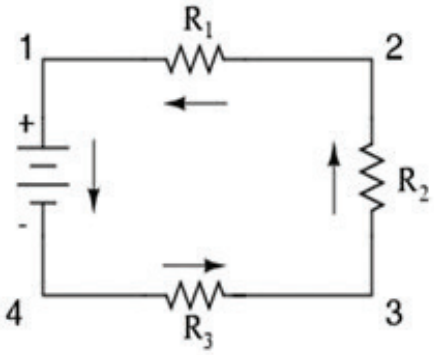
- In a “Series Circuit” every heater must function properly for the entire circuit to operate. If any heater fails, all other heaters within that circuit will not receive power to operate, whereas in a “Parallel Circuit” the failure of one heater will not affect the other heaters in that circuit.
- If two heaters are connected in a “Series Circuit” the voltage of each heater must be the same and equal to “one half” of the total voltage available. Example: Let’s say you have two 240 volt heaters connected in series, therefore you must provide a 480 volt supply for the heaters to function properly.
- The wattage of each heater is a “Series Circuit” must also be of the same value. If the wattage and voltage for each heater are not the same value the heaters will not split the voltage equally, resulting in improper heating.

If you must wire heaters in “Series” the basic rule of thumb is that only two heaters are wired together, and those heaters must have the same voltage and wattage specifications.

Parallel Circuit



Series Circuit



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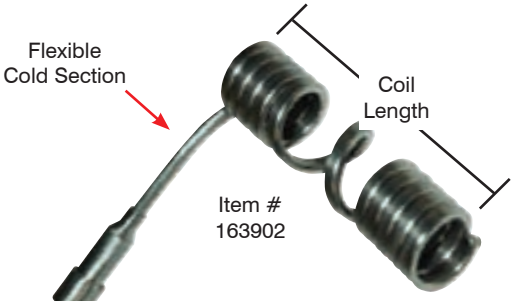
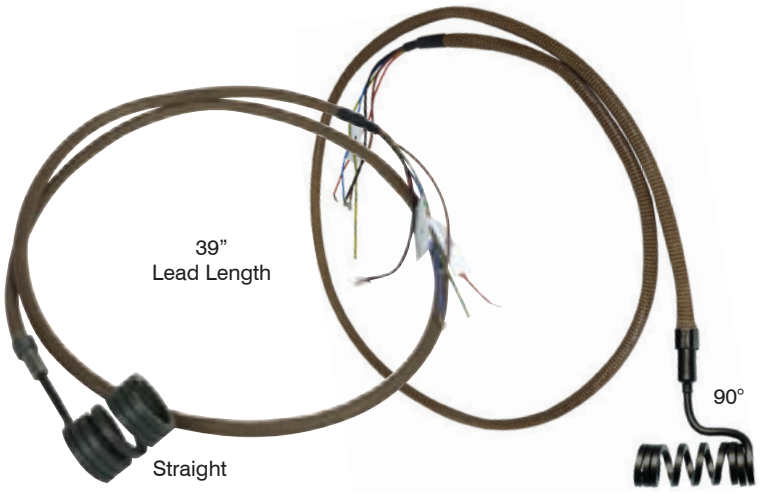
DME OEM Replacement Coil Heaters

Available With and Without Built-In Type J Thermocouple

- Flat profile ensures OPTIMUM control
- Thermocouple is placed at tip for more precise temperature measurements
- Flexible cold section will not break when installing (length may vary)





Item #	OEM Part #	Lead Exit	Coil ID	Coil Length	Cold Selection	Lead Length	Voltage	Wattage	T/C
163764	SSTC-62-90	90°	½"	1.45"	1¼"	39	230	200	Yes
163765	SSTC-72-90	90°		2"	1"			200	
163897	SSTC-42	Straight		2½"	0.95"			450	
163898	SSTC-42-90	90°		2½"	2.12"			450	
163763	SSTC-32-90	90°		4½"	2.12"			300	
163899	SST-31	Straight		4½"	1-⅛"		120	300	
163900	SSTC-31-90	90°		4⅝"	2.12"			300	
163775	SCH0003	Straight	⅝"	0.975"	1.65"	39	230	225	No
163862	SCH0081			2"	½"			300	Yes
163901	SCH0082			2½"				350	
163902	SCH0083			3"				400	
163766	SCH0084			3½"				450	
163904	SCH0085			4"				500	
163905	SCH0086			5"				500	
163767	SCH0087			6"				525	
163906	SCH0060	Straight	¾"	1.437"	½"	39	230	250	No
163768	SCH314-2			1¾"	1.87"			315	Yes
163907	SCH0061			1.937"	½"			300	No
163890	SCH0062			2.437"	1.87"			350	
163769	SCH324-2			2.437"	½"			315	Yes
163908	SCH0063			2.937"				400	No
163770	SCH0064			3.437"				400	
163909	SCH0065			4.437"				500	
163910	SCH0066			5.437"				500	
163911	SCH0088	Straight	⅞"	2⅛"	½"	39	230	400	Yes
163863	SCH0089			2⅝"				450	
163771	SCH0090			3⅛"				525	
163912	SCH0091			3⅝"				700	
163913	SCH0092			4⅛"				800	
163914	SCH0093			5⅛"				900	
163915	SCH0094			6⅛"				1000	
163772	SCH0095			7⅛"				1000	

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Husky 750 Series
OEM Replacement Coil Heaters

- Completely Interchangeable with existing OEM Heaters
- Coil ID: ¾" (19.05mm)
- Lead Length: 72"
- Wattage Tolerance: +/- 2%
- Voltage: 240

Item #	OEM Part #	Coil Length	Wattage	Unit Price
146569	534975	30mm	220	Contact IMS for current Pricing and Availability
146570	1501609		350	
146571	534976	40mm	220	
146572	1502992		350	
146573	534977	50mm	220	
146574	1045865		350	
146575	534978	60mm	220	
146576	1501594		400	
146577	534979	70mm	220	
146578	1502994		400	
146579	534980	80mm	220	
146580	1501595		400	
146581	534981	90mm	220	
146582	1502995		400	
146583	534982	100mm	220	
146584	1501596		400	
146585	534983	110mm	220	
143638	1502996		400	
146586	535470	130mm	220	
146587	1502997		400	
146588	535471	150mm	220	
146589	1502998		400	
146590	535472	170mm	220	
146591	1502999		450	
146592	535473	190mm	220	
146593	1503000		450	
146594	535474	210mm	220	

Custom Coil Heaters

Inquire for any Front Load Hot Runner Heater, Flat Profile Heater, or any other coil heater application at 1-800-537-5375

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Mica and Ceramic Strip Heaters

IMS can supply all your Strip Heater needs!

For Thermoforming, Molds, Platens, Dies, Hot Plates, Sealing Equipment, Hot Stamping, Ovens, Tank Heaters, Air Heating etc.

Mica Strip Heaters		Ceramic Strip Heaters
Nickel/Chrome ribbon	**Element**	Nickel/Chrome coil
Post Type with 10”-24 x 7⁄16" thread (12" flex leads available)	**Terminals**	Post Type with 10"-24 thread
¼" x ⅜"	**Mounting slots**	5⁄16" x ½"
Standard steel with special surface treatment to increase heat transfer and to retard oxidation (Stainless steel available)	**Sheath**	Stainless steel (heavy gauge) heat resistant coating is inorganic and baked to a peel-free finish
900°F / 482°C 1,200°F / 650°C	**Maximum Sheath Temp.** **Standard Steel** **Stainless Steel**	 N/A 1,400°F
35 Watts/Sq. In. Max.	**Watt density**	45 Watts/Sq. In, Max
480 VAC Max.	**Voltage**	240 VAC Max.

Whatever type, style or size you might need, IMS has it (or can get it) – FAST!

— Use Forms That Follow to Order —

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Custom Strip Heater Form

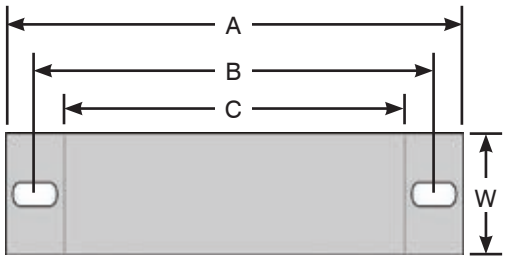
Specify: ☐ **MICA** — **or** — ☐ **CERAMIC**

Mica Dimensions

Length (A): _____ 2½" MIN

Length (B): _____

Length (C): _____



Width: ☐ ¾" ☐ 1" ☐ 1½" ☐ 2"

Thickness: ☐ ¼" ☐ 5/16"

Mounting Slot/Hole: ☐ ¼" x ⅜" (Standard)
☐ Custom
Specify: _____

Ceramic Dimensions

Length (A): _____ 4" MIN

Length (B): _____

Length (C): _____

Width: ☐ 1" ☐ 1½"

Thickness: ☐ ¼" ☐ 5/16" ☐ ⅜"

Mounting Slot/Hole: ☐ 5/16" x ½" (Standard)
☐ Custom
Specify: _____

Mounting Tabs:
☐ Yes ☐ No

Voltage: _____ **Wattage:** _____

Post Terminals Styles:

☐ 1
(**Mica:** ¾" Min Width) (**Ceramic:** 1" Min Width)

☐ 2
(**Mica:** 1½" Min Width) (**Ceramic:** 1½" Min Width)

☐ 3
(**Mica:** 1" Min Width) (**Ceramic:** 1" Min Width)

☐ 4
(**Mica:** 2" Min Width) (**Ceramic:** 1½" Min Width)

or

Lead Locations:

(**Mica:** 1" Min Width) (**Ceramic:** 1½" Min Width)

12" Leads standard ☐ Other / Specify: _____

OPTIONS:

☐ Stainless steel braid over leads
☐ Flexible armor over leads
☐ Strain relief bracket
☐ T/C hole (indicate location on drawing)
☐ Appliance pins
☐ Dual voltage
Specify: _____
☐ Grounding stud
☐ Other
Specify: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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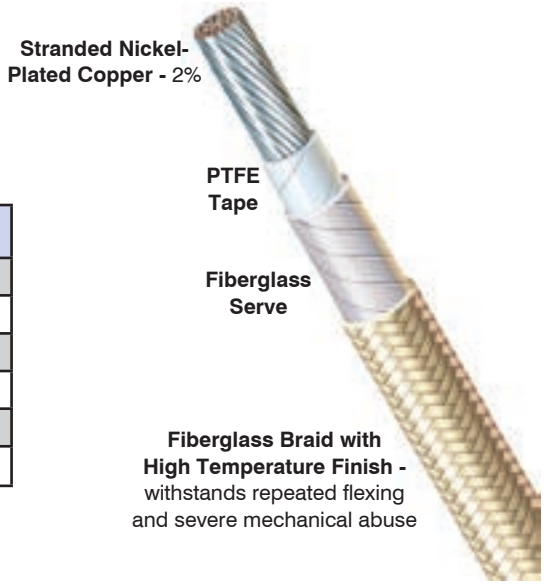
Heater Band and Cartridge Heater Wire

TGGT High Temperature Wire

- Moisture resistant
- Resists pushback and braid frey
- Flexible

Item #	Volt	Temp	Gauge
102373	600	482°F (250°C)	8
102379		482°F (250°C)	12
102377*		302°F (150°C)	12
102375		482°F (250°C)	14
102372		482°F (250°C)	18
102369		482°F (250°C)	16

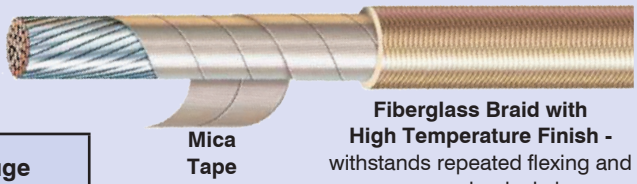


*Glass braided silicone, annealed tinned copper wire, silicone rubber insulation and braided glass jacket

24 AWG - 4/0 AWG available — Inquire

MGT Lead Wire

- UL rated
- Resists pushback and braid frey
- Flexible



Item #	Volt	Temp	Gauge
143844	600	842°F (450°C)	10
143845		842°F (450°C)	12
143846		842°F (450°C)	14

24-2 AWG Available — Inquire

Heater Band Wire Sleeving

Use Heater Band Wire Sleeving to protect personnel from electrical shock, and to help protect your heater band wire.

Item #	Description
102371	Woven fiberglass lead wire cover – ¼" I.D.
102382	Flexible, galvanized armor wire cover – 3/16" I.D.

#102371

#102382

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

www.imscompany.com phone order toll-free (USA & Canada) 1.800.537.5375
fax order toll-free (USA & Canada) 1.888.288.6900 | phone order toll-free (Mexico) 001.888.304.1307 | tech support toll-free (USA & Canada) 1.866.467.9001 | e-mail sales@imscompany.com

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Wire Connectors

Item #127271

Item #102374

Item #	Wire Size	Lug Size	Max Temp	Quantity
127271	12-10	#10	900°F	Package of 50
102374	8	#8	650°F	Each

High Heat Tape

Use High Heat Tape to help protect your operators from shock and from burns. Choose from either the glass cloth backed “sticky tape,” or the PTFE with silicone pressure sensitive adhesive. Both come in 36-yard rolls and can be used for temperatures up to 356° F.

Item #	Description
102378	Tape No. 60, PTFE with silicone pressure sensitive adhesive, 3½ mils. x ½" wide; 356°F max. temperature; black
102381	Glass cloth backed "sticky" tape

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Pin Crimping Tool

Precision tool at a great price

Parallel-jaw pliers frame - eliminates terminals from rocking out of position

Crimps:

- IMS Hot Runner Pin and Socket Contacts
- Metri-Pack & Weather Pack Terminals
- Most 18-24 Guage Terminals

Item #143673

Item #143673

Pin Extractor Tool

Use with connector pins for hot runners

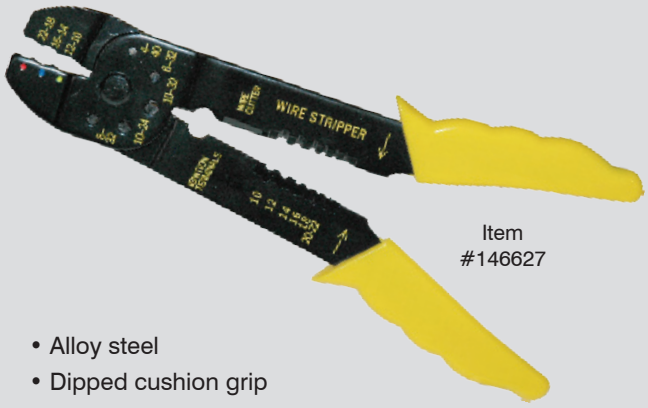
- Convenient Pin removal tool for use with IMS Hot Runner Pin and Socket Contacts (#104232 and #104224)
- Also for use with other Type II, III(+) Size 16 Pin & Socket Contacts.

Item #163917

Pin #104232 and Connector #104198 (shown for illustration) see page 251

Item #163917

8" 4-Way Crimping Tool



Item #146627

- Alloy steel
- Dipped cushion grip
- 4 tools in one: crimper, bolt cutter, wire stripper and cutter

Item #146627

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Ceramic Heater Band Post Protectors

Eliminate electrical hazards • Protect your operators • Easy to install

CLIP-ON TYPE
Fit ALL standard heater band posts ⅞" apart or farther

#102367 shown

(Includes Mica Insulators)

#102368

#102367

Heater Bands sold separately

#108972

#127270

102368	Style A: Double Opening (two-pack)	127270	Two-Piece Cap With 10-24 Thread
102367	Style B: Single Opening (two-pack)	165495	Two-Piece Cap With 10-32 Thread
		108972	One-Piece Cap With 10-32 Thread

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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GREEN Products

IMS Select UniVest® Barrel Insulation System

Made in the U.S.A

Contains and Conserves Costly Barrel Heat

Cuts energy use — increases profits

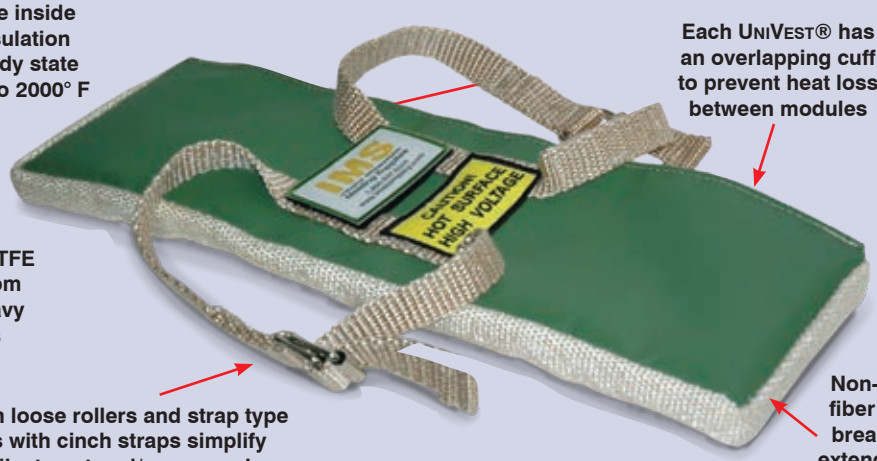
- Typical Pay Back: Generally 6-12 months
- Helps create a cooler work environment
- Safeguards personnel from accidental burns
- Promotes faster machine start-ups
- Stops barrel heat fluctuations — ensures consistent part quality
- Protects heater bands from trouble-causing drool and debris

A comparison of manual surface temperatures with and without a UniVest® shows a difference of 471° F.

UniVest® Modules are Made to Last!

Resist Material Degradation Better Than Any Other Blanket on the Market!

5 Year Warranty



Silica fiber on the inside maintains its insulation capability in steady state temperatures up to 2000° F

Each UniVest® has an overlapping cuff to prevent heat loss between modules

Fiberglass cloth impregnated with PTFE shields heaters from melted plastic, heavy greases and oils

Loops with loose rollers and strap type closures with cinch straps simplify vest adjustment and/or removal

Non-asbestos ceramic fiber insulation will not break down even after extended periods of heat

Blanket Specifications

- **Hot Face** (Inside Fabric)
  Silica Fabric (.042 Thick/1800° F Continuous)
- **Cold Face** (Outside Fabric) -
  Green Fiberglass Cloth Impregnated with PTFE (.016 Thick/550° F)
- **Insulation - Ceramic fiber**
  Non-Asbestos (1" Thick/2000° F)
- **Straps - (Fabric with PTFE)**
  Made of the same material as the Cold Face
- **Strap Enclosure**
  Cinch straps
- **Buckles - Nickel Plated Steel Wire**
  With a loose roller for tightening ease

continued on next page

UniVest® is a registered trademark of UniTherm Insulation Systems

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UniVest® Barrel Insulation System

IMS has completely overhauled our Barrel Blanket line.

Each standard IMS Barrel Blanket now covers a range of barrel circumferences and diameters. And each circumference now comes in a series of standard mix 'n' match widths to cover your barrel.

Standard Circumferences ranges are 6" to 13", 13" to 19", 19" to 25", 25" to 31", 31" to 38", 38" to 44", 44" to 50", 50" to 57", and 57" to 63".

Standard widths are 2, 4, 5, 6, 8, 10, 12, 14 and 16 inches. For odd-numbered widths, you can simply use a blanket that is 1" wider than you need.

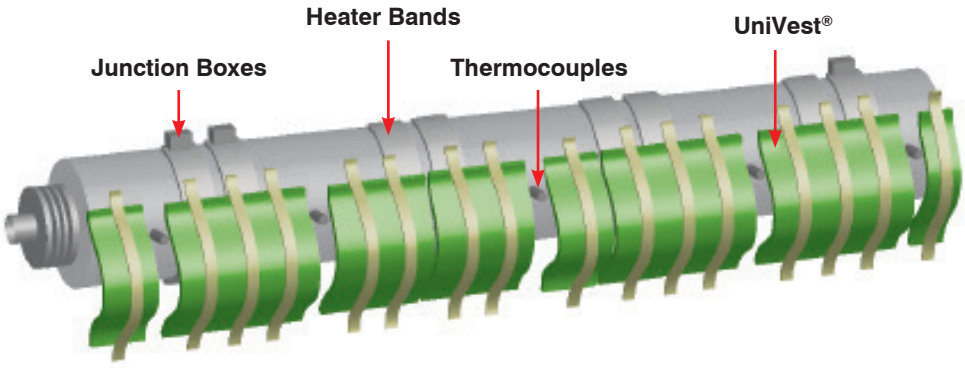
They easily compress in width. Or you can combine 5" width blankets with other available sizes.

These changes make your order simpler to place and IMS is more likely to ship same-day from stock. For blankets we don't have in the Ohio warehouse, the lead times are shorter than ever.

NOTE: Barrel blankets are also now Green instead of Blue, as a reminder of the energy savings these blankets offer.

Need Help? Contact a friendly Technical Specialist for prompt assistance and guidance.

Example of Typical Installation



Our easy 3-step process will guide you to the correct sizing options:

1. Measure current outer diameter of heater bands and junction boxes
2. Measure widths between thermocouples
3. Mix and match different widths to fit your requirements

UniVest® insulation jackets come with a 5-year warranty, under normal installation and operation applications. With its unique design, UniVest® can function at temperatures up to 1500°F.

UniVest® jackets are lightweight, modular and easy to handle for stress-free installation. No tools required for installation.

Barrel O.D.	Circ.	Length	Width	Item #
2" - 4"	6" - 13"	19"L	2"	164924
			4"	164925
			5"	164926
			6"	164927
			8"	164928
			10"	164929
			12"	164930
			14"	164931
			16"	164932

Barrel O.D.	Circ.	Length	Width	Item #
4" - 6"	13" - 19"	25"L	2"	164933
			4"	164934
			5"	164935
			6"	164936
			8"	164937
			10"	164938
			12"	164939
			14"	164940
			16"	164941

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UniVest® Barrel Insulation System

Barrel O.D.	Circ.	Length	Width	Item #
6" - 8"	19" - 25"	31"L	2"	164942
			4"	164943
			5"	164944
			6"	164945
			8"	164946
			10"	164947
			12"	164948
			14"	164949
			16"	164950

Barrel O.D.	Circ.	Length	Width	Item #
14" - 16"	44" - 50"	56"L	2"	164978
			4"	164979
			5"	164980
			6"	164981
			8"	164982
			10"	164983
			12"	164984
			14"	164985
			16"	164986

Barrel O.D.	Circ.	Length	Width	Item #
8" - 10"	25" - 31"	38"L	2"	164951
			4"	164952
			5"	164953
			6"	164954
			8"	164955
			10"	164956
			12"	164957
			14"	164958
			16"	164959

Barrel O.D.	Circ.	Length	Width	Item #
16" - 18"	50" - 57"	63"L	2"	164987
			4"	164988
			5"	164989
			6"	164990
			8"	164991
			10"	164992
			12"	164993
			14"	164994
			16"	164995

Barrel O.D.	Circ.	Length	Width	Item #
10" - 12"	31" - 38"	43"L	2"	164960
			4"	164961
			5"	164962
			6"	164963
			8"	164964
			10"	164965
			12"	164966
			14"	164967
			16"	164968

Barrel O.D.	Circ.	Length	Width	Item #
18" - 20"	57" - 63"	68"L	2"	164996
			4"	164997
			5"	164998
			6"	164999
			8"	165000
			10"	165001
			12"	165002
			14"	165003
			16"	165004

Barrel O.D.	Circ.	Length	Width	Item #
12" - 14"	38" - 44"	50"L	2"	164969
			4"	164970
			5"	164971
			6"	164972
			8"	164973
			10"	164974
			12"	164975
			14"	164976
			16"	164977

Custom Insulation Blanket Systems

For better fit and heat retention or for other applications such as on barrel end caps, extruders, die heads, melt pipes, hoppers, dryers, etc.

***Lead time required* — call for details**

Optional

If ordering a custom barrel end cap bonnet, you will also need to measure and note the distance from the nozzle hex to the front face of the barrel and the diameter of the nozzle.

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Custom UniVest® Barrel Insulation Form

Measuring Procedure (in inches):

Use form below

- The hopper is at the rear of the machine.
- Measure parts of the barrel from the operator's side, starting from the rear.
- Measure from face of the hopper flange to first thermocouple – round to closest whole inch and write it down on the form.
- Continue to measure from thermocouple to thermocouple, moving from rear to front.
- The front blanket width will end with the large diameter barrel (the start of the nozzle adapter).
- Measure the circumference of the barrel for each of the widths identified below. Include all obstructions and projections, such as a junction box. Write this in the Circumference box below.
- Divide the circumference by 3.141 to get the barrel outside diameter. This is the I.D. (inside diameter) of the UniVest® Barrel Insulation.
- Write the I.D. in the diameter box below.

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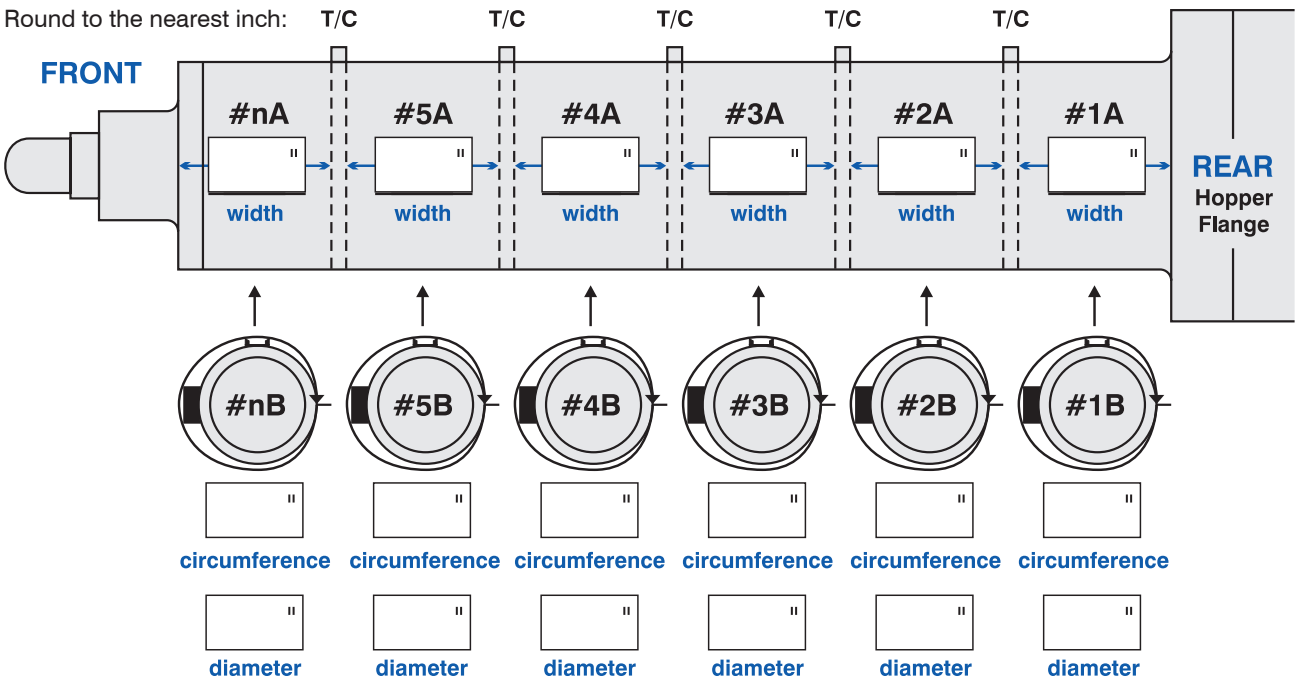

	Brand	oz./ton	Press#
Injection			
Extrusion			
Blow Mold			
Other			

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Calculating Barrel Heat Loss

Operating Temperature (°F)	No Insulation (Watts/Sq. Ft.)	1" Insulation (Watts/Sq. Ft.)	1.5" Insulation (Watts/Sq. Ft.)
300	180	18.6	12.4
325	210	20.9	14.0
350	243	23.4	15.6
375	275	26.0	17.3
400	313	29.0	19.0
425	350	31.5	21.0
450	387	34.3	22.9
475	425	37.2	24.8
500	465	40.1	25.8
525	505	43.2	26.9
550	550	46.5	28.3
575	605	49.9	29.9
600	660	54.1	32.1

Note: Heat loss values are based on an ambient room temperature of 70°F. Values are based on indoor installation with no wind using ceramic insulation.

Barrel Heat Loss Sample Problem

Barrel Length: 48"
Barrel Diameter: 6½"
Barrel Dimensions: 48" l x 6½" dia.
Surface Area: 6.8 sq. ft.

Heat Loss:

At 450° with no insulation: 387 watts/sq. ft.
At 450° with 1" ceramic insulation: 34.3 watts/sq. ft.

387 watts/sq. ft. x 6.8 sq. ft. = 2632 watts heat loss with no insulation
34.3 watts/sq. ft. x 6.8 sq. ft. = 233 watts heat loss with insulation

Savings:

$$\frac{\text{2632 watts without insulation} - \text{233 watts with insulation}}{\text{1000 w/kw}} = \text{2.40 kwh savings}$$

2.40 kwh savings x $.085/kwh x 24 hours x 7 days/week x 4.3 weeks/month x 12 months = $1,768.43 savings per year

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GREEN Products

White Board Mold Insulation

Reduce Heat Loss And Begin Molding Better Parts

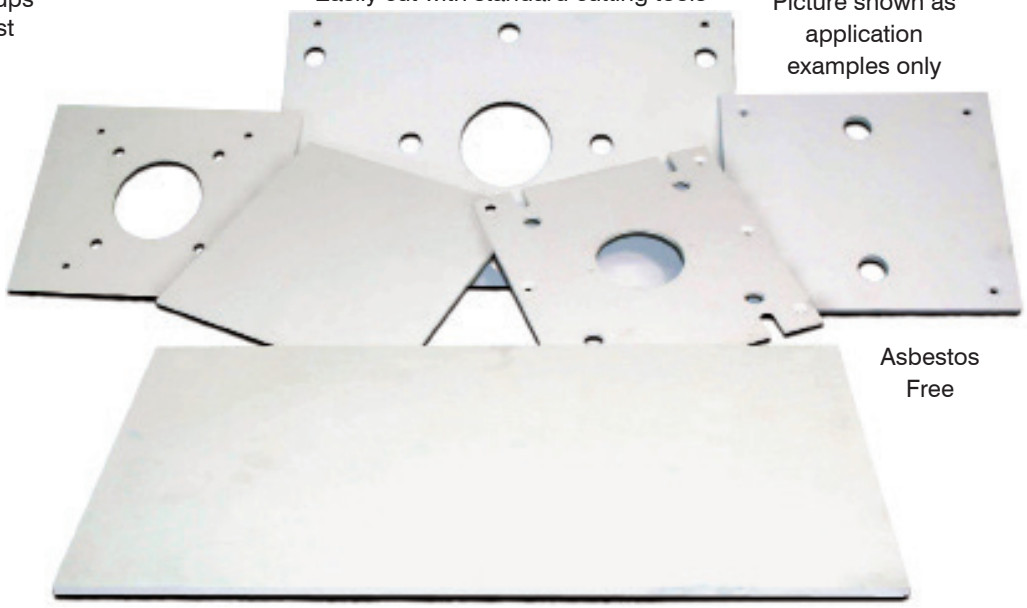
Using White Board Will Immediately:

- Improve mold temperature control
- Promote faster mold startups
- Lower energy use and cost

White Board Mold Insulation will help reduce heat loss, increase temperature control and speed up startup times. Finished to a close thickness tolerance, it is ideal for insulation between the mold and the press or within the mold itself.

Only available uncut — Easily cut with standard cutting tools

Picture shown as application examples only



Asbestos Free

Low Thermal Conductivity • Oil & Moisture Resistan • High Strength

Features and Benefits

- Fully Machinable
- Withstands High PSI Compression
- Available in Various Standard Thicknesses
- Heat and Flame Resistant up to 550° F
- Oil, Grease and Chemical Resistant
- 100% Asbestos Free
- High-Temperature Resistant

Applications:

- Injection & Compression Molding Platens
- High Compression Areas
- Sheet Dies

Item #	Thickness	Length	Width	Weight
148223	0.25”	36”	18”	12 lbs
148186			24”	16 lbs
147756			36”	24 lbs
149006	0.50”		18”	24 lbs
148563			24”	32 lbs
148562			36”	48 lbs

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Converting Fractional Inches To Decimals And Millimeters

Fraction	Decimal	MM
1/64"	.015625”	.3969
1/32"	.03125”	.7938
3/64"	.046875”	1.1906
1/16"	.0625”	1.5875
5/64"	.078125”	2.3812
3/32"	.09375”	2.3812
7/64"	.109375”	2.7781
1/8"	125”	3.175
9/64"	.140625”	3.5719
5/32"	.15625”	3.9688
11/64"	.171875”	4.3656
3/16"	.1875”	4.7625
13/64"	.203125”	5.1594
7/32"	.21875”	5.5562
15/64"	.234375”	5.9531
1/4"	.25”	6.35
17/64"	.265625”	6.7469
9/32"	.28125”	7.1438
19/64"	.296875”	7.5401
5/16"	.3125”	7.9375
21/64"	.328125”	8.3344
11/32"	.34375”	8.7312
23/64"	.359375”	9.1281
3/8"	.375”	9.525
25/64"	.390625”	9.9219
13/32"	.40625”	10.3188
27/64"	.421875”	10.7156
7/16"	.4375”	11.1125
29/64"	.453125”	11.5094
15/32"	.46875”	11.9063
31/64"	.484375”	12.3031
1/2"	.5”	12.7

Fraction	Decimal	MM
33/64"	.515625”	13.0969
17/32"	.53125”	13.4938
35/64"	.546875”	13.8906
9/16"	.5625”	14.2875
37/64"	.578125”	14.6844
19/32"	.59375”	15.0812
39/64"	.609375”	15.4781
5/8"	.625”	15.875
41/64"	.640625”	16.2719
21/32"	.65625”	16.6688
43/64"	.671875”	17.0656
11/16"	.6875”	17.4625
45/64"	.703125”	17.8594
23/32"	.71875”	18.2563
47/64"	.734375”	18.6531
3/4"	.75”	19.05
49/64"	.765625”	19.4469
25/32"	.78125”	19.8438
51/64"	.796875”	20.2406
13/16"	.8125”	20.6375
53/64"	.828125”	21.0344
27/32"	.84375”	21.4312
55/64"	.859375”	21.8281
7/8"	.875”	22.225
57/64"	.890625”	22.6219
29/32"	.90625”	23.0188
59/64"	.921875”	23.4156
15/16"	.9375”	23.8125
61/64"	.953125”	24.2094
31/32"	.96875”	24.6062
63/64"	.984375”	25.0031
1"	1.0”	25.4

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HOT STIX Cartridge Heaters

Internally Connected, High Temp Leads

- Fiberglass braided, mica tape insulated lead wires
- 850°F (450°C) maximum temperature rating
- ¼" minimum unheated area at lead end is required

- 100 Watts Per Square Inch
- 120 or 240 Volts

Electrical Connections:

Parallel - wired in parallel at applied voltage.

Series - two 120 volt heaters can be wired in series for 240 volt.
Or 240 volt heaters can be wired in series for 480 volt.

Cartridge Heater Selection Guide

Determine required heater specifications as indicated on this diagram, plus voltage and wattage.

Heater Construction Features

- Tubing is manufactured from alloy that maximizes heat transfer from the heating element to the part being heated.
- The outside diameter tolerance of the cartridge heater is -.004" ±.002" to ensure a tight fit in the hole into which the heater is installed. The tolerance on length is ±2% or ±3/32", whichever is greater.
- Nickel-Chromium resistance wire is precision wound to ensure the maximum amount of wire possible in each heater.
- Ceramic cores are manufactured to close tolerances to maximize heat transfer.
- Extra long, UL and CSA approved lead wire, exiting along the axis, is standard.
- High purity Magnesium Oxide packing for even heat distribution.

Fully swaged for higher temperatures and better durability

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HOT STIX GP Cartridge Heaters

Suitable for Most Heating Applications

- 842°F (450°C) maximum temperature
- 100 watts per square inch for fast start-ups
- 24" swaged electrical leads standard (except where noted)

Note: Actual cartridge diameters are .004" less than nominal size listed, ±.002"

Item #	Diameter	Length	Volts	Watts
135818	¼"	1"	120	150
135819		1½"	120	150
135820			240	200
135822		2"	120	250
135821			240	150
135823		2½"	120	150
135824			240	200
135826		3"	120	300
135825			240	
135828		4"	120	300
135827			240	200
137544 (36" leads)				300
135829	3/8"	1½"	240	250
135830		2"	120	200
135831			240	250
137634		2½"	120	300
135832			240	
150549		3"	120	300
135834			240	
135835				500
135836		3½"	120	300
135837			120	500
135838		4"	120	300
135839			240	400
135840				500
137805 (12" leads)		5"	120	500
135841			240	300
135842				500
135843		5½"	240	750
135844		6"	240	600
135845		7"	240	600
135846		8"	120	600
135847			240	1000
135848		10"	240	1000
137495		12"	240	1000

continued on next page

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HOT STIX GP Cartridge Heaters

(continued)

Item #	Diameter	Length	Volts	Watts
135849	½"	1½"	120	150
135850		2"	240	300
135851		2½"	120	300
137804 (12" leads)		3"	120	300
135852			240	
135853		3½"	240	500
135854		4"	120	300
135855			240	250
135856				500
135857				1000
135858		4½"	240	750
135859		5"	240	500
135860		6"	240	500
140082				1000
135861		8"	240	500
135862				1000
135863		10"	240	500
140083				1000
163234 (90° exit)				
162684		12"	240	1000
135864				1500
162685		14"	240	1000
162686		16"	240	
135865	⅝"	3"	240	500
135868		4"	240	
135869		5"	240	750
135866		7"	240	1000
135867		8"	240	500
135870		8"	240	1000
135871		10"	240	
135872		12"	240	
135873	¾"	4"	240	500
135874		5"	240	1000
135875		6"	240	500
135876		8"	240	1000
135877		10"	240	
135878		12"	240	

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¼" dia HOT STIX IN Cartridge Heaters

For Internally Heated Nozzles

Special Purpose ¼" diameter Cartridge Heaters are made expressly for nozzles. The mica-fiberglass lead sleeving protects the swaged leads from breaking, reducing equipment costs.

- 842˚F maximum temperature (higher temperatures available upon request)
- 10" swaged leads (not crimped)

Note: Insert cartridges into nozzle holes lead end first. Always push cartridges into nozzle, do NOT pull on leads.

Item #	Diameter	Length	Volts	Watts
135879	¼"	1"	120	125
135880		1½"	240	150
135881		2"	120	175
135882			240	
135883		2½"	240	175
135884		3"	120	200
135885			240	
135886		4"	120	300
135887			240	
135888		5"	120	300
135889			240	
135890		6"	120	400
135891			240	
135892		7"	240	600
135893		8"	120	600
135894			240	

Don't see what you need? Call IMS for a quote today!

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HOT STIX TC Cartridge Heaters

With Built-In Type J Thermocouple

Cartridge Heaters with Built-In Type J Thermocouple provide a quick and easy way to get accurate temperature readings of your cartridge heaters. No need to fumble with extra thermocouples when one is already included.

- 850°F (450°C) lead wire maximum temperature
- Built-in bottom grounded thermocouple
- 36" leads (both power and T/C standard)
- Power leads: T/C (-) red, T/C (+) white

Note: Actual cartridge diameters are .004" less than nominal size listed, ± .002".

Item #	Diameter	Length	Volts	Watts
135896	¼"	1½"	240	200
135897		2"	240	200
135898		2½"	120	200
135899			240	200
135900		3"	240	200
135901		4"	240	250
135902		5"	240	250
135903	⅜"	1½"	240	200
135904		1¾	240	250
135905		2"	240	250
135906				300
135907		2½"	240	300
135908		3"	240	260
135909				500
135910		3½"	240	320
135911				500
135912		4"	240	370
135913				500
135914		4½"	240	420
135915				500
135916		5"	240	750
135917		5½"	240	750
135918		6"	240	575
135919				750
135920				1000
135921		6½"	240	1000
135922		7"	240	1000
135923		8"	240	1000
137727		8½"	240	1000
136110		10"	240	1000

continued on next page

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HOT STIX TC Cartridge Heaters

With Built-In Type J Thermocouple (continued)

Item #	Diameter	Length	Volts	Watts
136111	½"	2"	240	400
136112		3"	240	750
136113		3½"	240	420
136114		4"	240	750
136115		4½"	240	750
136116		5"	240	1000
136117		6"	240	775
136118				1000
136119		7"	240	1000
136120		7½"	240	1000
136121		8"	240	1500
136122		9"	240	1500
137460		10"	240	2000
136124	⅝"	4"	240	1000
136126		7"	240	1500
136127		10"	240	2000

Check Out These Other Useful IMS Products!

Heat Resistant Gloves

Use them for quick transfer of hot Nozzles, Screws, Screw Tips, Molds, Water Lines, Heater Bands, etc.

- Heat resistant up to 400°F (short duration)
- Special nitrile rubber coating improves grip — prevents slipping
- Comfortable and breathable 100% cotton
- Extra thick inner liner resists heat
- One size fits all

Hot Nozzle Gloves
with anti-slip coating

Item No. 110671

- Maximum Use Temperature: 190°F
- Heat resistant dots leave no marks on product
- Dots on both sides
- One size fits all

High Heat PVC Dot Gloves

Item No. 136368

See Pages 446-447 For More Gloves and Pricing

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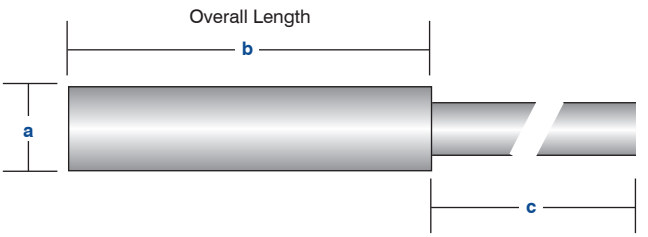
REQUEST FOR QUOTE: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

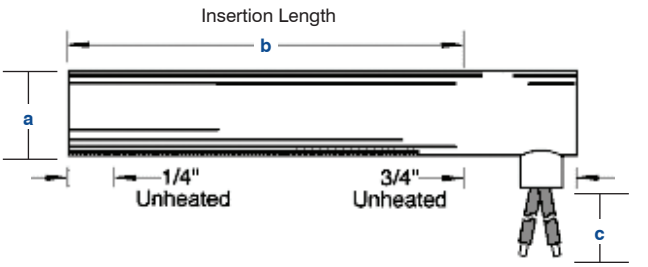
Non-Stock Cartridge Heaters

SPECIFY:

Standard



Right Angle



Style: ☐ Standard ☐ Right Angle

a) Outside Diameter: _____

b) Overall or Insertion Length: _____

c) Lead Length: _____

Lead Type: _____
(Standard, stainless steel braided and armored available)

Voltage: _____

Wattage: _____

Built-in Type J Thermocouple? ☐ Yes ☐ No

Is Heater for an Internally Heated Nozzle? ☐ Yes ☐ No

Maximum Use Temperature: _____ ° F

24-48 Hour Expedite Service? ☐ Yes ☐ No

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

If the heater you need isn't in stock, we'll have it made and get it to you in

24-48 HOURS!

(expedite charges apply)

NOTE: In the manufacture of non-stock products, it is necessary to allow for losses in production. We reserve the right to ship the following variations in quantities.

Quantity Ordered	Shipping Variations
1-5	No variation
6-10	+/- 1 unit
11-25	+/- 2 units
26-50	+/- 3 units
51-75	+/- 4 units
76-99	+/- 5 units
100 +	+/- 5 Percent

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GREEN Products

IMS Heat Transfer and Anti-Seize Compounds

SAFEKOTE 60™

INFRA-KOTE

These products consists of metal powders blended into a grease carrier to allow it to be applied. The grease carrier will break down at the temperature listed, but the products will continue to provide heat transfer up to the listed temperature limits of the metal powders.

Will Not Harden

Both excellent heat transfer compounds for use with cartridge heaters and heater bands.

Improve surface contact between heaters and equipment, extending heater life, providing better response times and reducing energy costs.

An affordable, high heat compound for continuous use up to 600°F

- Eliminates trouble-causing air pockets
- Distributes heat more uniformly
- Reduces scale and oxidation
- Helps prevent seizing and galling

Limited use heat transfer compound formulated for continuous use up to 350°F

- Prolongs heater life
- Cuts energy costs
- Ensures consistent heat transfer
- Facilitates heater removal

Specifications

Melting point of Copper:	1981°F
***Max. Continuous Service Temp. for Carrier Medium:**	600°F – For Cartridge Heaters and Threads (not exposed to air)

Also an excellent anti-seize compound for use on end cap bolts, and nozzle and screw tip threads.

Specifications

Melting point of Copper:	1981°F
Melting point of Aluminum:	1220°F
Melting point of Graphite:	In air, 750°F to 1100°F in a reduced oxygen environment, 6700°F
Max. Continuous Service Point:	350°F
Grease Media Decomposition:	550°F

Item #	Description
130787	12-oz. jar SAFEKOTE 60™ complete with brush top

Item #	Description
103781	16-oz. jar Infra-Kote with brush top

SAFEKOTE 60™ is a trademark of IMS Company

Available ONLY from IMS!

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Type J and K Thermocouples

Type	Conductor Characteristics		Temperature	Limits of Error	
	Positive	Negative	Range (°F)	Standard	Special
J	Iron-White	Constantan-Red	32 to 530	± 4° F	± 2° F
	(Magnetic)	(Non-Magnetic)	530 to 1400	± ¾ %	± ⅜ %
K	Chromel-Yellow	Alumel-Red	32 to 530	± 4° F	± 2° F
	(Non-Magnetic)	(Magnetic)	530 to 2300	± ¾ %	± ⅜ %

Thermocouple Junctions

Grounded:

This is the plastics industry standard. It is a good, general-purpose sensing system for measuring solids such as plastic material and for surface applications.

Ungrounded:

This junction is electrically isolated from the measured medium, making it excellent for use in conductive environments, where stray voltages and EMF can leak into normal millivolt outputs, resulting in false readings at the control or readout device. Most of our standard T/C's are available ungrounded to special order.

Type J and K (industry standard) Thermocouples are an excellent choice for molding temperature sensors. IMS carries several styles, providing you with exactly what you need.

How they work

Thermocouples are made of a variety of materials. When select dissimilar metals are joined, they produce a millivolt signal corresponding to the temperature. A rise or fall in temperature results in a rise or fall in the millivolt output. Millivolt signals are electronically amplified to display or control various thermal activities.

Additional thermocouple options

RTD (Resistance Temperature Detectors) and ungrounded thermocouples are all available as special orders. Contact the IMS Supplies Team at sales@imscompany.com or call 800.537.5375 for additional information.

Most IMS Stock Thermocouples are Grounded unless otherwise noted.

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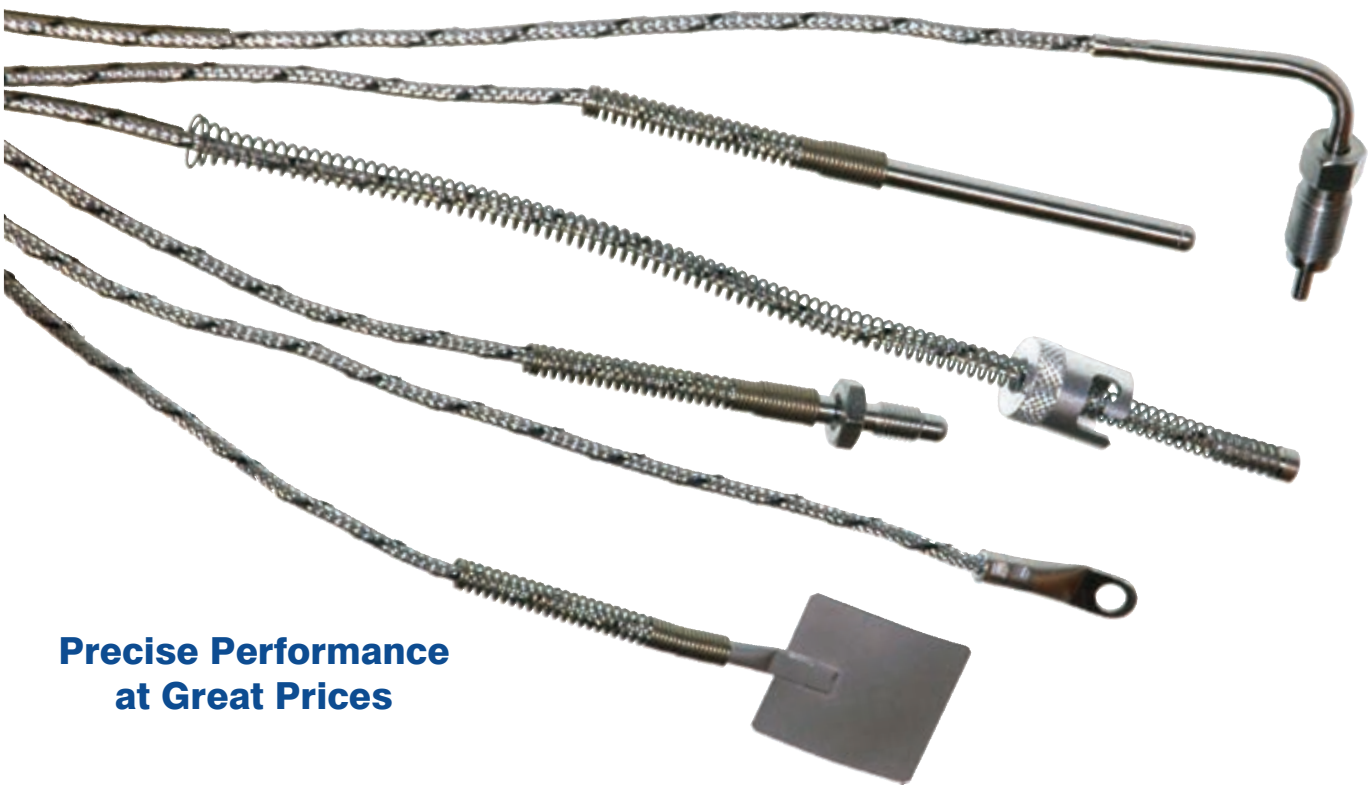
SAWI Swiss Made Thermocouples



Precise Performance at Great Prices

Unchallenged Quality and Performance

Since 1965, Sawi has manufactured premium temperature sensing products while closely following their core beliefs in quality improvement and uncompromised delivery. Sawi specializes in state of the art miniaturization, improved sensor response time, and the development of new temperature control sensors for the ever-changing demands of the market. These Swiss-made thermocouples are considered the highest quality sensors in the marketplace today. You can be assured when you receive a Sawi style thermocouple, you are receiving the most reliable and durable sensor out there. That is why Sawi sensors are so widely preferred in so many different temperature control and monitoring applications.

IMS is proud to offer the entire Sawi line of sensor products; from the plastics industry standard thermocouples, to ultrasensitive miniature temperature sensors, to the latest technology in mold and cavity sensors.

What does this mean for you and your company? If you need a temperature or pressure sensor for a hot runner system, nozzle or barrel temperature control, or any other special application sensor, IMS can deliver the very best available sensor there is to offer.

- Unchallenged Quality and Performance
- Dependability
- More Precise Measurements Allow You to Mold Better Parts

NOTE: Other types available upon request

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SAWI Swiss Made Thermocouples

In Hole Styles

Probe Type

- Tip OD: 3/16"
- Kapton® Coated Fiberglass Leads reinforced with Stainless Steel Overbraid for Durability
- Lead Termination: Stripped Ends
- Grounded
- MAX. Operating Temperature: 842°F / 450°C

Type J				Type K
Item #	Probe Length	Lead Length	Bendable	Item #
146643	1"	48"	Non-Bendable	
146644		96"		159850
146645		144"		
146646	2½"	48"		159852
146647		96"		159853
146648		144"		159854
146649	12"	48"	Bendable	159855
146650		96"		
146651		144"		

Spare Part	
103616	⅛" N.P.T. compression fitting

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Fixed Depth, Direct Melt Temperature-Sensing Type

- Direct Melt Style: "B" 90° Bend
- Thread: 3/8"-24 w/swivel nut
- Kapton® Coated Fiberglass Leads reinforced with Stainless Steel Overbraid for Durability
- Lead Termination: Spade Lugs
- MAX. Operating Temperature: 842°F / 450°C
- Hastelloy Tip Material

Type J Item #	Lead Length	Tip Depth	Tungsten Carbide Coating	Dual Leads*	Junction
147012	48"	⅛"	Yes	No	Grounded
147013	96"				
147014	144"				
146652	48"	¼"	No		
146653	96"				
146654	144"				

*1 to indicator, 1 to controller

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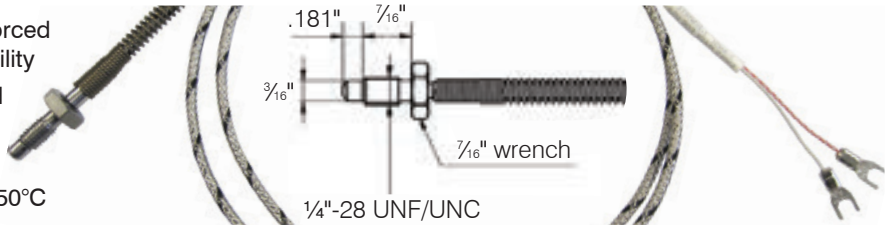
SAWI Swiss Made Thermocouples

In Hole Styles

Nozzle Bolt Type

- Kapton® Coated Fiberglass Leads reinforced with Stainless Steel Overbraid for Durability
- 118° Tip Shape to Optimize Contact and Heat Transmission
- Lead Termination: Spade Lugs
- MAX. Operating Temperature: 842°F / 450°C



Type J			Type K
Item #	Lead Length	Junction	Item #
146509	48"	Grounded	159858
146510	96"		159859
146511	144"		159860
146515	48"	Ungrounded	159861
146516	96"		159862
146517	144"		159863

Variable Depth Type – Bayonet & Spring

- Grounded
- Kapton® Coated Fiberglass Leads reinforced with Stainless Steel Overbraid for Durability
- 118° Tip Shape to Optimize Contact and Heat Transmission
- MAX. Operating Temperature: 842°F / 450°C
- Polarized Plug or Spade Lugs

Type J	Bayonet Cap Adjustment Range	Tip		Lead Length	Style	Lead Termination	Type K
Item #		Diameter	Length				Item #
146662	1" to 12"	1/4"	1/8"	48"	Straight	Polarized Plug	159864
146663				96"			159865
146664				144"			
147015				48"		Spade Lugs	159873
147016				96"			159874
147017				144"			159875
147029	1/2" to 3/4"	3/16"	9/32"	96"			159868
				144"			159869
147021	1 1/4" to 1 3/4"		25/32"	48"			159876
147022				96"			159877
147023				144"			
147025	1/2" to 3/4"		9/32"	96"	90°		159871
147018	1 1/4" to 1 3/4"		25/32"	48"			159879
147019				96"			159880
147020				144"			

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SAWI Swiss Made Thermocouples

Surface Styles

Spade Type

- Spade Size: 30mm square
- Kapton® Coated Fiberglass Leads reinforced with Stainless Steel Overbraid for Durability
- Lead Termination: Spade Lug
- Grounded
- MAX. Operating Temperature: 842°F / 450°C
- Heavy Duty Strain Relief to Promote Durability

Type J Item #	Lead Length	Type K Item #
146506	48"	159882
146507	96"	159883
146508	144"	159884

Washer Type

- Washer: Stainless Steel
- Kapton® Coated Fiberglass Leads reinforced with Stainless Steel Overbraid for Durability
- Lead Termination: Spade Lugs
- Grounded
- MAX. Operating Temperature: 842°F / 450°C

Type J Item #	Hole ID	Lead Length	Type K Item #
146512	1/4"	48"	159885
146513		96"	159886
146514		144"	159887
146518	3/16"	48"	159888
146519		96"	159889
146520		144"	

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SAWI Swiss Made Thermocouples

Hot Runner Style

- Kapton® Coated Fiberglass Leads reinforced with Overbraid for Durability
- Lead Termination: Stripped Ends
- Heavy Duty, Stainless Steel Strain Relief with 30 lb Rating
- Grounded
- High-Tech Sensor with Mineral Insulated Thermocouple
- Small, Stainless Steel Transition Fitting
- 482°F Max

Type J Item #	Tip OD	Tip Length	Lead Length	Type K Item #
147030	1mm	110mm	48"	159891
147031			96"	
147032			144"	
147033		150mm	48"	
147034			96"	159895
147035			144"	
147040		200mm	48"	
147041			96"	
147043	1.5mm	110mm	48"	Inquire
147044			96"	
147045			144"	
147046		150mm	48"	
147048			144"	
147049		200mm	48"	
147050			96"	

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SAWI Swiss Made Thermocouples

Newbury Nozzle Style

Held in place with a set screw, the Newbury Nozzle Thermocouple senses temperature from the hole sides. Insert it from either side since the nozzle has a straight through hole.

- Type J thermocouple
- 1" long with 90° bend
- 0.118 diameter stainless steel welded tip
- Braided stainless steel electrical leads with stripped ends
- Grounded
- Heavy duty strain relief

Type J Item #	Lead Length
147009	48"
147010	96"
147011	144"

Other lead lengths, types and ungrounded thermocouples available — Inquire

Band Clamp with Thermocouple Adaptor

IMS Band Clamp Adaptors secure thermocouples to permit highly accurate surface temperature readings. For even greater accuracy, drill a 7/32" hole 1/8" deep for thermocouple tip.

- 9/16" wide, stainless steel clamp
- Corrosion-resistant plated adaptor and bushings
- Replaceable 2" bayonet adaptor

Item #	Description
140592	1 1/16" - 2"
140593	2 1/16" - 3"
140595	3 5/16" - 4 1/4"
105566	4 1/8" - 7"

Thermocouple sold separately

Nozzle and heater band sold separately

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fax order toll-free (USA & Canada) 1.888.288.6900 | phone order toll-free (Mexico) 001.888.304.1307 | tech support toll-free (USA & Canada) 1.866.467.9001 | e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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All-In-One, Hose Clamp Thermocouples

Use anywhere T/C holes are unavailable or impractical. No drilling, No tapping required.

Quick, Easy Installation and Removal

T/C junction is on the inside of the clamp to ensure good surface contact

Nozzle and Heater Band sold separately

Available with 48" or 96" stainless steel braided leads

All corrosion-resistant stainless steel, including worm-gear housing and screw

Band and Thermocouple are one, complete, compact unit!

Photo shows an All-In-One Thermocouple on an injection nozzle

Type J (Iron/Constantan) - Grounded

ALL-IN-ONE Thermocouple Quantity Discounts
Order 25 or more **DEDUCT 10%**

Item #	Decimal	Metric	Lead Length (Inches)
140095	1 1/16" to 2 1/16"	27 to 51	48"
140102	1 1/16" to 2 1/16"	27 to 51	96"
140096	2 1/16" to 3"	52 to 76	48"

In Stock

Larger sizes available to special order

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Made in the U.S.A

IMS Brand Thermocouples

High Quality in a Basic Design

7 Styles Available

Common Specifications

- Grounded
- Flex Leads with Stainless Steel Braid
- Spade Lug Terminals

1 to 12" Variable Depth Style - Bayonet and Spring

- Type J
- 3/16" Tip Diameter x 3/16" Tip
  Can be used in place of 1/4" tip diameter
- Heavy Duty Strain Relief

Item #	Lead Length
171141	48"
171142	96"

Spade Style

- Type J
- 1" x 1" Spade
- Heavy Duty Strain Relief

Item #	Lead Length
169558	48"
171136	96"

- Type K
- 1" x 1" Spade
- Heavy Duty Strain Relief

Item #	Lead Length
171418	48"

Nozzle Style

- Type J
- 1/4" - 28 UNF Thread, 7/16" Hex Fitting
- 3/16" Tip Diameter
- Heavy Duty Strain Relief

Item #	Lead Length
171137	48"
171138	96"

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IMS Brand Thermocouples (continued)

High Quality in a Basic Design

Made in the U.S.A

Washer Style

- Type J
- Stainless Steel Washer
- Strain Relief on Leads

Item #	Hole	Lead
171139	¼"	48"
171140	3⁄16"	48"

Probe Style

- Type J
- 3⁄16" Probe Diameter

Item #	Probe	Lead
171132	1"	48"
171133	1"	96"
171134	2½"	48"
171135	2½"	96"

90˚ Variable Depth Style

- Type J
- ½" - ¾" Variable Depth Spring Style
- 90˚ Bend
- Stainless Steel Leads and Spade Lugs
- 3⁄16" Tip Diameter x 9⁄32" Tip Length

Item #	Lead Length
171697	48"

Variable Depth Extended Probe Style

- Type J
- 1-10" Variable Depth Spring Style
- Straight Style
- Stainless Steel Leads and Spade Lugs
- 3⁄16" Tip Diameter x 9⁄32" Tip Length
- 1 7⁄8" Overall Probe Length

Item #	Lead Length
171712	48"
171713	96"

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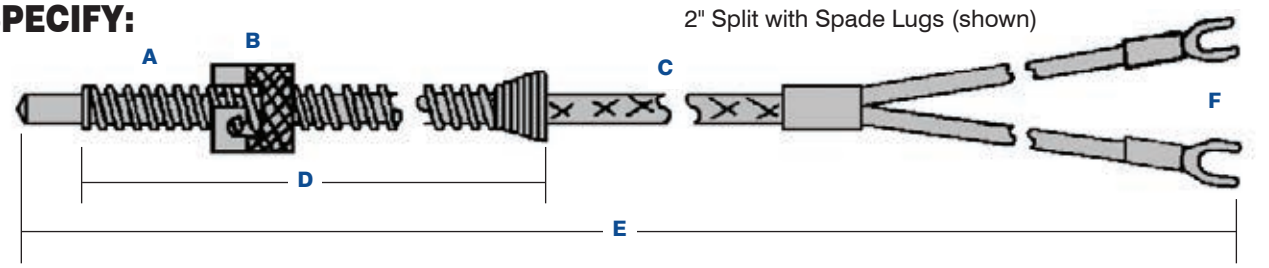
REQUEST FOR QUOTE: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

Non-Stock Spring Adjustable Immersion Thermocouples

SPECIFY:



Thermocouple Type: ☐ J ☐ K ☐ Other _____

Junction: ☐ Grounded ☐ Ungrounded

Conductor Wire: ☐ Solid ☐ Stranded

A) Tip and Spring O.D. (NOTE: Tip O.D. will indicate Spring O.D.)

Tip O.D.	Spring O.D.
☐ .125"	.203"
☐ .188"	.263"
☐ .250"	.324"

B) Bayonet Cap Style: ☐ 7⁄16" I.D. Single Slot (standard) o 15 mm I.D. Dual Slot ☐ 12 mm I.D. Slot o Positive Seat Indicating ☐ 12 mm O.D. Pin

C) Lead Type: ☐ Fiberglass Insulation ☐ Stainless Steel Braid ☐ Stainless Steel Armor

D) Spring Length: _____

E) Overall Length with Lead Wire Termination: _____

F) Terminations: ☐ Leads Not Stripped ☐ Standard Male Plug ☐ Mini Male Plug ☐ 2" Split, ¼" Stripped ☐ Standard Female Jack ☐ Mini Female Jack ☐ 2" Split with Spade Lugs ☐ 2" Split with ¼" Female Disconnects

Options: ☐ Mating Connector ☐ Cable Clamp ☐ Box Connector

If you have any questions, contact the IMS Supplies Team at sales@imscompany.com

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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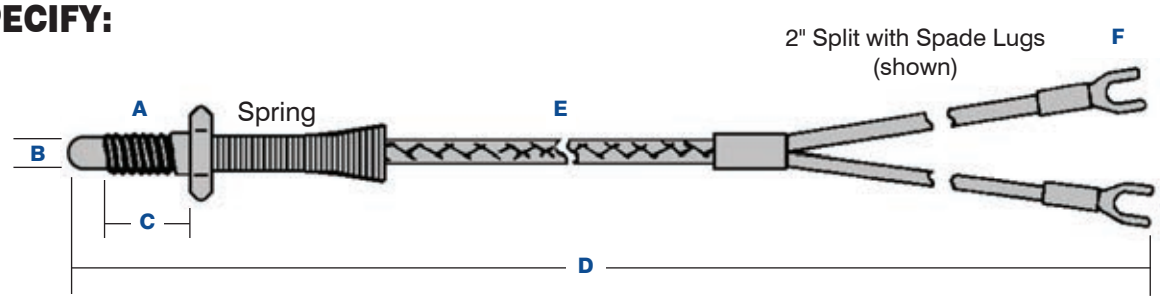
Non-Stock Threaded Nozzle Thermocouples

SPECIFY:



Thermocouple Type: ☐ J ☐ K ☐ Other _____

Junction: ☐ Grounded ☐ Ungrounded

Conductor Wire: ☐ Solid ☐ Stranded

A) Thread Size	B) Tip O.D.	C) Thread Length (NOTE: Thread Size will indicate Tip O.D. and Thread Length)
☐ ¼"-28	3⁄16"	⅜"
☐ ⅜"-24	¼"	½"
☐ 6mm X 1mm	3⁄16"	10mm
☐ 8mm X 1.25mm	¼"	10mm

D) Overall Length with Lead Wire Termination: _____

E) Lead Type: ☐ Fiberglass Insulation ☐ Stainless Steel Braid ☐ Stainless Steel Armor

F) Terminations: ☐ Leads Not Stripped ☐ Standard Male Plug ☐ Mini Male Plug
☐ 2" Split, ¼" Stripped ☐ Standard Female Jack ☐ Mini Female Jack
☐ 2" Split with Spade Lugs ☐ 2" Split with ¼" Female Disconnects

Options: ☐ Mating Connector ☐ Cable Clamp ☐ Box Connector

If you have any questions, contact the IMS Supplies Team at sales@imscompany.com

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Name: _____ Title: _____

Company Name: _____ Email: _____

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City: _____ State: _____ Zip: _____

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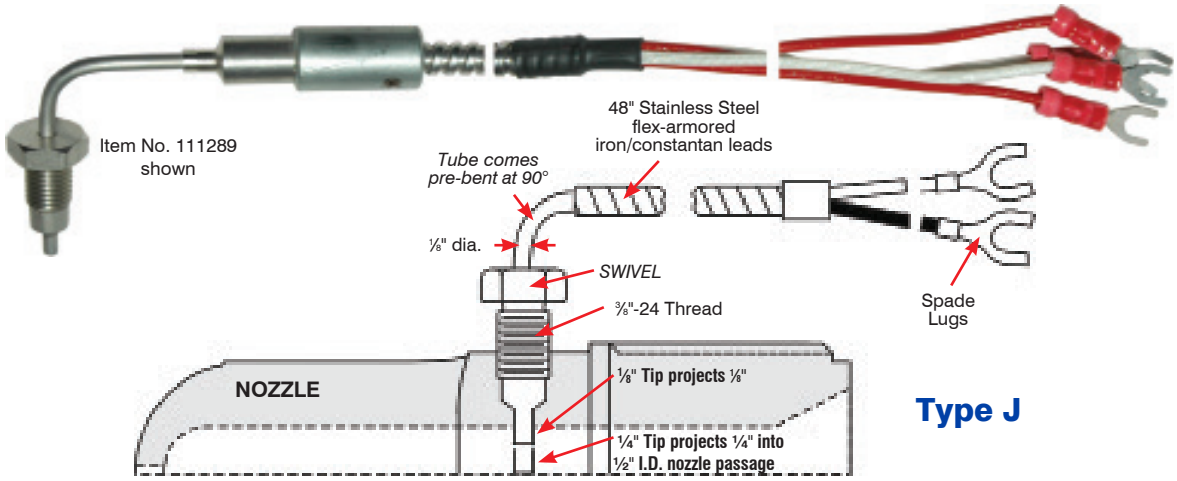
Direct Melt-Temperature-Sensing Thermocouples

Obtain Actual Temp of Hot-Melt Stream for Precise Process Control



Replaceable Type "J" Thermocouples screw into tapped hole in nozzle. Tip projects into material flow.

⅛" Tip

- Tip protrudes ⅛" into melt for less exposure to wear
- Use with filled or abrasive plastics
- 48" Lead and ⅜"-24 fitting

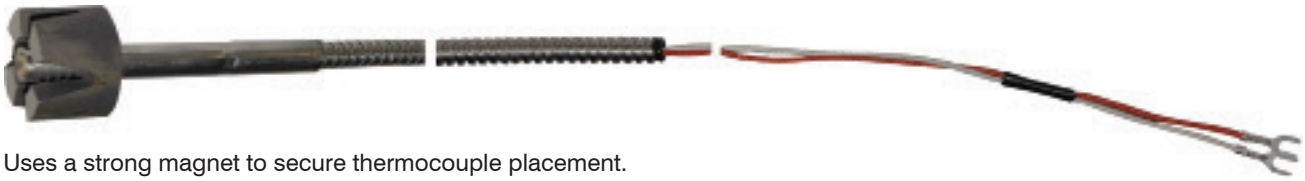
¼" Tip

- Tip protrudes ¼" into melt for most accurate measurement
- Use with non-abrasive materials
- 48" Lead and ⅜"-24 fitting

Item #	Description
111289	⅛" Tip Direct Melt Temperature Sensing Thermocouple Grounded with 2 pairs of leads (1 to indicator / 1 to controller)
Optional Accessories	
104720	Plug for style B thermocouple hole (⅜"-24 THD)

Surface Thermocouple — Magnetic Type

Ideal for Sensing Surface Temperatures



Uses a strong magnet to secure thermocouple placement.

- Type J thermocouple
- Simple installation
- 48" flexible armored lead and removable coupling
- Grounded

Item #	Description
103571	Magnetic Type Thermocouple

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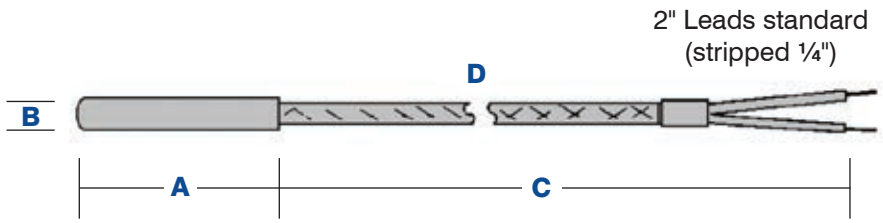
Non-Stock Cartridge Type Thermocouple

SPECIFY:



Thermocouple Type: ☐ J ☐ K ☐ Other _____

Junction: ☐ Grounded ☐ Ungrounded

A) Sheath Length: _____

B) Sheath Diameter: _____

C) Lead Length: _____

D) Lead Type: ☐ Stainless Steel Braid ☐ Stainless Steel Armor ☐ Other _____

E) Terminations: ☐ Leads Not Stripped ☐ Standard Male Plug ☐ Mini Male Plug

☐ 2" Split, ¼" Stripped ☐ Standard Female Jack ☐ Mini Female Jack

☐ 2" Split with Spade Lugs ☐ 2" Split with ¼" Female Disconnects

Options: ☐ Mating Connector ☐ Cable Clamp ☐ Box Connector

If you have any questions, contact the IMS Supplies Team at sales@imscompany.com

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Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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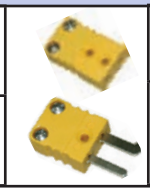
Type J and K Thermocouple Accessories

Polarized Mini Connectors

Item #	Description	Dimensions
103668	Type J female jack	¾" W x 1" L 5⁄16" hole spacing
103684	Type J male plug	¾" W x 1" L 5⁄16" pin spacing
103677	Cable clamp (Type J & K) Includes 4 screws	



Item #	Description	Dimensions
137268	Type K female jack	¾" W x 1" L 5⁄16" hole spacing
137269	Type K male plug	¾" W x 1" L 5⁄16" hole spacing

Polarized Connectors

Item #	Description	Dimensions
103639	Type J female jack	1" W x 1¼" L 7⁄16" hole spacing
175711	Type J female jack	1" W x 1⅜" L 7⁄16" hole spacing
103714	Type J male plug	1" W x 1¼" L 7⁄16" pin spacing
175710	Type J male plug	1" W x 1⅜" L 7⁄16" pin spacing

Item #	Description	Dimensions
135499	Type K female jack	1" w x 1¼" L 7⁄16" hole spacing
135497	Type K male plug	¾" w x 1" L 7⁄16" pin spacing
103648	Cable clamp (fits: 103639, 103714, 135499, 135497)	
175712	Wire clamp (fits: 175710, 175711)	

Thermocouple Lead Wire (Iron/Constantan)

16-Gauge for Standard Connection - This duplex, solid-wire construction consists of wires individually covered with extruded, color-coded PVC, then paralleled and jacketed with PVC to provide excellent moisture and abrasion resistance. Continuous-use temperature limit: 221°F (105°C).

24-Gauge for Mini Connection - Duplex, solid-wire construction consists of wires individually covered with glass or glass insulation. For temperatures up to 900°F (482°C).

Single Circuit Thermocouple Jack Panels

Type K Standard shown

Type K Mini shown

Item #	Desc.
103579	Type J 16-Gauge
108415	Type J 24-Gauge

Item #	Desc.
148224	Type K 16-Gauge
148711	Type K 24-Gauge

Item #	Desc.
137116	Type J Mini
138770	Type J Standard

Item #	Desc.
148712	Type K Mini
160704	Type K Standard

NOTE: When installing plugs or jacks remember - Iron is the positive wire (white) and can be identified with a magnet. Constantan is the negative wire (red).

Thermocouple Adaptors

⅛"-27 N.P.T.

Item #	Length
103585	⅞"
103645	2¼"
158322	3½"

⅜"-24 NF

Item #	$11.75
103704	⅞"
131699	2½"

12mm x 1mm

Item #	Length
112803	1"

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Microprocessor Calibrator Thermometer

Now just one, single instrument can be used to check the calibration accuracy of the eight most common T/C Type devices: J, K, T, E, C, R, S and N

1) Lets you calibrate temperature equipment more accurately

High accuracy calibration function simulates precision thermocouple outputs for use in calibrating thermometers, transmitters, controllers or recorders.

2) Lets you check temperatures more quickly

One model for multiple thermocouple types with precision output displayed as mv or °c/°f.

- Five user adjustable calibration values for fast calibrations
- °C/°F switchable for increased versatility
- Displays output in terms of millivolts or temperature based on thermocouple tables
- 4 digit LCD display is easy to read with thermocouple type indication

Measurements and Source Ranges:

Type J	-58° to 1830°F	-50° to 1000°C
Type K	-58° to 2498°F	-50° to 1370°C
Type T	-184° to 752°F	-270° to 400°C
Type E	-58° to 1382°F	-50° to 750°C
Type C	32° to 3182°F	0° to 1750°C
Type R	32° to 3182°F	0° to 1750°C
Type S	32° to 3182°F	0° to 1750°C
Type N	-58° to 2372°F	-50° to 1300°C
Voltage	-5.00mV to +55.00mV	10μV

Thermocouple calibration cables (terminated with subminiature connectors on either side) are standard

100-240 Volt CE

Item #170050

Includes: Type K thermocouple calibration cable, copper calibration cable, 6 AA batteries, AC adaptor/recharger and hard carrying case.

Resolution: 0.1° (measure) / 1° (source)
Accuracy: ±0.05% +1.8° F / 1°C
Input Impedance: 10 Mohm
Display Update: 4 times per second
Cold Junction Compensation: 0.02°F per °F (0.03°C per °C)
Battery: 6 AA batteries or AC adaptor
Dimension: 6.3" x 3.2" x 1.7" (159mm x 80mm x 44mm)
Weight: 8 oz (not including batteries)

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Type K Digital Thermometers

Use to Check Temperatures Of Melted Plastic, Hot Air and Mold Cooling/Heating Fluids

NIST Certificate of Calibration available
Inquire

Versatile
-58° to +1,999° F Range

Accurate
±(0.3% of reading +2° F)

Easy To Read
11/16" high LCD digits

Thick Rubber Holster not only provides protection but also includes a handy, flip-out stand.

NOTICE
NOT for use on electric components — SHOCK HAZARD

Readout Specifications

Measuring Range: .....58° to +1,999°F (-50° to +1,300° C)
Accuracy: ..... ±(0.3% rdg. +2° F)
±(0.3% rdg. +1° C); >1,000° C (0.5%)
Resolution: ..... 0.1° or 1°
Display: ..... Four LCD Digits, 11/16" high
Power Source: ..... 6 AAA batteries
Overall Dimensions: ..... 5.2" L x 2.8" W x 1.2" D
Weight: ..... 8.3 oz.

INCLUDES: Meter, Rubber Holster with Flip-out Stand, Naked-bead Temperature Probe (T/C wires soldered at end) and 6 AAA Batteries.

117659	Type K Thermometer
129099	Type K Thermometer w/NIST Certificate
124061	Dual Input Type K&J w/programmable alarms

Case ONLY — Digital Thermometer not included

Optional
Stainless Steel Type K Temperature Probes

118019	General Purpose Probe (1292°F/700°C) (4" long Probe with 3 ft. Lead and 2-Pin Connector)
127717	Surface Probe (932°F/500°C) (6" long Probe with 8 mm dia. Tip and 24" coiled Lead and 2-Pin Connector)
128102	Immersion Probe (1652°F/900°C) (6" long Probe with 24" coiled Lead and 2-Pin Connector)
123136	Naked-bead Temperature Probe
136845	Carrying Case Soft Vinyl

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Type K & J Input Thermometers

Provides Greater Flexibility For Accurate Temperature

Large backlit LCD display

improves ease of readability for operator

1 Year Warranty

Side-button controls

provides one-handed operation

- Wide temperature range with 0.1°/1° resolution
- Readout in °F, °C, or K (Kelvin)
- Data Hold function freezes reading on display
- Max/Min/Avg readings with relative time stamp
- Offset key used for zero function to make relative measurements
- Auto Power off with disable feature
- Single unit complete with Type K temperature probe and 9V battery

Single Input #161925 shown

Specifications

Accuracy: ± (0.15% + 1.8°F/1°C)
Size: 8¾" l x 2½" w x 1⅛" h
Weight: 7 oz.

Item #	Extech #	Description
161925	TM100	Single input thermometer
161926	TM100-NIST	Single input thermometer with NIST
	Optional Accessories	
161937	TP870	Type K bead wire temperature probe (482°F)
161938	TP875	Type K bead wire temperature probe (1000°F)

Compatible with the Stainless Steel Type K Temperature Probes on page 230

#118019

#127717

#128102

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Mini IR Non-Contact Thermometer

Precise Temperature Measurement in Difficult to Reach Surfaces

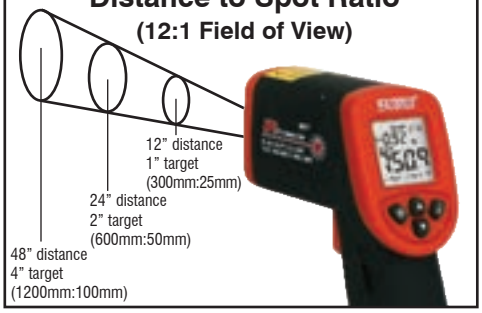
Adjustable Emissivity • Lightweight • Compact

This Improved Mini IR Non-Contact Thermometer from IMS measures surface temperature up to 1112°F and is ideal for spot checking heater bands, bearings, mold and melt temperatures and other hard to reach or unsafe to contact areas. The lightweight instrument is operated by a trigger, making it easy and convenient to use. A large, bright white backlit display makes temperature reading easy even in dim lighting, and the built-in laser pointer improves aim for increased accuracy.

New Features:

- Wider temperature range
- Includes removeable Type K Probe for readings up to 1832˚F
- Simultaneous Ambient, IR and Type K input temperature measurements

Distance to Spot Ratio
(12:1 Field of View)



Item #173605

Includes: Thermometer, Type K Probe and 9V Battery

Just Point and Squeeze Trigger for Reading

- Built-in laser helps pinpoint spot to be measured
- Automatic data hold maintains reading while writing documentation
- Bright backlighting facilitates use in dark areas
- Molded plastic housing
- Measures temperature up to 1112°F
- °F / °C Switchable

Includes Type K Probe

CE **Auto power off**

Specifications

Temperature Range

IR:	-58 to 1112°F (-50 to 600°C)
Ambient:	-4°F to 158°F (-20 to 70°C)
Type K:	-58 to 1832°F (-50 to 1000°C)
Accuracy:	±2% of reading or ±4°F (2°C)
Resolution:	0.1°F/°C
Distance to Target:	12:1
Emissivity:	0.05 to 1.00 (adjustable)
Power Supply:	9V Battery (included)
Size:	6.0" x 4.7" x 1.7" 153 mm x 120 mm x 42 mm
Weight:	5.1oz. (145g) without battery

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Hi Temp IR Thermometer

Facilitates Precise Temperature Measurement of Difficult to Reach Surfaces

Lightweight • Compact • Easy to handle

- Measures from -58°F to +1,832°F with 50 to 1 distance to target ratio
- Built-in laser pointer identifies target area
- High and low alarms
- Adjustable emissivity increases measurement accuracy for different surfaces
- Adjustable High/Low setpoints with audible alarm alerts user when temperature exceeds the programmed setpoints
- Min/Max/Avg plus differential between Max-Min
- Backlighting illuminates display for taking measurements at night or in areas with low background light levels
- Automatic Data Hold when trigger released (for 7 seconds — or lockable)
- Auto power off

Item #141777

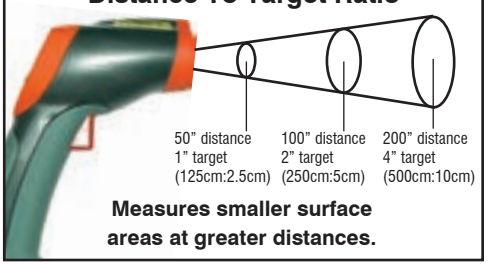
Includes: Thermometer, Hard Carrying Case and 9 volt Battery

Just Point and Squeeze Trigger for Reading

Large electroluminescent backlit LCD display facilitates use in dark areas

Hard Carrying Case

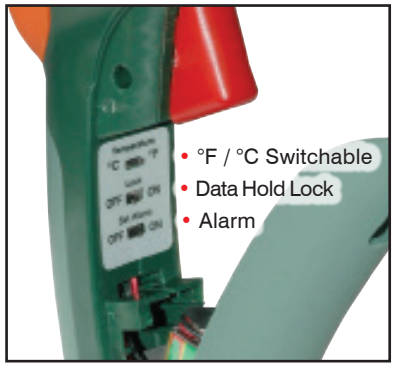
High 50:1
Distance To Target Ratio



Measures smaller surface areas at greater distances.

Specifications

Range:	-58° F to 1,832°F -50° C to 1,000°C
Accuracy:	±2% of reading +4°F (2°C)
Emissivity:	Adjustable
Resolution:	0.1° to 199.9°
Power Supply:	9 volt battery
Size:	3.9"L x 2.2"W x 9"H 100 mm x 56 mm x 230 mm
Weight:	10.2 oz. (290 g)



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Converting Fractional Inches To Decimals And Millimeters

Fraction	Decimal	MM
1/64"	.015625”	.3969
1/32"	.03125”	.7938
3/64"	.046875”	1.1906
1/16"	.0625”	1.5875
5/64"	.078125”	2.3812
3/32"	.09375”	2.3812
7/64"	.109375”	2.7781
1/8"	125”	3.175
9/64"	.140625”	3.5719
5/32"	.15625”	3.9688
11/64"	.171875”	4.3656
3/16"	.1875”	4.7625
13/64"	.203125”	5.1594
7/32"	.21875”	5.5562
15/64"	.234375”	5.9531
1/4"	.25”	6.35
17/64"	.265625”	6.7469
9/32"	.28125”	7.1438
19/64"	.296875”	7.5401
5/16"	.3125”	7.9375
21/64"	.328125”	8.3344
11/32"	.34375”	8.7312
23/64"	.359375”	9.1281
3/8"	.375”	9.525
25/64"	.390625”	9.9219
13/32"	.40625”	10.3188
27/64"	.421875”	10.7156
7/16"	.4375”	11.1125
29/64"	.453125”	11.5094
15/32"	.46875”	11.9063
31/64"	.484375”	12.3031
1/2"	.5”	12.7

Fraction	Decimal	MM
33/64"	.515625”	13.0969
17/32"	.53125”	13.4938
35/64"	.546875”	13.8906
9/16"	.5625”	14.2875
37/64"	.578125”	14.6844
19/32"	.59375”	15.0812
39/64"	.609375”	15.4781
5/8"	.625”	15.875
41/64"	.640625”	16.2719
21/32"	.65625”	16.6688
43/64"	.671875”	17.0656
11/16"	.6875”	17.4625
45/64"	.703125”	17.8594
23/32"	.71875”	18.2563
47/64"	.734375”	18.6531
3/4"	.75”	19.05
49/64"	.765625”	19.4469
25/32"	.78125”	19.8438
51/64"	.796875”	20.2406
13/16"	.8125”	20.6375
53/64"	.828125”	21.0344
27/32"	.84375”	21.4312
55/64"	.859375”	21.8281
7/8"	.875”	22.225
57/64"	.890625”	22.6219
29/32"	.90625”	23.0188
59/64"	.921875”	23.4156
15/16"	.9375”	23.8125
61/64"	.953125”	24.2094
31/32"	.96875”	24.6062
63/64"	.984375”	25.0031
1"	1.0”	25.4

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Converting Fractional Inches To Decimals And Millimeters

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1"	1.0”	25.4

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Process Trouble-Shooting Guidelines				
Problem	CRYSTALLINE MATERIALS Lower/Reduce	Raise/Increase	AMORPHOUS MATERIALS Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

IMS Hot Runner Testing System

Safely Troubleshoot Various Electrical Problems With Ease

Eliminates Days in Downtime - Save Hours in Maintenance

The Affordable Diagnostics System That Can Increase Worker Safety and Reduce Costly Mistakes

- Predict Heater and Thermocouple failure
- Spot check your hot runner system before and after installation of your manifold
- Simplifies troubleshooting, minimum training required
- Verify all hot runner cables are wired correctly and functional
- Completely portable and powered by 9-volt batteries (included)
- Prevent work place accidents – can prevent electrocution, burns and falls associated with climbing on machines

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Hot Runner Mold Testing System

MoldXChecker™

Troubleshoot And Diagnose Various Common Electrical Problems Within Your Hot Runner/Temperature Control System Quickly With Ease

>MoldXChecker™<

Check for Opens: Shows thermocouple or heater opens which can indicate damage to the mold or a misplaced wire.

Check for Shorts: Electrical shorts are dangerous and destructive to your temperature controller and its delicate components.

Check Mold Health: Test the Ohms in the drops, manifolds and sprues to ensure heaters and thermocouples are operating properly.

Dimensions: 8" x 8" x 4" Weight: 7 lbs

Item #166199

Includes: Checker, Two Year Warranty, Instruction Manual and Two 9V Batteries

Avoid Dangerous and Costly Unknown Electrical Shorts!

The Mold X Checker is equipped with standard DME® Style Power and Thermocouple Hot Runner Housing Connectors.

Custom Connectors Available

www.imscompany.com phone order toll-free (USA & Canada) 1.800.537.5375

fax order toll-free (USA & Canada) 1.888.288.6900 | phone order toll-free (Mexico) 001.888.304.1307 | tech support toll-free (USA & Canada) 1.866.467.9001 | e-mail sales@imscompany.com

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Hot Runner Cable Testing System

CableXChecker™

Quickly Diagnose Problems With Standard Hot Runner Heater and Thermocouple Cables

Check Pin and Wire Continuity: Pushed-in pins, unseated sockets, damaged pin crimps and severed wires are commonly difficult to detect with a standard multimeter.

Check for Cable Shorts: Shorts can be the most labor intensive diagnosis. The routine method for a standard 24-pin cable requires a 576 point-to-point test to diagnose a problem. The CableXChecker™ can check the same cable in less than a minute.

Check for Incorrectly Wired Connectors: Use the CableXChecker™ to assist in repairing and making cables. This unit allows for quick and easy bench testing during cable assembly or repair.

Dimensions: 8" x 8" x 4" Weight: 7 lbs

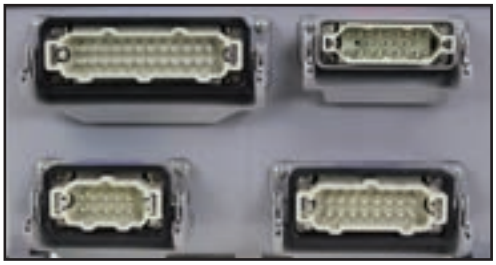
Includes: Checker, Two Year Warranty, Instruction Manual, Testing Lead and One 9V Battery

For 5 Zone Cables (Item #166196)
For 8 Zone Cables (Item #166197)
For 12 Zone Cables (Item #166198)

The CableXChecker is equipped with standard DME® Style Power and Thermocouple Hot Runner Cable and Housing Connectors.
Custom Connectors Available

5 Zone | 8 Zone | 12 Zone

5/8/12 Zone



Also Available!

CableXChecker DELUXE™

Dimensions: 16" x 13" x 8" **Weight:** 8 lbs

For 5, 8 &12 Zone Cables (Item #166945)

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Mold and Cable Checker Protective Blow Molded Case

Protect your diagnostics investment with a protective blow molded case:

Item #168638

Fits (1) MoldXChecker or (1) CableXChecker

Item #168637

Fits (1) MoldXChecker and (1) CableXChecker
or (1) Deluxe CableXChecker Only

Cases come with customizable foam inserts

#168637

#168638

Request for quote: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

Custom Mold and Cable Checkers Form

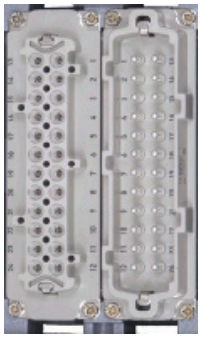
Specify:

1. ☐ MoldXChecker™ ☐ CableXChecker™ 2. ☐ Single Latch ☐ Double Latch (Connector Hood)

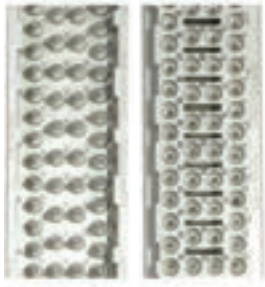
3. Common Connector Styles:

10 HA - Male 10 HA - Female

32 HBE - Female/Male


48 HBE - Female/Male

32 EE - Male 32 EE - Female


46 EE - Male 46 EE - Female

Amphenol Round Military Style - Male

Amphenol Round Military Style - Male

6 HBS - Male 6 HBS - Female

25 HD - Male 25 HD - Female

40 HD - Male 40 HD - Female

64 HD - Male 64 HD - Female

Amphenol Round Military Style - Female

Amphenol Round Military Style - Female

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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IMS Select Lockouts

Works With All IEC Circuit Breakers

Made in the U.S.A

- Keep your machines running safely
- Protects against accidental turn on/off
- Anodized aluminum construction
- Red or black color
- Compatible with Airpax/Sensata, Heinemann, Carling Switch, Potter-Brumfield, CBI and more

Custom Lockouts Available — Inquire

Contact the Equipment Team for pricing and additional information: sales@imscompany.com or Call: 1.886.467.9001

IMS Select Switch Guards

Great for the Aerospace, Medical and Food Industries

Made in the U.S.A

- Prevents operator from accidentally turning on/off important switches to the process
- Stainless steel construction

Contact the Equipment Team for pricing:
sales@imscompany.com

IEC Circuit Breakers

- All OEM's available - Heinemann, Carling Switch, CBI and more
- 1, 2, 3 or 4 poles
- Many stock sizes

Contact the Equipment Team for pricing:
sales@imscompany.com

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Single Zone Temperature Control System

Totally Digital and Self Contained for Today's Industry

The MFH-1 is a 240V, 15 amp, microprocessor-based, single zone temperature controller designed for today's demanding needs. It's compact foot print, robust design with rugged extruded aluminum case and advanced features are ideally suited for use with hot sprue bushings, machine nozzles or in areas where this condensed size and all inclusive design are requisites.

The latest in microprocessor technology offers many improved and unique operating features not found elsewhere, providing ease of use, the flexibility of menu selectable features and settings, as well as real time fault detection and alarm.

Superior Features:

- Compact, durable and full featured design
- Easy to use
- Preferred diagnostic features
- Large Dual Digital Displays — Easy to read temperature, setpoint and diagnostic conditions
- Audible Alarm — Sounds during error conditions
- Fuses — Mounted on rear panel for easy access
- Soft Start LED Indicator — Lit when in soft start mode
- Heater Load LED Indicator — Lit as power is applied to heater
- Bumpless Transfer — APO (average power output) with learned % power for thermocouple failure conditions

Selectable Features:

- Auto or Manual Operation — LED mode indicator
- Type J or K Thermocouple — LED mode indicator
- F° or C° Temperature Range — LED mode indicator
- Amperage Monitoring and Display — LED mode indicates AMP mode
- Audible Alarm — Selectable on/off
- Front Panel Lockout — Selectable on/off

Enhanced Diagnostics:

- High/Low Temperature — LED's indicate fault (selectable range)
- tCr Error Display — Thermocouple Reverse
- tCO Error Display — Thermocouple Open
- tCS Error Display — Thermocouple Shorted
- tOh Error Display — Triac/Heater Open
- tSh Error Display — Triac Shorted
- HiC Error Display — High Amperage Alarm (selectable range)

Safety Features:

- High Voltage Thermocouple Protections (fused)
- Module High Current Protection (fused)
- Electrically Isolated Front Panel
- Power Disabled to Heater:
  - Triac Shorted
  - Triac Open
  - Heater Open
  - Over Temperature
  - High Amperage

continued on next page

IMS Company

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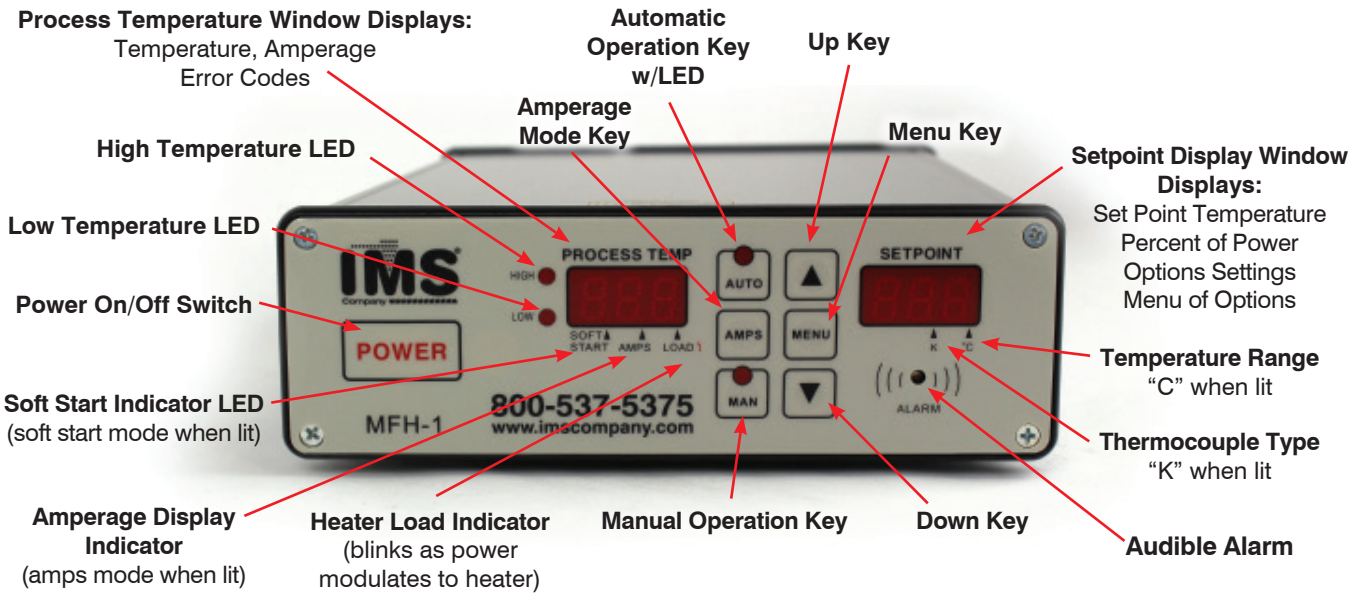
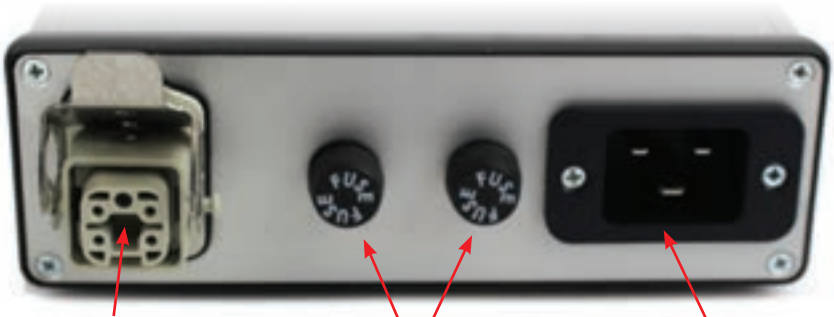


Mating connector #104248
supplied with system



Mold Power and Thermocouple Main Frame Connector (female)

15 Amp Fuse
#104251

240V Input Power Connector (male)

Mating connector #147229
supplied with system.

Specifications and Prices

Control System Power Usage:	Less than 5 watts
Set Point Range:	0° to 999°F
Control Accuracy:	± 1° F (0.5°C)
Calibration Accuracy:	Better than 0.2% full range
Temperature Range:	-32° to 120°F
Output Drive:	Internal solid state triac, zero crossing AC pulse

Size: 6½" wide x 1²⁵⁄₁₀₀" high x 10" deep

- 120/60/1 or 208 to 240/60/1
- 50/60 Hz
- 15 Amp Capable
- 3600 Watts
- Cold Junction Compensation

Item #	Voltage	Description
149127	120V	MFH-1 Single Zone Temperature Control System
145116	208 to 240V	
Optional Accessories		
147229	Input Power Connector	
104248	Spare Male Connector	
104251	15 AMP Fuse	
147230	MFH-1-IPC 240Vac Input Power Cable	
104212	10' PTC1 Combination Power and T/C Cable	
104191	20' PTC1 Combination Power and T/C Cable	

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IMS CLOSED-LOOP 15 Amp Temperature Control Modules

Precise, Dependable Control of Probes and Heaters

Now Get Even Better:

- Performance
- Versatility
- Durability
- Ease of operation

For Less Money!

2 Year Warranty!

Common Features Of Both Models

Compatible with DME and Athena Housings and Main Frames

- **Selectable Control Methods** - Adaptive-auto-tuning PID or Fuzzy Logic (amperage control)
- **Interchangeable with all "G" series mainframes, including DME, ITC, EMI, Athena, PPE, and others.**
- **Can be used with Type "J" or "K" Thermocouples**
- **Automatic Mode** - Just turn on the power and enter the desired temperature.
- **Manual Mode** - Allows manual adjustment if thermocouple feed-back is lost
- **LED Digital Read-Out** - Displays actual process temperature in degrees Fahrenheit or Celsius or Amperage Draw
- **High and Low Temperature Indicator**
- **Open Thermocouple Indicator/Protection** - Continues to apply learned percentage of power based on conditions prior to break
- **Reversed Thermocouple Indicator**
- **Shorted Thermocouple Indicator** - Help prevent heater run-away
- **Open Triac / Heater Indicator**
- **Shorted Triac Indicator/Protection** - Automatically turns off power to heater if controller detects continued power draw when temperature is well above the setpoint
- **Over Current Indicator** - warns if current exceeds a selected value - helps detect leakage in wires, cables, heaters etc. at an early stage
- **Advanced Automatic Soft Start** - "Cooks-out" trouble-causing moisture before applying full power to heaters
- **Blown Fuse Indicators**
- **Advanced Anti-Arcing Circuitry** (when used in IMS's updated Main Frames) - helps prevent damage if module is changed while main frame is under power
- **Durable, Industrial Grade Electronics**

Common Specifications Of Both Models

Amps: 15 / 3,600 watts

Setpoint: 0°F to 999°F

Dimensions: 2" wide x 7" tall x 7½" deep

Accuracy: ±1½° F (200°F to 800°F)

Tech Tips

All new temp controllers are fitted with anti-arcing jumper. If you have an old control housing you'll need to remove this for proper operation.

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S20-D3C

Rock-solid performance

Delivers simple operation and reliability

- Manual buttons for fast and easy setpoint selection
- Amp-draw display is now standard — lets you check for faulty heaters. Also lets you see how much heat each zone is pulling — a powerful tool for diagnosing molding issues

IMS Select UATC-20

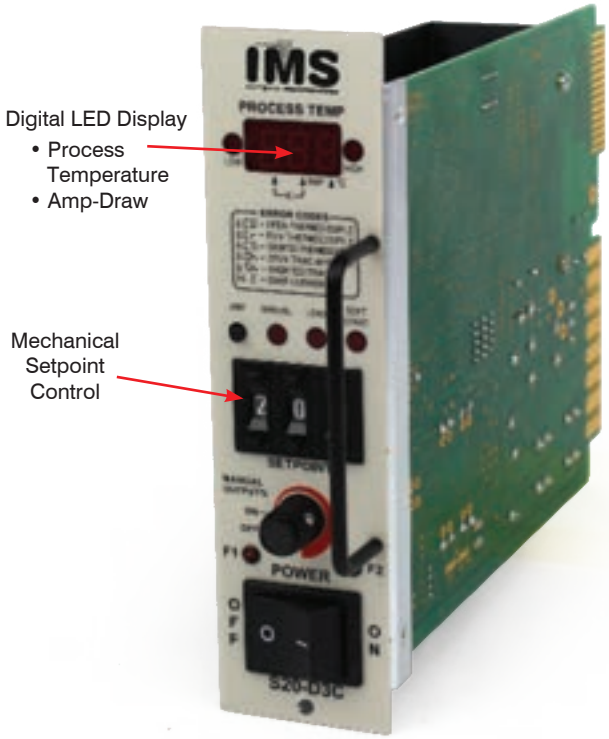
Intelligent design and advanced

Perfectly matched control for Hot Runners

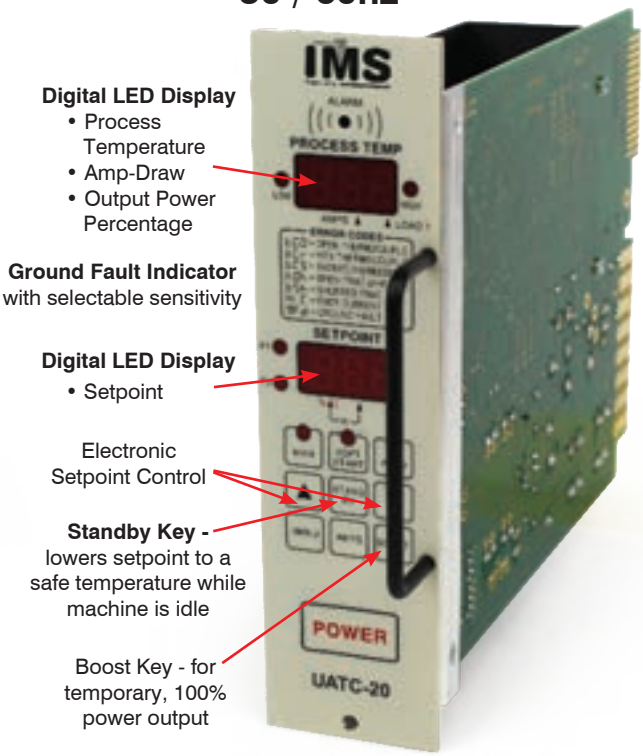
- Advanced membrane keypad for multiple functions and displays
- New Standby Key function for one touch, safe idle temperature setting

In addition to the common features listed on previous page, specific controller features include:

50 / 60hz



50 / 60hz



Accurate, reliable temperature regulation at an economical price!

Stock Model S20-D3C		Stock Model UATC-20
#137679 (120V)		#134360 (120V)
#133753 (240V)		#133752 (240V)
Spare Parts (For Either Model)		**Optional Features (UATC-20 Only) (requires main frame modification)**
Item #	**Description**	Global Standby - places all or a group of zones in standby mode: **Inquire**
104251	15-amp Rectifier Fuse	
127511	Trans Triac (for TM315M, UATC-15, S20-D3C, UATC-20)	Global Power Boost - raises temperature for all or a selected group of zones for user selected time: **Inquire**

Housings, connectors and other controller accessories also stocked - Inquire
Custom panel racks - available to order

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IMS CLOSED-LOOP Temperature Control Housings

Accept IMS, DME® G-Series and Athena (SPP) Modules

1 Zone Housing Assembly

Up to 15 amp Capacity
3,600 Watts (240 Volt)
1,800 Watts (120 Volt)

NOTE
For 1 Zone, 30 AMP Housing Inquire

Height: 10¾" x Width: 7" x Depth: 10"

Voltage: Designed for both 240/60/1 or 120/60/1

(See next page for component part numbers and prices)

Item #	
104199	Housing Assembly with power jack only

Order modules, cable and/or connector separately as required

Industry Standard Mounting
Accepts Most Power Modules!

2 Zone Housing Assembly

Up to 15 amp Capacity
3,600 Watts (240 Volt) each zone
1,800 Watts (120 Volt) each zone

Height: 10¾" x Width: 7" x Depth: 10"

Voltage: Designed for both 240/60/1 or 120/60/1

(See next page for component part numbers and prices)

Item #	
104303	Housing Assembly with power jack

Order modules, cable and/or connector separately as required

Choose Between Two Heater Hookup Methods

A. Connect heater and T/C wires directly to connector, when housing is adjacent to heater (lowest cost method)

Item #	
104248	Male Cable-to-Housing Connector with cable hood

B. Use 10 or 20 foot, armored cable assembly to reach heater and T/C wires attached to mountable connector with clamps (most versatile method)

Items Required:

Combination Heater and T/C Cable/Connector Assembly

Item #	
104212	10'
104191	20'
104202	Male Mold Connector with clamp

Spare Parts	
108157	10-amp rectifier fuse
104184	Blank module panel cover
107485	Plastic push pin for panel cover (2 required per cover)

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IMS Cable Connector Sets

For 1 and 2 Zone Controllers

1 & 2 Zone Cables

Heater and Thermocouple Combination Cables

1 & 2 Zone Cables	
104212	10 Foot Cable
104191	20 Foot Cable

Tech Tips

Using spare temperature controls will eliminate wasting time having to wait for a mold to come to temperature. It can be brought to temperature before it is hung.

1 & 2 Zone Connectors

130888

104202

104309

104248

1 & 2 Zone Connectors	
130888	Stand Alone Male Mold Connector
104202	Male Mold Mountable Heater & TC
104309	Female Cable to Mold Connector
104248	Male Cable to Housing Connector

1 & 2 Zone Housing Replacement Parts

104290

113640

109040

1 & 2 Zone Housing Replacement Parts	
104290	Mountable Female Housing Connector
113640	Flanged Inlet Housing Power Male Receptacle
109040	Housing Power Connector Female Plug

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Tech Tips

How To Order Temperature Controllers & Housings

Cards shown for
demonstration purposes only

1. **Specify how many zones of control are required.**
2. **Specify amperage required per zone (15 or 30).**
3. **Specify control modules required.**
4. **Specify the main frame size.**
5. **Specify cables, connectors and terminal boxes.**
6. **Choose optional accessories: Current/Voltage Monitor, Floor Stands, Transformer Kits, Fuses and Blank Module Panels.**

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IMS Closed-Loop Temperature Control Housings

Accept IMS, DME® G-Series and Athena (SPP) Modules

Side-Mounted Ventilation Fan and Phase Indicator Lights Standard

24 & 36 Zone Housing Assemblies Available – Inquire

5 Zone Housing Assembly

Height: 8½" x
Width: 14³⁄₁₆" x Depth: 11½"

Voltage: 240/60/3
(Can be wired to 120 or 240/60/1 by user.
- For 480 operation, see transformer kits on page 253)

Item #	Description
104280	Housing Assembly ONLY (shown)
104269	Housing with 10' Heater & T/C Cable/Connector Assemblies and Mold Connectors
104250	Housing with 20' Heater & T/C Cable/Connector Assemblies and Mold Connectors
104262	Dual Mold Heater and T/C Connector Mounting Box

8 Zone Housing Assembly

Height: 8½" x
Width: 20³⁄₁₆" x Depth: 11½"

Voltage: 240/60/3
(Can be wired to 120 or 240/60/1 by user.
- For 480 operation, see transformer kits on page 253)

Item #	Description
104259	Housing Assembly ONLY (shown)
104225	Housing with 10' Heater & T/C Cable/Connector Assemblies and Mold Connectors
104204	Housing with 20' Heater & T/C Cable/Connector Assemblies and Mold Connectors
104240	Dual Mold Heater and T/C Connector Mounting Box

12 Zone Housing Assembly

Height: 8½" x
Width: 28³⁄₁₆" x Depth: 11½"

Voltage: 240/60/3
(Can be wired to 120 or 240/60/1 by user.
- For 480 operation, see transformer kits on page 253)

Item #	Description
104242	Housing Assembly ONLY (shown)
104173	Housing with 10' Heater & T/C Cable/Connector Assemblies and Mold Connectors
104291	Housing with 20' Heater & T/C Cable/Connector Assemblies and Mold Connectors
104185	Dual Mold Heater and T/C Connector Mounting Box

Spare Parts	
104184	Blank module panel cover
107485	Plastic push pin for panel cover (2 required per cover)
106124	Heineman circuit breaker (230 volt, 50 amp)

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IMS Connector Sets and Accessories

For 5, 8 and 12 Zone Controllers

Temperature Control Cables

104255

104297

Thermocouple Cable			Mold Power Cable 15 Amp		
Item #	Zones	Length	Item #	Zones	Length
104234	5	10'	104278	5	10'
104214		20'	104258		20'
104209	8	10'	104254	8	10'
104189		20'	104228		20'
104255	12	10'	104297	12	10'
104231		20'	104274		20'

Need a Custom Cable?
(DME, Husky, INCOE, etc.)
Call to Inquire

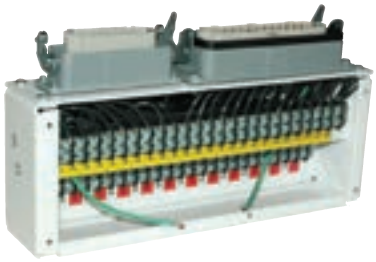
Great Prices and Fast Delivery on these OEM style cables.

Mounting Box (Thermocouple & Power)	
Item #	Zones
104262	5
104240	8
104185	12

104185

IMS also offers the EZ-Junxxion Box to speed up your mold connections

See Page 252 for details



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Mold End Connectors

Controller End Connectors

With Pigtail

With Pigtail

With Pigtail

104177

104198

109465

108611

Male Mold Thermocouple Connector		Male Mold Heater Connector		Male Housing Thermocouple Connector		Female Housing Power Connecter	
Item #	Zones	Item #	Zones	Item #	Zones	Item #	Zones
104301	5	104181	5	109463	5	108610	5
104272	8	104294	8	109459	8	108609	8
104177	12	104198	12	109465	12	108611	12

104273

109031

106362

106361

Male Metal Panel Mounting Base with Gasket for Heaters & Connectors		Female Metal Panel Mounting Base with Gasket for Thermocouples		Plastic Male Insert, with Pin Contacts		Female Insert with Socket Contacts	
Item #	Zones	Item #	Zones	Item #	Zones	Item #	Zones
104273	5, 8, 12	109034	5	109042	5	109038	5
		109031	8	109037	8	109036	8
		106360	12	106362	12	106361	12

Plastic Male Insert, No Pins		Female Insert, No Socket Contacts	
Item #	Zones	Item #	Zones
104275	5,8,12	104249	5,8,12

106359

Cable Hood for Power		Cable Hood for Thermocouple		Pins Crimp Type		Sockets Crimp Type	
Item #	Zones	Item #	Zones	Item #	Zones	Item #	Zones
104279	5,8,12	109032	5	104232	5,8,12	104224	5,8,12
		109030	8				
		106359	12				

Optional Accessory

Pin Extractor Tool see page 196

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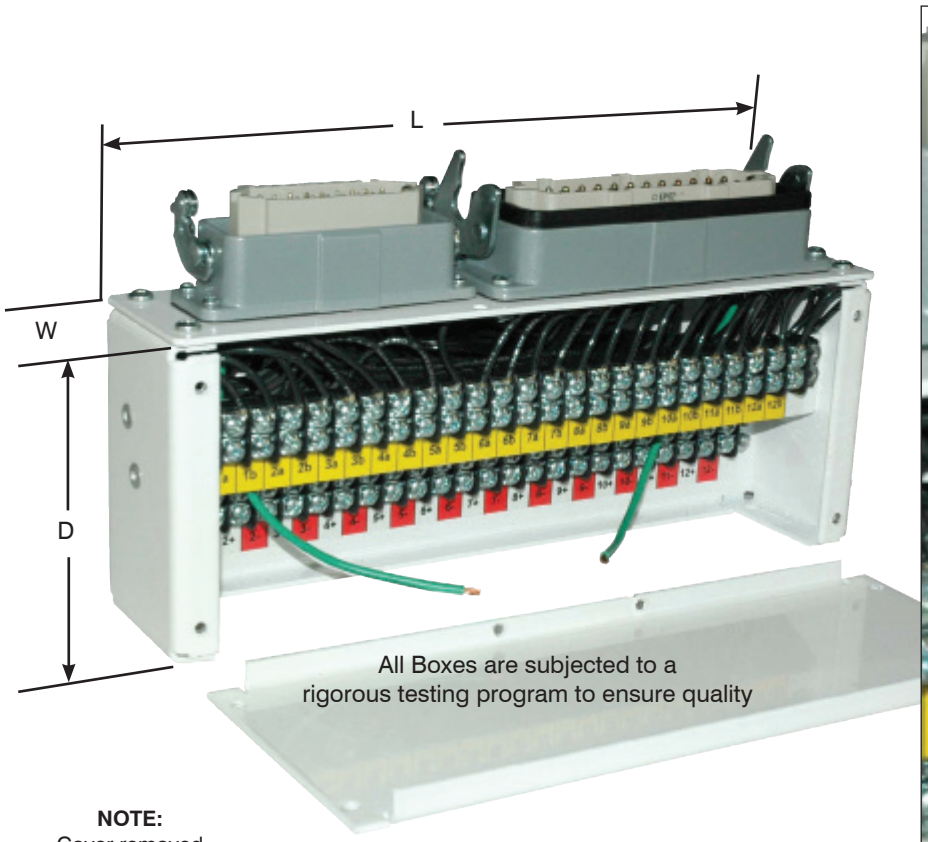
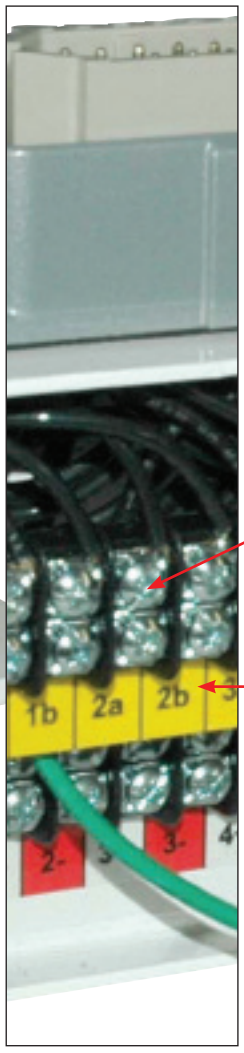
IMS EZ JUNXXION BOX™

Help Simplify and Speed Up Mold Setup!



All Boxes are subjected to a rigorous testing program to ensure quality



Power and Thermocouple Connectors Are Pre-Wired To Terminal Strips

Terminal Strips Are Pre-Numbered To Correspond With Connectors

NOTE:
Cover removed to show terminals

Boxes are Powder Coated for durability

Mount directly on mold

Easy to install and maintain

16 Amp, 240 Volt

Item #	Zones	Box Dimensions L	W	D
140111	5	8.66"	2.34"	4.00"
140112	8	9.47"	2.34"	4.00"
140113	12	10.53"	2.34"	4.00"

Different Configurations Available on Request

EZ JUNXXION BOX™ is a Trademark of IMS Company

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Accessories for IMS 5, 8 & 12 Zone Control Systems

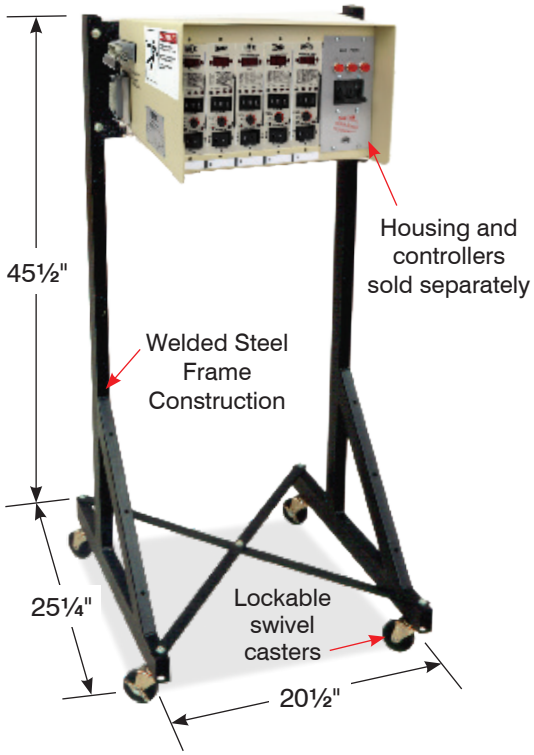
Housing Stand

Permits fast, safe movement of controllers from press to press!

#112695 (One Stand Fits All)

Complete with all installation hardware for 5, 8 or 12 zone housings

Can also be used with 1 & 2 zone by special order



Transformer Kits

Converts 480/60/3 to 240/60/3

Includes: Stand (same as shown above)

Plus:
- Enclosed Transformer
- 6 ft. cable for controller
- Disconnect Switch
- Mounting Hardware
- Pre-Assembly of Transformer and Stand

How To Size A Transformer

Add the wattage of all heaters. Divide by 1000. This is the maximum KVA used if every zone were drawing full power simultaneously. Choose the transformer size that is the closest, but not lower than your calculation.

Item Number	Power Capacity
109467	6kVA
109464	9kVA
109323	15kVA
137354	30kVA
158275	45kVA
165257	75kVA

Consult an IMS Technical Specialist for Other Voltage and Current Capacities

Housings and controllers sold separately

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West Temperature Controllers

West Temperature Controllers hold barrel and nozzle temperatures within a 2° to 3° F variation. They provide a steady temperature that not only helps to improve quality, but also decreases part reject rate and reduces cost.

Retrofitting your machine is simple and straightforward as well. Usually only six wires are needed for connection and IMS can supply you with an electrical drawing to aid in conversion from an older controller, at no extra charge. Adaptor plates are available for retrofitting panel cutouts.

Setting the range is also easy. The simplified front panel permits quick and uncomplicated access to adjustments.

In many cases the instruments can be directly configured via a PC. The Large 3-digit LED display on any West Controller provides maximum visibility at a glance.

West Controllers are programmable for nearly any thermocouple input range and accept 96 - 264 VAC 50 and 60 Hz power. IMS can provide you with a wide selection of options to ensure that you only pay for the functions you need. Let us know exactly what you require in a temperature controller, and chances are we have precisely what you want.

Cross Reference Single Relay Output

(Heat Only) Controls — Type J Thermocouple

Model	Size
Barber Colman	
272 P	(full)DIN*
520 series	Odd**
580 Series	1/4 DIN
220 Series	1/8 DIN
AT580 Series	1/4 DIN
MAM Series	1/16 DIN
Eurotherm	
Model 94	1/8 DIN
Model 91 E	1/16 DIN

*use 1/4 DIN to replace
**use 1/8 DIN to replace

Model	Size
Older West Instruments	
Gardsman (JP)	Odd*
800 Series	1/4 DIN
2000 Series	1/4 DIN
3000 Series	1/8 DIN
400 Series	1/4 DIN
1400 Series	1/4 DIN
Fuji	
PYW4	1/16 DIN
PYX4	1/16 DIN
PYW5	1/8 DIN
PYX5	1/8 DIN

Model	Size
Cal	
Model 9900	1/16 DIN

The West controls listed below can be used to replace all the controls listed. The difference is in size and features.

West Instruments Replacements

Size	Series	IMS Item #
1/16 DIN	6100	119499
	6500	163528
1/8 DIN	8100	119511
1/4 DIN	4100	119504

IMS Item # is for single relay output (heat only) control. Adaptor plates are available to convert between control sizes.

OVERVIEW

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100 Series Temperature Controllers

Our Most Advanced Microprocessor-Based Controllers

Innovative design combines sophisticated functionality with built-in versatility and ease of use.

These units will hold barrel and nozzle temperatures to within a 2° F to 3° F variation. The 3-digit LED displays provide maximum visibility at a glance. A wide selection of options ensure that you pay only for the functions you need. Contact the IMS Supplies Team at sales@imscompany.com for additional information.

- Microprocessor-based closed-loop temperature control
- Configurable directly from a PC
- Three tuning options:

  Pre-tune — This is a single shot tune that increases the power to 2/3 of setpoint and then turns off until the process slows and the PID terms can be calculated. The setpoint is then returned to normal and the process goes to temperature using the PID terms it has calculated.

  Self-Tune — This is a continuous tune that runs while the process is on control.
  Manual Tune — This is where you enter your own calculated PID terms.
- Accommodates a variety of thermocouple and sensor types
- Pre-programmed for 32° F to 842° F range with Type J T/C input
- Large, dual LED display of temperature and setpoint
- Power relays turned off if T/C fails
- User-defined setpoints for process temperature
- User-defined setpoints for temperature high and low alarms
- Bumpless auto/manual transfer

92mm X 92mm

¼ DIN

45mm X 92mm

⅛ DIN

48mm X 48mm

1/16 DIN

- Field upgradeable
- Sealed control panel
- Password protected operator access
- ¼ DIN, ⅛ DIN, and 1/16 DIN panel sizes
- CE approved, UL and Canadian UL recognized or pending

Options:

- Celsius display of temperature and setpoint
- Handles Type K T/C input for higher temperatures
- Second relay output (secondary control or alarm 2)
- Third relay output (alarm 1 or DC recorder output — setpoint or process variable)
- Field installable RS485 serial communications protocols
- Dual setpoint operation
- 20-50 VAC/VDC power input

Specifications and Prices

Accuracy: ±.25% of span ±1 LSD (least significant digit; typically 1°F)

Control Output: 1 SPDT (2A) relay or solid state relay driver

Power Input: 96 to 264 VAC

Item#	Description
119504	West Model 4100+ Temperature Controller (¼ DIN)
119511	West Model 8100+ Temperature Controller (⅛ DIN)
119499	West Model 6100+ Temperature Controller (1/16 DIN - Standard Relay Output)
119863	West Model 6100+ Temperature Controller (1/16 DIN - Standard Relay Output) with dual outputs
135686	West Model 6100+ Temperature Controller (1/16 DIN - Solid State Relay Driver Output)
135687	West Model 6100+ Temperature Controller (1/16 DIN - Solid State Relay Driver Output) with dual outputs
Spare Part	
160429	Replacement Plug-In Relay Board

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Model 6500 Temperature Controller

For Precise Temperature Control at an Affordable Price

Designed for basic electric heater applications, the TEC-9300 uses the latest proven technology. Usually only six wires are needed for connection. IMS offers a wide selection of options to ensure that you only pay for the functions you need.

- TEC-9300 1/16 DIN temperature controller
- Large red three-digit display
- Continuous indication of alarm status
- Easy-tune — This is similar to Pre-Tune (see previous page) except it runs every time the controller is turned on and the over shoot is stored from the previous time it ran. The over shot is then used to move the calculation of the PID terms closer to the setpoint. (NOTE: This can not be disengaged.)
- Sealed control panel
- Accommodates a variety of T/C types
- Pre-programmed for 32° F to 842° F range with Type J T/C input

1/16 DIN

- CE approved, UL and Canadian UL recognized or pending

Options:

- Celsius display of temperature and setpoint
- High-range Type K input
- 20-50 VAC/VDC power input

Specifications and Prices

Accuracy:	±.25% of span ±1 LSD (least significant digit; typically 1° F)	Control Output:	1 SPDT (2A) relay
		Power Input:	96 to 264 VAC

Item #	Description
163528	Model TEC-9300 Temperature Controller (1/16 DIN)

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Check out these other useful IMS products!

Heater Bands
Pages 160 – 189

Cartridge Heaters
Pages 206 – 212

Thermocouples
Pages 214 – 228

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Model 6010 Temperature Indicator

Provides Good Visible Indication, Alarm Capability and Security

This unit has fast identification of alarms via separate LED indicators. Other options include a retransmission output, a 24 volt AC/DC input power supply, plus a remote input for a security lock.

Configuration can be easily setup through the front panel, plus, unauthorized user can be locked out of changing the alarm values and configuration parameters via a simple security code or by a remote.

- Large, red 4-digit LED display
- 3 alarms: latching, relay and multiple alarm options
- Plug and Play technology allows for field upgrades
- Retransmission output
- Security via password protection and remote lock option

Options:

- 20-50VAC, 22-65VDC low voltage option
- RS485 serial communications protocols
- Remote reset

1/16 DIN

Specifications and Prices

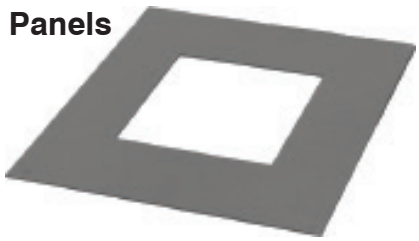
Temperature Range:	32°F to 842°F	Accuracy:	±.25% of span ±1 LSD (least significant digit; typically 1° F)
Control Output:	1 SPST (2A) relay	Power Input:	90 to 264V AC 50/60Hz

Item #	Description
128292	Model 6010+ Temperature Indicator (1/16 DIN)

Adaptor Plate

Simplify Retrofitting of Existing Control Panels

- ¼ DIN to 1/16 DIN



Specifications and Prices

Material:	16 gauge Stainless Steel	
Dimensions:	Cutout Dimensions	Panel Dimensions
	92 mm x 45 mm	114 mm x 142 mm

Item #	Description
168676	¼ DIN to ⅛ DIN
	Ask about other sizes

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IMS Microstat®

5 Amp Open Loop Temperature Controllers

Compact, Solid-State Replacements for Variable Transformers

IMS solid state Microstat® open loop controllers regulate power to heaters, replacing variable transformers. An analog AC ammeter shows amps drawn for each zone (selectable by pushbutton). Needle movement verifies heater band is working.

- Heavy duty constructions for tough shop conditions
- One low cost replacement part per zone
- Amp meter selectable for each zone
- Zone control dial is graduated 0 to 10 (For 120 volt systems, effective control is from 6.5 to 10 on dial)
- Both sides of the power line fused for fast blow
- Amber light ON indicates a good fuse
- Operates on either 120 or 240/60/1 input: 1,200 watts on 240 volts (each zone) 600 watts on 120 volts (each zone)

#107522

Complete Microcircuit Control

Just One Low-Cost Replacement Part!

Quickly and easily installed with just a screwdriver and wrench

Specifications and Prices

Max. Load Current:	5 amps AC each zone		
Dimensions:	2 zone: 8⅝"h x 5⅛"w x 3⅝"d 8 zone: 20⅝"h x 5⅛"w x 3⅝"d	Weight:	2 zone: 3¼ lbs. 8 zone: 9½ lbs.

Item #	Description
107522	Temperature Controller, Solid State, 2 Zone 5 Amp Microstat, 120/240 V, Analog Amp Meter Includes: 5 Spare Fuses (#104265), (2) Male Hubbell Plugs (#104179), & 6' Cord.

MICROSTAT® is a registered trademark of IMS Company

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Please refer to imscompany.com for current pricing

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Spare Parts for IMS Microstat®
5 Amp Open Loop Temperature Controllers

Spare Parts	
104265	Rectifier fuse (5 amp)
101344	Fuse holder w/ cap
108092	Zone power switch
104196	Meter buttons
104300	Female socket
104179	Male hubbel plug (15 amps)
104192	Microstat® control assembly
104216	Knob with “0” to “10” scale markings

CAUTION: Use only IMS #104265 fuses. Failure to use 5 amp, 250 volt fast blow, rectifier fuses voids all warranties.

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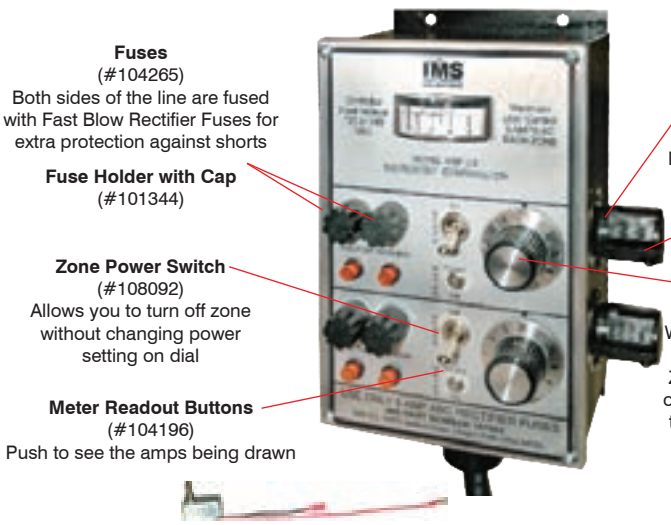

Fuses
(#104265)
Both sides of the line are fused with Fast Blow Rectifier Fuses for extra protection against shorts

Fuse Holder with Cap
(#101344)

Zone Power Switch
(#108092)
Allows you to turn off zone without changing power setting on dial

Meter Readout Buttons
(#104196)
Push to see the amps being drawn

Female Socket
(#104300)

Output Plugs
(#104179)
Male Output Plugs speed wiring to your elements (One plug provided for each zone)

Zone Controls
(#104216)
While holding in the Meter Readout Button, turn the Zone Control Knob to set output. Dial is graduated 0 to 10 NOTE: On 120 volt, effective control is from 6.5 to 10 on dial

Microstat® Control Assembly
(#104192)

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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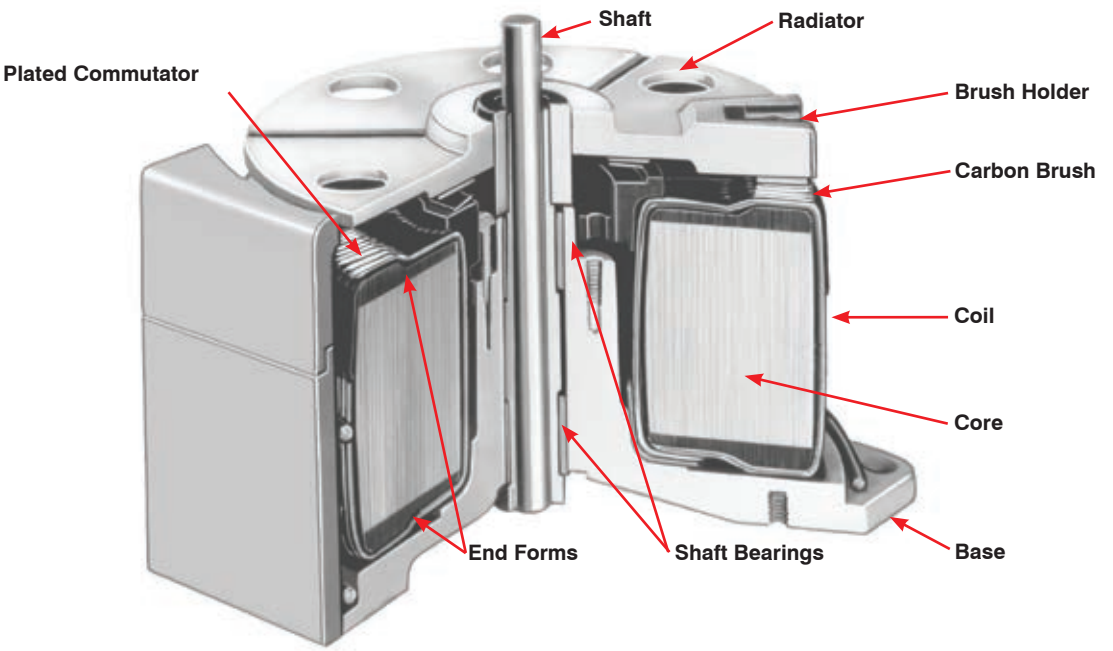
GREEN Products

ROHS Compliant

Voltage Controllers

Put Out Up To 17% More Voltage Than Is Put In

Voltage Controllers overcome costly effects of low line voltage common in many molding plants. These Auto Transformers put out UP TO 17% more VOLTAGE than is put in. If your line voltage is 104 (or 208) volts, you can still get 120 (or 240) volts at full setting of the controller. Production benefits are immediate because your heater bands can still be run at full rated voltage.



OVERVIEW

Linear Output Voltage
Output voltage is continuously adjustable from zero to maximum output voltage proportionately over the full range.

Smooth Control
The output voltage of a variable transformer can be considered continuously adjustable. The voltage between turns is a fraction of a volt and the brush-tap is always in contact with one or more turns of the winding. Adjustment of output voltage can be made to a fraction of a volt.

Low Operating Torque
The glass-smooth commutator surface, the constant and correct contact pressure of the brush-tap to the commutator and the stable positioning of coil and internal components result in the low operating torque of all variable transformers.

Rugged Mechanical Construction
All variable transformers are designed for heavy-duty, trouble-free operation. Rigid inspection at every stage of manufacture gives assurance of a quality-built product. The securely mounted core and coil, extra-large aluminum brush heat radiator and durable brush assembly reduce the need for attention or replacement.

Negligible Maintenance
With ordinary care and attention to the operating instructions, the only elements that may require periodic inspection and maintenance are the brushes. Their replacement is infrequently needed because they are made of a special carbon and are of a design that ensures proper contact of the brush to the commutator at any setting.

Long Life
Variable transformers give reliable performance over extended periods of time even under extreme operating conditions. Materials are constantly being improved to give increased life expectancy.

IMS Company

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4.5 Amp Constant Impedance Voltage Controller

(Enclosed Model)

Adjust input voltage to your plastics process heaters with IMS Variable Transformers to provide open loop control of temperatures. These auto transformers put out up to 17% more voltage (at lower current) than line input voltage. They provide reliable performance even under extreme operating conditions.

- Continuously adjustable from zero to maximum voltage for smooth control
- Minimal maintenance required
- Heavy duty construction for long service life and trouble-free operation
- Grounded power cord with plug

Dust proof case helps extend controller life!

Specifications and Prices

L501B Voltage Controller

	Input		Output					
				Constant Current Load		Constant Impedance Load		Shipping
Item #	Volts	Hertz	Volts	Max. Amp	Max. kVA	Max. Amp	Max. kVA	Weight
104247	120	50/60	0-140	4.5	0.63	—	—	11 lbs.

Spare Parts

104168	Fuse holder with cap, right angle terminals

Check out these other useful IMS products!

Thermocouple Adaptors
Page 228

⅛"-27 N.P.T.

⅜"-24 NF

12mm x 1mm

Machine Components

Nozzle Thread Adapters
Pages 482-488

Screw Tips
Pages 524-550

Feed Screws
Pages 560 – 573

Temperature Controllers

Page 245

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3.5 Amp Constant Impedance Voltage Controller

- Continuously adjustable from zero to maximum voltage for smooth control
- Minimal maintenance required
- Heavy duty construction for long service life and trouble-free operation
- Grounded power cord with plug

Specifications and Prices

3PN1020B Voltage Controller								
Input			Output					
Item #	Volts	Hertz	Volts	Constant Current Load Max. Amp	Constant Current Load Max. kVA	Constant Impedance Load Max. Amp	Constant Impedance Load Max. kVA	Shipping Weight
104295	240	50/60	0-280	3.5	.98	—	—	12 lbs.
Spare Parts								
104168	Fuse holder with cap, right angle terminals							

10 Amp Constant Impedance Voltage Controller

- Continuously adjustable from zero to maximum voltage for smooth control
- Minimal maintenance required
- Heavy duty construction for long service life and trouble-free operation
- Grounded power cord with plug

Specifications and Prices

3PN1010B Voltage Controller								
Input			Output					
Item #	Volts	Hertz	Volts	Constant Current Load Max. Amp	Constant Current Load Max. kVA	Constant Impedance Load Max. Amp	Constant Impedance Load Max. kVA	Shipping Weight
109303	120	50/60	0-140	10	1.4	—	—	12 lbs.
Spare Parts								
104168	Fuse holder with cap, right angle terminals							

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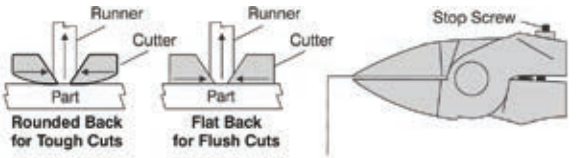
Tech Tips

How to select the right gate cutter for your job.

De-gating a plastic part from its runner may be your final operation before shipping the parts to the customer. Often it is a challenge to remove a runner and leave the part cosmetically, functionally and structurally intact. Choosing the proper gate cutter with the necessary physical characteristics and features becomes an important decision. Therefore, when selecting a gate cutter, consider the length of the handle, blade length and opening, blade angle relative to the handle and the contour of the back of the blade (the blade characteristics should match the part at the area of the de-gating) and features such as a blade stop, type of spring and handles. Consider the following features:



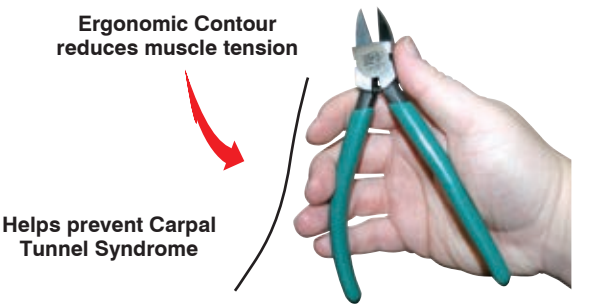
NOTICE: To ensure maximum blade life, adjust stop screw so that the blades just barely touch on soft plastics and leave a gap of 1/32" on hard materials.

Blade Stop:

Gate cutters are actually wedges that cut from both sides until the tensile strength of the uncut section at the middle is overcome, and the remainder of the runner or sprue is "snapped" out. This rapid release causes blades to hit each other, shortening their life. For this reason, a blade stop screw is recommended if the cutter is to be used on hard, brittle materials. The screw should be set so the blades stop short of hitting each other. For softer materials, a better cut can be obtained using a very thin, sharp blade. If a blade stop is used with softer materials (polyethylene, flexible PVC, etc.), it should be adjusted for minimal blade gap. This allows the blades to cut farther through the runner, yet only allows the blades to touch slightly.

Springs:

Leaf springs are welded to the handles and covered by hand grips. Generally, they are set to a lower pressure and require less effort to squeeze, thereby reducing user fatigue. Coil springs offer a stronger return pressure "fly back" when releasing from a cut, but require more pressure to make a cut. Also, they can be easily and inexpensively replaced by the operator.



Handles:

The length of the cutter's handles determines how much pressure the operator must exert to cut through a gate or sprue. A cutter with a handle that is too short will cause excessive strain on the operator's hand. A cutter with a handle that is too large for the operator's hand is difficult to grip. Try to match the cutter with the operator's hand and the gate or sprue being cut. Ergonomic-contoured handles are effective in reducing the fatigue that can accompany the prolonged squeezing action of gate cutting. They minimize strain on the smaller, weaker fingers by keeping them from pulling from a tight-fisted position. This reduces the risk of carpal tunnel syndrome.

We have a wide range of gate cutters to fit all your gate cutting needs. If we don't have it in stock, chances are, we can make it!

We encourage you to send us a small quantity of parts with the runners attached, so we can recommend the best cutter for your application.

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Stock Model Cutters and Trimmers

All the following are included in this section

Extra Slim Blade Cutters

Standard Blade Cutters

Slim-Line Blade Cutters

Needle-Nose Blade Cutters

Convex Blade Cutters

Concave Blade Cutters

End Nippers

Air Powered Cutters
(5 Models)

All the following are included in our Special application gate cutter section

20° Mini Nippers

25°-Angle Blade Cutters

35°-Angle Blade Cutters

45°-Angle Blade Cutters

80°-Angle Blade Cutters

90°-Angle Blade Cutters

10" Cutters with 30° - Angle Blade

All the following are included in our Utility and deflashing tools sections

Utility Knives

Rout-a-Burrs

Flash Trimmers

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Super Series Gate Cutters

The Best Cutters on the Market!

Made in the U.S.A

Constructed of High Chromium, Swedish/American Steel - superior quality that delivers the longest life cycle, permitting multiple resharpening for your best overall cost

Induction-Hardened Cutting Edge - provides high hardness on the cutting edge, but allows full toughness on the rest of the tool

New, Special, Hard Alloy Pivot Pin
- is self lubricating and wear resistant
- prevents shifting of jaws, delivering a "clean cut"

Adjustable Stop - protects cutting edge

Black Oxide Finish - prevents rusting

Ergonomic Handle Design - reduces discomfort, strain and the risk of injury

Comfortable, extra thick Anti-Static Foam Handles - helps prevent user fatigue

- Available ergonomic Leaf Springs or user replaceable Coil Springs
- Blade Stop Option on select models

Re-sharpening program is available to maximize the value of your investment.

Delivers over 200,000 cuts before needing re-sharpening for a cost of 21¢ per 1000 cuts

Quantity Discounts Available, Inquire Today.

IMS Classic Series Gate Cutters

- Manufactured from high carbon steel with a low profile for terrific performance and a long life
- Delivers over 150,000 cuts before needing re-sharpening for a cost of 24¢ per 1000 cuts*!

See Page 274

IMS Signature Series Gate Cutters

The Best Buy Available on the Market!

- Manufactured from M4151 Steel for Long Life Cycle and Multiple Re-sharpening for the Best Overall Cost
- Delivers 75,000 cuts before needing re-sharpening for a cost of 34¢ per 1000 cuts*

See Pages 275-278

Economy Gate Cutters

Great Price & Performance Package!

- Great quality cutter at the lowest price ever offered by IMS on any gate cutter
- Drop forged from alloy steel
- Delivers 15,000 cuts for a cost of 48¢ per 1000 cuts*

See Pages 279-285

Foam handle covers	PVC handle covers	Foam handle covers
Slim line, flat back blades	Some models available with adjustable stop	
Black oxide finish to prevent rust		
Available ergonomic leaf spring or user-replaceable coil springs		

IMS recommends assigning SW and IMS Series cutters to workers and establishing an aggressive re-sharpening program to maximize the value of your investment

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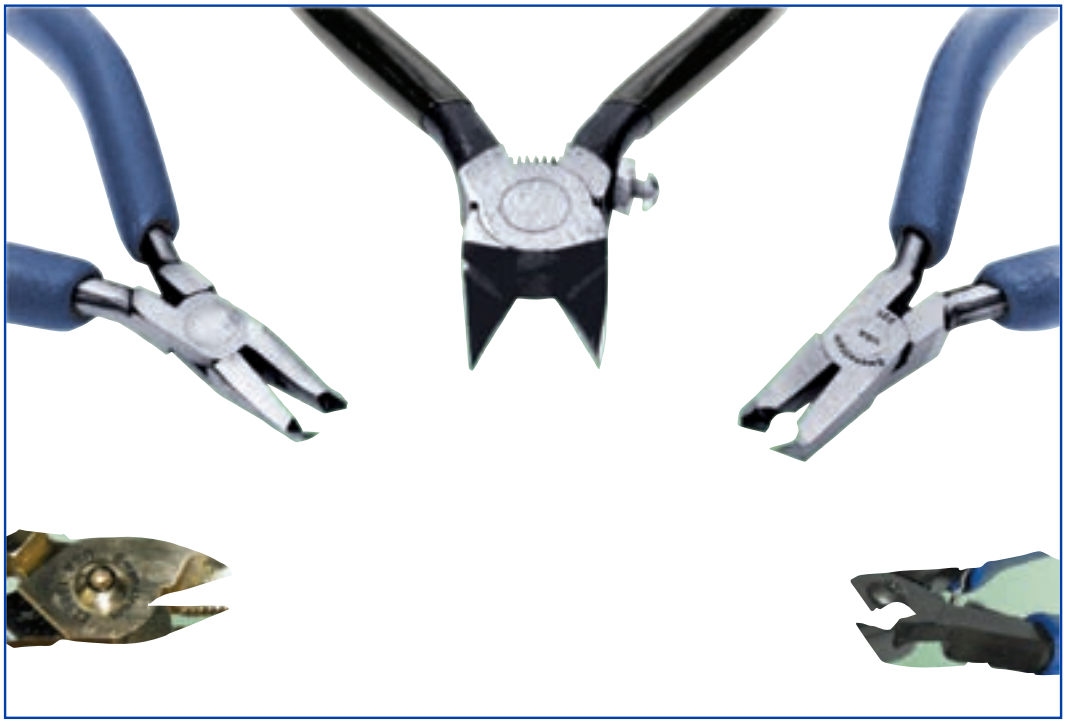
IMS Custom-Made Gate Cutters

Specially designed to suit your molded parts!



IMS can design unique cutter blade configurations to your specifications

Let IMS make the perfect gate cutters for your molding process. Have gate cutters designed to easily and comfortably reach hard-to-manage cuts. Reduce muscle fatigue and Carpal Tunnel Syndrome with custom-made ergonomic gate cutters.

Contact the IMS Supply Team today at sales@imscompany.com or call for more details and an RA number. Then send a sketch and some samples of your molded parts with uncut gates to get a prompt quotation.

Tech Tips

Gate Cutter Cost Per Cut Analysis

Cost Per 1000 Cuts					
Quality Level	**Tool Brand**	**Item Number**	**Cycles Before Failure**	**Price**	**Price/1000 Cuts**
5	SUPER	102589	200,000+	**$43.22**	$0.21
4	IMS Classic	101534	150,000+	**37.36**	0.24
3	IMS Signature	123898	75,000	**26.33**	0.34
$	Economy	130593	15,000	**7.62**	0.48

***Cost per 1000 Cuts:**

Cost per cut analysis completed by an independent authority in the industry. Each cutter was tested by cutting copper wire in an automated test. Testing ceased when the cutter was unable to make a clean slice of the copper wire which indicates the cutter needs to be reconditioned or replaced.

Using a lot of Cutters? Ordering in bulk?

Ask IMS about bigger quantity discount offers suited to fit your needs! Call or email for a fast quote!

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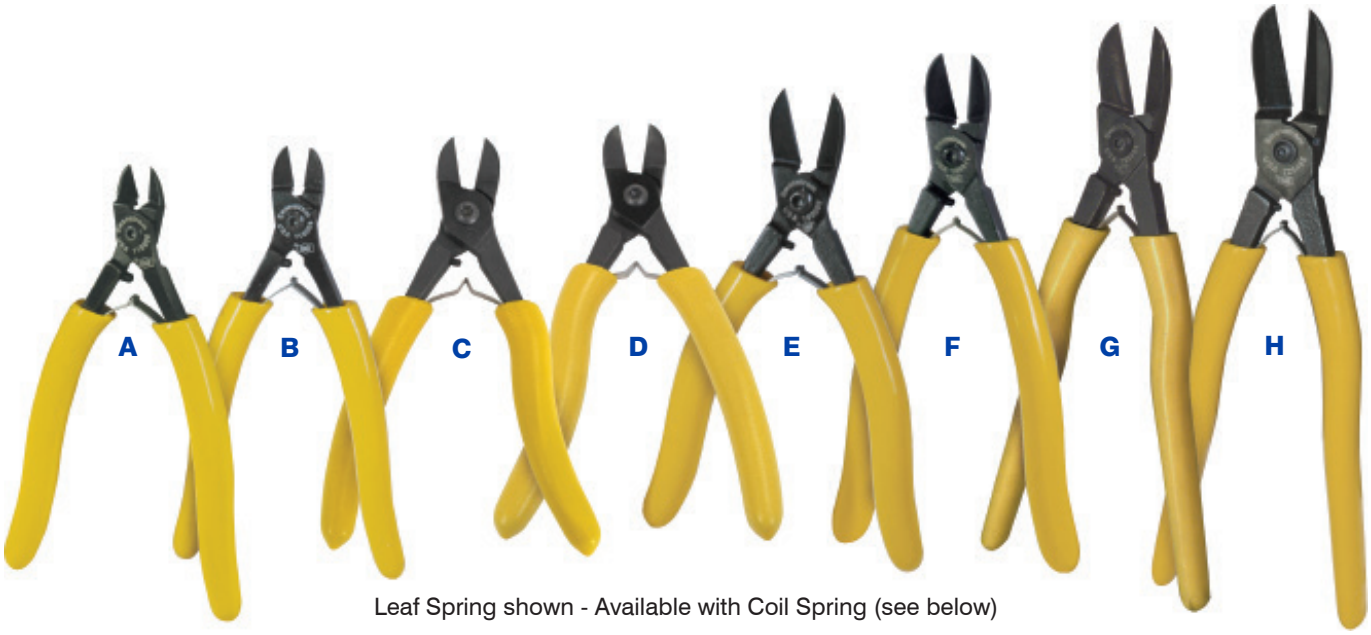
Standard Super Gate Cutters

Quick Reference

Flat Back, Slim Profile Blades for Flush Cuts



Leaf Spring shown - Available with Coil Spring (see below)

Standard Super Gate Cutters with Leaf Spring						
	Item #	Length	Description	Model	Spring	Page
A	118000	5"	15˚ Flat Back, Slim Blade	S-44	Leaf	270
B	118004	5⅝"	15˚ Flat Back, Slim Blade	S-55		
C	167506	6"	15˚ Flat Back, Slim Blade - Right Hand	S66ER		271
D	167507	6"	15˚ Flat Back, Slim Blade - Left Hand	S66EL		
E	102589	6⅝"	15˚ Flat Back, Slim Blade	S-66		272
F	102571	7⅞"	15˚ Flat Back, Slim Blade	S-77		
G	123494	8"	15˚ Flat Back, Slim Blade	S-88		273
H	123495	9¾"	20˚ Flat Back, Slim Blade	S-99		

Standard Super Gate Cutters with Coil Spring						
	Item #	Length	Description	Model	Spring	Page
A	131670	5⅝"	15˚ Flat Back, Slim Blade	S44-C	Coil	270
B	131481	5⅝"	15˚ Flat Back, Slim Blade	S55-C		
C	167515	6"	15˚ Flat Back, Slim Blade - Right Hand	S66ER-C		271
D	167511	6"	15˚ Flat Back, Slim Blade - Left Hand	S66EL-C		
E	130253	6⅝"	15˚ Flat Back, Slim Blade	S66-C		272
F	128238	7⅞"	15˚ Flat Back, Slim Blade	S77-C		
G	131669	8"	15˚ Flat Back, Slim Blade	S88-C		273
H	131668	9¾"	20˚ Flat Back, Slim Blade	S99-C		

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Standard Gate Cutters Quick Reference Price Chart

IMS Classic Series Gate Cutters (Leaf Spring)

Item #	Description	Model	Spring Type	Page
101534 shown	6", 15° Flat Back Slim Line Blade	SW6	Leaf	274
109824	9", 20° Flat Back Slim Line Blade (extra thin)	SW9		

IMS Classic Series Gate Cutters (Coil Spring)

Item #	Description	Model	Spring Type	Page
131662	6", 15° Flat Back Slim Line Blade	SW6-C	Coil	274
131667	9", 20° Flat Back Slim Line Blade (extra thin)	SW9-C		

IMS Signature Series Gate Cutters (Leaf Spring)

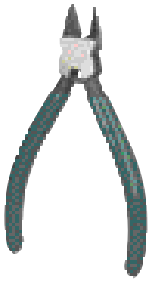
Item #	Description	Model	Spring Type	Page
123898 shown	6”, 15° Flat Back Slim Line Blade	IMS6S	Leaf	276
123456	6”, 15° Flat Back Slim Line Blade	IMS6		277
123464	7”, 15° Rounded Back Blade	IMSB7		
123899	7”, 15° Flat Back Slim Line Blade	IMS7S		
123454	7”, 15° Flat Back Slim Line Blade	IMS7		278

IMS Signature Series Gate Cutters (Coil Spring)

Item #	Description	Model	Spring Type	Page
130693	4”, 15° Flat Back Standard Profile Blade	IMS3-C	Coil	275
129667	4½", 15° Flat Back Slim Line Blade	IMS4-C		
129501	5”, 15° Flat Back Slim Line Blade	IMS5-C		276
129502	6”, 15° Flat Back Slim Line Blade	IMS6-C		
129532	7”, 15° Flat Back Slim Line Blade	IMS7S-C		278
129534	7”, 15° Flat Back Slim Line Blade	IMS7-C		

Economical Gate Cutters (Coil Spring)

Item #	Description	Spring Type	Page
130592	5”, 15° Flat Back Blade	Coil	279
130912	5”, 15° Rounded Back Blade		
130593 shown	6”, 15° Flat Back Blade		280
130913	6”, 15° Rounded Back Blade		
131351	6”, 15° Flat Back Blade, Right Hand		281
131352	6”, 15° Flat Back Blade, Left Hand		
131355	6”, 15° Flat Back Blade with Adjustable Stop		282
130594	7”, 15° Flat Back Blade		283
130914	7”, 15° Rounded Back		
131353	7”, 15° Flat Back Blade - Right Hand		284
131354	7”, 15° Flat Back Blade - Left Hand		
131356	7”, 15° Flat Back Blade with Adjustable Stop		285



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- Adjustable stop to protect cutting edge
- Black oxide finish to prevent rust
- Extra thick, foam handle covers
- Available with ergonomic leaf springs* or user-replaceable coil springs

Gate Cutter Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 6%**

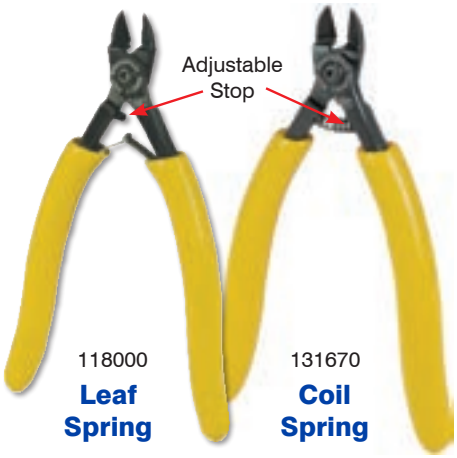
4" Model S44

Specifications	
Overall Length:	5"
Blade Length:	3/8"
Usable Blade Opening at Tip:	3/8"
Usable Blade Opening at Base:	3/16"
Weight:	4 oz.

Item #	Description
118000	5" Model S44 with twin leaf spring*
131670	5 5/8" Model S44-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

15° flat back blades for flush cuts



Cut plastic only. Wear eye protection.

5" Model S55

Specifications	
Overall Length:	5 5/8"
Blade Length:	9/16"
Usable Blade Opening at Tip:	9/16"
Usable Blade Opening at Base:	3/16"
Weight:	4 oz.

Item #	Description
118004	5 5/8" Model S55 with twin leaf spring*
131481	5 5/8" Model S55-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

15° flat back blades for flush cuts

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6" Model S66ER - Right Hand

Specifications	
Overall Length:	6"
Blade Length:	13/16"
Usable Blade Opening at Tip:	1/2"
Usable Blade Opening at Base:	13/16"
Weight:	6 oz.

Item #	Description
167506	6" Model S66ER with twin leaf spring*
167515	6" Model S66ER-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

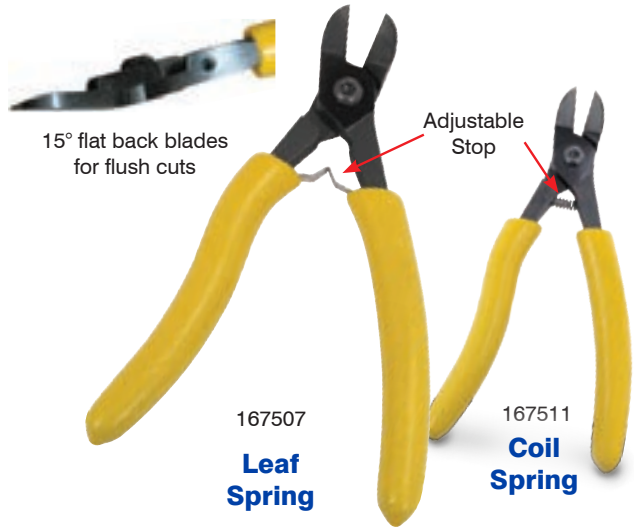
Cut plastic only. Wear eye protection.

6" Model S66EL - Left Hand

Specifications	
Overall Length:	6"
Blade Length:	13/16"
Usable Blade Opening at Tip:	1/2"
Usable Blade Opening at Base:	13/16"
Weight:	6 oz.

Item #	Description
167507	6" Model S77EL with twin leaf spring*
167511	6" Model S77EL-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service



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Gate Cutter Quantity Discounts
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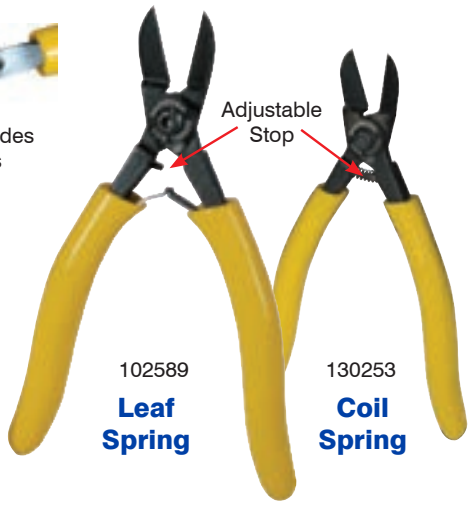
6" Model S66

Specifications	
Overall Length:	6⅝"
Blade Length:	⅞"
Usable Blade Opening at Tip:	⅝"
Usable Blade Opening at Base:	¼"
Weight:	6 oz.

Item #	Description
102589	6" Model S66 with twin leaf spring*
130253	6" Model S66-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

15° flat back blades for flush cuts



Cut plastic only. Wear eye protection.

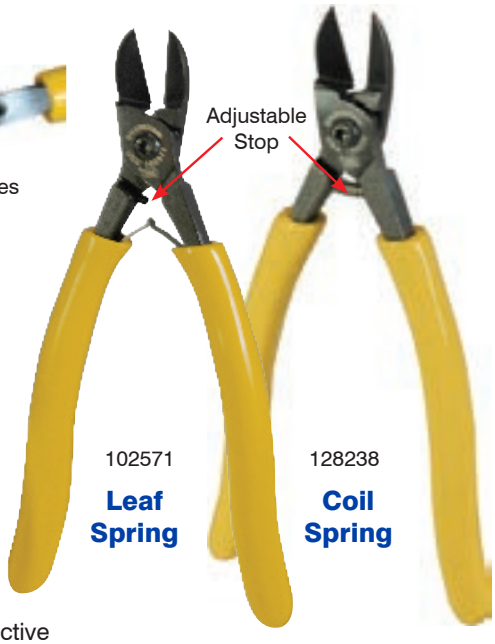
7" Model S77

Specifications	
Overall Length:	7"
Blade Length:	15/16"
Usable Blade Opening at Tip:	½"
Usable Blade Opening at Base:	3/16"
Weight:	8 oz.

Item #	Description
102571	7" Model S77 with twin leaf spring*
128238	7" Model S77-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

15° flat back blades for flush cuts



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- Adjustable stop to protect cutting edge
- Black oxide finish to prevent rust
- Extra thick, foam handle covers
- Available with ergonomic leaf springs* or user-replaceable coil springs

Gate Cutter Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 6%**

8" Model S88

Specifications	
Overall Length:	8"
Blade Length:	1¼"
Usable Blade Opening at Tip:	¾"
Usable Blade Opening at Base:	1/16"
Weight:	6⅖ oz.

Item #	Description
123494	8" Model S88 with twin leaf spring*
131669	8" Model S88-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

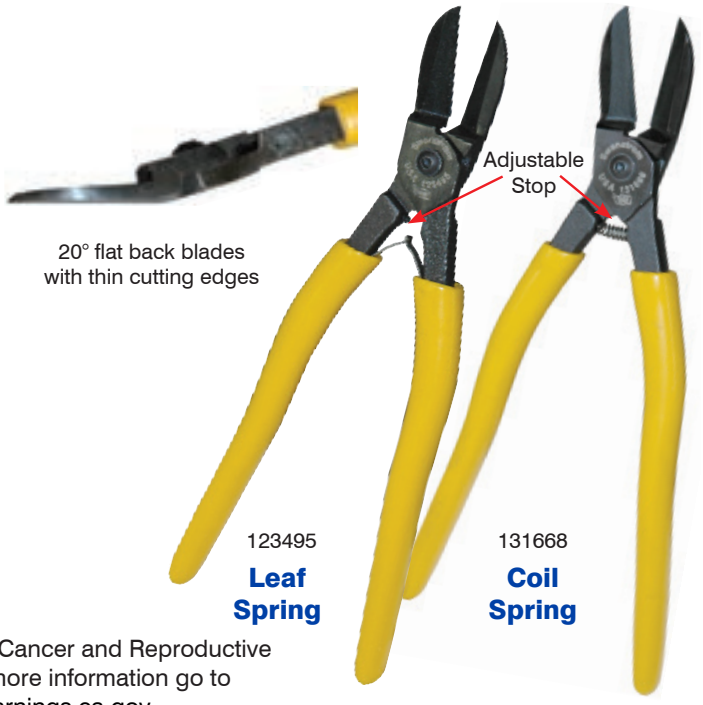
Cut plastic only. Wear eye protection.

9" Model S99

Specifications	
Overall Length:	9¾"
Blade Length:	1½"
Usable Blade Opening at Tip:	1"
Usable Blade Opening at Base:	3/16"
Weight:	6.4 oz.

Item #	Description
123495	9" Model S99 with twin leaf spring*
131668	9" Model S99-C with coil spring
Spare Parts	
130935	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service



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IMS Standard Classic Series Gate Cutters

Made in the U.S.A

High Quality Cutters

- Slim line, flat back blades
- Adjustable stop to protect cutting edge
- Foam handle covers
- Available with ergonomic leaf springs* or user-replaceable coil springs

Gate Cutter Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 6%**

6" Model SW6

Specifications	
Overall Length:	6"
Blade Length:	13/16"
Usable Blade Opening at Tip:	1/2"
Usable Blade Opening at Base:	3/16"
Weight:	6 oz.

Item #	Description
101534	6" Model SW6 with twin leaf spring*
131662	6" Model SW6-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

15° slim line blade with flat back

Cut plastic only. Wear eye protection.

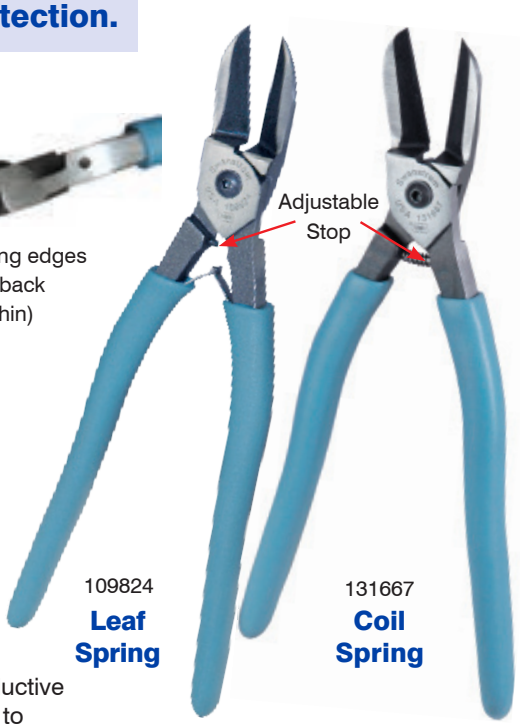
9" Model SW9

Specifications	
Overall Length:	9"
Blade Length:	1 1/2"
Usable Blade Opening at Tip:	1 1/8"
Usable Blade Opening at Base:	3/16"
Weight:	12 1/2 oz.

Item #	Description
109824	9" Model SW9 with twin leaf spring*
131667	9" Model SW9-C with coil spring
Spare Parts	
130935	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

20° thin cutting edges with flat back (extra thin)



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Made in the U.S.A

- Foam PVC handle covers

Gate Cutter Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 6%**

4" Model IMS3

Specifications	
Overall Length:	4"
Blade Length:	7/16"
Usable Blade Opening at Tip:	1/4"
Usable Blade Opening at Base:	3/32"
Weight:	1½ oz.

Item #	Description
130693	4" Model IMS3-C with coil spring
Spare Parts	
131329	Extra Coil Springs with Spacers

15° flat back,
standard profile

Cut plastic only. Wear eye protection.

4½" Model IMS4

Specifications	
Overall Length:	4½"
Blade Length:	5/8"
Usable Blade Opening at Tip:	5/16"
Usable Blade Opening at Base:	1/8"
Weight:	2½ oz.

Item #	Description
129667	4½" Model IMS4-C with coil spring
Spare Parts	
131329	Extra Coil Springs with Spacers

15° flat back,
slim line profile

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IMS Standard Signature Series Gate Cutters

- Foam PVC handle covers

Gate Cutter Quantity Discounts
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5" Model IMS5

Specifications	
Overall Length:	5"
Blade Length:	5/8"
Usable Blade Opening at Tip:	1/2"
Usable Blade Opening at Base:	1/4"
Weight:	3 oz.

Item #	Description
129501	5¼" Model IMS5-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

15° flat back, slim line profile

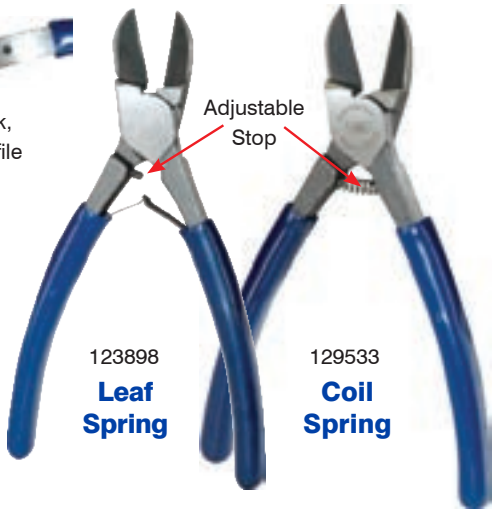
Cut plastic only. Wear eye protection.

6" Model IMS6S with Adjustable Stop

Specifications	
Overall Length:	6"
Blade Length:	7/8"
Usable Blade Opening at Tip:	9/16"
Usable Blade Opening at Base:	3/16"
Weight:	6 oz.

Item #	Description
123898	6" Model IMS6S with twin leaf spring*
129533	6" Model IMS6S-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

15° flat back, slim line profile



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Gate Cutter Quantity Discounts
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6" Model IMS6

Specifications	
Overall Length:	6½"
Blade Length:	13/16"
Usable Blade Opening at Tip:	¾"
Usable Blade Opening at Base:	¼"
Weight:	6oz.

Item #	Description
123456	6" Model IMS6 with twin leaf spring*
129502	6" Model IMS6-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

15° flat back, slim line profile

Cut plastic only. Wear eye protection.

7" Model IMSB7

Specifications	
Overall Length:	7"
Blade Length:	1"
Usable Blade Opening at Tip:	7/8"
Usable Blade Opening at Base:	¼"
Weight:	8 oz.

Item #	Description
123464	7" Model IMSB7 with twin leaf spring*

*Replaceable only through gate cutter repair service

15° rounded back, standard profile

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- Foam PVC handle covers

Gate Cutter Quantity Discounts
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7" Model IMS7S with Adustable Stop

Specifications

Overall Length:	7"
Blade Length:	1"
Usable Blade Opening at Tip:	7/16"
Usable Blade Opening at Base:	1/8"
Weight:	8 oz.

Item #	Description
123899	7" Model IMS7S with twin leaf spring*
129532	7" Model IMS7S-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

Cut plastic only. Wear eye protection.

7" Model IMS7

Specifications

Overall Length:	7"
Blade Length:	15/16"
Usable Blade Opening at Tip:	7/16"
Usable Blade Opening at Base:	3/16"
Weight:	8 oz.

Item #	Description
123454	7" Model IMS7 with twin leaf spring*
129534	7" Model IMS7-C with coil spring
Spare Parts	
129503	Extra Coil Springs with Spacers

*Replaceable only through gate cutter repair service

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Gate Cutter Quantity Discounts
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5" Flat Back

Specifications	
Overall Length:	5"
Blade Length:	11/16"
Usable Blade Opening at Tip:	9/16"
Usable Blade Opening at Base:	3/16"
Weight:	3.5 oz.

Item #	Description
130592	5" Flat Back with coil spring
Spare Parts	
131804	Extra Coil Springs

15° flat back, slim line profile

Cut plastic only. Wear eye protection.

5" Rounded Back

Specifications	
Overall Length:	5"
Blade Length:	11/16"
Usable Blade Opening at Tip:	9/16"
Usable Blade Opening at Base:	3/16"
Weight:	3.5 oz.

Item #	Description
130912	5" Rounded Back with coil spring
Spare Parts	
131804	Extra Coil Springs

15° slightly rounded back, slim line profile

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6" Flat Back

Specifications	
Overall Length:	6"
Blade Length:	¾"
Usable Blade Opening at Tip:	⅝"
Usable Blade Opening at Base:	¼"
Weight:	5 oz.

Item #	Description
130593	6" Flat Back with coil spring
Spare Parts	
131804	Extra Coil Springs

15° flat back, slim line profile

Cut plastic only. Wear eye protection.

6" Rounded Back

Specifications	
Overall Length:	6"
Blade Length:	¾"
Usable Blade Opening at Tip:	⅝"
Usable Blade Opening at Base:	¼"
Weight:	5 oz.

Item #	Description
130913	6" Rounded Back with coil spring
Spare Parts	
131804	Extra Coil Springs

15° slightly rounded back, slim line profile

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6" Flat Back, Right Hand

Specifications	
Overall Length:	6"
Blade Length:	¾"
Usable Blade Opening at Tip:	⅝"
Usable Blade Opening at Base:	¼"
Weight:	5 oz.

Item #	Description
131351	6" Flat Back, RH with coil spring
Spare Parts	
131804	Extra Coil Springs

15° flat back, slim line profile

Cut plastic only. Wear eye protection.

6" Flat Back, Left Hand

Specifications	
Overall Length:	6"
Blade Length:	¾"
Usable Blade Opening at Tip:	⅝"
Usable Blade Opening at Base:	¼"
Weight:	5 oz.

Item #	Description
131352	6" Flat Back, LH with coil spring
Spare Parts	
131804	Extra Coil Springs

15° flat back, slim line profile

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6" Flat Back with Adjustable Stop

Specifications	
Overall Length:	6"
Blade Length:	¾"
Usable Blade Opening at Tip:	5/8"
Usable Blade Opening at Base:	¼"
Weight:	5 oz.

Item #	Description
131355	6" Flat Back with Adjustable Stop and coil spring
Spare Parts	
131804	Extra Coil Springs

15° flat back, slim line profile

Cut plastic only. Wear eye protection.

6" Flat Back, 45° Blade

Specifications	
Overall Length:	6"
Blade Length:	13/16"
Usable Blade Opening at Tip:	11/16"
Usable Blade Opening at Base:	11/32"
Weight:	4.8 oz.

Item #	Description
133130	6" Flat Back, 45° with coil spring
Spare Parts	
131804	Extra Coil Springs

45° flat back, standard profile

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Gate Cutter Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 8%**

7" Flat Back

Specifications	
Overall Length:	7¼"
Blade Length:	1"
Usable Blade Opening at Tip:	⅞"
Usable Blade Opening at Base:	5/16"
Weight:	8.3 oz.

Item #	Description
130594	7" Flat Back with coil spring
Spare Parts	
131805	Extra Coil Springs

15° flat back, slim line profile

Cut plastic only. Wear eye protection.

7" Rounded Back

Specifications	
Overall Length:	7¼"
Blade Length:	1"
Usable Blade Opening at Tip:	⅞"
Usable Blade Opening at Base:	5/16"
Weight:	8.3 oz.

Item #	Description
130914	7" Rounded Back with coil spring
Spare Parts	
131805	Extra Coil Springs

15° slightly rounded back, slim line profile

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Gate Cutter Quantity Discounts
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7" Flat Back, Right Hand

Specifications	
Overall Length:	7¼"
Blade Length:	1"
Usable Blade Opening at Tip:	⅞"
Usable Blade Opening at Base:	5/16"
Weight:	8.3 oz.

Item #	Description
131353	7" Flat Back, RH with coil spring
Spare Parts	
131805	Extra Coil Springs

15° flat back,
slim line profile

Cut plastic only. Wear eye protection.

7" Flat Back, Left Hand

Specifications	
Overall Length:	7¼"
Blade Length:	1"
Usable Blade Opening at Tip:	⅞"
Usable Blade Opening at Base:	5/16"
Weight:	8.3 oz.

Item #	Description
131354	7" Flat Back, LH with coil spring
Spare Parts	
131805	Extra Coil Springs

15° flat back,
slim line profile

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Gate Cutter Quantity Discounts
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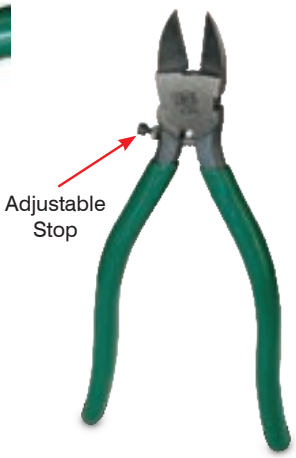
7" Flat Back with Adjustable Stop

Specifications	
Overall Length:	7¼"
Blade Length:	1"
Usable Blade Opening at Tip:	⅞"
Usable Blade Opening at Base:	5/16"
Weight:	8.3 oz.

Item #	Description
131356	7" Flat Back with Adjustable Stop and coil spring
Spare Parts	
131805	Extra Coil Springs

15° flat back, slim line profile



Cut plastic only. Wear eye protection.

Gate Cutter Springs

Item #	Description
129503	For: S44-C, S55-C, S66-C, S77-C, S88-C, SW5-C, SW5ER-C, SW6-C, SW6ER-C, SW6EL-C, S7S-C, IMS5-C, IMS6S-C, IMS6-C, IMS6NN-C, IMS7S-C, IMS7-C, SW6C.35, SW6C.45, SW6C.90, SW6CN, SW6CBXN, SWB7CSB90, SWB7CSB45
130935	For: S99-C, SW9-C
131329	For: IMS3-C, IMS4-C, SB5C.80
131804	For: 130592, 130912, 130593, 130913, 131351, 131352, 131355, 133130, 133131, 163729, 133130, 133131
131805	For: 130594, 130914, 131353, 131354, 131356
106426	For: 100832
144599	For: SW10C.30
102908	For: F1, FH2, FH245, FH290, 109470, 109466

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Special Application Super Gate Cutters Quick Reference

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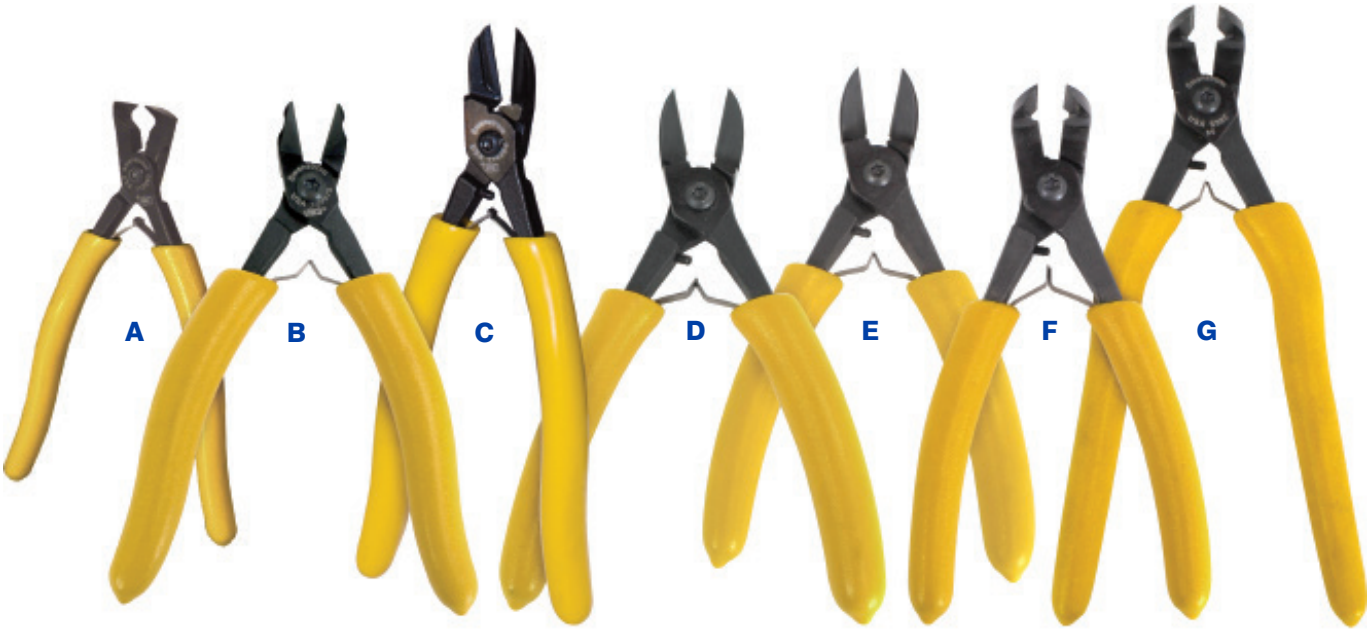

Leaf Spring shown - Available with Coil Spring (see below)

Special Application Super Gate Cutters (Leaf Spring)						
	Item #	Length	Description	Model	Spring	Page
A	113593	5¾"	Flat Back - End Nipper	SB5.80	Leaf	288
	129907	5⅝"	15° Flat Back, Oval Blade	SB5.CH		289
B	129975	6½"	15° Flat Back, Oval Blade	SB6.CH		
C	110284	7"	15° Flat Back, Extra Slim Blade	S7S		
D	167508	6"	35° Flat Back, Full Blade	S66.35		290
E	167509		45° Flat Back, Full Blade	S66.45		
F	167510		90° Flat Back, Full Blade	S66.90		291
G	167582	7¾"	90° Flat Back, Slim Blade	S88.90		

Special Application Super Gate Cutters (Coil Spring)						
	Item #	Length	Description	Model	Spring	Page
A	133163	5¾"	Flat Back - End Nipper	SB5C.80	Coil	290
C	131665	7"	15° Flat Back, Extra Slim Blade	S7S-C		289
D	167512	6"	35° Flat Back, Full Blade	S66C.35		290
E	167513		45° Flat Back, Full Blade	S66C.45		
F	167514		90° Flat Back, Full Blade	S66C.90		291
G	167583	7¾"	90° Flat Back, Slim Blade	S88C.90		

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Special Application Gate Cutters

Quick Reference Price Chart

Special Application Gate Cutters		
Description	**Item #**	**Page**
5¾" Model IMS6CC, Concave Blade	131186	292
6" Model IMS6CX-C, Convex Blade	163729	293
6" Economy, 45° Blade	133130	295
6" Economy, 90° Blade	133131	295
6½" Model SW6N End Nipper	123486	296
6½" Model SW6CN End Nipper	144565	296
6" Model SW6BXN Box End Nipper	133334	297
6" Model IMS6NN Needle-Nose	123453	297
6" Model IMS6NN-C Needle-Nose	129447	297
7" Bent Handle Model SWB7CSB90, Rounded Back Blade	144566	298
7½" Bent Handle Model SWB7CSB45, Rounded Back Blade	123484	298
7½" Model SWB7.25, 25 Rounded Back	123483	299
10" Model SW10.30, 30° Flat Back Blade	144597	299
5" Lightweight Nips	100832	300
5" Mini-Nippers	129941	300

Have a tough gate cutting job? Not sure which cutter to try?

Send your parts to IMS and let our experts recommend the perfect cutter for the job. There is never a charge for this service. Call and ask for details! We're here to help!

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Special Application Super Gate Cutters

5¾" Model SB5.80, 80° Rounded Back Blade

- Stop screw to extend blade life
- For concave surface cuts; rounded angles
- High chromium Swedish/American steel
- Black oxide finish
- Soft foam grips

Blade with rounded back

Specifications and Prices

Spring Type:	Stainless steel twin leaf* or coil
Overall Length:	5¾"
Blade Length:	½"
Usable Blade Opening at Tip:	5/16"
Weight:	7 oz.

*Replaceable only through gate cutter repair service

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
113593	5¾" Model SB5.80, 80° Rounded Back Blade with Leaf Spring*
133163	5¾" Model SB5C.80, 80° Rounded Back Blade with Coil Spring
Spare Part	
131329	Extra springs

Cut plastic only. Wear eye protection.

Cuts Tough Jobs - Doesn't Scratch

Custom Cutters Made-To-Order — See Page 267 For Details

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Special Application Super Gate Cutters

Made in the U.S.A

5⅝" and 6½" Model SB.CH, Oval Blade

- High chromium Swedish/American steel for far greater cutting edge life
- Black oxide finish
- Soft foam grips

15° oval blade with flat back

Specifications and Prices

Spring Type:	Stainless steel twin leaf*	
	129907	129975
Overall Length:	5⅝"	6½"
Blade Length:	½"	¾"
Usable Blade Opening at Tip:	9/16"	⅝"
Usable Blade Opening at Base:	3/16"	¼"
Weight:	4 oz.	4 oz.

*Replaceable only through gate cutter repair service

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
129907	5⅝" Model SB5.CH, Oval Blade with Leaf Spring*
129975	6½" Model SB6.CH, Oval Blade with Leaf Spring*

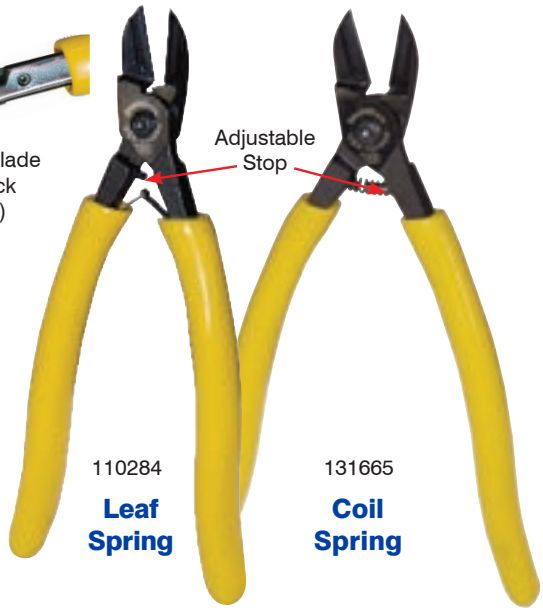
Cut plastic only. Wear eye protection.

Cuts Tough Jobs - Doesn't Scratch

7" Model S7S

- Ultra slim line, flat back blades - milled for extra flush cuts
- Adjustable stop to protect cutting edge
- Foam handle covers

15° slim line blade with flat back (extra slim)



Specifications and Prices

Spring Type:	Stainless steel twin leaf* or coil
Overall Length:	7"
Blade Length:	⅞"
Usable Blade Opening at Tip:	½"
Usable Blade Opening at Base:	3/16"
Weight:	7 oz.

*Replaceable only through gate cutter repair service

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
110284	7" Model S7S with twin leaf spring*
131665	7" Model S7S-C with coil spring
Spare Part	
131329	Extra springs

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Made in the U.S.A

Special Application Super Gate Cutters

6" Model S66.35

- 35° angled blade for hard to reach gates
- High chromium Swedish/American steel
- Black oxide finish
- Soft foam grips

35° full blade with flat back

Specifications and Prices

Spring Type:	Stainless steel twin leaf* or coil
Overall Length:	6"
Blade Length:	¾"
Usable Blade Opening at Tip:	½"
Usable Blade Opening at Base:	¼"
Weight:	6 oz.

*Replaceable only through gate cutter repair service

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
167508	6" Model S66.35, 35° Blade with twin leaf spring*
167512	6" Model S66.35C, 35° Blade with coil spring
Spare Part	
129503	Extra springs

Cut plastic only. Wear eye protection.

Cuts Tough Jobs - Doesn't Scratch

6" Model S66.45

- 45° angled blade for hard to reach gates
- High chromium Swedish/American steel
- Black oxide finish
- Soft foam grips

45° full blade with flat back

Specifications and Prices

Spring Type:	Stainless steel twin leaf* or coil
Overall Length:	6"
Blade Length:	15/16"
Usable Blade Opening at Tip:	9/16"
Usable Blade Opening at Base:	¼"
Weight:	6 oz.

*Replaceable only through gate cutter repair service

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
167509	6" Model S66.45, 45° Blade with twin leaf spring*
167513	6" Model S66.45C, 45° Blade with coil spring
Spare Part	
129503	Extra springs

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Special Application Super Gate Cutters

Made in the U.S.A

6" Model S66.90

- Flat cutting surface for reaching into hollow objects
- High chromium Swedish/American steel
- Black oxide finish
- Soft foam grips

90° full blade with flat back

Specifications and Prices

Spring Type:	Stainless steel twin leaf* or coil
Overall Length:	6"
Blade Length:	11/16"
Usable Blade Opening at Tip:	5/16"
Weight:	6 oz.

*Replaceable only through gate cutter repair service

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
167510	6" Model S66.90, 90° Blade with twin leaf spring*
167514	6" Model S66.90C, 90° Blade with coil spring
Spare Part	
129503	Extra springs

Cut plastic only. Wear eye protection.

Cuts Tough Jobs - Doesn't Scratch

7¾" Model S88.90

- Flat cutting surface for reaching into hollow objects
- High chromium Swedish/American steel
- Black oxide finish
- Soft foam grips

90° slim blade with flat back

Specifications and Prices

Spring Type:	Stainless steel twin leaf* or coil
Overall Length:	7¾"
Blade Length:	11/16"
Usable Blade Opening at Tip:	5/16"
Weight:	8 oz.

*Replaceable only through gate cutter repair service

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
167582	7¾" Model S88.90, 90° Blade with twin leaf spring*
167583	7¾" Model S88.90C, 90° Blade with coil spring
Spare Part	
129503	Extra springs

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Special Application Gate Cutters

5¾" Model IMS6CC, Concave Blade

- Concave curved blades with rounded angles
- Long-life box joint protects pivot joint
- Stop screw extends blade life
- Reduced operator fatigue and strain
- Bonded plastic grips

Concave back

Stop Screw

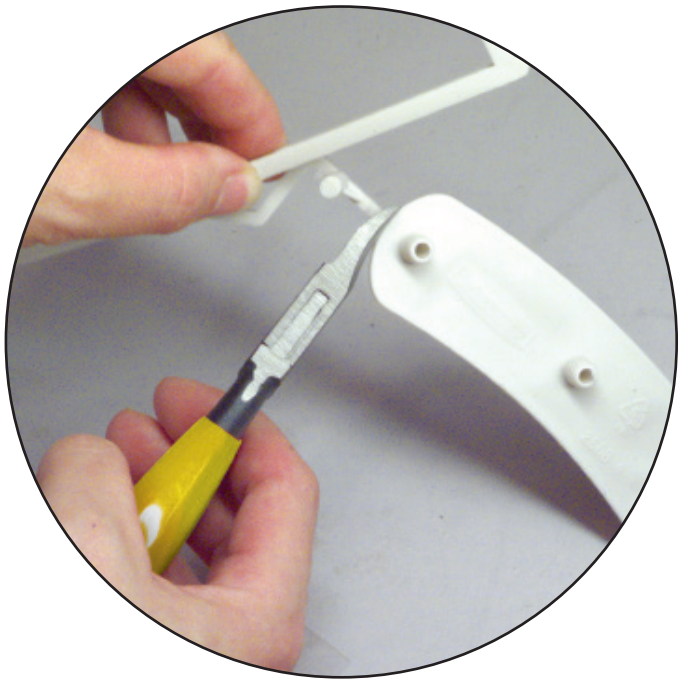
Leaf Spring

Specifications and Prices	
Spring Type:	Single leaf
Overall Length:	5¾"
Blade Length:	⅞"
Usable Blade Opening at Tip:	⅜"
Usable Blade Opening at Base:	3/16"
Weight:	6 oz.

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
131186	5¾" Model IMS6CC, Concave Blade

Cut plastic only.
Wear eye protection.



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Special Application Gate Cutters

6" Convex Blade

- Convex blade trims inside curves
- Trims closely on radii and round parts
- Reduced operator fatigue and strain
- Bonded PVC grips

Blade is convex for trimming inside curves

Coil Spring

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Specifications and Prices

Spring Type:	Coil
Overall Length:	6 1/8"
Blade Length:	29/32"
Usable Blade Opening at Tip:	18/32"
Usable Blade Opening at Base:	7/32"
Weight:	4¾oz.

Item #	Description
163729	6" Convex Blade
Spare Part	
131804	Extra springs

Cut plastic only.
Wear eye protection.

Custom Cutters Made-To-Order — See Page 267 For Details

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IMS Special Application Gate Cutters

Economy 6" Flat Back, 45° Blade

Specifications	
Overall Length:	6"
Blade Length:	13/16"
Usable Blade Opening at Tip:	11/16"
Usable Blade Opening at Base:	11/32"
Weight:	4.8 oz.

Gate Cutter Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 8%**

Item #	Description
133130	6" Flat Back, 45° with coil spring
Spare Part	
131804	Extra Coil Springs

45° flat back, standard profile

PVC dip-coated handles

Cut plastic only. Wear eye protection.

Economy 6", 90° Blade

Specifications and Prices	
Overall Length:	6"
Blade Length:	3/4"
Usable Blade Opening at Tip:	9/16"
Weight:	6 oz.

Gate Cutter Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 8%**

Item #	Description
133131	6", 90° Blade with coil spring
Spare Part	
131804	Extra Coil Springs

90° blade

PVC dip-coated handles

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IMS Special Application Gate Cutters

Made in the U.S.A

6½" Model SW6N End Nipper

- Flat cutting face for reaching into narrow channels
- Blade stop with adjustable set screw lengthens life
- Bonded PVC grips

Cuts Tough Jobs – Doesn't Scratch

Blade is convex for trimming inside curves

Specifications

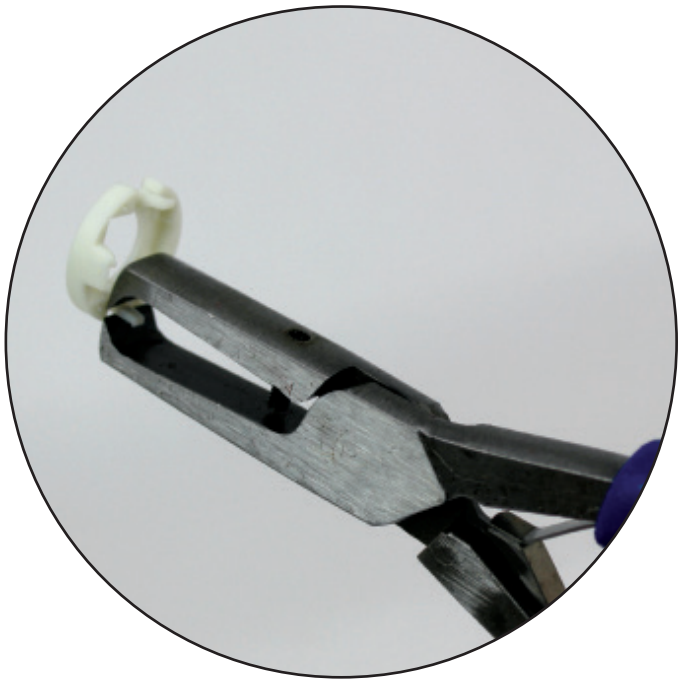
Spring Type:	stainless steel twin leaf* or coil
Overall Length:	6½"
Blade Length:	3/8"
Usable Blade Opening at Tip:	7/16"
Weight:	5 oz.

*Replaceable only through gate cutter repair service

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
123486	6½" Model SW6N End Nipper with Leaf Spring
144565	6½" Model SW6CN End Nipper with Coil Spring
Spare Part	
129503	Extra springs

Cut plastic only. Wear eye protection.



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Made in the U.S.A

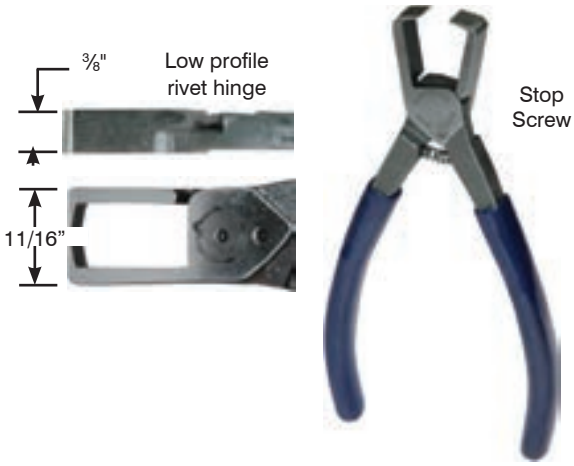
IMS Special Application Gate Cutters

6" Model SW6BXN Box Style End Nipper

Specifications	
Overall Length:	6"
Blade Length:	½"
Usable Blade Opening at Tip:	⅝"
Weight:	5 oz.

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
133334	6" Box Style Nipper with coil spring
Spare Part	
129503	Extra Coil Springs



Cut plastic only. Wear eye protection.

6" Model IMS6NN (Needle-Nose) with Adjustable Stop

Specifications	
Overall Length:	6½"
Blade Length:	13/16"
Usable Blade Opening at Tip:	¾"
Usable Blade Opening at Base:	¼"
Weight:	6 oz.

Gate Cutter Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 6%**

Item #	Description
123453	6½" Model IMS6NN w/ twin leaf spring*
129447	6½" Model IMS6NN-C with coil spring
Spare Part	
129503	Extra Coil Springs

* Replaceable only through gate cutter repair service

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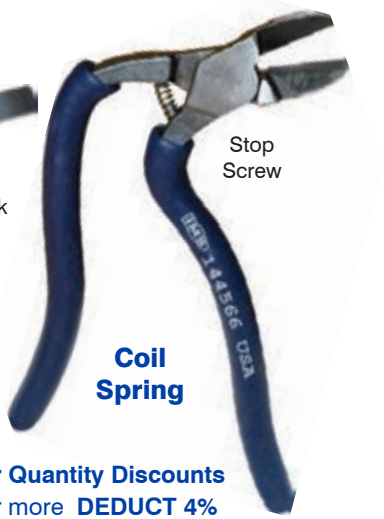
IMS Special Application Gate Cutters

Made in the U.S.A

7" Bent Handle Model SWB7CSB90, Rounded Back Blade

- 25° angled blade with slightly rounded back
- Bent handle for easy side cutting
- Blade stop with adjustable set screw lengthens life
- Durable construction
- Bonded foam grips

15° blade with slightly rounded back



Specifications and Prices

Spring Type:	Coil
Overall Length:	7"
Blade Length:	1"
Usable Blade Opening at Tip:	¾"
Usable Blade Opening at Base:	½"
Weight:	6.25 oz.

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
144566	7" Bent Handle Model SWB7CSB90, Rounded Back Blade
Spare Part	
129503	Extra springs

Cut plastic only. Wear eye protection.

Cuts Tough Jobs - Doesn't Scratch

7½" Bent Handle Model SWB7CSB45, Rounded Back Blade

- 15° angled blade with slightly rounded back
- Bent handle for easy side cutting
- Blade stop with adjustable set screw lengthens life
- Durable construction
- Bonded PVC grips

15° blade with slightly rounded back

Specifications and Prices

Spring Type:	Coil
Overall Length:	7½"
Blade Length:	15/16"
Usable Blade Opening at Tip:	¾"
Usable Blade Opening at Base:	¼"
Weight:	8 oz.

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
123484	7½" Bent Handle Model SWB7CSB45, Rounded Back Blade
Spare Part	
129503	Extra springs

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Made in the U.S.A

IMS Special Application Gate Cutters

7½" Model SWB7.25, 25° Rounded Back Blade

- Unique blade milling
- Slightly rounded back for extra blade strength
- Thin blade to slice cleanly
- Bonded PVC grips

25° blade with slightly rounded back

Specifications and Prices

Spring Type:	Stainless steel twin leaf*
Overall Length:	7½"
Blade Length:	⅞"
Usable Blade Opening at Tip:	5/16"
Usable Blade Opening at Base:	⅛"
Weight:	8 oz.

*Replaceable only through gate cutter repair service

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
123483	7½" Model SWB7.25, 25° Rounded Back Blade

Cut plastic only. Wear eye protection.

Cuts Tough Jobs - Doesn't Scratch

10" Model SW10.30, 30° Flat Back Blade

- Bonded plastic grips with contoured handles

30° blade with thin cutting edges and flat back

Specifications and Prices

Spring Type:	Stainless steel twin leaf* or coil
Overall Length:	9¾"
Blade Length:	1 5/16"
Usable Blade Opening at Tip:	1⅝"
Usable Blade Opening at Base:	¾"
Weight:	16 oz.

*Replaceable only through gate cutter repair service

Gate Cutter Quantity Discounts
Order 25 or more **DEDUCT 4%**

Item #	Description
144597	10" Model SW10.30, 30° Flat Back Blade with Leaf Spring*
144598	10" Model SW10C.30, 30° Flat Back Blade with Coil Spring
Spare Part	
144599	Extra spring

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Special Application Gate Cutters

5" Lightweight Nips

- Fully flush ground flat back blades
- Fast acting, long lasting spring
- Made of case hardened steel
- Stainless steel pivot

20° fully flush-ground flat back blades

Fast acting, semi-hidden U-Type spring

Specifications and Prices

Spring Type:	U-Type
Overall Length:	5"
Blade Length:	3/8"
Usable Blade Opening at Tip:	11/16"
Usable Blade Opening at Base:	3/8"
Weight:	1½ oz.

Gate Cutter Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 6%**

Item #	Description
100832	5" Model T1055 Lightweight Nips
Spare Part	
106426	Extra U-Type Springs

Cut plastic only. Wear eye protection.

5" Mini-Nippers

- .004" offset flat-back blades
- Fast acting, long lasting spring
- Made of case-hardened steel
- Soft-touch handle grips for safety
- Blades heat treated to 57 Rockwell C
- .004 offset flat back blades

20°.004 offset flat back blades

Fast acting, semi-hidden spring

Thick Handles

Specifications

Spring Type:	semi-hidden torsion
Overall Length:	5"
Blade Length:	7/16"
Usable Blade Opening at Tip:	¼"
Usable Blade Opening at Base:	5/32"
Copper Wire:	1.3 mm (16 gauge) max.
Weight:	1½ oz.

Gate Cutter Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 6%**

Item #	Description
129941	5" Mini-Nippers

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Keiba Precision-Ground Gate Cutters

Features

- High-Carbon Alloy Steel: Engineered for long life, edge durability, and clean gate cuts
- Precision-Ground Blade Edges: Engineered for exact alignment—deliver cleaner cuts, faster performance, and reduced operator fatigue
- Made in Japan: Known worldwide for precision, durability, and consistent quality

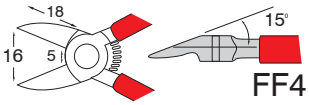
Cut plastic only. Wear eye protection.

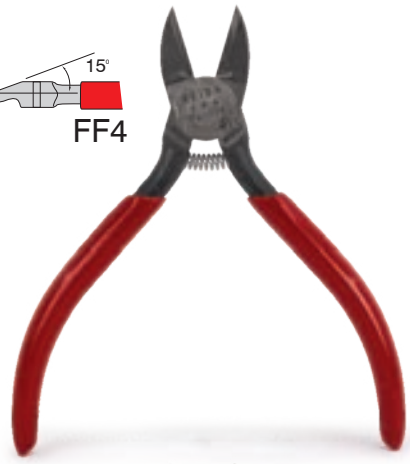
4" Flat Back, Model FF4

Specifications	
Overall Length:	4 5/8" (117mm)
Blade Length:	11/16" (17mm)
Usable Blade Opening at Tip:	5/8" (16mm)
Usable Blade Opening at Base:	3/16" (5mm)
Weight:	2.3 oz.

Item #	Description
176010	15° Flat Back Blade, Slim Profile

15° flat back blades for flush cuts



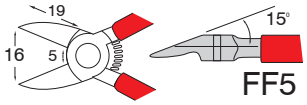


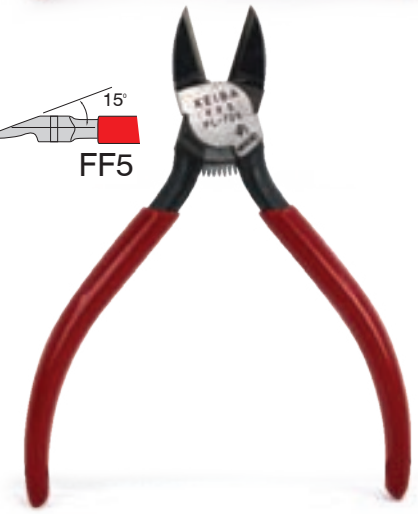
5" Flat Back, Model FF5

Specifications	
Overall Length:	5" (127mm)
Blade Length:	3/4" (19mm)
Usable Blade Opening at Tip:	5/8" (16mm)
Usable Blade Opening at Base:	3/16" (5mm)
Weight:	2.9 oz.

Item #	Description
176011	15° Flat Back Blade, Slim Profile

15° flat back blades for flush cuts



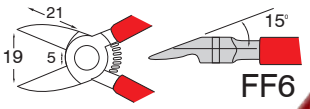


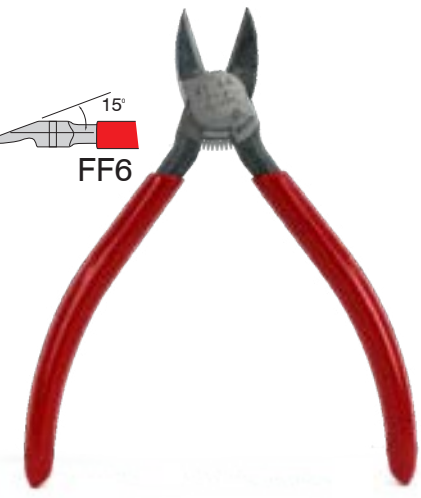
6" Flat Back, Model FF6

Specifications	
Overall Length:	6 1/8" (156mm)
Blade Length:	13/16" (21mm)
Usable Blade Opening at Tip:	13/16" (21mm)
Usable Blade Opening at Base:	3/16" (5mm)
Weight:	4.7 oz.

Item #	Description
176012	15° Flat Back Blade, Slim Profile

15° flat back blades for flush cuts





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Keiba Precision-Ground Gate Cutters

Features

- High-Carbon Alloy Steel: Engineered for long life, edge durability, and clean gate cuts
- Precision-Ground Blade Edges: Engineered for exact alignment—deliver cleaner cuts, faster performance, and reduced operator fatigue
- Made in Japan: Known worldwide for precision, durability, and consistent quality

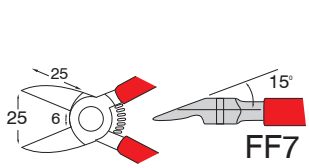
Cut plastic only. Wear eye protection.

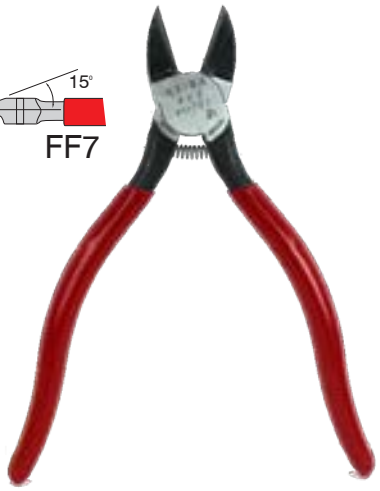
7" Flat Back, Model FF7

Specifications	
Overall Length:	7 ½" (190mm)
Blade Length:	1" (25mm)
Usable Blade Opening at Tip:	1" (25mm)
Usable Blade Opening at Base:	¼" (6mm)
Weight:	8.2 oz.

Item #	Description
176016	15° Flat Back Blade, Slim Profile

15° flat back blades for flush cuts



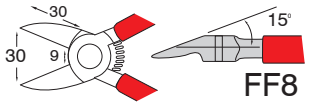


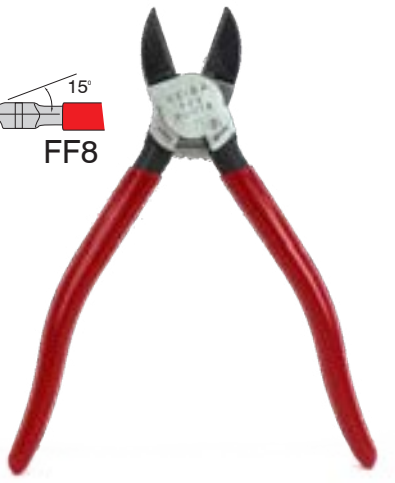
8" Flat Back, Model FF8

Specifications	
Overall Length:	8" (205mm)
Blade Length:	1 3/16" (30mm)
Usable Blade Opening at Tip:	1 3/16" (30mm)
Usable Blade Opening at Base:	3/8" (9mm)
Weight:	11 oz.

Item #	Description
176021	15° Flat Back Blade, Slim Profile

15° flat back blades for flush cuts





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Keiba Precision-Ground Gate Cutters

Features

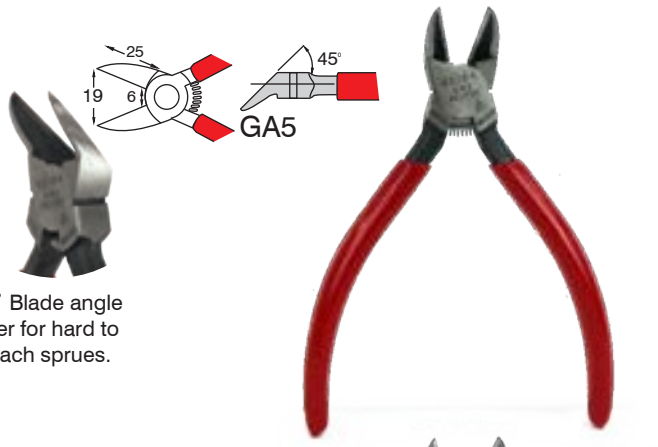
- High-Carbon Alloy Steel: Engineered for long life, edge durability, and clean gate cuts
- Precision-Ground Blade Edges: Engineered for exact alignment—deliver cleaner cuts, faster performance, and reduced operator fatigue
- Made in Japan: Known worldwide for precision, durability, and consistent quality

Cut plastic only. Wear eye protection.

6", 45° Blade, Model GA5

Specifications	
Overall Length:	5 7/8" (150mm)
Blade Length:	1" (25mm)
Usable Blade Opening at Tip:	3/4" (19mm)
Usable Blade Opening at Base:	1/4" (6mm)
Weight:	4.5 oz.

Item #	Description
176022	45° Flat Back Blade, Slim Profile

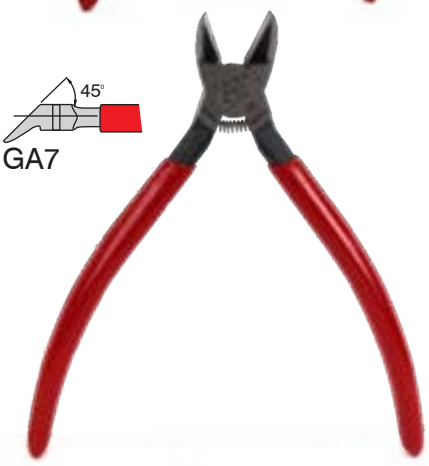


45° Blade angle Plier for hard to reach sprues.

6 ½", 45° Blade, Model GA7

Specifications	
Overall Length:	6 ½" (166mm)
Blade Length:	1" (25mm)
Usable Blade Opening at Tip:	3/4" (19mm)
Usable Blade Opening at Base:	1/4" (6mm)
Weight:	5.5 oz.

Item #	Description
176024	45° Flat Back Blade, Slim Profile

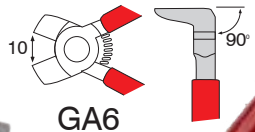


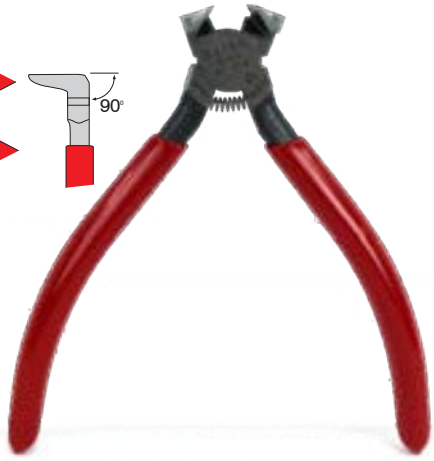
45° Blade angle Plier for hard to reach sprues.

5 ½", 90° Blade, Model GA6

Specifications	
Overall Length:	5 ½" (140mm)
Blade Length:	13/16" (20mm)
Usable Blade Opening at Tip:	3/8" (10mm)
Usable Blade Opening at Base:	3/8" (10mm)
Weight:	5.2 oz.

Item #	Description
176023	90° Flat Back Blade, Slim Profile





90° Blade angle Plier for hard to reach sprues.

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tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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Keiba Precision-Ground Gate Cutters

Features

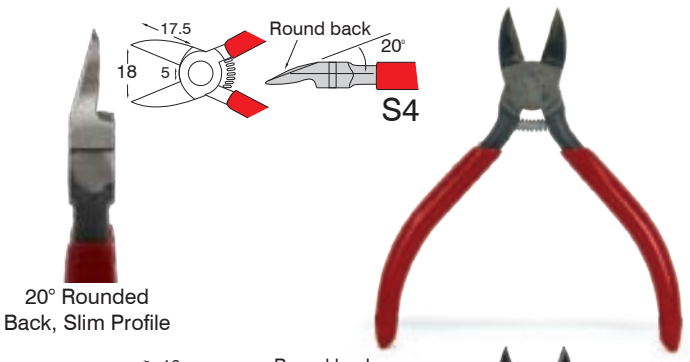
- High-Carbon Alloy Steel: Engineered for long life, edge durability, and clean gate cuts
- Precision-Ground Blade Edges: Engineered for exact alignment—deliver cleaner cuts, faster performance, and reduced operator fatigue
- Made in Japan: Known worldwide for precision, durability, and consistent quality

Cut plastic only. Wear eye protection.

4-1/2" Rounded Back, Model S4

Specifications	
Overall Length:	4 5/8" (177mm)
Blade Length:	11/16" (17mm)
Usable Blade Opening at Tip:	11/16" (18mm)
Usable Blade Opening at Base:	3/16" (5mm)
Weight:	2.3 oz.

Item #	Description
176027	20° Rounded Back, Slim Profile

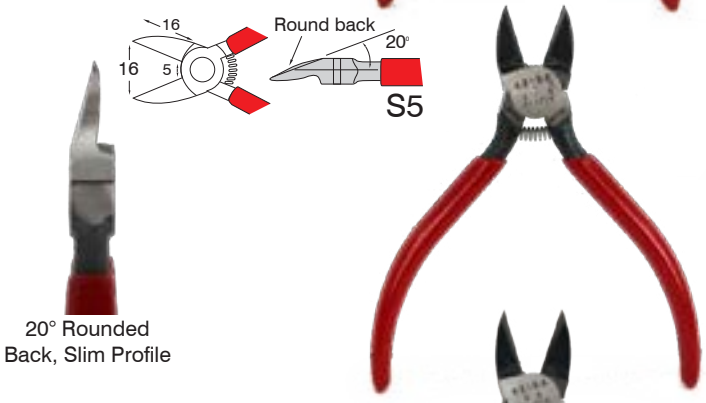


20° Rounded Back, Slim Profile

5" Rounded Back, Model S5

Specifications	
Overall Length:	5" (127mm)
Blade Length:	3/4" (19mm)
Usable Blade Opening at Tip:	11/16" (18mm)
Usable Blade Opening at Base:	3/16" (5mm)
Weight:	2.8 oz.

Item #	Description
176028	20° Rounded Back, Slim Profile

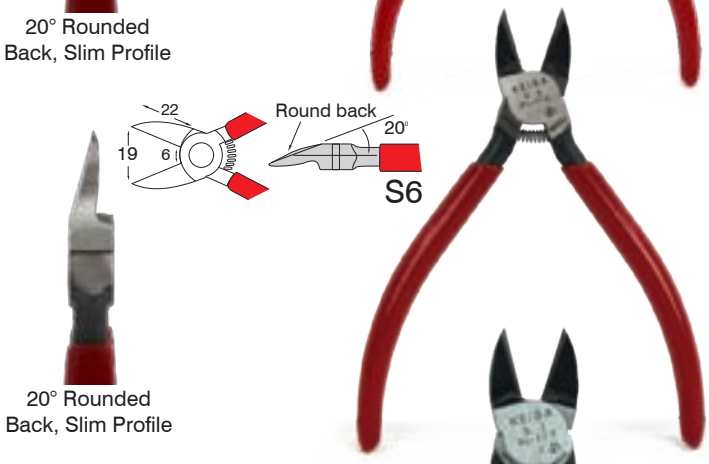


20° Rounded Back, Slim Profile

6" Rounded Back, Model S6

Specifications	
Overall Length:	6 1/8" (156mm)
Blade Length:	7/8" (22mm)
Usable Blade Opening at Tip:	3/4" (19mm)
Usable Blade Opening at Base:	1/4" (6mm)
Weight:	4.7 oz.

Item #	Description
176030	20° Rounded Back, Slim Profile

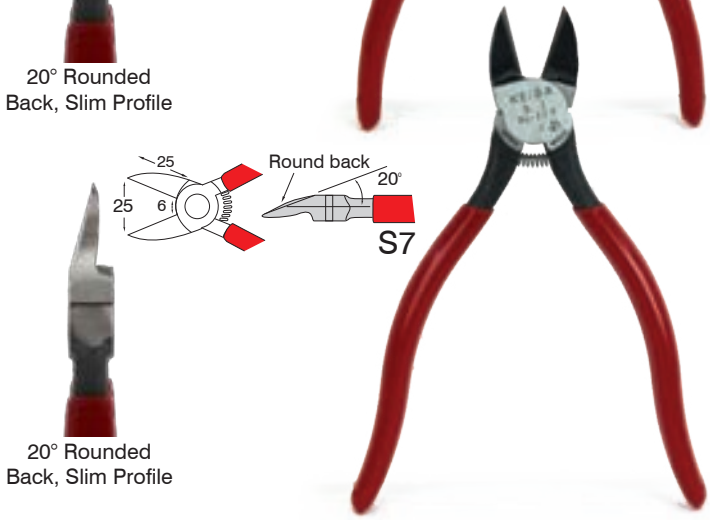


20° Rounded Back, Slim Profile

7" Rounded Back, Model S7

Specifications	
Overall Length:	7 1/2" (190mm)
Blade Length:	1" (25mm)
Usable Blade Opening at Tip:	1" (25mm)
Usable Blade Opening at Base:	1/4" (6mm)
Weight:	7.9 oz.

Item #	Description
176034	20° Rounded Back, Slim Profile



20° Rounded Back, Slim Profile

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IMS Gate Cutter Repair Service

You Save 5 Ways

1. Productivity increases as efficient tools help operator efficiency.
2. Quality of the product improves with precise, clean cuts; your product reject rate drops.
3. Expense of tool is significantly reduced.
4. Reduced operator strain can reduce repetitive-motion injuries.
5. Inventory costs for hand tools are reduced.

Worn And Damaged Gate Cutters Like These Can Be Completely Reconditioned Like These.

Quickly And Economically
(Lead time required — Call for details)

Like New Tools For Considerably Less Than The Cost Of New Ones

Satisfaction Guaranteed

Each Cutter Receives These Basic Services

- Thorough, Ultrasonic Cleaning removes damaging particles inside the joint.
- Precise Joint Adjustment brings dull edges back into line.
- Careful Honing restores cutting edges and tips without loss of temper.
- Grips replaced with soft, fatigue-reducing grips.
- New Springs installed if necessary.
- Polishing inhibits corrosion and makes your tools look as good as they will work.
- Cleaning and Lubrication guarantee longer tool life.
- A Final Testing insures that each tool meets the plastic industry's highest quality standards.

Call for Quote

For Gate Cutter Repair:

Call the IMS Order Line for a Return Authorization (RA) Number and Instructions.

Gate Cutters considered beyond repair will be returned on request or scrapped.

IMS Company

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phone order toll-free (USA & Canada) 1.800.537.5375

fax order toll-free (USA & Canada) 1.888.288.6900

phone order toll-free (Mexico) 001.888.304.1307

tech support toll-free (USA & Canada) 1.866.467.9001

e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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Air-Powered Gate Cutters and Accessories

Air-Powered Gate Cutters come in five models with cutting forces ranging from 250 to 2400 lbs. These cutters can take on tough materials that ordinary regular gate cutters just can't handle. The design, originally created for engineered plastics, ensures a quick, clean and easy cut. Trouble-free cutting improves your productivity and decreases operator fatigue, reducing the possibility of the painful and costly carpal tunnel syndrome. Other features include:

- Long-life neoprene O-ring springs
- Three blade styles for cutting through difficult plastics
- Safety lever latch (all models except PGC1)
- Optional foot-operated valve
- Optional suspension kit
- Optional blade coatings and treatments

Additional features and options

IMS includes the Safety Lever Latch on its air-powered cutters (not available on the PGC1). This requires the operator to release a spring-actuated latch prior to squeezing the lever to begin cutting. This feature enhances safety in your shop by preventing inadvertent actuation.

A popular optional accessory along these lines is the Hands-Free Foot-Operated Air Valve. This option fits conditions involving the de-gating of large parts secured by a fixture. Generally the gate cutter assembly is fixed in a stationary position. The Hands-Free option requires a modified power pack and is offered in an economically priced kit for all our air-powered cutters.

Suspension Kits fit all air-powered gate cutters and will keep cutters off the bench and in a ready-to-use position. This addition to your process will reduce repetitive motion strain and increase productivity.

Blades

We offer a variety of blade styles for five power ranges. We also offer specially coated blades for abrasive and talc or glass-filled materials. If your de-gating needs are unique, order blank blades that you can machine yourself. On request, we cryogenically treat the blades for extended wear resistance.

With such a vast variety of plastic types and sizes, we want to be absolutely sure that you receive the ideal model for your application.

Send us about a dozen parts, with the runner/ sprue attached, and one of our engineers will recommend the most suitable air-powered cutter for your application. Call an IMS Customer Service Representative for details and an RA number.

OVERVIEW

See Frequently Asked Questions & Answers — Page 313

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6" Model PGC1 Air-Powered Gate Cutter

Complete with 5 ft. Super-Flexible Air Hose (¼" N.P.T.)

250 lb. Cutting Pressure

Long Life Neoprene O-Ring Springs

Model MSP-1 Power Pack

Note

Special design of the blades on these IMS Air-Powered Gate Cutters limits their use strictly to plastics

Item No. 104016

With 25° Blades

Replacement Parts	
#104098	25° Blades (Per Pair)
	#104098
#104001	10' Replacement Hose

Accessory	
#100764	Air Line Filter, Oiler and Regulator

Foot switch operation available — see page 312

Specifications

Blade Angle: ..... 25°
Blade Length: ..... ½"
Usable Blade Opening at Tip: ..... ¼"
Usable Blade Opening at Base: ..... ⅛"
Cutting Pressure Midway on Blade: ..... 250 lbs
Weight: ..... 10 oz.
Recommended Air Pressure: ..... 60-80 psi

Please Note: An Air Line Filter, Oiler and Regulator must be used to maintain warranty. See Accessories for price.

IMS Company

www.imscompany.com

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fax order toll-free (USA & Canada) 1.888.288.6900 | phone order toll-free (Mexico) 001.888.304.1307 | tech support toll-free (USA & Canada) 1.866.467.9001 | e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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7" Model PGC2 Air-Powered Gate Cutter

Complete with 5 ft. Super-Flexible Air Hose (¼" N.P.T.) and Hanger Clip

780 lb. Max Cutting Pressure

Long Life Neoprene O-Ring Springs
An IMS Exclusive

Lever Latch Assembly helps prevent inadvertent actuation

Note

Special design of the blades on these IMS Air-Powered Gate Cutters limits their use strictly to plastics

Item No. 104088
With 45° Blades

Item No. 125379
90° Blades Only

Replacement Parts	
#104111	Valve Assembly
#104001	10' Replacement Hose
Accessories	
#100764	Air Line Filter, Oiler and Regulator

Foot switch operation available — see page 312

Specifications

Blade Angle: ..... 45°
Blade Length: ..... ⅞"
Usable Blade Opening at Tip: ..... ½"
Usable Blade Opening at Base: ..... ¼"
Cutting Pressure Midway on Blade: 575 lbs
Weight: ..... 16 oz.
Recommended Air Pressure: ..... 60-100 psi

Please Note: An Air Line Filter, Oiler and Regulator must be used to maintain warranty. See Accessories for price.

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7" Model PGC3 Air-Powered Gate Cutter

Complete with 5 ft. Super-Flexible Air Hose (¼" N.P.T.) and Hanger Clip

1100 lb. Max Cutting Pressure

Long Life Neoprene O-Ring Springs
An IMS Exclusive

Note

Special design of the blades on these IMS Air-Powered Gate Cutters limits their use strictly to plastics

Item No. 104061
With 18° Blades

Item No.125379
90° Blades only

Replacement Parts	
#104093	Valve Assembly
#104001	10' Replacement Hose
Accessories	
#100764	Air Line Filter, Oiler and Regulator

Foot switch operation available — see page 312

Specifications

Blade Angle: ..... 18°
Blade Length: ..... ⅞"
Usable Blade Opening at Tip: ..... ½"
Usable Blade Opening at Base: ..... ¼"
Cutting Pressure Midway on Blade: ..... 850 lbs
Weight: ..... 18 oz.
Recommended Air Pressure: ..... 60-100 psi

Please Note: An Air Line Filter, Oiler and Regulator must be used to maintain warranty. See Accessories for price.

IMS Company

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phone order toll-free (Mexico) **001.888.304.1307**
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e-mail **sales@imscompany.com**

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.
-17.8	**0**	32.0
-17.2	**1**	33.8
-16.7	**2**	35.6
-16.1	**3**	37.4
-15.6	**4**	39.2
-15.0	**5**	41.0
-14.4	**6**	42.8
-13.9	**7**	44.6
-13.3	**8**	46.4
-12.8	**9**	48.2
-12.2	**10**	50.0
-11.7	**11**	51.8
-11.1	**12**	53.6
-10.6	**13**	55.4
-10.0	**14**	57.2
- 9.44	**15**	59.0
- 8.89	**16**	60.8
- 8.33	**17**	62.6
- 7.78	**18**	64.4
- 7.22	**19**	66.2
- 6.67	**20**	68.0
- 6.11	**21**	69.8
- 5.56	**22**	71.6
- 5.00	**23**	73.4
- 4.44	**24**	75.2
- 3.89	**25**	77.0
- 3.33	**26**	78.8
- 2.78	**27**	80.6
- 2.22	**28**	82.4
- 1.67	**29**	84.2
- 1.11	**30**	86.0
- 0.56	**31**	87.8
0	**32**	89.6
0.56	**33**	91.4
1.11	**34**	93.2
1.67	**35**	95.0
2.22	**36**	96.8
2.78	**37**	98.6
3.33	**38**	100.4
3.89	**39**	102.2
4.44	**40**	104.0
5.00	**41**	105.8
5.56	**42**	107.6
6.11	**43**	109.4
6.67	**44**	111.2
7.22	**45**	113.0
7.78	**46**	114.8
8.33	**47**	116.6
8.89	**48**	118.4
9.44	**49**	120.2
10.0	**50**	122.0
10.6	**51**	123.8
11.1	**52**	125.6
11.7	**53**	127.4
12.2	**54**	129.2
12.8	**55**	131.0
13.3	**56**	132.8
13.9	**57**	134.6
14.4	**58**	136.4
15.0	**59**	138.2
15.6	**60**	140.0
16.1	**61**	141.8
16.7	**62**	143.6
17.2	**63**	145.4
17.8	**64**	147.2
18.3	**65**	149.0
18.9	**66**	150.8
19.4	**67**	152.6
20.0	**68**	154.4
20.6	**69**	156.2
21.1	**70**	158.0
21.7	**71**	159.8
22.2	**72**	161.6
22.8	**73**	163.4
23.3	**74**	165.2
23.9	**75**	167.0
24.4	**76**	168.8
25.0	**77**	170.6
25.6	**78**	172.4
26.1	**79**	174.2
26.7	**80**	176.0
27.2	**81**	177.8
27.8	**82**	179.6
28.3	**83**	181.4
28.9	**84**	183.2
29.4	**85**	185.0
30.0	**86**	186.8
30.6	**87**	188.6
31.1	**88**	190.4
31.7	**89**	192.2
32.2	**90**	194.0
32.8	**91**	195.8
33.3	**92**	197.6
33.9	**93**	199.4
34.4	**94**	201.2
35.0	**95**	203.0
35.6	**96**	204.8
36.1	**97**	206.6
36.7	**98**	208.4
37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.
38	**100**	212
43	**110**	230
49	**120**	248
54	**130**	266
60	**140**	284
66	**150**	302
71	**160**	320
77	**170**	338
82	**180**	356
88	**190**	374
93	**200**	392
99	**210**	410
100	**212**	413.6
104	**220**	428
110	**230**	446
116	**240**	464
121	**250**	482
127	**260**	500
132	**270**	518
138	**280**	536
143	**290**	554
149	**300**	572
154	**310**	590
160	**320**	608
166	**330**	626
171	**340**	644
177	**350**	662
182	**360**	680
188	**370**	698
193	**380**	716
199	**390**	734
204	**400**	752
210	**410**	770
216	**420**	788
221	**430**	806
227	**440**	824
232	**450**	842
238	**460**	860
243	**470**	878
249	**480**	896
254	**490**	914
260	**500**	932
266	**510**	950
271	**520**	968
277	**530**	986
282	**540**	1004
288	**550**	1022
293	**560**	1040
299	**570**	1058
304	**580**	1076
310	**590**	1094
316	**600**	1112
321	**610**	1130
327	**620**	1148
332	**630**	1166
338	**640**	1184
343	**650**	1202
349	**660**	1220
354	**670**	1238
360	**680**	1256
366	**690**	1274
371	**700**	1292
377	**710**	1310
382	**720**	1328
388	**730**	1346
393	**740**	1364
399	**750**	1382
404	**760**	1400
410	**770**	1418
416	**780**	1436
421	**790**	1454
427	**800**	1472
432	**810**	1490
438	**820**	1508
443	**830**	1526
449	**840**	1544
454	**850**	1562
460	**860**	1580
466	**870**	1598
471	**880**	1616
477	**890**	1634
482	**900**	1652
488	**910**	1670
493	**920**	1688
499	**930**	1706
504	**940**	1724
510	**950**	1742
516	**960**	1760
521	**970**	1778
527	**980**	1796
532	**990**	1814
538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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10⅜" Model PGC5 Air-Powered Gate Cutter

Complete with 5 ft. Super-Flexible Air Hose (¼" N.P.T.) and Hanger Clip

2,400 lb. Max Cutting Pressure

Model SP-04 Power Pack

Note

Special design of the blades on these IMS Air-Powered Gate Cutters limits their use strictly to plastics.

Item No. 103986

With 25° Blades

Replacement Parts	
#110232	Lever latch safety assembly
#104051	Valve Assembly
#104001	10' Replacement Hose
Accessories	
#100764	Air Line Filter, Oiler and Regulator

Foot switch operation available — see page 312

Specifications

Blade Angle:	25°
Blade Length:	⅞"
Usable Blade Opening at Tip:	⅝"
Usable Blade Opening at Base:	⅜"
Cutting Pressure Midway on Blade:	2,400 lbs
Weight:	44 oz.
Recommended Air Pressure:	80-110 psi

Please Note: An Air Line Filter, Oiler and Regulator must be used to maintain warranty. *See Accessories for price.*

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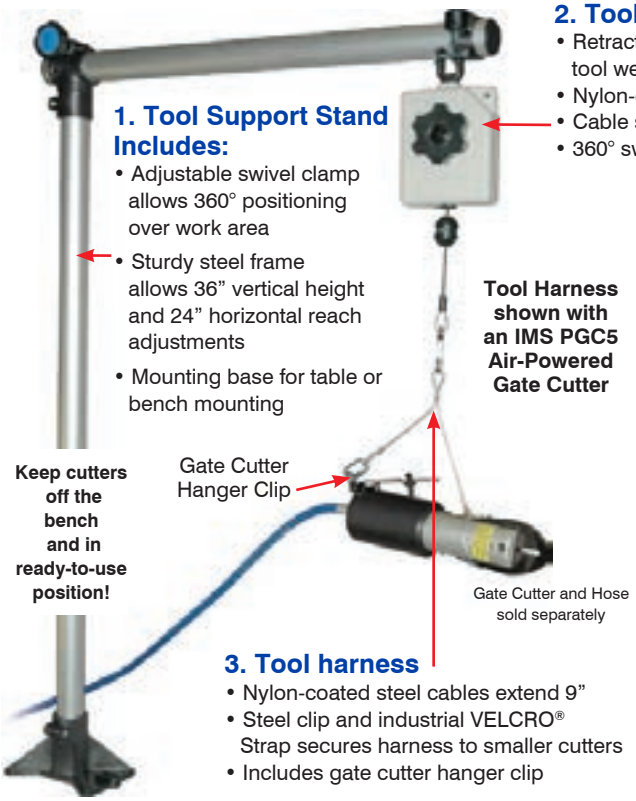
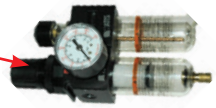
Air-Powered Gate Cutter Tool Suspension Kit

Reduce Repetitive-Motion Strain • Increase Productivity • Eliminate Dropped Tool And Blade Damage



Individual Components	
#127121	**1** Tool Support Stand
#174502	**2** Tool Retractor
#137449	**3** Small Tool Harness
#137448	**3** Large Tool Harness
Accessories	
Air Filter, Regulator and Lubricator 	
#100764	Air Filter, Regulator and Lubricator
#104001	10' Replacement Air Hose for Gate Cutters
Spare Parts	
#104118	Gate Cutter Hanger Clip

VELCRO® is a registered trademark of Velcro Companies

Air-Powered Gate Cutter Foot Switch

Hands free operation

#144840	Works with IMS Models PGC2-PGC5
Accessories	
#104001	10' Replacement Air Hose for Gate Cutters
NOTE: Foot switch requires power pack with two pneumatic lines.	

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Air-Powered Gate Cutters Frequently Asked Questions

Question	Answer
Does my air-powered gate cutter need to be lubricated? What kind of oil should I use?	Use of an air line filter, oiler and regulator is required to prevent O-ring failure and to maintain the cutter's warranty. See the Optional Accessories listed for your model cutter. Any light hydraulic oil or sewing machine oil may be used.
How do I know when the blades need to be resharpened?	When cuts are not as smooth and easy as they should be, your blades can be returned to IMS for resharpening. Turnaround time is within 14 days, and blades can usually be resharpened up to 5 times. It is not recommended that you try to resharpen the blades yourself. Any material removed from the blades needs to be compensated for by using larger rollers on the back of the blades.
Why do I feel air blowing out of the back of the cutter during operation?	This is usually caused by worn or damaged O-rings. Ask us about a replacement O-ring kit for your model cutter. DO NOT increase air pressure above recommended levels.
Standard blades will not quite fit into our application. Do you make any different blades?	Yes, we have engineers to design blades specifically for your application. Ask us about the custom blades that we can make for you.
How do I know what cutter to use for my application?	Send in sample parts and we will recommend a cutter for your job. Please call for a Return Authorization (RA) number before shipping parts.
Will increasing the air pressure increase the cutting power?	Increasing air pressure beyond the recommended level will not increase cutting power and may damage the cutter.

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IMS Air-Powered Gate Cutter Reconditioning Services

Extend Cutter Life - Cut Tool Replacement Cost

Let IMS save you money by repairing and resharpening your worn air-powered gate cutters. Simply contact the IMS Supplies Team at sales@imscompany.com for a return authorization (RA) number and instructions, then ship your worn or damaged cutter to IMS.

If sending blades for resharpening, please include the jaw housing to ensure proper blade alignment. Replacement rollers and pins are included in the price of the Resharpening Service.

If ordering the Reconditioning Service, we will inspect your cutter and issue a quotation before work proceeds.

Note: Gate Cutters considered beyond repair will be returned on request or scrapped

Note: Actuating lever safety latch and foam grip (for PGC2 and PGC3) are available — specify

Note: This service is for Simonds Air Powered Gate Cutters only

Item #	Description	Prices (each)
105745	Air-Powered Gate Cutter Blade Resharpening ONLY	RQF*
105787	Air-Powered Gate Cutter Reconditioning Service (blade sharpening not included)	RQF**

NOTE: There will be a $27 (per item) evaluation fee for customers who decline the resharpening/reconditioning service

* PLUS shipping (Allow 4 weeks for delivery)

** PLUS cost of parts replaced and shipping (Allow 4 weeks for delivery)

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Utility Knives and Deflashing Tools Quick Reference Chart

Description	Item #	Page
Flash Trimmers	multiple	316
High Visibility Retractable Blade	115722	317
Retractable Blade 99™	100835	317
Fixed Blade Utility Knife	100908	317
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5¾" Self-Retracting Utility Knife (10 Pack)	144719	318
6½" Front Loading Retractable Blade Utility Knife	144720	318
Retractable Blade Utility Knife	107826	319
Fixed Utility Knife	107828	319
Utility Knife, Carton Cutter	144715	319
Folding Blade Pocket Knife	129900	320
High Quality Industrial Hand Knife	143668	320
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5½" Mini Pocket-Style Utility Knife	137580	321
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9mm Standard Snap-Off Trimming Knife	107829	322
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9mm Ceramic Heavy Duty Snap-Off Knife	165842	322
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Ceramic Scraper Utility Knife	165846	323
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Plastic Safety Knife	165820	324
ROUT-A-BURR Deflashing Tools	multiple	326-329

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IMS Flash Trimmers

The Original — and Still The Best

Now Take Advantage Of Quantity Breaks To Lower Your Cost!

Safe
No sharp edges like razors and knives

Long Lasting
Easily resharpened on a belt sander

Versatile
Use either end

Made of 1075 Spring Steel Heat Treated to 46 Rockwell

IMS flash trimmers safely and quickly remove parting line flash - reduce risk of damaging your molded parts.

Compact: Overall Length: 5⅞" x Overall Width: ⅞"

Light Weight: Just 2 oz.

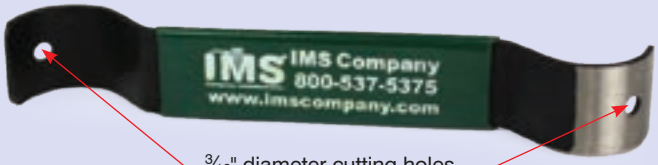
Bonded Plastic Grip: Never comes loose

Item #: 100861 - ½" and 3⁄16" Cutting Holes

½" diameter cutting holes for parting lines on large parts

3⁄16" diameter cutting hole for trimming part edge

Item #: 110853 - 3⁄16" Cutting Hole on Both Ends



3⁄16" diameter cutting holes for trimming part edge

Item #: 165514 - ¼" Cutting Hole on Both Ends

¼" diameter cutting holes for trimming part edge

Item #: 100875 - ½" Cutting Hole on Both Ends

½" diameter cutting holes for parting lines on large parts

Item #
100861
110853
165514
100875

Save 10% when ordering by the dozen (12)

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STANLEY Utility Knives

High Visibility Retractable Blade Utility Knife #10-179

- Easy-to-find, eye-catching colored handles
- Three blade positions
- Push button blade lock
- Flat-sided handle (keeps knife from rolling off surfaces)
- Diagonal non-slip ribs on the handle
- Blade safely secured between the two handle halves
- Comes with two extra blades

Item #115722

Retractable Blade 99™ Utility Knife

- Three blade positions
- Push button blade lock
- Two-piece die cast aluminum handle
- Flat-sided handle (keeps knife from rolling off surfaces)
- Comes with two extra blades

Item #100835

Fixed Blade Utility Knife #10-299

- Sturdy two-piece die cast aluminum handle
- Flat-sided handle (keeps knife from rolling off surfaces)
- Comes with two extra blades

Item #100908

Utility Knife Replacement Blades

- Reversible blades with two cutting edges for double usage
- Straight and rounded-edge (reduced puncture damage) blade styles

Reversible straight blade

Reversible rounded edge blade

Item #	Description
115722	6½" High Visibility Retractable Blade Utility Knife includes 2 extra blades
100835	6" Retractable Blade 99™ Utility Knife includes 2 extra blades
100908	6" Fixed Blade Utility Knife includes 2 extra blades
Spare Parts	
For #115722, #100835 and #100908 Utility Knives	
100859	Reversible straight blades (dispenser of 100)
109243	Reversible rounded edge blades (pack of 5)
109241	Reversible rounded edge blades (dispenser of 100)

Retractable Blade 99™ is a trademark of STANLEY Tools

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Made in the U.S.A

HYDE Retractable Blade Utility Knives

Standard Retractable Blade Utility Knife

- Blade will not retract while cutting
- Lightweight, 2 piece diecast aluminum handle
- Spare blade can be stored in handle

Item #130676

Self-Retracting Utility Knife

- Blade self-retracts upon release of button
- No-tool blade replacement
- Bright orange, ultra-light polypropylene handle

Item #144719

Front Loading Retractable Utility Knife

- Blades installed directly in front — No tools needed
- Blade storage in aluminum die cast handle
- String cutter in handle
- Three blade positions

Item #144720

Reversible straight blade

Reversible hook blade

Item #	Description
130676	6½" HYDE® Standard Retractable Blade Utility Knife
144719	5¾" HYDE® Self-Retracting Utility Knife (10 Pack)
144720	6½" HYDE® Front Loading Retractable Blade Utility Knife (includes 3 blades)
Spare Parts	
102544	Reversible straight blades (pack of 5)
102594	Reversible straight blades (dispenser of 100)

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Allway Utility Knives

Retractable Blade Utility Knife

- Four-position retractable blade
- Contoured to fit comfortably in palm
- Flat-sided handles (keeps knife from rolling off surfaces)
- Convenient blade-storage compartment
- Push button blade lock
- Two-piece, zinc, die cast handle with locking nose design
- Comes with one blade

Item #107826

Reversible straight blade

Reversible hook blade

Fixed Utility Knife

- Two fixed blade positions
- Blade secured safely between handle halves
- Contoured to fit comfortably in palm
- Flat-sided handles (keeps knife from rolling off surfaces)
- Convenient blade-storage compartment
- Two-piece, zinc, die cast handle with locking nose design
- Comes with three blades

Item #107828

Utility Knife, Carton Cutter

- Replaceable metal blade
- Low cost
- No tool blade replacement
- Push-pull action to expose blade

Item #144715

Reversible carton cutter blade

Item #	Description
107826	6⅞" Retractable Blade Utility Knife (includes 1 blade)
107828	6¼" Fixed Blade Utility Knife (includes 3 blades)
107825	Reversible straight blades for #107826 and #107828 (20 packs of 5 blades = 100 blades)
107827	Reversible hook blades for #107826 and #107828 (20 packs of 5 blades = 100 blades)
144715	3¾" Utility Knife, Carton Cutter (includes 1 blade)
144716	Reversible blades for #144715 (100 blades)

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STANLEY Folding Blade Pocket Knife

- Blade rotates into handle for safe storage
- Flat-sided handle (keeps knife from rolling off surfaces)
- Blade lock

Item #129900

Item #	Description
129900	6” Folding Blade Pocket Knife
129901	Replacement blade for #129900

Item #129901

STANLEY Folding Pocket Knife w/ Blade Lock

- Craft Blade for clean accurate cuts
- Blade Can Be Folded Away: Additional safety when not in use
- Metal Body: For additional strength & durability
- 5.65” Overall Length (with blade extended)

Item #	Description
175680	Folding Pocket Knife (includes 2 blades)

HYDE High Quality Industrial Hand Knife

Item #136726

Item #143668

Item #171338

Item #	Description
143668	4 3/8" Long Wood/Aluminum Knife Handle
136726	4 3/4" Long x 3/8" wide Bevel Point Blades (pack of 10)
171338	2 1/4" Long x 3/8" wide Concave Carving Blades (each)

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Flash-Trimming Knives

- Honed, carbon-steel blades hardened for long cutting life
- Multiple blades available for many applications
- 5.5" knife length

Item #137579

Item #171526

15-B 15-D 15-E 15-H

15-C

15-A

Trimmer Quantity Discounts
Order 25-49 **DEDUCT 4%** Order 50 or more **DEDUCT 6%**

Item #	Description
137579	5½" Heavy Duty (Red Handle) Flash-Trimming Knife w/ 15-A 45° angled blade
171526	5½" Medium Duty Knife Handle (Blade Not Included)
137576	15-H large fine-point blades* (pack of 100)

*Blades interchangeable with both #137579 and #171526 handles

Mini Pocket-Style Utility Knife

- Thin yellow handle
- Twist lock screw locks blade
- Thumb indent for better control
- High quality carbon steel
- Fully adjustable and reversible
- Pocket clip and keychain hole

Item #137580

Item #	Description
137580	5½" Mini Pocket-Style Utility Knife with 110B double end blade

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Break-Away/Snap-Off Knives

Superior Quality IMS Trimming Knives with 2X Life Blades or Ceramic Blades

- Blades are scored allowing tips to be snapped off to reveal fresh tip when blade becomes dull
- Blades are fully retractable
- Push button with blade lock
- Knives available in standard and heavy duty
- Bright colors for safety
- 9mm and 18mm sizes to fit a variety of trimming and cutting applications

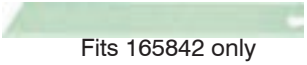
18mm Knives and Blades

Snap-Off Style Trimming Knives	Item #
18mm Width Standard Duty w/Std Blade	108651
18mm Width Heavy Duty w/2X† Blade and Stainless Steel Blade Track	166178
Ceramic Style* **18mm Heavy Duty w/Ceramic Blade and Stainless Steel Blade Track**	165844

Replacement Blades
18mm 2X† Life Blade (50 Pack) **Item # 166176** Fits both 108651 & 166178
18mm Ceramic Blade (each) **Item # 165845** Fits 165844 only

9mm Knives and Blades

9mm Width Standard Duty w/Std Blade	107829
9mm Width Heavy Duty w/2X† Blade and Stainless Steel Blade Track	166177
Ceramic Style* **9mm Heavy Duty w/Ceramic Blade and Stainless Steel Blade Track**	165842

Replacement Blades
9mm 2X† Life Blade (50 Pack) **Item # 166175** Fits both 107829 & 166177
9mm Ceramic Blade (6 Pack) **Item # 165843**  Fits 165842 only

***Ceramic Knives/Blades** are much safer than conventional steel blades, however much like paper, they can still cut you if drawn across the skin at a rapid pace. Due to the nature of ceramic blades and widths they are not compatible with knives other than the Ceramic Style Snap-Off Knives. The also have a tendancy to be brittle if not treated with care.

†**2X Blades** are Extra Sharp and Longer Life than Conventional Blades

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Ceramic Trimming Knives

Deflashing With No Sharp Edges — Boost Worker Safety

Noga CR2000 Ceramic Trim Knife

- "No edge" blade avoids accidents
- Low profile handle fits nicely in hand
- Grey easy grip design
- Easy view blade storage
- Easy swap
- Easily check extra blade stock

Item #137112

Item #137113

Ceramix Utility Knife Style Flash Trimming Set

- Two sided blade for surface or sheet edge cleaning
- Retractable, light weight red handle
- Quick release access to spare blades
- Metal utility blade included with set

Item #136867

Item #136868

Ceramic Scraper Utility Knife

- One-touch safety lever design
- Clear Light Weight Handle
- Long Lasting Ceramic Blade for Safety in Multiple Applications

Item #165846

Item #165847

SafeCut Flash Trimming and Deburring Knives

- Deburrs plastic safely and efficiently
- SafeCut Mini ideal for smaller hands
- Never needs resharpened

Item #136862

Item #136863

Item #	Description
137112	Ceramic Trim Knife CR2000
137113	Replacement blade for #137112
136867	Ceramix Utility Knife Style Flash Trimming Set with metal utility blade
136868	Replacement blade for #136867
165846	5" Ceramic Scraper Utility Knife with Ceramic Blade
165847	Replacement blade for #165846
136862	7" SafeCut Flash Trimming and Deburring Knife
136863	5⅜" SafeCut Mini Flash Trimming and Deburring Knife

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Square-Point Trim Knives

- Blade guard helps avoid worker injury
- Blunt, square tip for safety

Item #135799

Item #135801

Item #135800

Item #136590

Item #	Description
135799	6" Square-Point Trim Knife
135801	Sheath for 6” Knife
135800	4" Square-Point Trim Knife
136590	Sheath for 4” Knife

Safety-Style Trim Knife

- Avoid accidental operator cuts — Blade only access through notches
- Quick blade release
- Covered tip
- Blue, light weight handle

Item #131839

Item #	Description
131839	Safety-Style Trim Knife, T-500 Series (Includes knife and 1 blade)
131840	Replacement blade for #131839

Plastic Safety Knife

- Spring-loaded blade retracts automatically when handle is released
- Metal protection on edge of knife
- Squeeze handle prevents hand fatigue

Item #165820

— Quantity Discounts —

Item #	Description
165820	Plastic Safety Knife (Includes knife and 1 blade)
107825	Replacement blades for #165820 (pack of 100)

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Tool Holsters

Keep Your Most Frequently Used Tools Always Within Reach!

2 Styles in 2 Sizes!

- Hold Flash Trimmers, Gate Cutters, Utility Knives, Pliers, Sprue Pullers etc.
- Keep tools from damaging clothes or equipment
- Protect tools
- Made of Durable, Lightweight Black Nylon

Both sizes are 3" wide

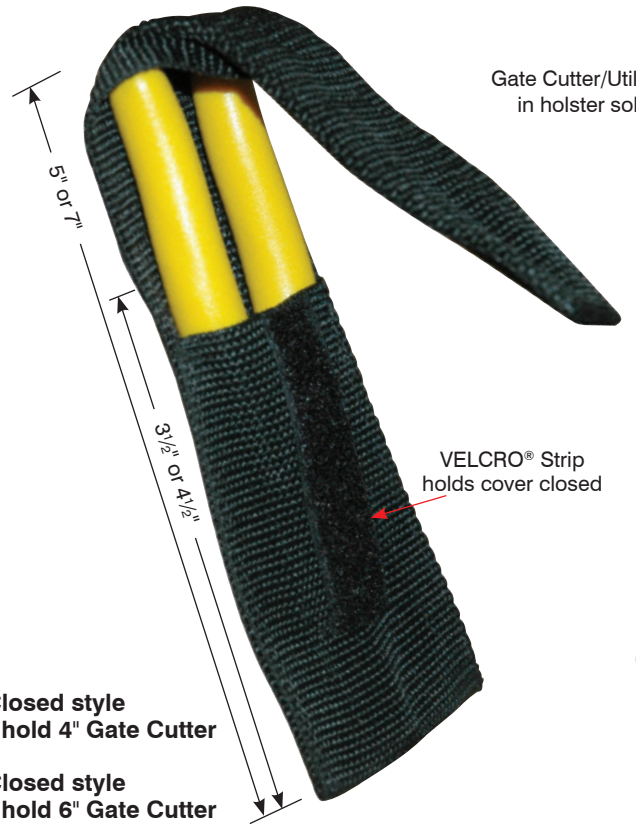
Metal clip on back of Tool Holster attaches easily and comfortably to your belt or pocket.

#110606	5” long	Open Style
#110611		Closed Style
#110604	7” long	Open Style
#110609		Closed Style

VELCRO® is a registered trademark of VELCRO Industries

Closed Style

Holds tools securely in place

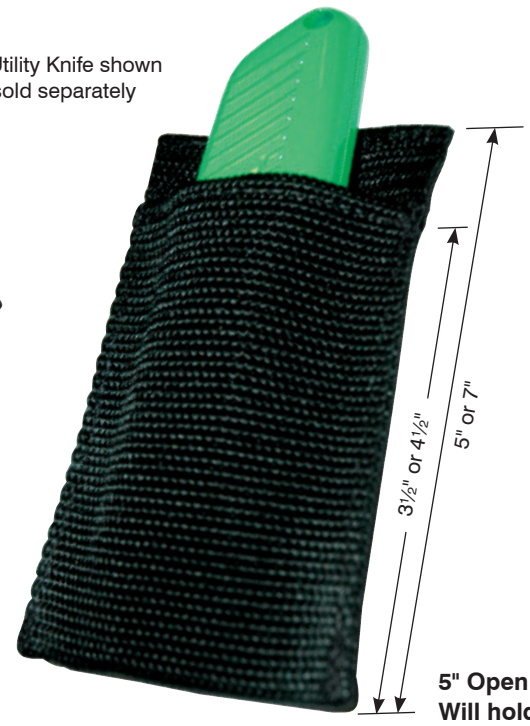


5" Closed style will hold 4" Gate Cutter

7" Closed style will hold 6" Gate Cutter

Open Style

Allows quick and easy access



5" Open style Will hold 6" Gate Cutter

7" Open style Will hold 7" Gate Cutter

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ROUT-A-BURR Deflashing Tools

Speed part deflashing with ROUT-A-BURR Deflashing Tools. These tools come in a wide selection of handles, blade holders and blades to provide flexibility for all applications. The blades are good for plastic, steel, aluminum, brass and cast iron.

Handles and Holders

- Adjustable blades can swivel a full 360°
- Excellent for both internal and external part deflashing
- Heavy duty styles for tough applications
- Easy and comfortable to use
- ARB-1 and PRB-2 blade holder accepts all B series blades
- PRB-3 and GB-E accept all E series blades directly into the handle

Standard B Blades

- Come on ROUT-A-BURRS with anodized aluminum holders and plastic handles
- Vertical or horizontal insertion
- Curved to automatically follow contours and edges of work pieces
- High grade steel
- B10 — for small holes
- B20 — can rotate clockwise and counter clockwise

Standard E Blades

- Come on ROUT-A-BURRS with transparent plastic container handles and aluminum swivel blade holders
- Larger blade diameters
- Meant for heavy duty jobs where subjected to extra pressure
- High grade steel
- E100: Basic blade (right-handed)
- E200: Can rotate clockwise and counter clockwise
- E300: Removes external and internal burrs simultaneously from holes drilled into tubing and sheet metal. Follows inside walls for burrs deeper than E100 or 200
- E350: Used for straight edges, key ways, etc.
- E600: Used for deburring in the most inaccessible locations. Ideal for deep cross drilled holes

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Specifications and Prices

- Smooth 360° swivel action
- ARB-1 and PRB-2 blade holder accepts all B series blades and allows blades to be used in a vertical or horizontal position
- PRB-3 and GB-E accept all E series blades directly into the handle
- All blades are made of high speed steel

ARB-1

Size (without blade): 4.2" l x .975" dia.
Weight: 9 oz.

PRB-2

Size (without blade): 4.002" l x .975" dia.
Weight: 3 oz.

PRB-3

Size (without blade): 4.2" l x .975" dia.
Weight: 6 oz.

GB-E

Size (without blade): 5.125" l x .625" dia.
Weight: .7 oz.

UB1

Size (without blade): 4.75" l x .354" dia.
Weight: .7 oz.

Item #	Description
122706	ARB-1 Rout-A-Burr with Anodized Aluminum Holder complete with blade holder and B10 and B20 blades
122707	PRB-2 Rout-A-Burr with Plastic Handle complete with blade holder and B10 and B20 blades
138142	Blade Holder B - Holds all B Blades, for use with 122706 & 122707
122708	PRB-3 Rout-A-Burr with Transparent Plastic Container Handle complete with E100, E200 and E300 blades
127808	GB-E Red Multi-Burr ABS Plastic Swivel Blade Holder complete with E100 blade
144567	GB-E Green Multi-Burr ABS Plastic Swivel Blade Holder complete with E100 blade
144568	GB-E Blue Multi-Burr ABS Plastic Swivel Blade Holder complete with E100 blade
144569	GB-E Yellow Multi-Burr ABS Plastic Swivel Blade Holder complete with E100 blade
140609	UB1 Red DisposaBurr complete with non-replaceable E100 blade

See Next Page for Rout-A-Burr Blades

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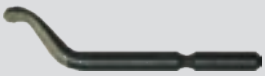
ROUT-A-BURR Blades

Item #	Description
122715	B10 blade (for small holes, right-handed)
144570	B10L blade (for small holes, left-handed)
122716	B20 blade (can rotate clockwise and counter clockwise)
144571	B25 blade (thin-nosed for standard plastics)
144579	B25C blade (solid carbide thin-nosed for abrasive plastics)
144572	B30 blade (simultaneously deburrs the inside and outside of holes up to 0.16" thick)
122710	E100 blade (basic blade, right-handed)
144573	E100L blade (basic blade, left-handed)
144574	E110 blade (B10 blade with E shaft)
144575	E111 blade (thin-nosed for holes with min. dia. 0.06")
122711	E200 blade (can rotate clockwise and counter clockwise)
144580	E250 blade (very thin, heavy duty) 
122712	E300 blade (removes external and internal burrs simultaneously from holes drilled into tubing and sheet metal)
122713	E350 blade (for straight edges, key ways, etc.)
122714	E600 blade (for deburring in the most inaccessible locations) Ideal for deep cross drilled holes
144581	E750 blade (for deburring for rubber and soft plastics without poking or sticking into product)

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Mango II Deburring Tool Sets

Comfort and Control

Mango II Handle

- Comfortable, ergonomic handle
- Holds B- and E-type blades
- Easy to load
- Telescopic blade holder

148975	Mango II Handle ONLY (shown)
144752	Blade Holder (not shown)

The Sheet Cleaner

Ideal for flat surface sheets

- Deburrs in one pass
- Telescopic blade holder

144750	Sheet Cleaner Set
144751	Replacement Blade

The Scraper

Ideal for straight edge, hole edge, hole back edge, flat surface and hole inner surface

- Triangular blade with 3 cutting edges for high quality
- Telescopic blade holder to reach difficult to reach areas
- Key for safely removing blades

144732	Scraper Set
144733	Replacement Blade Holder
144734	Replacement Blade

Slot Edge Cleaner

Ideal for edges, external keyways and slots up to .6” (14mm)

- Blade with 8 cutting edges for deburring and cleaning
- Telescopic blade holder to reach difficult to reach areas

144742	Slot Edge Cleaner Set
144743	Replacement Blade

The Countersink

Ideal for chamfering countersinks

- Use for hole edge applications up to .79” (20mm) dia.
- Telescopic blade holder to reach difficult to reach areas

144735	Countersink Set
144736	Replacement Blade Holder
144738	Replacement ¾" Blade
144737	Optional ½" Blade
144739	Optional 1¼" Blade

Heavy Duty Sheet Cleaner

Ideal for straight edge sheets

- For difficult materials with single or double edges
- Uses two blades to create an arc finish
- Hand guard included for worker safety

144741	Replacement Blade (requires 2)

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Converting Fractional Inches To Decimals And Millimeters

Fraction	Decimal	MM
1/64"	.015625”	0.3969
1/32"	.03125”	0.7938
3/64"	.046875”	1.1906
1/16"	.0625”	1.5875
5/64"	.078125”	2.3812
3/32"	.09375”	2.3812
7/64"	.109375”	2.7781
1/8"	125”	3.175
9/64"	.140625”	3.5719
5/32"	.15625”	3.9688
11/64"	.171875”	4.3656
3/16"	.1875”	4.7625
13/64"	.203125”	5.1594
7/32"	.21875”	5.5562
15/64"	.234375”	5.9531
1/4"	.25”	6.35
17/64"	.265625”	6.7469
9/32"	.28125”	7.1438
19/64"	.296875”	7.5401
5/16"	.3125”	7.9375
21/64"	.328125”	8.3344
11/32"	.34375”	8.7312
23/64"	.359375”	9.1281
3/8"	.375”	9.525
25/64"	.390625”	9.9219
13/32"	.40625”	10.3188
27/64"	.421875”	10.7156
7/16"	.4375”	11.1125
29/64"	.453125”	11.5094
15/32"	.46875”	11.9063
31/64"	.484375”	12.3031
1/2"	.5”	12.7

Fraction	Decimal	MM
33/64"	.515625”	13.0969
17/32"	.53125”	13.4938
35/64"	.546875”	13.8906
9/16"	.5625”	14.2875
37/64"	.578125”	14.6844
19/32"	.59375”	15.0812
39/64"	.609375”	15.4781
5/8"	.625”	15.875
41/64"	.640625”	16.2719
21/32"	.65625”	16.6688
43/64"	.671875”	17.0656
11/16"	.6875”	17.4625
45/64"	.703125”	17.8594
23/32"	.71875”	18.2563
47/64"	.734375”	18.6531
3/4"	.75”	19.05
49/64"	.765625”	19.4469
25/32"	.78125”	19.8438
51/64"	.796875”	20.2406
13/16"	.8125”	20.6375
53/64"	.828125”	21.0344
27/32"	.84375”	21.4312
55/64"	.859375”	21.8281
7/8"	.875”	22.225
57/64"	.890625”	22.6219
29/32"	.90625”	23.0188
59/64"	.921875”	23.4156
15/16"	.9375”	23.8125
61/64"	.953125”	24.2094
31/32"	.96875”	24.6062
63/64"	.984375”	25.0031
1"	1.0”	25.4

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Made in the U.S.A

SMARTFLOW

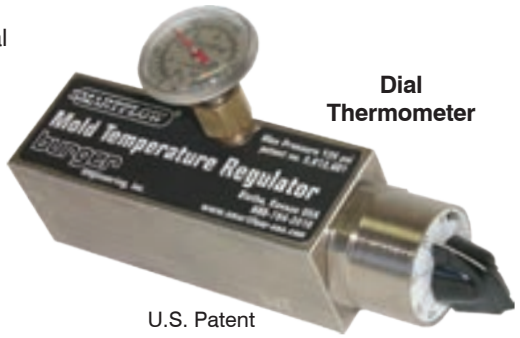
Mold Temperature Regulators

GREEN Products

Recovers Waste Heat From Resin Shot To Stabilize Mold Temperature
Compact / Easy to Install / Needs No Electricity!

Smartflow Mold Temperature Regulators

- **Multiple zone control** - using several regulators or an optional inlet manifold facilitates effective zone control
- **Unaffected by pressure changes** - the Mold Temperature Regulator uses the thermal expansion principle for operation
- **Handles tower water temperature changes** - modulates flow to control cooling water temperature
- **In-Line mounting** - installs easily without additional hardware
- **Cost of ownership** - typically 1/6 the cost of a conventional electric mold heater
- **Maintenance free** - few internal parts for trouble-free operation
- **Energy saving** - it uses no electricity, conserving precious energy dollars
- **Small size** - cleans up shop floor clutter: no hoses or power cords to trip over
- **Integral dial thermometer** - verifies Set Point temperature
- **Optional inlet manifold** - provides temperature control for multiple zones with one regulator



Dial Thermometer

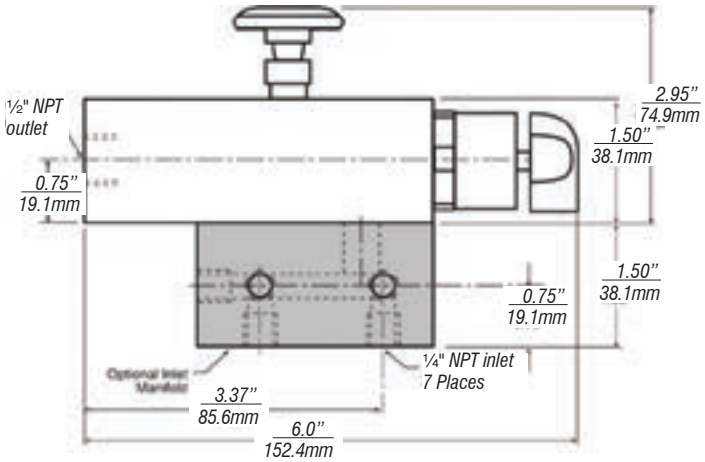
U.S. Patent No. 5,813,601

Set Point Knob

Hold Constant Temperatures to Mold Better Parts

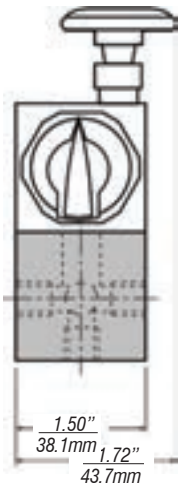
The Smartflow Mold Temperature Regulator effectively controls mold cooling water temperature between 80°F and 120°F (27° and 49°C) to maintain a steady mold temperature. Installed to control water flow exiting an injection mold, the Mold Temperature Regulator quietly recovers waste heat from the resin shot, working without electricity to reduce shop floor clutter, and cut production costs. In many cases, it is a simple, inexpensive substitute for a conventional electric mold heater.

Cooling water temperature always corresponds to higher mold (steel) temperatures (for example: 120°F water temperature may result in 180°F mold temperature).



Specifications

Physical	
Material (wetted parts)	Electroless Nickel-Plated Brass & 303 Stainless Steel
O-Rings	Buna-N
Inlet Size	¼" NPT(F)
Outlet Size	½" NPT(F)
Maximum Pressure	125 psi (8.6 bar)
Weight	3 lbs (1.5 kg
Operating: Regulator	
Cooling water set point range	80° to 120°F (27° to 49°C)
Accuracy	±1°F
Regulator operation is more accurate than dial thermometer.	
Dial Thermometer	
Range	0 to 250°F (-18 to 121°C)
Accuracy	±1°F Mid Scale ±2°F Full Scale



Turbulent Flow, Supply Cooling Water Pressure & Temperature

Traditionally, high turbulent flow rates are used in cooling water loops to achieve acceptable heat transfer rates from the mold. High turbulent flow rates are irrelevant when using the Smartflow Mold Temperature Regulator. It regulates cooling water flow leaving the mold to achieve Set Point temperature. The unit is also unaffected by supply cooling water pressure and temperature. For example, it automatically compensates for temperature changes of cooling tower water between night and day.

continued on next page

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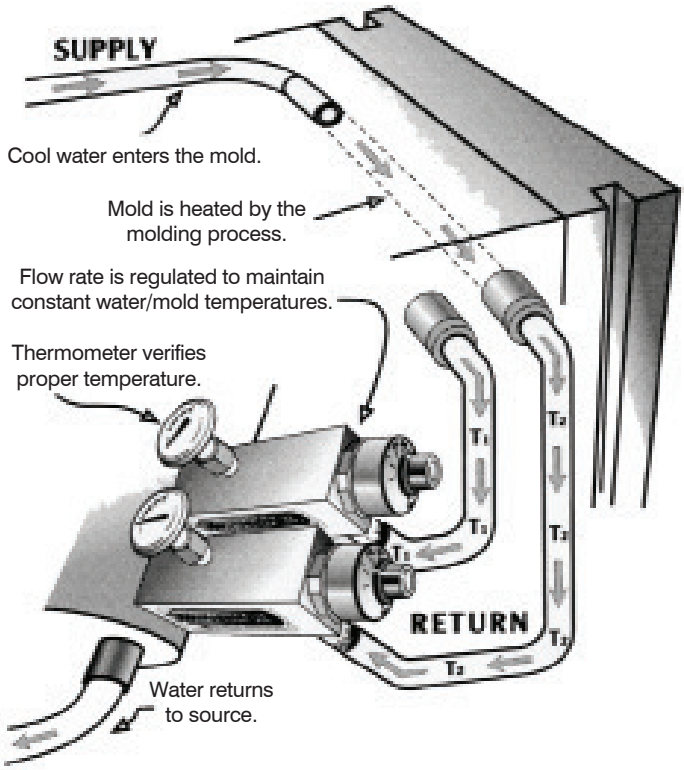
Principle of Operation

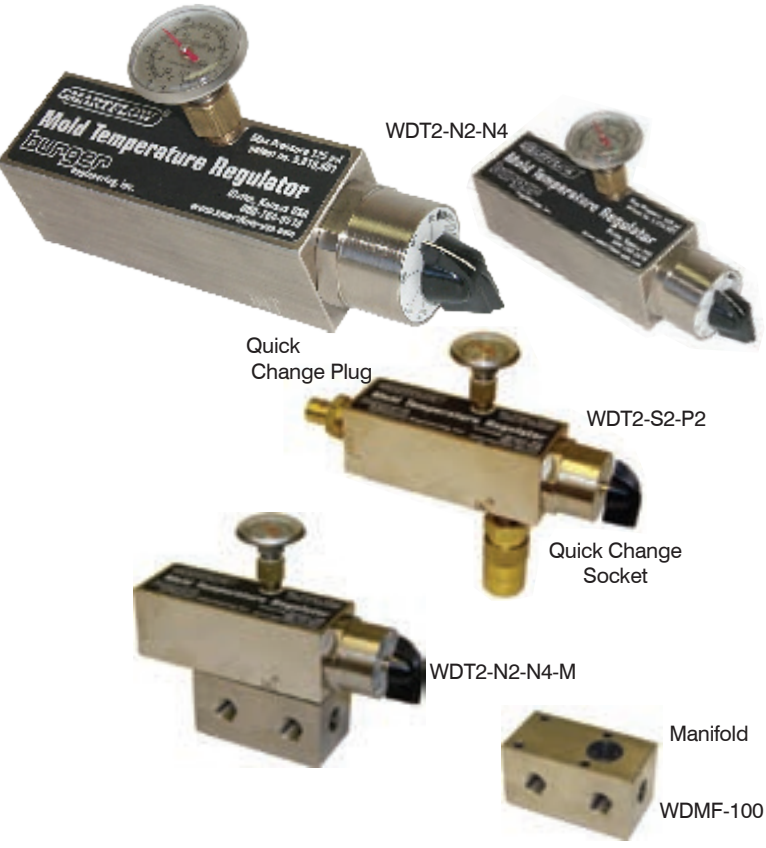
The Smartflow Mold Temperature Regulator works on the principle of thermal expansion. It is connected to the return lines of the mold cooling water loop. A simple bellows and range spring capsule senses the temperature of the water leaving the mold and compares it to the Set Point temperature. The Set Point is easily adjusted by rotating the pointer knob to the desired water temperature value on the calibration scale. The dial thermometer provides visual verification of the setting. Note: A discrete cooling water temperature always corresponds to a hotter mold (steel) temperature.

When the water temperature leaving the mold is hotter than the Set Point, the internal valve modulates toward open, cooling water flow rate increases, and cooling water temperature decreases to stabilize at the Set Point. When the water temperature leaving the mold is cooler than the Set point, the internal valve modulates toward close, cooling water flow rate decreases, residency time in the mold increases and cooling water temperature rises until stabilizing at the Set Point. The valve never completely closes.

Note: The Mold Temperature Regulator recovers waste heat energy from the resin shot and transfers it to heat the cooling water and the mold. The Mold Temperature Regulator does not generate heat, and it does not function as a chiller.



No Electricity Required • No Floor Space Required • No Noise



Smartflow Mold Temperature Regulators

Item #	Model #
142850	¼" NPT Inlet, ½" NPT Outlet WDT2-N2-N4
143573	¼" NPT Inlet/Outlet with Quick Connect Socket and Plug - WDT2-S2-P2
143574	⅜" NPT Inlet/Outlet with Quick Connect Socket and Plug - WDT2-S3-P3
143575	¼" NPT Inlet, ½" NPT Outlet with 7 Port Manifold - WDT2-N2-N4-M
143576	7 Port Manifold (¼" NPT) Only WDMF-100

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SMARTFLOW®

Flow Regulators

GREEN Products

Allow Manual Control of Individual Cooling Water Lines

Smartflow Flow Regulators

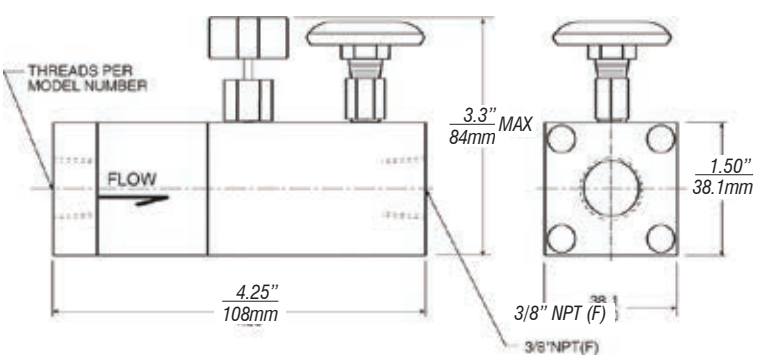
- Compact size works well in restricted-space locations.
- Rugged construction provides years of dependable service.
- 210°F (99°C) Temperature Rating allows installation into a wide range of applications.
- Optional Temperature Gauge displays additional process information.
- No Mounting Restrictions ease installation in any position without extra brackets or hardware.

Smartflow® flow regulators provide a unique, leak-free, single-point manual flow control. This regulator incorporates the proven mechanical flowmeter and integral needle valve in a compact design. Very few moving parts improve reliability and leak-free operation.

Used singly or in combination with a water manifold, the flow regulator allows manual control of individual cooling water lines.

Inlet Sizes - ¼", ⅜" & ½" NPT Outlet Sizes - ⅜" NPT Flow Rates - 1.5 to 8 GPM (Most ranges also available in liters per minute) **Rugged, wetted parts are compatible with many process liquids**	
End Cap and Regulator Body	Brass
Flow Body	Polysulfone
Vane	Glass-Filled Nylon
Viewing Window	Polysulfone
Spring	Stainless Steel
O-Rings	EPDM
Cap Screws	Stainless Steel
Opt. Quick-Connect Fittings	Brass
Specifications	
Flow Accuracy	±10% full scale
Operating Temperature	210°F (99°C) max.
Operating Pressure	100 psi (6.9 bar) max.
Dial Thermometer	0° to 250°F (-20° to 120°C) ±2% accuracy (full scale)

Precise Control of Water Flow



Manually control multiple cooling zones on a single tool with ganged installation on a return manifold. (Factory installation required.)

continued on next page

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Flow Regulators (continued)

¼", ⅜" & ½" NPT

Item #	Model #	NPT	Flow Range
143938	FR2-A-15	¼"	0.2 - 1.5 gpm
143939	FR3-A-15	⅜"	0.2 - 1.5 gpm
143940	FR4-A-15	½"	0.2 - 1.5 gpm
143941	FR2-A-25	¼"	0.5 - 2.5 gpm
143942	FR3-A-25	⅜"	0.5 - 2.5 gpm
143943	FR4-A-25	½"	0.5 - 2.5 gpm
143944	FR2-A-80	¼"	1- 8.0 gpm
143945	FR3-A-80	⅜"	1- 8.0 gpm
143946	FR4-A-80	½"	1- 8.0 gpm
143947	FR2-A-100	¼"	2 -10 lpm
143948	FR3-A-100	⅜"	2 -10 lpm
143949	FR4-A-100	½"	2 -10 lpm
143950	FR2-A-300	¼"	4 -30 lpm
143951	FR3-A-300	⅜"	4 -30 lpm
143952	FR4-A-300	½"	4 -30 lpm

Item #	Model #	NPT	Flow Range
143961	FR2-B-15	¼"	0.2 - 1.5 gpm
143962	FR3-B-15	⅜"	0.2 - 1.5 gpm
143963	FR4-B-15	½"	0.2 - 1.5 gpm
143964	FR2-B-25	¼"	0.5 - 2.5 gpm
143965	FR3-B-25	⅜"	0.5 - 2.5 gpm
143966	FR4-B-25	½"	0.5 - 2.5 gpm
143967	FR2-B-80	¼"	1- 8.0 gpm
143968	FR3-B-80	⅜"	1- 8.0 gpm
143969	FR4-B-80	½"	1- 8.0 gpm
143970	FR2-B-100	¼"	2 -10 lpm
143971	FR3-B-100	⅜"	2 -10 lpm
143972	FR4-B-100	½"	2 -10 lpm
143973	FR2-B-300	¼"	4 -30 lpm
143974	FR3-B-300	⅜"	4 -30 lpm
143975	FR4-B-300	½"	4 -30 lpm

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Model Number Explanation

Example: FR3-B-25

Would signify the Flow Regulator has ⅜" NPT female threads, includes a Temperature Gauge and has a maximum Flow Rate of 2.5 gallons per minute

Inlet Size		Flow Regulator Accessories		Flow Rate	
FR2	¼" NPT (F)	**A**	Flow Regulator ONLY	**15**	0.2 - 1.5 gpm (gal per minute)
FR2B	¼" BSPP (F)	**B**	with Thermometer	**25**	0.5 - 2.5 gpm
FR3	⅜" NPT (F)	**E**	with Thermometer and Quick Change Socket and Plug (NPT only)	**80**	1 - 8.0 gpm
FR3B	⅜" BSPP (F)			**100**	2 - 10 lpm (liters per minute)
FR4	½" NPT (F)			**200**	5 - 20 lpm
FR4B	½" BSPP (F)			**300**	4 - 30 lpm

Other Thread Styles and Sizes Available on Request - Inquire

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Calculating Heat Load for a Circuit

Application Procedure

Use the following formula and method to calculate heat load for one cooling circuit. This will help determine suitability of the Smartflow Mold Temperature Regulator to your process.

1. Select material from the table at right and calculate BTU/hr using the formula below. Shot weight is the total drop including cold runner (if any).

$$\frac{\text{BTU/lb} \times \text{Shot Weight (oz.)} \times 225}{\text{Cycle Time (sec)}} = \text{BTU/hr}$$

2. Find BTU/hr along the X axis of the graph below. Locate the desired steel temperature along the Y axis of the graph. Find the spot where the X and Y values intersect.
3. The graphed line nearest this intersection point represents the difference in temperature between the incoming water and the Mold Temperature Regulator set point (ΔT).
4. The Smartflow Mold Temperature Regulator should work in your application if the sum of the incoming water temperature and the ΔT value is between 80° and 120°F.

Every mold is different! The effectiveness of the Mold Temperature Regulator relies on the ability of the resin shot to heat the mold, and the efficiency of the cooling lines inside the mold.

NOTE: These graphs and information are intended as a general guide for sizing and initial setup of the mold temperature regulator. Due to the different mold designs, results may vary from the graphs.

Typical Heat Values of Plasticized Resin*

Material	BTU/lb
ABS	81
Acrylic	109
Nylon	183
Polycarbonate	112
Polyethylene - High Density	276
Polyethylene - Low Density	202
Polypropylene	291
Polystyrene	88
SAN	88

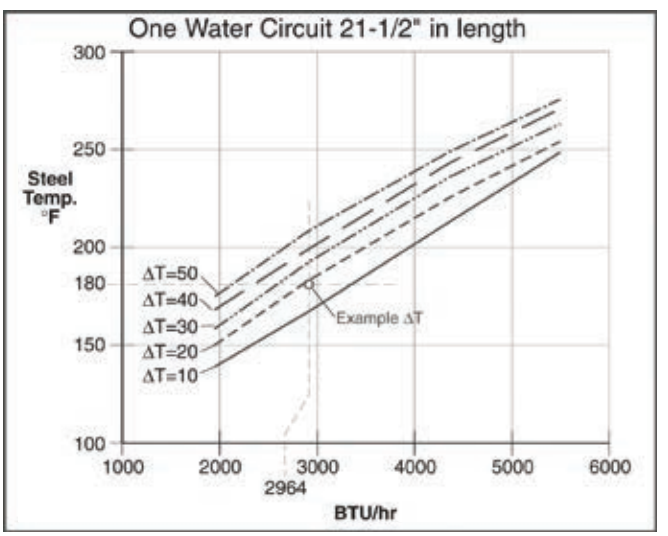
*Total Heat Content + Latent Heat of Fusion

Example:

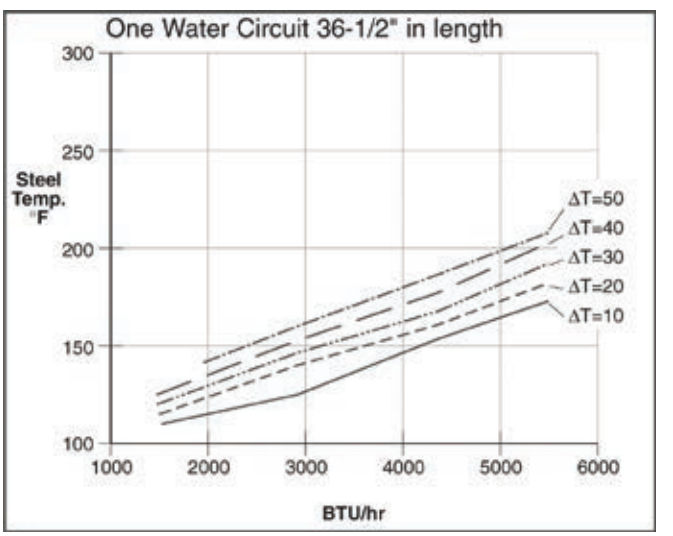
A molder is using nylon material in a four-cavity mold with a shot weight of .90 ounces (including the runner). The cycle time is 12.5 seconds with a mold steel temperature of 180°F. BTU/hr formula is as follows:

$$\frac{183 \text{ BTU/lb} \times .90 \text{ oz.} \times 225}{12.5 \text{ sec}} = 2964.6 \text{ BTU/hr}$$

See the One Water Circuit Graph below left for the differential temperature (ΔT) value. Add 70°F incoming water temp. to the ΔT value (20°F). This is the beginning set point for the mold temperature regulator, and may be adjusted as needed.



Mold Temperature vs. Heat Input for 36-1/2" Water Circuit and Five Different Values of ΔT



Mold Temperature vs. Heat Input for 21-1/2" Water Circuit and Five Different Values of ΔT

These graphs were generated by simulated molds, with BTU input varied by electric heaters. The water line path through each mold was 7/16" dia.

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Injection Mold Water Flow Regulators

Flow Regulators indicate the exact flow rate and temperature of the fluid in your mold circuits, eliminating trial and error experimentation, calculations and pyrometer readings. Use them to establish a consistent heating or cooling process in your molding system and improve your part quality.

Standard IMS Flow Regulators feature:

- Highly visible calibrated nylon sight tube
- Adjustable setpoint marker
- Solid brass float
- Brass needle valve for flow control
- Shut-off valve
- Removable dial thermometer
- No-rust design

Special O-ring seals enhance the no rust design and protect the brass threads of the needle valve spindle to provide long life and trouble-free operation.

These flow regulators come stocked with calibrated Style A sight tubes. Style A tubes, made of nylon, are highly resistant to most chemicals.

Flow-Rate Table

Shaded flow range is for standard sight tube (A) and float (No. 1)

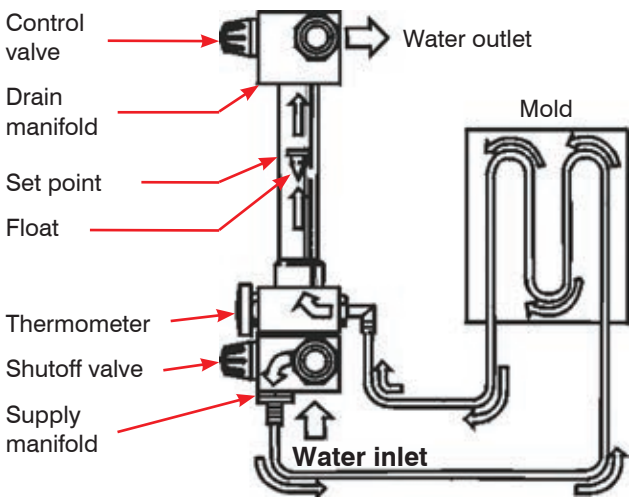
Level on Sight Glass	A			
	(1) Solid Brass	(2) Plastic	(3) Hollow Brass	(4) PVC
200				1.20
180	8.7	4.2	12.1	1.05
150	6.8	3.5	10.8	0.80
125	6.0	2.85	9.6	0.65
100	4.5	2.3	8.3	0.48
75	3.5	1.75	7.0	0.32
50	2.55	1.3	5.5	0.18
25	1.6	0.8	4.0	0.0
10	1.0	0.5	3.2	0.0
	GPM			

To help in selection of flow regulators, the flow rate table below shows the flow rates for different float positions, using Style A sight tube and Float Numbers 1, 2, and 3. The standard sight tube and float are Style A and Float 1, represented by the shaded area.

You can easily remove the sight tubes for cleaning without special tools. We recommend that you clean sight tubes regularly.

Flow Regulators can be made with sight tubes numbering from 1 to 12. So you can monitor up to 12 different zones in one mold or monitor as many as 12 different molds.

How It Works



Fluid from the mold flows to the regulator via a fitting that directs it up the sight tube. The float in the sight tube sits at a position that depends on the flow rate. (Once you have determined the best flow rate for your parts, adjust the set point marker on the sight tube to compare and match fluid rates every time.) Then the fluid exits the regulator by way of the fluid outlet, flows back to the manifold, and on to a mold passage.

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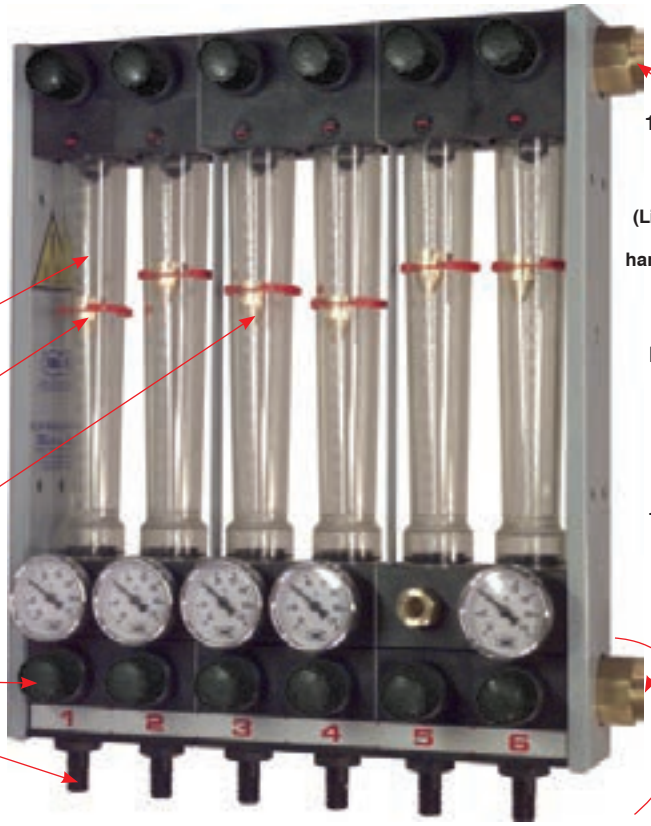
GREEN Products

Injection Mold Water Flow Regulators

Indicate Flow Rate And Temperature Of Each Mold Circuit

- Maintain different temperatures uniformly in each circuit of multi-channel molds
- Eliminate trial and error, calculations and need for pyrometer readings
- High visibility
- Help prevent wasting costly coolant fluids
- Accurate, repeatable, precision adjustment
- No rust design



1" N.P.T. Brass Water Outlet (Lightweight units hang on pipe)

Item No. 105477 6 lines *(shown)*

Calibrated sight tube
With quick release feature

Set point marker

Solid brass float
(1.0 To 8.7 gpm range-standard)

1" N.P.T. Brass Water Inlet

Shut-off valve

Straight Barb-Type fittings
(For ½" I.D. Hose std. Supply to mold)

Removable non-contact Indicating thermometer
(30° - 170° F)

90° Barb-Type Fittings On Back — Return From Mold
(for ½" I.D. Hose Std. Return from mold)

Specifications

Maximum Working Pressure: 100 psi
Maximum Working Temperature: 170°F

Item #	Zones	Height	Width	Depth	Boxed Weight	Unit Price
105430	1	18¼"	4"	5¼"	9 lbs.	**$225.00**
105398	2		6¼"		11 lbs.	**300.00**
105369	3		8⅜"		14 lbs.	**425.00**
105532	4		10⅝"		16 lbs.	**550.00**
105506	5		12¾"		18 lbs.	**690.00**
105477	6		15"		20 lbs.	**825.00**
105452	7		17¼"		21 lbs.	**963.00**
105420	8		19⅝"		25 lbs.	**1,100.00**
105390	9		21¾"		27 lbs.	**1,230.00**
105514	10		24"		29 lbs.	**1,390.00**
105460	12		28⅝"		33 lbs.	**1,650.00**

Optional Accessories

	#117360	Cleaning brush for Style A sight tube	**$1.58**

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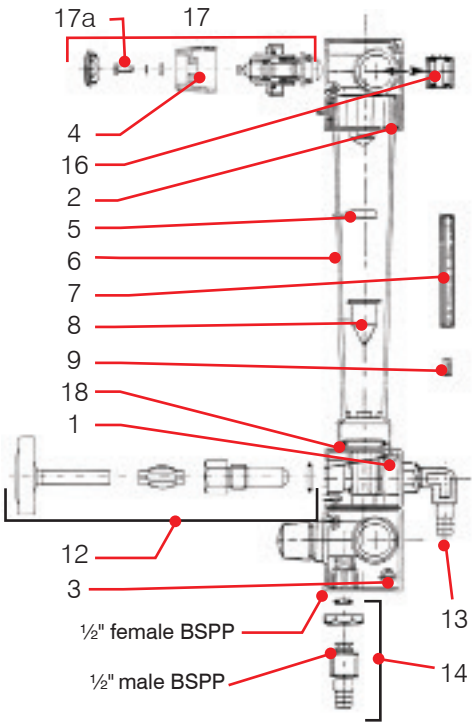
Injection Mold Water Flow Regulator

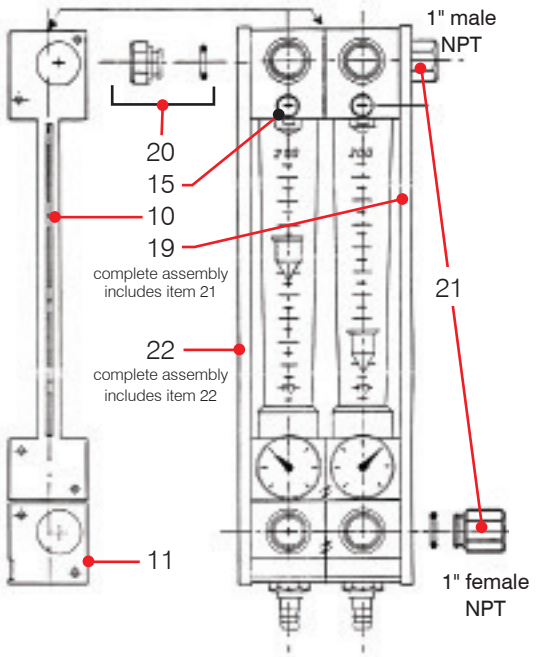
Spare Parts

Part List

Illus #	Item #	Description
1	132732	Injection manifold
2	105459	Return manifold
3	105429	Supply manifold
4	105397	Knob
	138516	Black cap for knob
5	105368	Set point indicator
6	105375†	Nylon sight tube A
7	105451‡	Tie rod 1 zone
	105419‡	Tie rod 2 zone
	113184‡	Tie rod 6 zone
	113661‡	Tie rod 8 zone
8	105499	Float N.1 (solid brass) 10 & 12 zone
	105470‡	Float N.2 (plastic)
	105444‡	Float N.4 (PVC)
9	105490	Tie rod connection
10	105435	Central spacer
11	105403	Distributor tie spacer
12	105523	Thermometer assembly (°F)
	109955‡	Thermometer assembly (°C)
13	105442†	90° Hose Barb, ½" ID Hose, ½" Male BSPP (nylon)
13	105409‡	90° Hose Barb, ⅜" ID Hose, ½" Male BSPP (brass)
13	105497‡	90° Hose Barb, ¾" ID Hose, ½" Male BSPP (brass)
14	105516†	Straight Hose Barb, ½" ID Hose, ½" Male BSPP (nylon)
14	105488‡	Straight Hose Barb, ⅜" ID Hose, ½" Male BSPP (brass)
14	105380‡	Straight Hose Barb, ¾" ID Hose, ½" Male BSPP (brass)
13/14	107490‡	Hose Barb Adapter, ½" Male BSPP x ¼" Female NPT (brass) Converts ½" Female BSPP Hose Barb Thread to ¼" Female NPT
13/14	105388‡	Hose Barb Adapter, ½" Male BSPP x ⅜" Female NPT (brass) Converts ½" Female BSPP Hose Barb Thread to ⅜" Female NPT
13/14	107492‡	Hose Barb Adapter, ½" Male BSPP x ½" Female NPT (brass) Converts ½" Female BSPP Hose Barb Thread to ½" Female NPT
15	105479	Sight glass lock assembly
16	105423	Manifold internal connecting assembly
17	105392	Valve assembly
17a	133801	Screw for Control Knob
18	105513	O-ring for sight glass (25.9 x 3.53 x 32.96 mm)
19	105432	Right side plate assembly (includes #105417)
20	105455	Manifold plug assembly
21	105417	1" female N.P.T. supply connector (brass)
22	105372	Left side plate assembly (includes #105455)
	105547	Complete O-Ring Kit Includes: (2) Valve Stem O-Rings, (2) Valve Nut O-Rings, (2) Sight Glass O-Rings, (5) Hose Fitting, Plug, Piston O-Rings, (1) Thermometer, Plug, Nipple O-Ring, (12) Internal and Manifold Connection O-Rings and (1) Valve Seat O-Ring
	105401	FR1 Zone Kit - Includes items 1-18 and complete O-Ring Kit

†Standard equipment ‡Optional equipment





#105409 #107490 #105488

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Made in the U.S.A

SMARTFLOW®

Standard Mechanical Flowmeters

Smartflow mechanical flowmeters are durable, vane-operated devices that provide visual indication of flow rate in many different styles and sizes.

Smartflow Flowmeters

- Stretch your MRO budget. Rugged construction and corrosion resistant materials ensure years of dependable service. Add-on gauges give instant access to temperature and pressure readings in addition to flow rate.
- Simplify mold setup. Compact size facilitates installation in restricted space locations.
- Help optimize cycle times. Optional quick disconnect fittings create an excellent tool for spot checking flow and locating clogged lines

Inlet sizes - ¼" - 3"

Flow Ranges - Small: 1.5 To 8 GPM, Medium: 20 GPM, Large: 40 to 150 GPM

(Most ranges also available in liters per minute)

Rugged, wetted parts are compatible with many process liquids

	Small (Brass)	Small (Nylon)	Medium	Large
End Caps	Brass	Glass-Filled Nylon	N/A	N/A
Body	Polysulfone	Polysulfone	Anodized Aluminum	Anodized Aluminum
Vane	Glass-Filled Nylon	Glass-Filled Nylon	Stainless Steel	Stainless Steel
Viewing Window	Polysulfone	Polysulfone	Polysulfone	Polysulfone
Spring	302 Stainless Steel	302 Stainless Steel	Stainless Steel	Stainless Steel
Pin	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel
Gasket	N/A	N/A	Neoprene	Neoprene
O-Rings	EPDM	EPDM	N/A	N/A
Cap Screws	Stainless Steel	Zinc-Plated Steel	N/A	N/A
Opt.Gauge Block	Brass	Brass	N/A	N/A
Opt. Quick-Connect Fittings	Brass	Brass	N/A	N/A
Specifications				
Flow Accuracy	±10% full scale		±10%	
Operating Temperature	210°F (99°C) max.		210°F (99°C) max	
Operating Pressure	100 psi (6.9 bar) max		100 psi (6.9 bar) max	
Dial Thermometer	0° to 250°F (-20° to 120°C) ±2% accuracy (full scale)		0° to 250°F (-20° to 120°C) ±2% accuracy (full scale)	
Pressure Gauge	0 to 100 psi (0 to 700 Kpa) ±3% accuracy (full scale)		0- to 100 psi (0 to 700 Kpa) ±3% accuracy (full scale)	

Dimensions (Inches)	¼", ⅜", ½"	¾"	¼", ⅜", ½"	¾" & 1"	1", 1¼"	1½", 2"	3"
Length	2.25	3.25	2.25	4.13	4.75	5.50	6.50
Length with gauges	2.75	3.75	2.75	N/A	N/A	N/A	N/A
Width	1.50	1.50	1.50	1.75	2.25	3.00	4.00
Width with gauges	3.25	3.25	3.25	3.00	3.00	N/A	N/A
Height	1.50	1.50	1.50	1.75	2.25	3.00	4.00
Height with thermometer	3.10	3.10	3.10	2.60	3.10	3.90	4.90
Height with pressure gauge	3.70	3.70	3.70	3.20	3.80	4.50	5.50

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Small - Brass End Caps (¼", ⅜", ½" & ¾")

Item #	Model #	Inlet Size	Flow Range
Flowmeter Only			
143553	F2-A-15	¼" NPT	0.2 - 1.5 gpm
143554	F3-A-15	⅜" NPT	0.2 - 1.5 gpm
143555	F4-A-15	½" NPT	0.2 - 1.5 gpm
143556	F6-A-15	¾" NPT	0.2 - 1.5 gpm
143449	F2-A-25	¼" NPT	0.5 - 2.5 gpm
143453	F3-A-25	⅜" NPT	0.5 - 2.5 gpm
143557	F4-A-25	½" NPT	0.5 - 2.5 gpm
143558	F6-A-25	¾" NPT	0.5 - 2.5 gpm
143451	F2-A-80	¼" NPT	1.0 - 8.0 gpm
143455	F3-A-80	⅜" NPT	1.0 - 8.0 gpm
143457	F4-A-80	½" NPT	1.0 - 8.0 gpm
143559	F6-A-80	¾" NPT	1.0 - 8.0 gpm
With Temperature Gauge			
143980	F2-B-15	¼" NPT	0.2 - 1.5 gpm
143981	F3-B-15	⅜" NPT	0.2 - 1.5 gpm
144359	F4-B-15	½" NPT	0.2 - 1.5 gpm
143982	F6-B-15	¾" NPT	0.2 - 1.5 gpm
143983	F2-B-25	¼" NPT	0.5 - 2.5 gpm
143984	F3-B-25	⅜" NPT	0.5 - 2.5 gpm
143985	F4-B-25	½" NPT	0.5 - 2.5 gpm
143986	F6-B-25	¾" NPT	0.5 - 2.5 gpm
143987	F2-B-80	¼" NPT	1.0 - 8.0 gpm
143988	F3-B-80	⅜" NPT	1.0 - 8.0 gpm
143989	F4-B-80	½" NPT	1.0 - 8.0 gpm
143990	F6-B-80	¾" NPT	1.0 - 8.0 gpm
With Pressure Gauge			
144771	F2-F3-15	¼" NPT	0.2 - 1.5 gpm
144772	F3-F3-15	⅜" NPT	0.2 - 1.5 gpm
144773	F4-F3-15	½" NPT	0.2 - 1.5 gpm
144774	F6-F3-15	¾" NPT	0.2 - 1.5 gpm
144775	F2-F3-25	¼" NPT	0.5 - 2.5 gpm
144776	F3-F3-25	⅜" NPT	0.5 - 2.5 gpm
144777	F4-F3-25	½" NPT	0.5 - 2.5 gpm
144778	F6-F3-25	¾" NPT	0.5 - 2.5 gpm
144779	F2-F3-80	¼" NPT	1.0 - 8.0 gpm
144780	F3-F3-80	⅜" NPT	1.0 - 8.0 gpm
144781	F4-F3-80	½" NPT	1.0 - 8.0 gpm
144782	F6-F3-80	¾" NPT	1.0 - 8.0 gpm

Small - Brass End Caps (¼", ⅜", ½" & ¾")

Item #	Model #	Inlet Size	Flow Range
With Liquid-Filled Pressure Gauge (100 psi)			
144783	F2-FL-15	¼" NPT	0.2 - 1.5 gpm
144784	F3-FL-15	⅜" NPT	0.2 - 1.5 gpm
144785	F4-FL-15	½" NPT	0.2 - 1.5 gpm
144786	F6-FL-15	¾" NPT	0.2 - 1.5 gpm
144787	F2-FL-25	¼" NPT	0.5 - 2.5 gpm
144788	F3-FL-25	⅜" NPT	0.5 - 2.5 gpm
144789	F4-FL-25	½" NPT	0.5 - 2.5 gpm
144790	F6-FL-25	¾" NPT	0.5 - 2.5 gpm
144791	F2-FL-80	¼" NPT	1.0 - 8.0 gpm
144792	F3-FL-80	⅜" NPT	1.0 - 8.0 gpm
144793	F4-FL-80	½" NPT	1.0 - 8.0 gpm
144794	F6-FL-80	¾" NPT	1.0 - 8.0 gpm
With Temperature Gauge & Quick Change Socket and Plug			
144795	F2-E-15	¼" NPT	0.2 - 1.5 gpm
144796	F3-E-15	⅜" NPT	0.2 - 1.5 gpm
144797	F4-E-15	½" NPT	0.2 - 1.5 gpm
144798	F2-E-25	¼" NPT	0.5 - 2.5 gpm
144799	F3-E-25	⅜" NPT	0.5 - 2.5 gpm
144800	F4-E-25	½" NPT	0.5 - 2.5 gpm
144801	F2-E-80	¼" NPT	1.0 - 8.0 gpm
144802	F3-E-80	⅜" NPT	1.0 - 8.0 gpm
144803	F4-E-80	½" NPT	1.0 - 8.0 gpm
With Temperature Gauge (100 psi) & Pressure Gauge			
143560	F2-C3-15	¼" NPT	0.2 - 1.5 gpm
143561	F3-C3-15	⅜" NPT	0.2 - 1.5 gpm
143562	F4-C3-15	½" NPT	0.2 - 1.5 gpm
143563	F6-C3-15	¾" NPT	0.2 - 1.5 gpm
143459	F2-C3-25	¼" NPT	0.5 - 2.5 gpm
143564	F3-C3-25	⅜" NPT	0.5 - 2.5 gpm
143565	F4-C3-25	½" NPT	0.5 - 2.5 gpm
143566	F6-C3-25	¾" NPT	0.5 - 2.5 gpm
143461	F2-C3-80	¼" NPT	1.0 - 8.0 gpm
143463	F3-C3-80	⅜" NPT	1.0 - 8.0 gpm
143465	F4-C3-80	½" NPT	1.0 - 8.0 gpm
143567	F6-C3-80	¾" NPT	1.0 - 8.0 gpm

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Small - Brass End Caps (¼", ⅜", ½" & ¾")

Item #	Model #	Inlet Size	Flow Range
With Temperature Gauge 100 psi, Pressure Gauge & Quick Change Socket and Plug			
143568	F2-D3-15	¼" NPT	0.2 - 1.5 gpm
143569	F3-D3-15	⅜" NPT	0.2 - 1.5 gpm
143570	F4-D3-15	½" NPT	0.2 - 1.5 gpm
143571	F2-D3-25	¼" NPT	0.5 - 2.5 gpm
143469	F3-D3-25	⅜" NPT	0.5 - 2.5 gpm
143572	F4-D3-25	½" NPT	0.5 - 2.5 gpm
143467	F2-D3-80	¼" NPT	1.0 - 8.0 gpm
143473	F4-D3-80	½" NPT	1.0 - 8.0 gpm
With Temperature Gauge & Liquid-filled Pressure Gauge (100 psi)			
144804	F2-CL-15	¼" NPT	0.2 - 1.5 gpm
144805	F3-CL-15	⅜" NPT	0.2 - 1.5 gpm
144806	F4-CL-15	½" NPT	0.2 - 1.5 gpm
144807	F6-CL-15	¾" NPT	0.2 - 1.5 gpm
144808	F2-CL-25	¼" NPT	0.5 - 2.5 gpm
144809	F3-CL-25	⅜" NPT	0.5 - 2.5 gpm
144810	F4-CL-25	½" NPT	0.5 - 2.5 gpm
144811	F6-CL-25	¾" NPT	0.5 - 2.5 gpm
144812	F2-CL-80	¼" NPT	1.0 - 8.0 gpm
144813	F3-CL-80	⅜" NPT	1.0 - 8.0 gpm
144814	F4-CL-80	½" NPT	1.0 - 8.0 gpm
144815	F6-CL-80	¾" NPT	1.0 - 8.0 gpm
With Temperature Gauge, Liquid-filled Pressure Gauge (100 psi) & Quick Change Socket and Plug			
144816	F2-DL-15	¼" NPT	0.2 - 1.5 gpm
144817	F3-DL-15	⅜" NPT	0.2 - 1.5 gpm
144818	F4-DL-15	½" NPT	0.2 - 1.5 gpm
144819	F2-DL-25	¼" NPT	0.5 - 2.5 gpm
144820	F3-DL-25	⅜" NPT	0.5 - 2.5 gpm
144821	F4-DL-25	½" NPT	0.5 - 2.5 gpm
144822	F2-DL-80	¼" NPT	1.0 - 8.0 gpm
144823	F3-DL-80	⅜" NPT	1.0 - 8.0 gpm
144824	F4-FL-80	½" NPT	1.0 - 8.0 gpm

Small - Nylon End Caps (¼", ⅜" & ½")

Item #	Model #	Inlet Size	Flow Range
Flowmeter Only			
143910	FP2-A-15	¼" NPT	0.2 - 1.5 gpm
143911	FP3-A-15	⅜" NPT	0.2 - 1.5 gpm
143912	FP4-A-15	½" NPT	0.2 - 1.5 gpm
143450	FP2-A-25	¼" NPT	0.5 - 2.5 gpm
143454	FP3-A-25	⅜" NPT	0.5 - 2.5 gpm
143913	FP4-A-25	½" NPT	0.5 - 2.5 gpm
143452	FP2-A-80	¼" NPT	1.0 - 8.0 gpm
143456	FP3-A-80	⅜" NPT	1.0 - 8.0 gpm
143458	FP4-A-80	½" NPT	1.0 - 8.0 gpm
With Temperature Gauge			
143953	F2-B-15	¼" NPT	0.2 - 1.5 gpm
143954	F3-B-15	⅜" NPT	0.2 - 1.5 gpm
143955	F4-B-15	½" NPT	0.2 - 1.5 gpm
143933	F2-B-25	¼" NPT	0.5 - 2.5 gpm
143956	F3-B-25	⅜" NPT	0.5 - 2.5 gpm
143957	F4-B-25	½" NPT	0.5 - 2.5 gpm
143958	F2-B-80	¼" NPT	1.0 - 8.0 gpm
143959	F3-B-80	⅜" NPT	1.0 - 8.0 gpm
143960	F4-B-80	½" NPT	1.0 - 8.0 gpm
With Pressure Gauge (100 psi)			
144825	FP2-F3-15	¼" NPT	0.2 - 1.5 gpm
144826	FP3-F3-15	⅜" NPT	0.2 - 1.5 gpm
144827	FP4-F3-15	½" NPT	0.2 - 1.5 gpm
144828	FP2-F3-25	¼" NPT	0.5 - 2.5 gpm
144829	FP3-F3-25	⅜" NPT	0.5 - 2.5 gpm
144830	FP4-F3-25	½" NPT	0.5 - 2.5 gpm
144831	FP2-F3-80	¼" NPT	1.0 - 8.0 gpm
144832	FP3-F3-80	⅜" NPT	1.0 - 8.0 gpm
144833	FP4-F3-80	½" NPT	1.0 - 8.0 gpm
With Liquid-filled Pressure Gauge (100 psi)			
144891	FP2-FL-15	¼" NPT	0.2 - 1.5 gpm
144892	FP3-FL-15	⅜" NPT	0.2 - 1.5 gpm
144893	FP4-FL-15	½" NPT	0.2 - 1.5 gpm
144894	FP2-FL-25	¼" NPT	0.5 - 2.5 gpm
144895	FP3-FL-25	⅜" NPT	0.5 - 2.5 gpm
144896	FP4-FL-25	½" NPT	0.5 - 2.5 gpm
144897	FP2-FL-80	¼" NPT	1.0 - 8.0 gpm
144898	FP3-FL-80	⅜" NPT	1.0 - 8.0 gpm
144899	FP4-FL-80	½" NPT	1.0 - 8.0 gpm

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Small - Nylon End Caps (¼", ⅜", ½")

Item #	Model #	Inlet Size	Flow Range
With Temperature Gauge & Quick Change Socket and Plug			
144900	FP2-E-15	¼" NPT	0.2 - 1.5 gpm
144901	FP3-E-15	⅜" NPT	0.2 - 1.5 gpm
144902	FP4-E-15	½" NPT	0.2 - 1.5 gpm
144903	FP2-E-25	¼" NPT	0.5 - 2.5 gpm
144904	FP3-E-25	⅜" NPT	0.5 - 2.5 gpm
144905	FP4-E-25	½" NPT	0.5 - 2.5 gpm
144906	FP2-E-80	¼" NPT	1.0 - 8.0 gpm
144907	FP3-E-80	⅜" NPT	1.0 - 8.0 gpm
144908	FP4-E-80	½" NPT	1.0 - 8.0 gpm
With Temperature Gauge & Pressure Gauge (100 psi)			
143914	FP2-C-15	¼" NPT	0.2 - 1.5 gpm
143915	FP3-C-15	⅜" NPT	0.2 - 1.5 gpm
143916	FP4-C-15	½" NPT	0.2 - 1.5 gpm
143917	FP3-C-25	⅜" NPT	0.5 - 2.5 gpm
143918	FP4-C-25	½" NPT	0.5 - 2.5 gpm
With Temperature Gauge, Pressure Gauge (100 psi) & Quick Change Socket and Plug			
143919	FP2-D3-15	¼" NPT	0.2 - 1.5 gpm
143920	FP3-D3-15	⅜" NPT	0.2 - 1.5 gpm
143921	FP4-D3-15	½" NPT	0.2 - 1.5 gpm
143922	FP2-D3-25	¼" NPT	0.5 - 2.5 gpm
143923	FP4-D3-25	½" NPT	0.5 - 2.5 gpm
143468	FP2-D3-80	¼" NPT	1.0 - 8.0 gpm
143474	FP4-D3-80	½" NPT	1.0 - 8.0 gpm
With Temperature Gauge & Liquid-filled Pressure Gauge (100 psi)			
144909	FP2-CL-15	¼" NPT	0.2 - 1.5 gpm
144910	FP3-CL-15	⅜" NPT	0.2 - 1.5 gpm
144911	FP4-CL-15	½" NPT	0.2 - 1.5 gpm
144912	FP2-CL-25	¼" NPT	0.5 - 2.5 gpm
144913	FP3-CL-25	⅜" NPT	0.5 - 2.5 gpm
144914	FP4-CL-25	½" NPT	0.5 - 2.5 gpm
144915	FP2-CL-80	¼" NPT	1.0 - 8.0 gpm
144916	FP3-CL-80	⅜" NPT	1.0 - 8.0 gpm
144917	FP4-CL-80	½" NPT	1.0 - 8.0 gpm

Small - Nylon End Caps (¼", ⅜", ½")

Item #	Model #	Inlet Size	Flow Range
With Temperature Gauge, Liquid-filled Pressure Gauge & Quick Change Socket and Plug			
144918	FP2-DL-15	¼" NPT	0.2 - 1.5 gpm
144919	FP3-DL-15	⅜" NPT	0.2 - 1.5 gpm
144920	FP4-DL-15	½" NPT	0.2 - 1.5 gpm
144921	FP2-DL-25	¼" NPT	0.5 - 2.5 gpm
144922	FP3-DL-25	⅜" NPT	0.5 - 2.5 gpm
144923	FP4-DL-25	½" NPT	0.5 - 2.5 gpm
144924	FP2-DL-80	¼" NPT	1.0 - 8.0 gpm
144925	FP3-DL-80	⅜" NPT	1.0 - 8.0 gpm
144926	FP4-DL-80	½" NPT	1.0 - 8.0 gpm

Medium (¾" & 1")

Item #	Model #	Inlet Size	Flow Range
Flowmeter Only			
143924	F6-A-20	¾" NPT	2.0 - 20 gpm
143925	F8-A-20	1" NPT	2.0 - 20 gpm
With Temperature Gauge			
144927	F6-B-20	¾" NPT	2.0 - 20 gpm
144928	F8-B-20	1" NPT	2.0 - 20 gpm
With Pressure Gauge (100 psi)			
144929	F6-F3-20	¾" NPT	2.0 - 20 gpm
144930	F8-F3-20	1" NPT	2.0 - 20 gpm
With Liquid-filled Pressure Gauge (100 psi)			
144931	F6-FL-20	¾" NPT	2.0 - 20 gpm
144932	F8-FL-20	1" NPT	2.0 - 20 gpm
With Temperature Gauge & Pressure Gauge (100 psi)			
144501	F6-C3-20	¾" NPT	2.0 - 20 gpm
144502	F8-C3-20	1" NPT	2.0 - 20 gpm
With Temperature Gauge & Liquid-filled Pressure Gauge (100 psi)			
144933	F6-CL-20	¾" NPT	2.0 - 20 gpm
144934	F8-CL-20	1" NPT	2.0 - 20 gpm

continued on next page

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Large (1", 1¼", 1½", 2" & 3")

Item #	Model #	Inlet Size	Flow Range	Unit Price
Flowmeter Only				
143926	F8-A-40	1" NPT	2.5 - 40 gpm	**$228.00**
143927	F10-A-40	1¼" NPT	2.5 - 40 gpm	**245.00**
143928	F12-A-40	1½" NPT	2.5 - 40 gpm	**258.00**
143929	F16-A-40	2" NPT	2.5 - 40 gpm	**274.00**
143930	F12-A-100	1½" NPT	10 - 100 gpm	**258.00**
143931	F16-A-100	2" NPT	10 - 100 gpm	**274.00**
143932	F16-A-150G	2" NPT	10 - 150 gpm	**289.00**
144935	F24-A-150G	3" NPT	10 - 150 gpm	**435.00**
With Temperature Gauge				
144687	F8-B-40	1" NPT	2.5 - 40 gpm	**$262.00**
144688	F10-B-40	1¼" NPT	2.5 - 40 gpm	**281.00**
144689	F12-B-40	1½" NPT	2.5 - 40 gpm	**293.00**
144690	F16-B-40	2" NPT	2.5 - 40 gpm	**308.00**
144691	F12-B-100	1½" NPT	10 - 100 gpm	**293.00**
144692	F16-B-100	2" NPT	10 - 100 gpm	**308.00**
144693	F16-B-150G	2" NPT	10 - 150 gpm	**Inquire**
144936	F24-B-150G	3" NPT	10 - 150 gpm	**470.00**
With Pressure Gauge (100 psi)				
144937	F8-F3-40	1" NPT	2.5 - 40 gpm	**$262.00**
144938	F10-F3-40	1¼" NPT	2.5 - 40 gpm	**281.00**
144939	F12-F3-40	1½" NPT	2.5 - 40 gpm	**293.00**
144940	F16-F3-40	2" NPT	2.5 - 40 gpm	**308.00**
144941	F12-F3-100	1½" NPT	10 - 100 gpm	**293.00**
144942	F16-F3-100	2" NPT	10 - 100 gpm	**308.00**
144943	F16-F3-150G	2" NPT	10 - 150 gpm	**324.00**
144944	F24-F3-150G	3" NPT	10 - 150 gpm	**470.00**
With Liquid-filled Pressure Gauge (100 psi)				
144945	F8-FL-40	1" NPT	2.5 - 40 gpm	**$283.00**
144946	F10-FL-40	1¼" NPT	2.5 - 40 gpm	**295.00**
144947	F12-FL-40	1½" NPT	2.5 - 40 gpm	**311.00**
144948	F16-FL-40	2" NPT	2.5 - 40 gpm	**325.00**
144949	F12-FL-100	1½" NPT	10 - 100 gpm	**311.00**
144950	F16-FL-100	2" NPT	10 - 100 gpm	**325.00**
144951	F16-FL-150G	2" NPT	10 - 150 gpm	**343.00**
144952	F24-FL-150G	3" NPT	10 - 150 gpm	**489.00**

Item #	Model #	Inlet Size	Flow Range	Unit Price
With Temperature Gauge & Pressure Gauge (100 psi)				
144503	F8-C3-40	1" NPT	2.5 - 40 gpm	**$301.00**
144504	F10-C3-40	1¼" NPT	2.5 - 40 gpm	**314.00**
144505	F12-C3-40	1½" NPT	2.5 - 40 gpm	**330.00**
144506	F16-C3-40	2" NPT	2.5 - 40 gpm	**344.00**
144507	F12-C3-100	1½" NPT	10 - 100 gpm	**330.00**
144508	F16-C3-100	2" NPT	10 - 100 gpm	**344.00**
144509	F16-C3-150G	2" NPT	10 - 150 gpm	**358.00**
145045	F24-C3-150G	3" NPT	10 - 150 gpm	**505.00**
With Temperature Gauge & Liquid-filled Pressure Gauge (100 psi)				
144953	F8-CL-40	1" NPT	2.5 - 40 gpm	**$318.00**
144954	F10-CL-40	1¼" NPT	2.5 - 40 gpm	**333.00**
144955	F12-CL-40	1½" NPT	2.5 - 40 gpm	**347.00**
144956	F16-CL-40	2" NPT	2.5 - 40 gpm	**362.00**
144957	F12-CL-100	1½" NPT	10 - 100 gpm	**347.00**
144958	F16-CL-100	2" NPT	10 - 100 gpm	**362.00**
144959	F16-CL-150G	2" NPT	10 - 150 gpm	**379.00**
144960	F24-CL-150G	3" NPT	10 - 150 gpm	**524.00**

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Model Number Explanation

Example: F4-C-80

Would signify the Flowmeter is made of Brass, has ½" NPT female threads, includes a Temperature Gauge and Pressure Gauge and has a maximum Flow Rate of 8.0 gallons per minute.

End Cap		Inlet Size		Flowmeter Accessories		Flow Rate	
F	Brass	2	¼" NPT	A	Flowmeter ONLY	15	0.2 - 1.5 gpm (gal per minute)
FP	Nylon*	2B	¼" BSPP	B	Thermometer	20	2.0 - 20 gpm
		3	⅜" NPT	C1	Thermometer and 30 psi Pressure Gauge	25	0.5 - 2.5 gpm
		3B	⅜" BSPP	C2	Thermometer and 60 psi Pressure Gauge	40	2.5 - 40 gpm
		4	½" NPT	C3	Thermometer and 100 psi Pressure Gauge	80	1.0 - 8.0 gpm
		4B	½" BSPP	CL	Thermometer and Liquid-Filled Pressure Gauge (100 psi)	100G	10 - 100 gpm
		6	¾" NPT	D1	Thermometer, 30 psi Pressure Gauge, Quick Change Socket and Plug **	150G	10 - 150 gpm
		6B	¾" BSPP	D2	Thermometer, 60 psi Pressure Gauge and Quick Change Socket and Plug **	75	7 - 75 lpm (liters per minute)
		8	1" NPT	D3	Thermometer, 100 psi Pressure Gauge, Quick Change Socket and Plug **	100	2- 10 lpm
		8B	1" BSPP	DL	Thermometer, Liquid-filled Pressure Gauge (100 psi) and Quick Change Socket and Plug **	150	19 - 150 lpm
		10	1¼" NPT	E	Thermometer, Quick Change Socket and Plug	200	5 - 200 lpm
		12	1½" NPT	F1	30 psi Pressure Gauge	300	4 - 30 lpm
		12B	1½" BSPPC	F2	60 psi Pressure Gauge	375	38 - 375 lpm
		16	2" NPT	F3	30 psi Pressure Gauge		
		16B	2" BSPP	FL	Liquid-filled Pressure Gauge		
		24	3" NPT				

* Available with ¼", ⅜", & ½" Inlets Only
** Not available with ¾" inlet or BSPP Threads

Other Thread Styles and Sizes Available on Request - Inquire

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GREEN Products

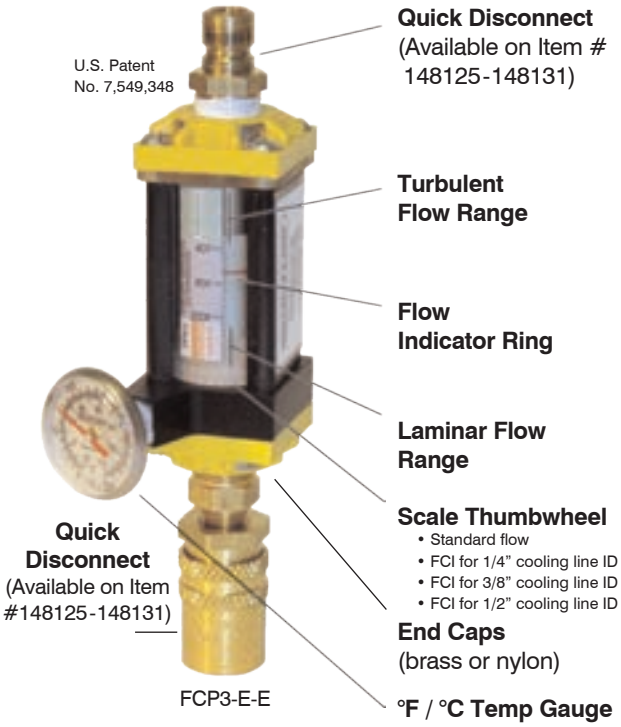
SMARTFLOW

Dr. Eddy™ Flowmeters

with FCI (Fluid Characteristic Indication) Technology

Provide a direct prediction of Turbulent Flow taking into account all relevant conditions – flow, fluid temperature and passage size

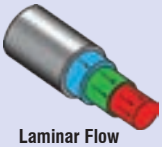
- **Cut Production Time.** Using FCI (Fluid Characteristic Indication) to achieve Turbulent Flow (maximum heat transfer) helps minimize cycle times and maximize part production.
- **Reduce Water Use**. Using FCI, systematic cooling fluid flow can be optimized, conserving water and maximizing cooling plant-wide without plumbing changes.
- **Simplify Mold Setup.** Compact size facilitates installation in restricted space locations.
- **Help Stretch Your MRO Budget.** Rugged construction and corrosion resistant materials ensure years of dependable service.

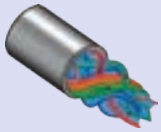


Inlet Sizes - ¼" & ⅜" (Also available in liters per minute) Rugged, wetted parts are compatible with many process liquids		
	Small (Nylon)	Small (Brass)
End Caps	Glass-Filled Nylon	Brass
Body	Polysulfone	
Indicator Ring	Silicone Rubber	
Piston	Acetal	
Spring	302 Stainless Steel	
O-Rings	EPDM	
Cap Screws	Stainless Steel	
Gauge Block	Brass	
Opt. Quick-Connect Fittings	Brass	
Specifications		
Accuracy	±10% full scale	
Operating Temperature	210°F (99°C) max	
Operating Pressure	100 psi (6.9 bar) max.	
Dial Thermometer	0° to 250°F (-20° to 120°C) ±2% accuracy (full scale)	
Dimensions (Inches)	¼" & ⅜"	
Length	3.75	
Width	1.50	
Width with gauge	2.10	
Height	1.50	
Height with thermometer	2.80	

Turbulent Flow Basics

- If your flow rate is **too low** (laminar flow), it will be hard to keep your mold temperature from rising.
- If your flow rate is **too high**, it will effectively remove heat, but you will be wasting water and the extra energy required to pump it.
- **Turbulent flow** is a point somewhere in between where heat removal is maximized and water use is minimized.


Laminar Flow


Turbulent Flow

A Dr. Eddy Flowmeter with FCI Technology can help you set the flow rate that achieve Turbulent Flow - No charts or calculations are necessary.

It's easy to use!
To achieve Turbulent Flow, simply note the fluid temperature on the built-in °F/°C thermometer and adjust the flow to line up with the temperature marks on the scale.

continued on next page

SMARTFLOW is a registered trademark of Burger & Brown Engineering, Inc.
Dr. Eddy is a trademark of Burger & Brown Engineering, Inc.

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Dr. Eddy™ - Nylon End Caps (¼" & ⅜")

Item #	Model #	Inlet Size	Unit Price
Flowmeter Only			
148117	FCP2-B-E	¼" NPT	**Inquire**
148119	FCP3-B-E	⅜" NPT	**Inquire**
With Quick Change Socket Plug			
148125	FCP2-E-E	¼" NPT	**Inquire**
148127	FCP3-E-E	⅜" NPT	**Inquire**

Dr. Eddy™ - Brass End Caps (¼" & ⅜")

Item #	Model #	Inlet Size	Unit Price
Flowmeter Only			
148121	FC2-B-E	¼" NPT	**Inquire**
148123	FC3-B-E	⅜" NPT	**Inquire**
With Quick Change Socket Plug			
148129	FC2-E-E	¼" NPT	**Inquire**
148131	FC3-E-E	⅜" NPT	**Inquire**

Model Number Explanation

Example: FC3-B-E

Would signify the Flowmeter is a Dr. Eddy™ Style with Brass End Caps, has ⅜" NPT female threadsand is a standard unit with English Scale Units

End Cap		Inlet Size		Flowmeter Accessories		Flow Rate	
FC	Brass	**2**	¼" NPT (F)	**B**	Thermometer (Standard)	**E**	English (Temp in °F and flow in GPM)
FCP	Nylon	**2B**	¼" BSPP† (F)	**E**	Thermometer with Quick Change Socket and Plug	**M**	Metric (Temp in °C and flow in LPM)
		3	⅜" NPT (F)				
		3B	⅜" BSPP† (F)				

† BSPP: British Parallel Thread

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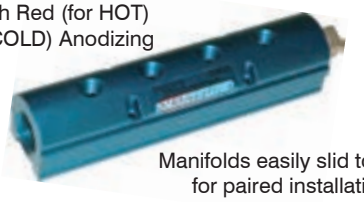
Check Out These Other Useful IMS Products!

Available with Red (for HOT) or Blue (for COLD) Anodizing



Manifolds easily slid together for paired installations

One Piece, Straight-Through Aluminum Manifolds

Won't leak / Resists Corrosion

4, 6, 8, 10, 12 or 16 Port
Inlet Sizes: ¾", 1", 1½" or 2" Port Sizes: ¼", ⅜" or ½"

Available with Brass or Nylon End Caps

Standard Mechanical Flowmeters

Expressly designed for accuracy and longevity

Inlet Sizes: ¼" – 3"
Flow Ranges: SMALL 1.5 to 8 GPM, MEDIUM 20 GPM, LARGE 40 to 150 GPM

Available in numerous colors

Mold Circulator Hose

5 Styles

Max. Use Temperatures: 212°F to 350°F Min. Burst Pressure: 175 – 1,200 PSI
Hose I.D.: ¼" – 1½"

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Made in the U.S.A

SMARTFLOW

Hot Oil/Water Mechanical Flowmeters

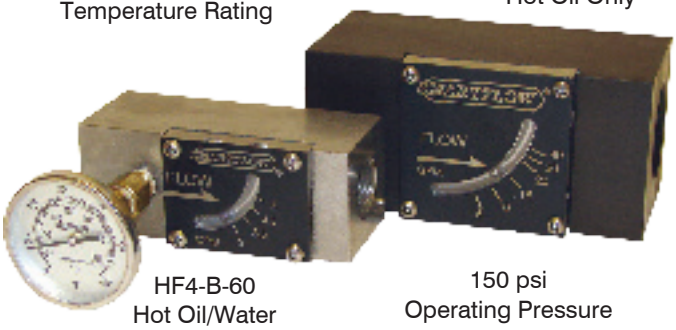
Smartflow Hot Oil/Water Flowmeters are Durable, Vane-Operated Devices Designed Specifically for High Temperature Circulating Loops

Smartflow Flowmeters

- **Stretch your MRO budget.** Rugged construction and corrosion resistant materials ensure years of dependable service. Add-on thermometer gives instant access to temperature in addition to flow rate.
- **Simplify mold setup.** Compact size facilitates installation in restricted space locations.

550°F
Temperature Rating

HF8-A-40
Hot Oil Only



HF4-B-60
Hot Oil/Water

150 psi
Operating Pressure

Inlet sizes – ½" - 1"
Flow Ranges – Hot Oil/Water: 2 to 6 GPM, Hot Oil Only: 5 to 40 GPM
Rugged, wetted parts are compatible with many process liquids

	Hot Oil/Water	Hot Oil Only
Body	Stainless Steel	Carbon Steel (black oxide finish)
Vane	Stainless Steel	
Viewing Window	Glass	
Spring	Stainless Steel	
Pin	Stainless Steel	
Gasket	Non-Asbestos Fiber	
Magnet	Sintered Alnico 8HE	

Specifications	
Flow Accuracy	±10% full scale
Operating Temperature	550°F (288°C) max
Operating Pressure	150 psi (10.3 bar) max.
Dial Thermometer	0° to 600°F (-20° to 310°C)

Dimensions (Inches)	½"	1"
Length	3.75	4.75
Width	1.50	2.25
Height	1.50	2.25

SMARTFLOW is a registered trademark of Burger & Brown Engineering, Inc.

Special, High Temperature Flow Gauge and 600°F Thermometer

The indicator ball is separated from the process by a high temperature gasket and stainless steel plate. A glass window retains the indicator ball. Big, easy to read 600°F (300°C) thermometer shown below.

Stainless Steel Body (½")

Item #	Model #	Inlet Size	Flow Range
Flowmeter Only			
143934	HF4-A-60	½" NPT	2 - 6 gpm
With Temperature Gauge			
143935	HF4-B-60	½" NPT	2 - 6 gpm

Carbon Steel Body (1")

Item #	Model #	Inlet Size	Flow Range
Flowmeter Only			
143936	HF8-A-40	1" NPT	5 - 40 gpm
With Temperature Gauge			
143937	HF8-B-40	1" NPT	5 - 40 gpm

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Quick Change Fittings & Thread Profile Sizing

All Fittings Shown Actual Size

Simply hold your fitting up to the appropriate profile to determine the NPT, Series or Barb Size.

Common Pipe Thread

¼" NPT

.540"

⅜" NPT

.675"

½" NPT

.840"

¾" NPT

1.05"

Coupler / waterline / thread Quick reference charts

Coupler specifications

Series - Body Size	200 - ¼"	300 - ⅜"	500 - ½"
Rated Pressure (PSI)	200	200	200
Rated Flow (GPM)	3	6	12

Coupler seals

Material	Temperature Range
Standard Silicone Seal	-90° to +400° F
Optional Flourocarbon Seal*	-15° to +400° F

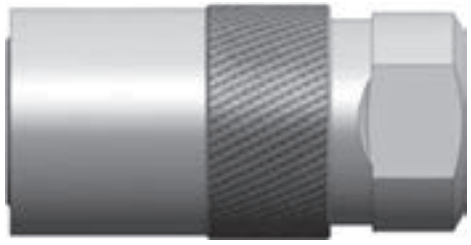
**For use with oil based fluids only*

Water Capacity (gpm)

Pipe Size	P_2 Variation	Differential Pressure (P_1-P_2) PSI			
		10	25	50	100+
½" & ¾"	5 PSI	1.8	2.3	2.4	2.8
	10 PSI	4.8	5.3	6.0	8.9
	15 PSI	9.1	10.1	10.9	11.8
	20 PSI	14.3	15.8	16.5	16.6
1"	5 PSI	1.5	2.0	2.7	6.9
	10 PSI	8.7	12.8	13.6	17.5
	15 PSI	14.2	20.9	27.3	28.0
	20 PSI	17.3	25.7	30.9	42.8
1¼" 1½" & 2"	5 PSI	18.5	20.0	25.4	25.7
	10 PSI	43.2	45.5	48.6	50.4
	15 PSI	64.8	67.4	69.5	70.5
	20 PSI	77.7	80.3	87.8	95.2

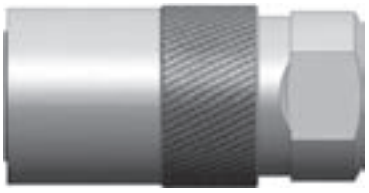
500 Series Coupler

1.177"



300 Series Coupler

.912"

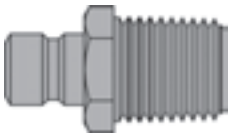


200 Series Coupler

.66"

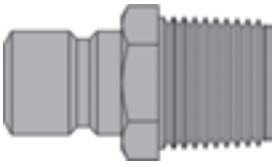
200 Series Plug

.368"



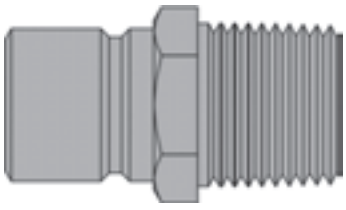
300 Series Plug

.531"



500 Series Plug

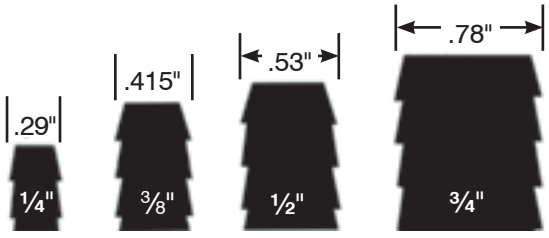
.782"



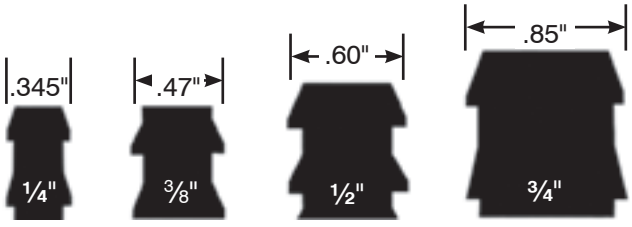
Pipe Thread Data

Pipe Size	Threads Per Inch	Outside Dia. of Pipe	Inside Diameter of Pipe	Tap Drill Size	
				Without Ream	With Ream
¼	18	.540	.364	7/16	23/64
⅜	18	.675	.493	9/16	9/16
½	14	.840	.622	45/64	11/16
¾	14	1.050	.824	29/32	53/64

Common Standard Hose Barbs



Common Push-On Hose Barbs



Made in the U.S.A

SMARTFLOW

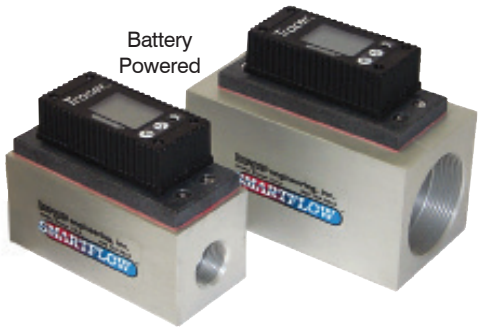
GREEN Products

Tracer® Electronic Flowmeters with Liquid Crystal Display

Measures, Calculates and Shows: Flow Rate, Temperature, BTU's/minute and Turbulent Flow*

Smartflow Flowmeters…

- **Conserve Water.** Using FCI (Flow Characteristic indicator), systemic cooling water flow can be optimized, conserving water and maximizing cooling plant-wide without plumbing changes
- **Stretch your MRO budget.** Corrosion-resistant wetted parts assure long-lasting durability
- **Simplify mold setup.** Compact size and bi-directional flow reading makes installation simple and convenient
- **Help optimize cycle times.** Optional quick disconnect fittings create an excellent tool for spot checking temperature and flow and locating clogged lines



With Unique FCI (Flow Characteristic Indicator) U.S. Patent Pending

* Turbulent Flow is the point at which cooling efficiency is optimized. Flow rates higher than the point of Turbulent Flow do not improve cooling. "TFLOW" displays on the FCI when Turbulent Flow is present within the Tracer Flowmeter.

Inlet Sizes – ⅜" - 2" Flow Ranges – 0 to 110 GPM Rugged, wetted parts are compatible with many process liquids		
	⅜"	2"
Body	Nickel-Plated Brass	Clear, Anodized Aluminum
Viewing Window	Polysulfone	N/A
Impeller	Nylon 6/12	
Impeller Shaft	18-8 Stainless Steel	
Magnet	Neodymium	
Magnet	3.6V, 1.0A Lithium	
Battery Life (actual use)	500 Hours	
Specifications		
Flow Accuracy	±5%	
Flow Repeatability	±3%	
Operating Temperature	32° to 180°F (0° to 82°C)	
Temperature Accuracy	±2% of display value	
Repeatability	±1% of display value	
Operating Pressure	150 psi (10.3 bar) max	100 psi (6.9 bar) max
Dimensions	3.45"L x 1.67"W x 2.27"H	5.50"L x 3.00"W x 4.65"H

NOTE: Accuracy and Repeatability Figures are based on the full scale of the range

FCI (Flow Characteristic Indicator)

- Display is configured with sealed push-buttons and user-friendly menus
- Flow Rate can be shown in gal or liters per minute
- Temperature can be shown in Fahrenheit or Celsius
- Calculates BTU's per minute
- Displays "TFLOW" when turbulent flow is achieved
- Programmable "ON" Time
- Adjustable, Automatic Display Shut-Off
- RoHS Compliant

Tracer®

Item #	Model #	Inlet Size	Flow Range
Flowmeter Only			
143515	DD-3B	⅜" NPT	0 - 8 gpm
144961	DD-3B-B	⅜" BSPP	0.5 - 8 gpm
143542	DD-16B	2" NPT	10 - 110 gpm
144965	DD-16B-B	2" BSPP	10 - 110 gpm
With Quick Change Socket and Plug			
143544	DD-3E	⅜" NPT	0-8

Item above includes 300 Series* Coupler and Plug

Accessories

Item #	Model #	
143577	EFB-36	Battery (3.6V, 1.0A)

Note: Add "-SS" suffix to model numbers for 303 Stainless Steel Bodies with NPT threads only

SMARTFLOW and Tracer are registered trademarks of Burger & Brown Engineering, Inc.

IMS Company

www.imscompany.com phone order toll-free (USA & Canada) 1.800.537.5375
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Please refer to imscompany.com for current pricing

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GREEN Products

SMARTFLOW

Made in the U.S.A

Tracer® Electronic Switching Flowmeters with Liquid Crystal Display Switching

Measure, Calculate and Show: Flow Rate, Temperature, BTU's/minute and Turbulent Flow*

Also provide a programmable switch for low or high flow or temperature and a selectable analog signal

Smartflow Flowmeters…

- **Protect equipment and processes.** Programmable SPDT Switch ensures production remains within set flow and temperature parameters
- **Stretch your MRO budget.** Corrosion-resistant wetted parts ensure years of dependable service
- **Simplify mold setup.** Compact size and bi-directional flow reading makes installation simple and convenient
- **Conserve Water.** Using FCI (Flow Characteristic indicator), systemic cooling water flow can be optimized, conserving water and maximizing cooling plant-wide without plumbing changes

Features a Unique FCI (Flow Characteristic Indicator† with Programmable SPDT Switch††

Remote Power and Switch Connection Cable

* Turbulent Flow is the point at which cooling efficiency is optimized. Flow rates higher than the point of Turbulent Flow do not improve cooling. "TFLOW" displays on the FCI when Turbulent Flow is present within the Tracer Flowmeter.

Inlet Sizes – 2" Flow Ranges – 10 to 110 GPM Rugged, wetted parts are compatible with many process liquids	
	2"
Body	Clear, Anodized Aluminum
Impeller	Nylon 6/12
Impeller Shaft	18-8 Stainless Steel
Magnet	Neodymium
Power	8 to 28VDC
Programmable SPDT Switch	1A, 30VAC, 42VDC
Analog Output	0-5 or 0-10V – selectable
Specifications	
Flow Accuracy	±5%
Flow Repeatability	±3%
Operating Temperature	32° to 180°F (0° to 82°C)
Temperature Accuracy	±2% of display value
Repeatability	±1% of display value
Operating Pressure	100 psi (6.9 bar) max
Dimensions	5.50"L x 3.00"W x 4.65"H

NOTE: Accuracy and Repeatability Figures are based on the full scale of the range

† FCI (Flow Characteristic Indicator)

- Display and switching operations are configured with sealed push-buttons and user-friendly menus
- **Flow Rate can be shown in gallons or liters** per minute
- Temperature can be shown in Fahrenheit or Celsius
- Calculates BTU's per minute
- Displays "TFLOW" when turbulent flow is achieved
- Programmable "ON" Time
- Adjustable, Automatic Display Shut-Off
- RoHS Compliant

U.S. Patent Pending

†† Programmable SPDT Switch

- One SPDT switch is provided with four programmable set points. Low or high flow or temperature set points can be used together or individually
- Selectable analog signal is scalable for flow and temperature
- Switch can be wired directly to an alarm circuit in a process control system or other peripheral equipment

Switching Tracer®

Item #	Model #	Inlet Size	Flow Range
Flowmeter Only			
143548	DDS-16B	2" NPT	10 - 110 gpm
144970	DDS-16B-B	2" BSPP	10 - 110 gpm

Note: Add "-SS" suffix to model numbers above for 303 Stainless Steel Bodies with NPT threads only

Also suitable for use in lube oil systems, blending systems filter condition indicators and varied applications requiring flow measurement of clean, non-viscous, chemically compatible process liquids

NOT recommended for use with liquids containing metallic particles

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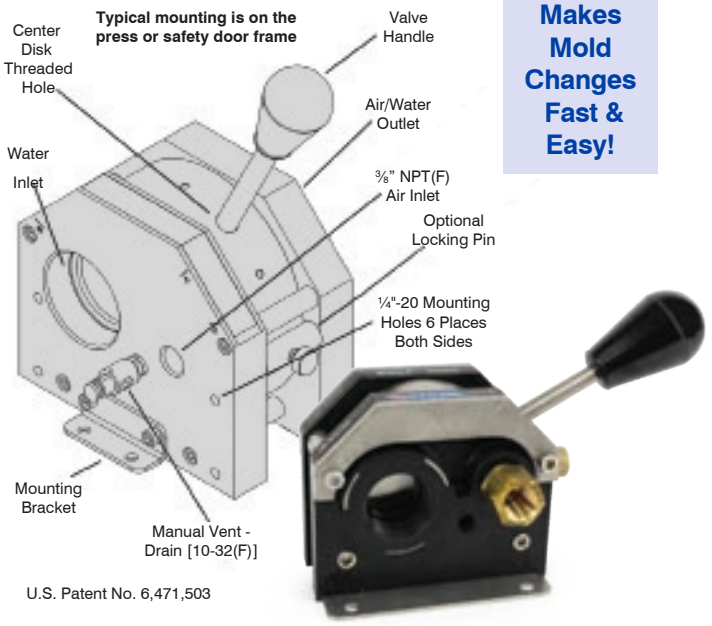
SMARTFLOW Swap® Valve

Compressed Air Mold Cooling Water Purge / Choose from Brass or Glass Filled Nylon

Ideal for cooling water supply lines up to 2" NPT on frequently changed molds that are installed small to medium tonnage injection molding machines.

SMARTFLOW Swap Valves

- **Cut 15-20 minutes off mold changes** by eliminating the need to drain multiple Supply and Return hoses and clean up water spills
- **Help protect molds from corrosion** during downtime and storage by evacuating water quickly and thoroughly
- **Permit fast identification of Supply lines** by noting which manifold is connected to the SWAP Valve
- **Provide a convenient Supply water shut-off** near the machine control, rather than with conventional ball valves on the Supply manifold, typically located on the other side of the press
- **Allow maximum cooling water to flow** at minimum pressure drop
- **Reduce accidents** around the press by helping to keep the floor dry

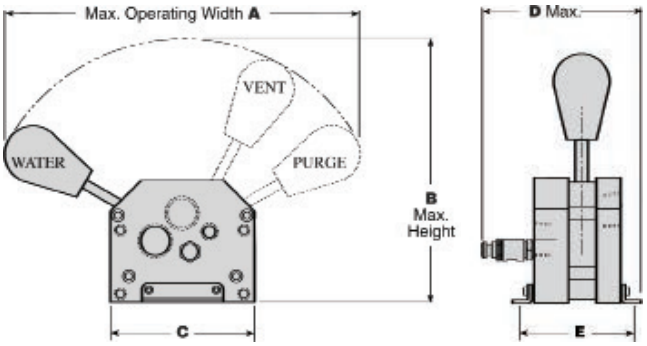


U.S. Patent No. 6,471,503

Makes Mold Changes Fast & Easy!

Specifications		
SWAP Body and Valve Disc: **Molded**		
Body	Glass-Filled Nylon	
Valve Disc	Stainless Steel	
Return Check Valve	Brass	
Maximum Pressure	150 psi (10.3 bar)	
Maximum Operating Temperature	250°F (121°C	
Normal Working Air Pressure	80 to 100 psi	
(Integral snubber prevents hose "whip" during purging)		
Pressure Drop Across Purge Valve	1 psi at 50 gpm	
Brass		
Body	Brass	
Valve Disc	Stainless Steel	
Return Check Valve	Brass (Recommended)	
Maximum Pressure	150 psi (10.3 bar)	
Maximum Operating Temperature	250°F (121°C)	
Normal Working Air Pressure	80 to 100 psi	
(Integral snubber prevents hose "whip" during purging)		
Pressure Drop Across Purge Valve	1 psi at 50 gpm	

Dimensions	SPV8	SPV16
A	11.75" (299 mm)	15.5" (395 mm)
B	8.7" (221 mm)	11.7" (297 mm)
C	4.7" (119 mm)	6.8" (173 mm)
D	5.1" (130 mm)	6.3" (160 mm)
E	3.9" (99 mm)	4.9" (126 mm)



Glass-Filled Nylon

INCLUDES: Return Check Valve and Mounting Brackets

Item #	Body	Model #	Thd. Size
167962	Molded	SPV8-A-M	1" NPT
169583	Molded	SPV8-L-M*	1" NPT

* w/Locking Pin

Brass

Item #	Body	Model #	Thd. Size
161962	Brass	SPV8-A-B	1" NPT
169618	Brass	SPV8-L-B*	1" NPT
173326	Brass	SPV16-A-B	2" NPT
171270	Brass	SPV16-L-B*	2" NPT

* w/Locking Pin

Optional Accessories

Item #	Model #	Description
144495	PVCV-3-A	Air Check Valve - ⅜" NPT

Spare Parts

Item #	Model #	Description
144496	PVOSET-100A	EPDM O-Ring Set - 1"
144497	PVOSET-200A	EPDM O-Ring Set - 2"
144498	PVCV-100-A**	Check Valve - 1" NPT
144499	PVCV-200-A**	Check Valve - 2" NPT

** Included with all new Swap Valves

ALL available with British Standard Pipe Thread – INQUIRE

SMARTFLOW and SWAP are registered trademarks of Burger & Brown Engineering, Inc.

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Taco® Series Air Separators

Eliminates Air From Closed Loop Water Circulating Systems

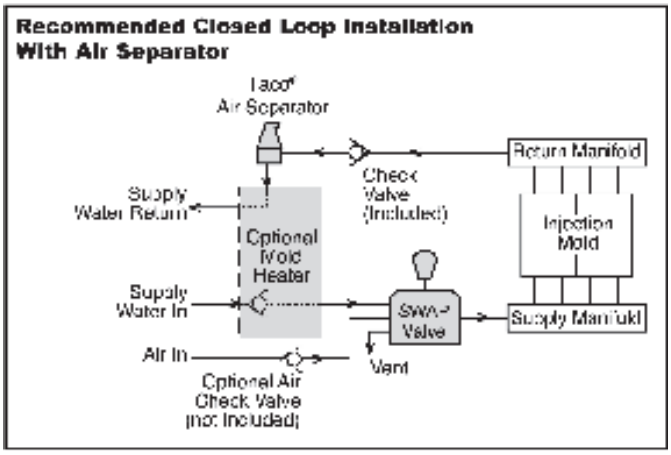
SMARTFLOW Taco Air Separators

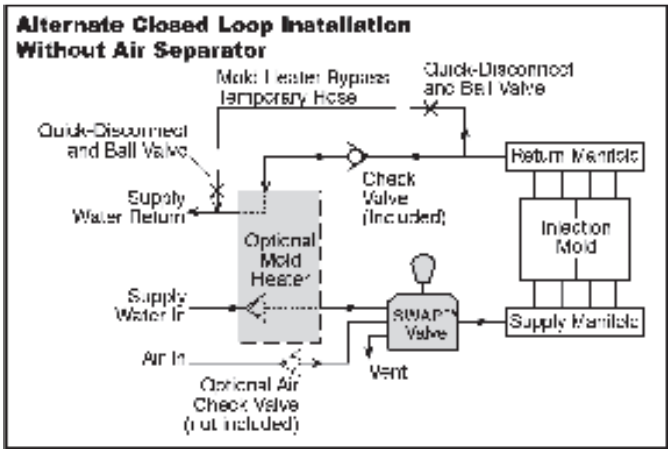
Small air bubbles and micro-bubbles adhere to surfaces on the pall rings in the water path and join together to form larger air bubbles. The combined bubbles then travel up through the water and into the conical air chamber to be released by the vent at the top.

Specifications	
Connection Sizes	1" & 2" NPT(F)
Housing Material	Brass
Pall Ring Material	Stainless Steel
Venting Unit Materials	Stainless Steel EPDM, Viton, Engineered Plastics
Max. Operating Pressure	150psi (10 bar)
Max. Operating Temperature	240°F (115°C)
Min. Operating Temperature	25°F (-4°C)
Media	Water or Water/Glycol
Max. Velocity	5 feet/second

A must for inline use with SMARTFLOW Swap Valves in a closed loop system

Item #	Model #	Thd. Size	Height	Width	Weight
161887	49-100	1" NPT	6¾"	4⅜"	4½ lbs
161888	49-200	2" NPT	8 7/16"	5 3/16"	6 lbs





NOTE: If temperature control units not used, install separator at highest point in return cooling water loop

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Anodized Aluminum Manifolds

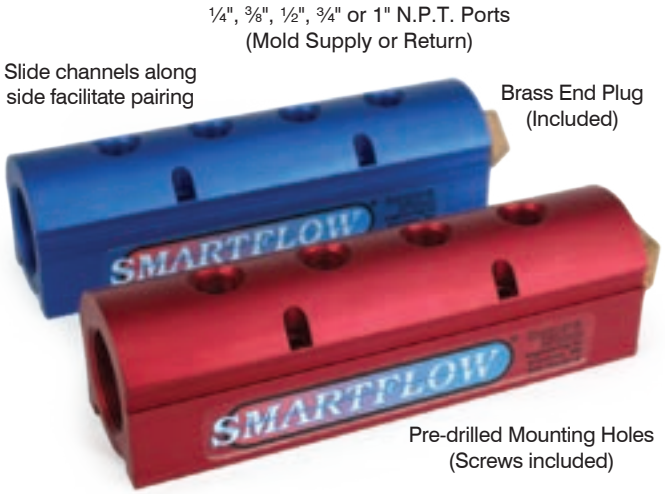
4, 6, 8, 10, 12 and 16 Port Straight-Through Models

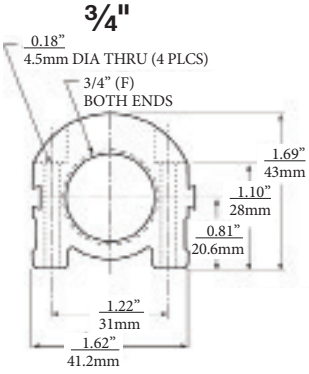
Smartflow® aluminum manifolds are constructed from extruded material, machined, then anodized for corrosion protection. Many manifold sizes are stocked, however custom manifolds can be made to your specifications.

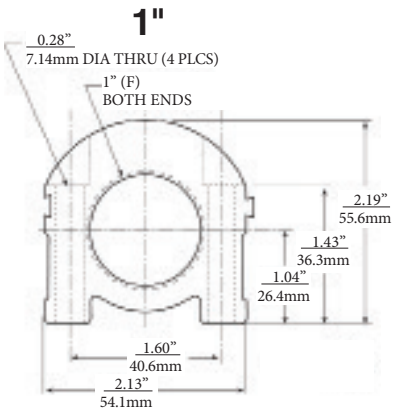
Standard red and blue anodizing denotes supply and return for cooling water lines. Green, black, clear and gold anodized manifolds are available. ¾", 1", and 1½" manifolds are equipped with dovetail locking channels, pre–drilled mounting holes, and screws for ease in pairing and installation. Call for pricing and delivery.

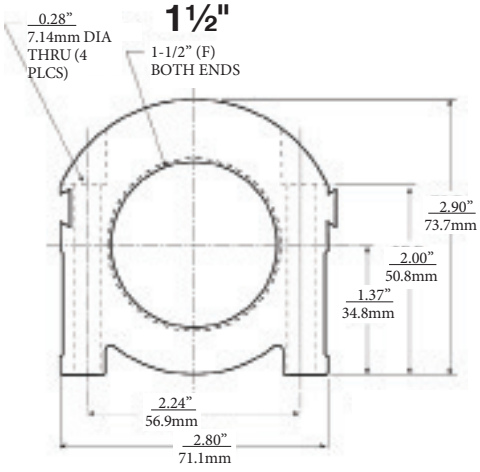
- Extend Equipment Life and Stretch Your MRO Budget
- Add-on Ball Valves and Flowmeters increase versatility
- One-piece, extruded anodized aluminum construction
- Won't leak / resists corrosion.

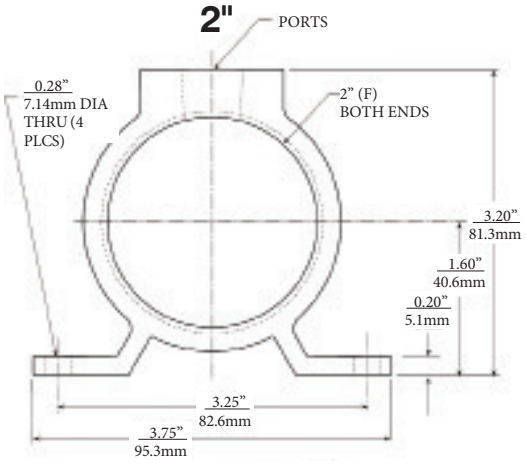
Specifications	
Material: ¾", 1", 1½" , 2"	Aluminum (6000 Series)
Inlet Size	¾", 1", 1½" or 2", NPT(F) standard British threads optional
Port Size	¼", ⅜", ½", ¾" or 1" NPT
Max. Pressure	150 psi (10 bar)
Max. Temperature	300°F (149°C)
Optional Ball Valves	NPT only to match port size





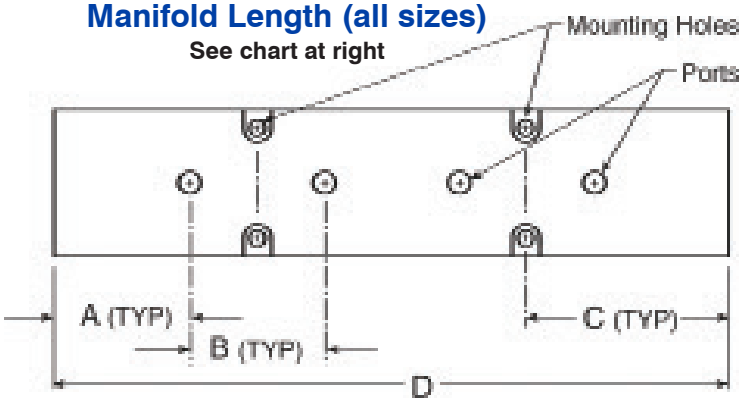






Manifold Length (all sizes)

See chart at right



Total Manifold Length: D = [(number of ports - 1) x B] + (2 x A)

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¾" Manifolds

Number of Ports	¼" Ports				
	Model #	Length		Weight	
		in.	mm	lbs.	kg
4	6SA- 4-2-2	7.5	190	1.1	0.5
6	6SA- 6-2-2	10.5	267	1.6	0.7
8	6SA- 8-2-2	13.5	343	2.0	0.9
Number of Ports	⅜" Ports				
4	6SA- 4-3-2	9	229	1.4	0.6
6	6SA- 6-3-2	13	330	2.0	0.9
8	6SA- 8-3-2	17	432	2.6	1.2

2" Manifolds

Number of Ports	½" Ports				
	Model #	Length		Weight	
		in.	mm	lbs.	kg
4	16SA-4-4	10	254	2.9	1.3
6	16SA-6-4	14	356	4.1	1.8
8	16SA-8-4	18	457	5.2	2.4
12	16SA-12-4	26	660	7.5	3.4
16	16SA-16-4	34	864	9.9	4.5

1" Manifolds

Number of Ports	¼" Ports				
	Model #	Length		Weight	
		in.	mm	lbs.	kg
4	8SA- 4-2-2	7.5	190	2.0	0.9
6	8SA- 6-2-2	10.5	267	2.8	1.3
8	8SA- 8-2-2	13.5	343	3.6	1.6
10	8SA-10-2-2	16.5	419	4.5	2.0
12	8SA-12-2-2	19.5	495	5.3	2.4
16	8SA-16-2-2	25.5	648	6.9	3.1
Number of Ports	⅜" Ports				
4	8SA- 4-3-2	9	229	2.4	1.1
6	8SA- 6-3-2	13	330	3.5	1.6
8	8SA- 8-3-2	17	432	4.6	2.1
10	8SA-10-3-2	21	533	5.7	2.6
12	8SA-12-3-2	25	635	6.8	3.1
16	8SA-16-3-2	33	838	8.9	4.0

1½" Manifolds

Number of Ports	½" Ports				
	Model #	Length		Weight	
		in.	mm	lbs.	kg
4	12SA- 4-4-2	10	254	4.4	2.0
6	12SA- 6-4-2	14	356	6.2	2.8
8	12SA- 8-4-2	18	457	7.9	3.6
10	12SA-10-4-2	22	559	9.7	4.4
12	12SA-12-4-2	26	660	11.4	5.1
16	12SA-16-4-2	34	864	15.0	6.7

Dimension Chart (inches/mm)

Manifold Size	Port Size	Suggested Ball Valve*	A	B	C
¾" & 1"	⅛"	Low Profile	1.5" 38.1mm	1.0" 25.4mm	2.0" 50.8mm
	¼"	Low Profile		1.5" 38.1mm	2.25" 57.2mm
	⅜"	Low Profile/ Standard		2.0" 50.8mm	2.5" 63.5mm
	½"	Low Profile			
1½"	¼"	Low Profile	1.5" 38.1mm	1.5" 38.1mm	2.25" 57.2mm
	⅜"	Low Profile/ Standard		2.0" 50.8mm	2.5" 63.5mm
	½"	Low Profile	2.0" 50.8mm	2.0" 50.8mm	3.0" 76.2mm
	¾"	Low Profile		3.0" 76.2mm	3.5" 88.9mm
2"	½"	Low Profile	2.0" 50.8mm	2.0" 50.8mm	1.0" 25.4mm
	¾"	Low Profile/ Standard		3.0" 76.2mm	
	1"	Low Profile/ Standard			

*See **Ball Valves** on page **371-373**

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

continued on next page

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Item #	Model #	Color	Inlet/ Outlet NPT	Port NPT	# of Ports
Aluminum (¾" Inlet/Outlet NPT) **Single Manifolds**					
143475	6SA-4-2-2-AY	Red	¾"	¼"	4
143476	6SA-4-2-2-AZ	Blue	¾"	¼"	4
143479	6SA-6-2-2-AY	Red	¾"	¼"	6
143480	6SA-6-2-2-AZ	Blue	¾"	¼"	6
143483	6SA-8-2-2-AY	Red	¾"	¼"	8
143484	6SA-8-2-2-AZ	Blue	¾"	¼"	8
143578	6SA-10-2-2-AY	Red	¾"	¼"	10
143579	6SA-10-2-2-AZ	Blue	¾"	¼"	10
143493	6SA-12-2-2-AY	Red	¾"	¼"	12
143494	6SA-12-2-2-AZ	Blue	¾"	¼"	12
143580	6SA-16-2-2-AY	Red	¾"	¼"	16
143581	6SA-16-2-2-AZ	Blue	¾"	¼"	16

Item #	Model #	Color	Inlet/ Outlet NPT	Port NPT	# of Ports
Aluminum (¾" Inlet/Outlet NPT) **Single Manifolds**					
143477	6SA-4-3-2-AY	Red	¾"	⅜"	4
143478	6SA-4-3-2-AZ	Blue	¾"	⅜"	4
143481	6SA-6-3-2-AY	Red	¾"	⅜"	6
143482	6SA-6-3-2-AZ	Blue	¾"	⅜"	6
143582	6SA-8-3-2-AY	Red	¾"	⅜"	8
143583	6SA-8-3-2-AZ	Blue	¾"	⅜"	8
143584	6SA-10-3-2-AY	Red	¾"	⅜"	10
143585	6SA-10-3-2-AZ	Blue	¾"	⅜"	10
143495	6SA-12-3-2-AY	Red	¾"	⅜"	12
143496	6SA-12-3-2-AZ	Blue	¾"	⅜"	12
143586	6SA-16-3-2-AY	Red	¾"	⅜"	16
143587	6SA-16-3-2-AZ	Blue	¾"	⅜"	16

Aluminum (1" Inlet/Outlet NPT) **Single Manifolds**					
143588	8SA-4-2-2-AY	Red	1"	¼"	4
143589	8SA-4-2-2-AZ	Blue	1"	¼"	4
143590	8SA-6-2-2-AY	Red	1"	¼"	6
143591	8SA-6-2-2-AZ	Blue	1"	¼"	6
143489	8SA-8-2-2-AY	Red	1"	¼"	8
143490	8SA-8-2-2-AZ	Blue	1"	¼"	8
143592	8SA-10-2-2-AY	Red	1"	¼"	10
143593	8SA-10-2-2-AZ	Blue	1"	¼"	10
143594	8SA-12-2-2-AY	Red	1"	¼"	12
143595	8SA-12-2-2-AZ	Blue	1"	¼"	12
143596	8SA-16-2-2-AY	Red	1"	¼"	16
143597	8SA-16-2-2-AZ	Blue	1"	¼"	16

Aluminum (1" Inlet/Outlet NPT) **Single Manifolds**					
143485	8SA-4-3-2-AY	Red	1"	⅜"	4
143486	8SA-4-3-2-AZ	Blue	1"	⅜"	4
143487	8SA-6-3-2-AY	Red	1"	⅜"	6
143488	8SA-6-3-2-AZ	Blue	1"	⅜"	6
143491	8SA-8-3-2-AY	Red	1"	⅜"	8
143492	8SA-8-3-2-AZ	Blue	1"	⅜"	8
143598	8SA-10-3-2-AY	Red	1"	⅜"	10
143599	8SA-10-3-2-AZ	Blue	1"	⅜"	10
143600	8SA-12-3-2-AY	Red	1"	⅜"	12
143895	8SA-12-3-2-AZ	Blue	1"	⅜"	12
143896	8SA-16-3-2-AY	Red	1"	⅜"	16
143897	8SA-16-3-2-AZ	Blue	1"	⅜"	16

Aluminum (1½" Inlet/Outlet NPT) **Single Manifolds**					
143497	12SA-4-4-2-AY	Red	1-½"	½"	4
143498	12SA-4-4-2-AZ	Blue	1-½"	½"	4
143499	12SA-6-4-2-AY	Red	1-½"	½"	6
143500	12SA-6-4-2-AZ	Blue	1-½"	½"	6
143501	12SA-8-4-2-AY	Red	1-½"	½"	8
143502	12SA-8-4-2-AZ	Blue	1-½"	½"	8
143503	12SA-10-4-2-AY	Red	1-½"	½"	10
143504	12SA-10-4-2-AZ	Blue	1-½"	½"	10
143505	12SA-12-4-2-AY	Red	1-½"	½"	12
143506	12SA-12-4-2-AZ	Blue	1-½"	½"	12
143898	12SA-16-4-2-AY	Red	1-½"	½"	16
143899	12SA-16-4-2-AZ	Blue	1-½"	½"	16

Aluminum (2" Inlet/Outlet NPT) **Single Manifolds**					
143900	16SA-4-4-2-AY	Red	2"	½"	4
143901	16SA-4-4-2-AZ	Blue	2"	½"	4
166333	16SA-4-6-2-AY	Red	2"	¾"	4
166334	16SA-4-6-2-AZ	Blue	2"	¾"	4
148876	16SA-4-8-2-AY	Red	2"	1"	4
148877	16SA-4-8-2-AZ	Blue	2"	1"	4
143902	16SA-6-4-2-AY	Red	2"	½"	6
143903	16SA-6-4-2-AZ	Blue	2"	½"	6
163187	16SA-6-6-2-AY	Red	2"	¾"	6
163188	16SA-6-6-2-AZ	Blue	2"	¾"	6
147517	16SA-6-8-2-AY	Red	2"	1"	6
147518	16SA-6-8-2-AZ	Blue	2"	1"	6

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continued on next page

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Item #	Model #	Color	Inlet/ Outlet NPT	Port NPT	# of Ports
Aluminum (2" Inlet/Outlet NPT) **Single Manifolds**					
143904	16SA-8-4-2-AY	Red	2"	½"	8
143905	16SA-8-4-2-AZ	Blue	2"	½"	8
163053	16SA-8-6-2-AY	Red	2"	¾"	8
163054	16SA-8-6-2-AZ	Blue	2"	¾"	8
143906	16SA-12-4-2-AY	Red	2"	½"	12
143907	16SA-12-4-2-AZ	Blue	2"	½"	12
159726	16SA-12-6-2-AY	Red	2"	¾"	12
159727	16SA-12-6-2-AZ	Blue	2"	¾"	12
143908	16SA-16-4-2-AY	Red	2"	½"	16
143909	16SA-16-4-2-AZ	Blue	2"	½"	16
159915	16SA-16-6-2-AY	Red	2"	¾"	16
159916	16SA-16-6-2-AZ	Blue	2"	¾"	16

IMS is an official distributor of SMARTFLOW products

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Model Number Explanation

Example: **12SA-16-4-2-BY**

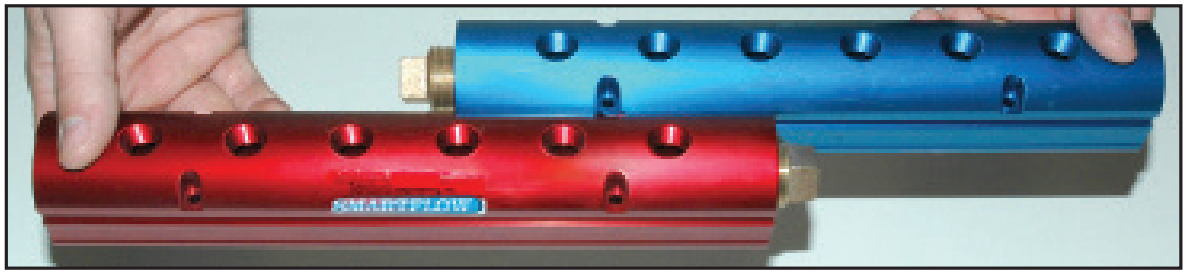
Would signify the Manifold is red, has 1½" NPT Inlets and 16, ½" NPT Ports that are centered and include ball valves.

Inlet Thread Size & Type		Number of Ports	Port Size		Port Location		Manifold Accessories		Color	
6SA	¾" NPT (F)	**4**	**2**	¼" NPT (F)	**0**	Left Side	**A**	Manifold only	**Y**	Red
8SA	1" NPT (F)	**6**	**3**	⅜" NPT (F)	**1**	Left 45°	**B**	Ball Valves only	**Z**	Blue
12SA	1½" NPT (F)	**8**	**4**	½" NPT (F)	**2**	Center	**C**	Ball Valves and Plain Flowmeters		
16SA	2" NPT (F)*	**10**	**6**	¾" NPT (F)**	**3**	Right 45°	**D**	Ball Valves and Flowmeters with Thermometers		
		12	**8**	1" NPT (F)**	**4**	Right Side	**E**	Ball valves and Flowmeters with Thermometers and Pressure Gauges		
		16					**F**	Plain Flowmeters only		
							H	Quick Connect Plugs		
							J	Port Hose Barbs		

* NOTE: All manifolds with 2" Inlet/Outlet have centered ports
** 3" Port center spacing

Other Thread Styles and Sizes Available on Request - Inquire

For paired installation, slide manifolds together using dovetail lock along the side of each manifold



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DUOFLOW™ Anodized Aluminum Manifolds

8 (4 in/4 out), 12 (6 in/6 out) and 16 (8 in/8 out) Port Split Models

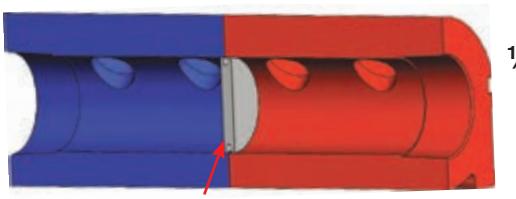
SMARTFLOW® DUOFLOW™ Manifolds are robust extruded aluminum manifolds similar to the Smartflow one-piece design. The manifolds are divided internally and anodized with one red end and one blue end to denote supply and return on a single manifold. No end plug is needed.

The Duoflow design provides a shorter footprint specifically for mounting a manifold directly to an injection mold, or where space is limited. Port spacing is narrow for installation of hose barbs or quick disconnect fittings only. Ball valves are not recommended due to port spacing.

Tool change time is significantly decreased by mounting manifolds directly to molds in storage. Water hookup is simplified to "Supply" and "Return" lines versus individual water lines for every circuit.

- Shorter length for easier mounting directly to injection molds
- Mold-Mount to speed mold change times
- Economical, Proven Design for reliability
- Optional Quick Disconnect Fittings for convenience and ease of installation

Section View



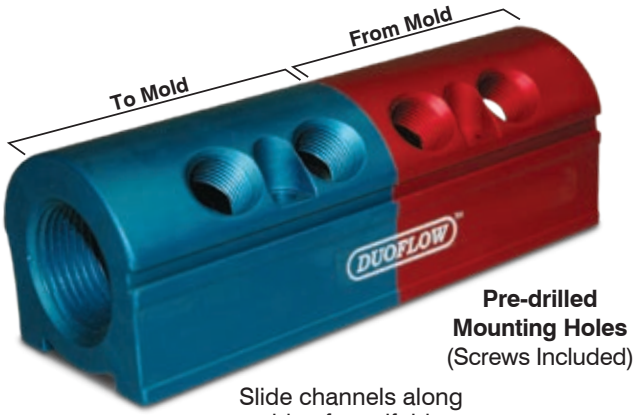
¼" , ⅜" or ½" N.P.T. Ports (Mold Supply or Return)

Stainless Steel Divider

Compact Design to be Mounted on the Mold

Red and Blue Anodizing Easily Identifies Hot and Cold Lines

NOTE: Ball valves not recommended due to port spacing



Pre-drilled Mounting Holes (Screws Included)

Slide channels along side of manifolds facilitate pairing

¾", 1" or 1½" Inlet/Outlet (Main Supply or Return)

Specifications	
Material	
Body	Aluminum (6000 Series)
Divider	Stainless Steel
O-Ring	EPDM
Inlet Size	¾", 1" or 1½", NPT(F) standard British threads optional
Port Size	¼", ⅜" or ½", NPT(F) standard British threads optional
Max. Pressure	150 psi (10 bar)
Max. Temperature	210°F (99°C)

DUOFLOW™ is a trademark of Burger & Brown Engineering, Inc.
SMARTFLOW® is a registered trademark of Burger & Brown Engineering, Inc.

Note: Tests have shown that if copper based alloys (brass) fittings are attached directly to aluminum, there is a high probability that galvanic corrosion will occur. Galvanic action can be reduced or prevented by breaking the path of electrical conductivity through the plumbing system.

Dimension Chart (inches/mm)

Manifold Size	Port Size	A	B	C	D
¾"	¼"	1" 25.4mm	1" 25.4mm	1.5" 38mm	2" 50.8mm
1"	⅜"	1.25" 32mm	1.25" 32mm	1.88" 47.6mm	2.25" 57.2mm
1½"	½"	1.75" 44.5mm	1.5" 38mm	2.5" 63.5mm	2.5" 63.5mm

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fax order toll-free (USA & Canada) 1.888.288.6900
phone order toll-free (Mexico) 001.888.304.1307
tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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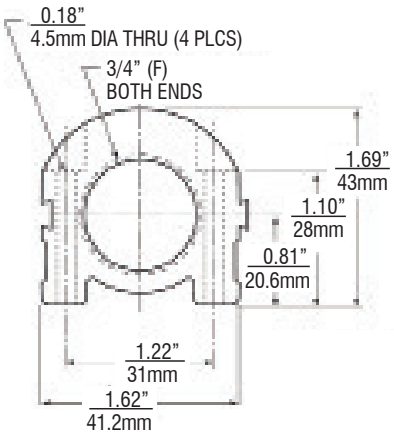
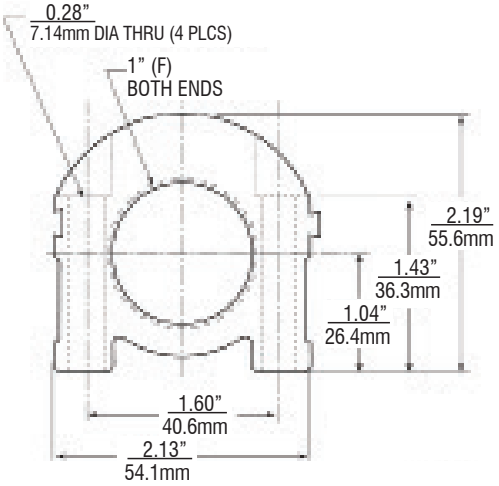
DUOFLOW™ (¾", 1" & 1½" Inlet/Outlet NPT)

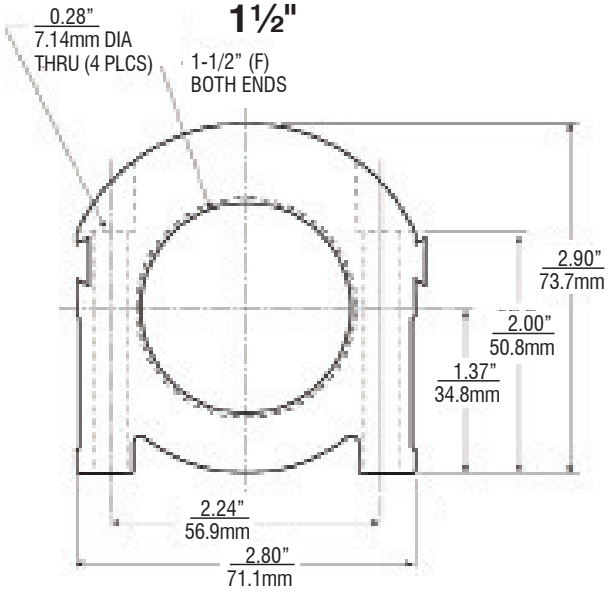
¾"



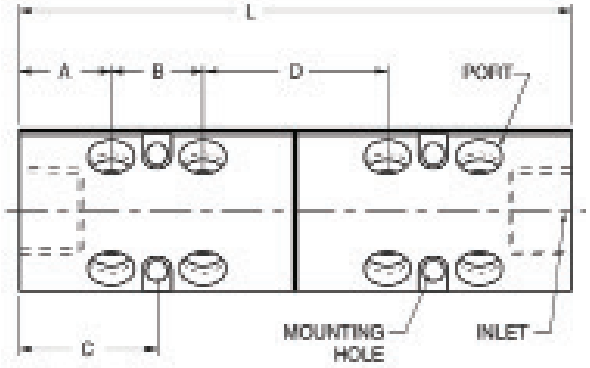
1"



1½"



Manifold Length (all sizes) see chart on 358



Item #	Model #	Inlet/Outlet NPT	Port NPT	# of Ports	Length in	Length mm	Weight lbs	Weight kg
Single Manifolds								
149536	6SDA-8-2-13-AYZ	¾"	¼"	8 (4 in/4 out)	6	152	0.75	0.3
149537	6SDA-12-2-13-AYZ	¾"	¼"	12 (6 in/6 out)	8	203	1.1	0.5
149538	6SDA-16-2-13-AYZ	¾"	¼"	16 (8 in/8 out)	10	254	1.4	0.6
Single Manifolds								
149539	8SDA-8-3-13-AYZ	1"	⅜"	8 (4 in/4 out)	7.25	184	1.7	0.8
149540	8SDA-12-3-13-AYZ	1"	⅜"	12 (6 in/6 out)	9.75	248	2.4	1.1
149541	8SDA-16-3-13-AYZ	1"	⅜"	16 (8 in/8 out)	12.25	311	3.1	1.4
Single Manifolds								
149542	12SDA-8-4-13-AYZ	1½"	½"	8 (4 in/4 out)	9	229	3.5	1.6
149543	12SDA-12-4-13-AYZ	1½"	½"	12 (6 in/6 out)	12	305	4.9	2.2
149544	12SDA-16-4-13-AYZ	1½"	½"	16 (8 in/8 out)	15	381	6.2	2.8

Customs are available on request!

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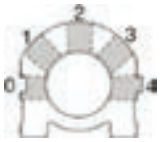
Model Number Explanation

Use This To Verify Manifold Style Or Use For Custom Ordering

Example: 8SDA-16-3-13-AYZ

Would signify the DUOFLOW™ Manifold, has 1" NPT Inlets and 16, ⅜" NPT Ports that are on the left and right at 45° and is red and blue.

Inlet Thread Size & Type		Number of Ports	Port Size		Port Location		Manifold Accessories		Color	
6SDA	¾" NPT (F)	4	2	¼" NPT (F)	0	Left Side	A	Manifold only	Y	Red
6BSDA	¾" British Parallel (F)	6	2B	¼" BSPP (F)	1	Left 45°	H	Port Quick Connect Plugs	Z	Blue
6TSDA	¾" British Taper (F)	8	2T	¼" BSPT (F)	2	Center	J	Port Hose Barbs		
8SDA	1" NPT (F)	10	3	⅜" NPT (F)	3	Right 45°				
8BSDA	1" British Parallel (F)	12	3B	⅜" BSPP (F)	4	Right Side				
8TSDA	1" British Taper (F)	16	3T	⅜" BSPT (F)						
12SDA	1½" NPT (F)		4	½" NPT (F)						
12BSDA	1½" British Parallel (F)		4B	½" BSPP (F)						
12TSDA	1½" British Taper (F)		4T	½" BSPT (F)						



Quick connect plugs and hose barbs are sized to match the ports. Contact the factory if different sizes or options are required. Ball valves are not recommended.

NOTE: For ¾" and 1" Manifolds, use port locations 1 & 3 or 0, 2, & 4 in combination for proper port spacing.

NOTE: Port locations 0 - 4 may be used in any combination on 1½" Aluminum Manifolds.

For paired installation, slide manifolds together using dovetail lock along the side of each manifold.

Please contact IMS for custom manifold configurations.

IMS Company

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Please refer to imscompany.com for current pricing

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MiniFold™
Steel, Straight-Through Manifolds

Made in the U.S.A

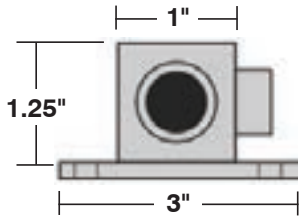
One Manifold with Many Uses!

All Inlet/Outlets And Ports Are The Same Size (⅜") To Maximize Versatility

Use with Water or Oil
- Perfect for use with smaller molds

Use with Air
- Great for use with robots and at work stations

Air Pressure Tested at 100 psi

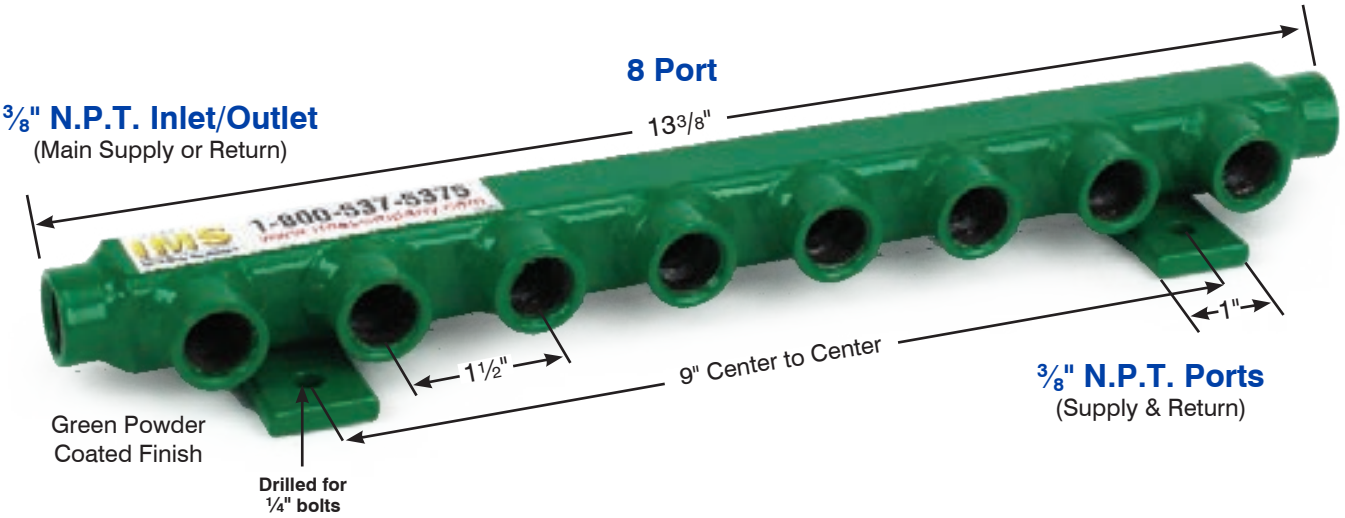


Compact Minifold™

For standard 8 port manifold see next page

8 Port

⅜" N.P.T. Inlet/Outlet
(Main Supply or Return)



Green Powder Coated Finish

Drilled for ¼" bolts

⅜" N.P.T. Ports
(Supply & Return)

Specifications and Prices

Item #	Ports	Material	Inlet/Outlet	Port Size	Port Spacing*	Mounting Hole Location*	OAL
138530	8	Steel	⅜" NPT	⅜" NPT	1½"	9"	13⅜"

*Center to center

Suggested Items	Description
138098	⅜" NPT Brass Socket Head Plug
105579	Pipe Thread Tape, 3.5 Mils, ½" Wide x 36 Yards

Same Day Shipment!

MiniFold™ is a trademark of IMS Company

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Made in the U.S.A

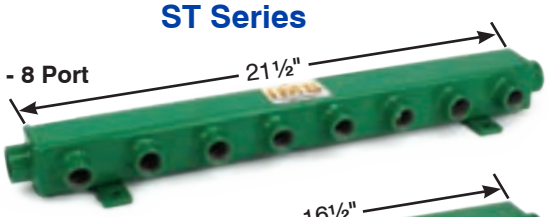
Injection Molding Water/Oil/Air Manifolds

Also good for: Compressed Air and Hot Oil (not pressurized)

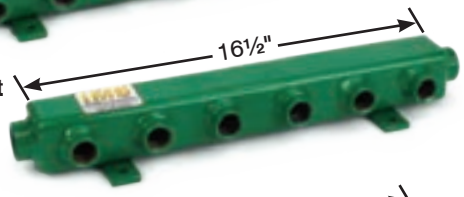
- Precision Welded
- Stocked in Stainless or Powder Coated Steel
- Stainless Steel is 14 Gauge Type 304 with 550°F max temp
- Powder Coated Steel is ⅛" thick CRS with 300°F max temp
- Air Pressure Tested @ 100 PSI
- Pre-Drilled Welded Mounting Tabs
- Styles: Straight-Through, High Volume Straight-Through and Split Bulkhead Styles
- Stocked in 4 to 12 ports

ST Series

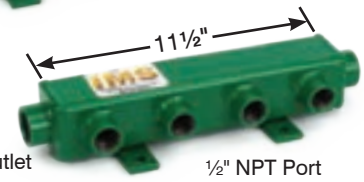
120751 - 8 Port 21½"



120745 - 6 Port 16½"



120716 - 4 Port 11½"



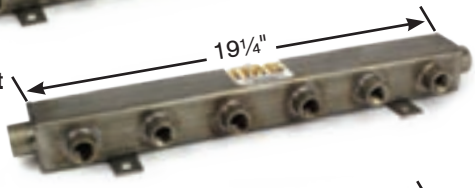
¾" NPT Inlet/Outlet

½" NPT Port

SS-ST Series

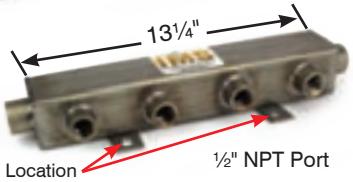
105546 - 8 Port 25¼"

105416 - 6 Port 19¼"



¾" or 1¼" NPT Inlet/Outlet

105529 - 4 Port 13¼"



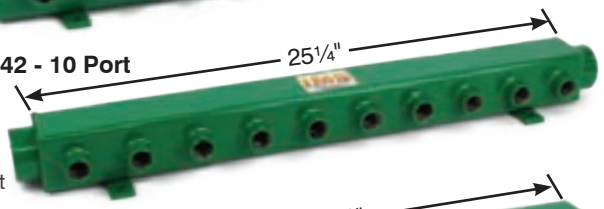
Mounting Hole Location (see chart below)

½" NPT Port

HV-ST Series

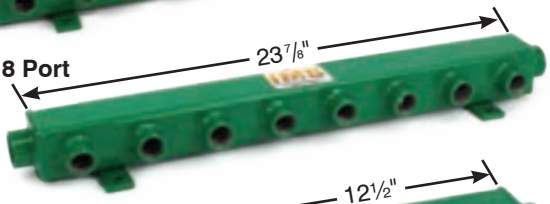
122303 - 12 Port 28¼"

120342 - 10 Port 25¼"



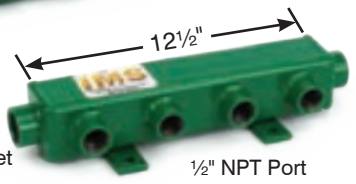
1½" NPT Inlet/Outlet

120744 - 8 Port 23⅞"



1¼" NPT Inlet/Outlet

120748 - 4 Port 12½"

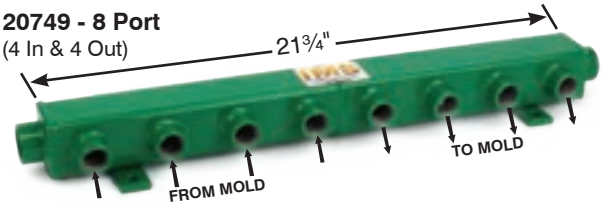


1" NPT Inlet/Outlet

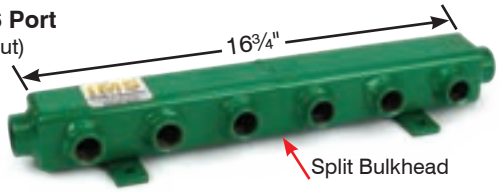
½" NPT Port

BH Series

#120749 - 8 Port (4 In & 4 Out) 21¾"

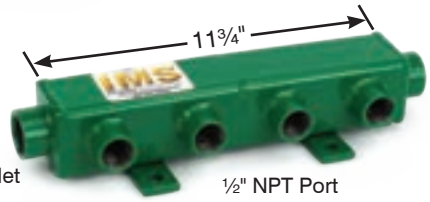


#120752 - 6 Port (3 In & 3 Out) 16¾"



Split Bulkhead

#120747 - 4 Port (2 In & 2 out) 11¾"



¾" NPT Inlet/Outlet

½" NPT Port

Series	Description	Tube Size Square	— Mounting Feet — L x W x Thick	Pre-Drilled Hole Size
ST	Steel Straight Through	2" x 2"	4" x 1" x ¼"	⅜"
SS-ST	Stainless Steel Straight Through	2" x 2"	4" x 1" x ⅛"	
HV-ST	High Volume Steel Straight Through	2½" x 2½"	4½" x 1" x ¼"	
BH	Steel Split Bulkhead (In-Out)	2" x 2"	4" x 1" x ¼"	

Please refer to imscompany.com for current pricing

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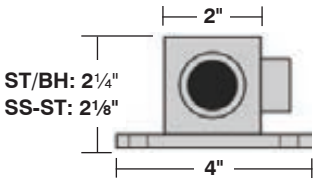
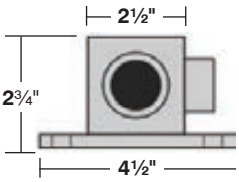
ST, SS-ST and BH Series "End View"

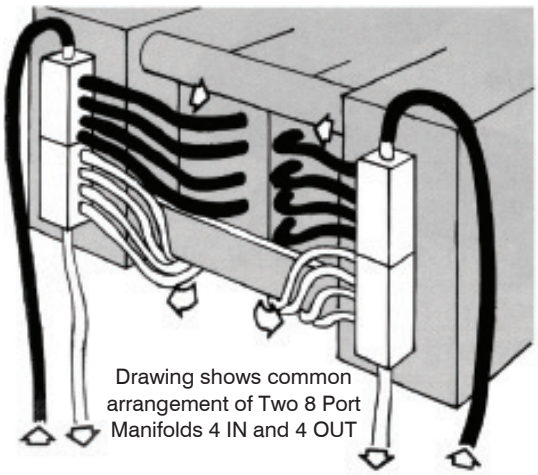


HV-ST Series "End View"



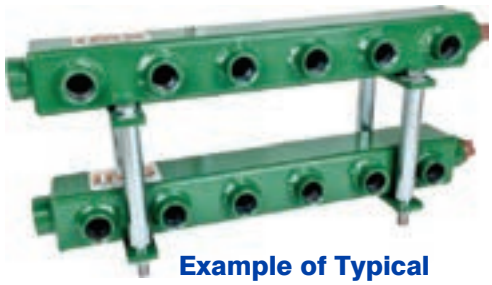
For best results, use Manifold Water Flow Control Valves only on RETURN Lines. This ensures keeping the mold water passages full at all times.

Typical Installation using Bulkhead Style Manifolds



(Recommended ball valve on return lines not shown).

⅜"-16 Thd.



Example of Typical Tandem Mount

Riser Kit for Tandem Mount

Includes (4) 6" Bolts, (4) 4½" Sleeves and (4) Washers

#101210: $25.30 ea.

Specifications

Item #	# of Ports	Material*	Series	Inlet/ Outlet	Port Size	Port Spacing†	Mounting Hole Location‡	OAL
120716	4	Steel	ST	¾" NPT	½" NPT	2½"	5⅛"	11½"
105529	4	Stainless	SS-ST	¾" NPT		3"	6"	13¼"
120748	4	Steel	HV-ST	1" NPT		3"	6¼"	12½"
160222	4	Stainless	SS-ST	1¼" NPT		3"	6"	13¼"
120745	6	Steel	ST	¾" NPT		2½"	10⅛"	16½"
105416	6	Stainless	SS-ST	¾" NPT		3"	12"	19¼"
160223	6	Stainless	SS-ST	1¼" NPT		3"	12"	19¼"
120751	8	Steel	ST	¾" NPT		2½"	15⅛"	21½"
105546	8	Stainless	SS-ST	¾" NPT		3"	18"	25¼"
160224	8	Stainless	SS-ST	1¼" NPT		3"	18"	25¼"
120744	8	Steel	HV-ST	1¼" NPT		3"	17¾"	23⅞"
120342	10	Steel	HV-ST	1½" NPT		2½"	19¼"	28¼"
122303	12	Steel	HV-ST	1½" NPT		2¼"	22¼"	30¼"
120747	2 in/2 out	Steel	BH	¾" NPT		2½"	5⅛"	11¾"
120752	3 in/3 out	Steel	BH	¾" NPT		2½"	10⅛"	16¾"
120749	4 in/4 out	Steel	BH	¾" NPT		2½"	15⅛"	21¾"

*Stainless steel is 14 gauge 304 type / Steel is ⅛" powder coated †Center to Center

Suggested Items:	Description
137835	½" NPT Male x Female Ball Valve
117871	½" Male x ⅜" Female NPT Bronze Hex Bushing Reducer
117897	½" NPT Bronze Square Head Plug
117889	¾" NPT Bronze Square Head Plug
117882	1" NPT Bronze Square Head Plug
117875	1¼" NPT Bronze Square Head Plug
117867	1½" NPT Bronze Square Head Plug
105579	Pipe Thread Tape, 3.5 Mils , ½" Wide x 36 Yards

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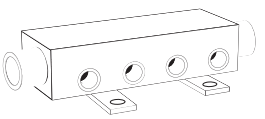
Manifold Styles

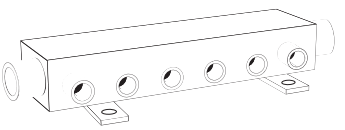
Straight-Through Style

High Volume Style

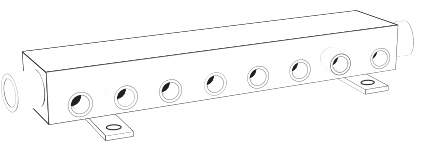


4 Port

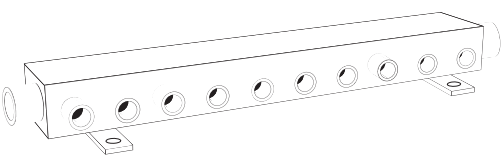
High Volume Straight-Through and Straight-Through Styles



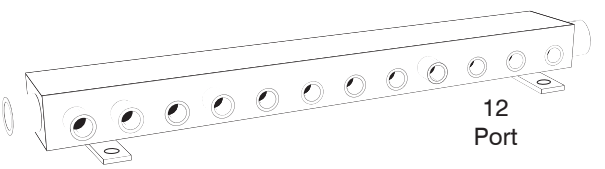
6 Port

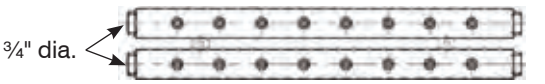
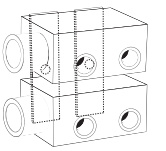


8 Port



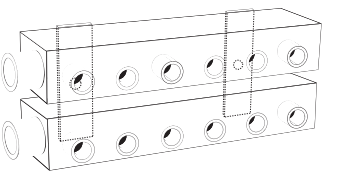
10 Port



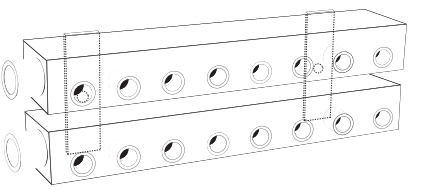
12 Port



4 Port (2 IN / 2 OUT)

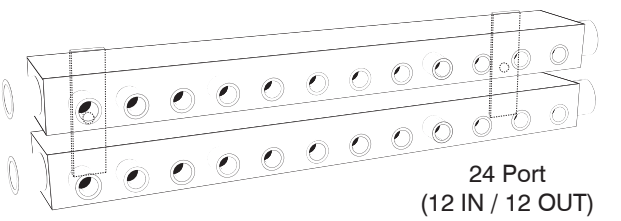
Stacked Style



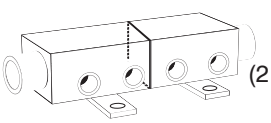
12 Port (6 IN / 6 OUT)



16 Port (8 IN / 8 OUT)

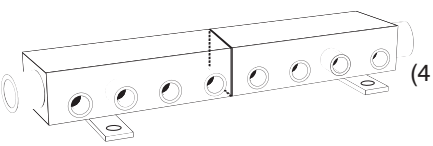


24 Port (12 IN / 12 OUT)

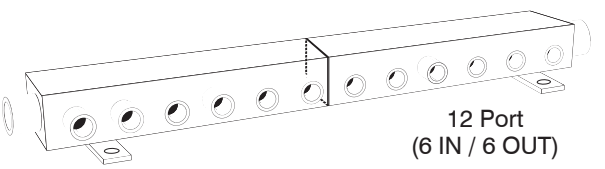


4 Port (2 IN / 2 OUT)

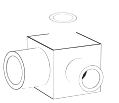
Split Bulkhead Style



8 Port (4 IN / 4 OUT)

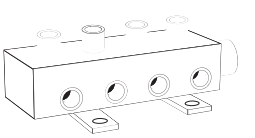


12 Port (6 IN / 6 OUT)

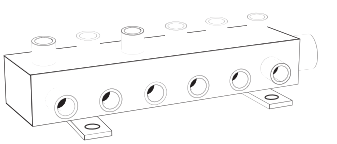


2 Port

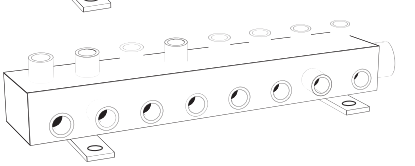
Multiple Sided Port Locations



8 Port



12 Port



16 Port

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

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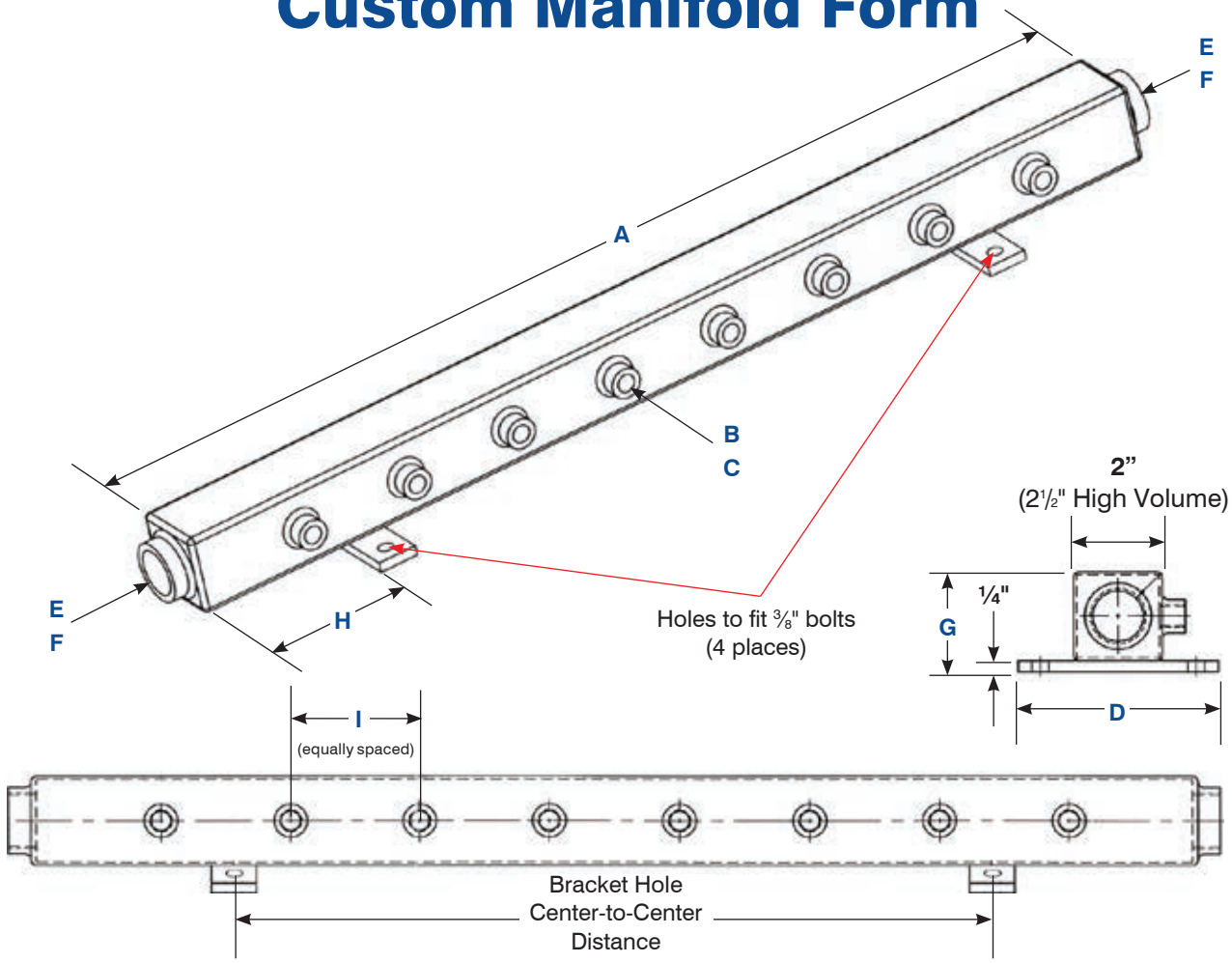
Custom Manifold Form



A) Overall Length: _____

B) Port Size (N.P.T.): _____ C) Number of Ports: _____

D) Width (includes mounting bracket): _____

E) Inlet/Outlet Size (N.P.T.): _____ F) Number of Inlet/Outlets: _____

G) Depth: _____ H) Mounting Bracket Distance: _____

I) Distance Between Ports (center-to-center): _____

J) Style: ❑ High Volume ❑ Straight-Through ❑ Split (Bulkhead) ❑ Stacked ❑ Multi-Sided Ports

K) Material: ❑ Stainless Steel ❑ Steel (Green) ❑ Steel (Custom Paint - Specify _____)

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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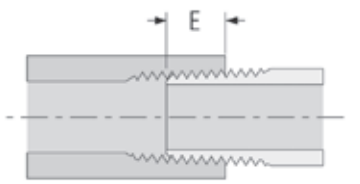
Tech Tips

Pipe Thread Data

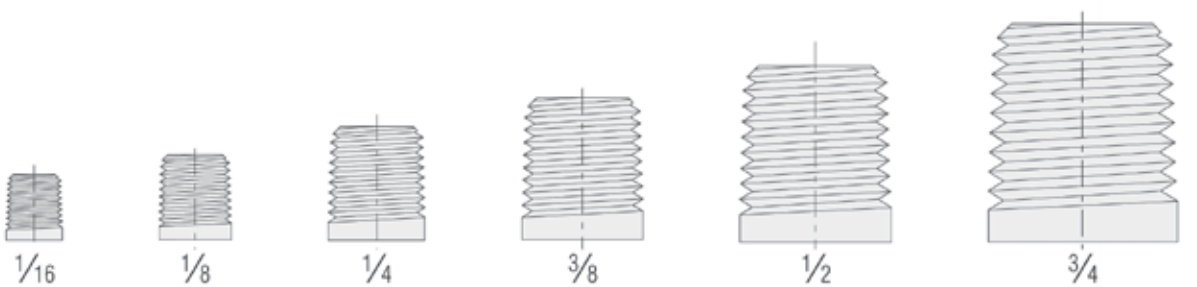
Most ordering mistakes are caused by measuring the pipe size of the fitting or component incorrectly. The nominal size of any pipe does not in fact refer to either the outside diameter (O.D.) or the inside diameter (I.D.) of the pipe. The table lists standard pipe sizes along with the actual O.D. and I.D. for each size. Keep in mind that manufacturers may slightly modify these dimensions to strengthen or enhance the performance of a product.

Pipe Size	Threads Per Inch	Outside Dia. of Pipe	Inside Diameter of Pipe	Tap Drill Size		E
				Without Ream	With Ream	
1/16	27	.312	.209	1/4	15/64	.261
1/8	27	.405	.269	11/32	21/64	.263
1/4	18	.540	.364	7/16	27/64	.395
3/8	18	.675	.493	9/16	9/16	.407
1/2	14	.840	.622	45/64	11/16	.534
3/4	14	1.050	.824	29/32	57/64	.545
1	11 1/2	1.315	1.049	1 9/64	1 1/8	.661
1 1/4	11 1/2	1.660	1.380	1 31/64	1 15/32	.681
1 1/2	11 1/2	1.900	1.610	1 23/32	1 45/64	.681
2	11 1/2	2.375	2.067	2 3/16	2 11/64	.697

Once the correct pipe size has been determined, the "E", dimension may be used to determine the length of the component required to assemble properly when fully tightened.



Pipes shown actual size



Check Out This Other Useful IMS Product!

IMS Hose and Fitting Sizer

Identify Hose I.D.

Identify Female Pipe Threads

Identify Male Pipe Threads

See more on page 383

Item No. 110658

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Socket Head Plug

N.P.T.	Black Steel	Galvanized	Brass
1/16"	143684	142790	142788
1/8"	146990	134540	135349
1/4"	146991	134541	135350
3/8"	146992	134542	138098
1/2"	146993	134543	129920
3/4"	146994	134544	142789
1"	146995	134545	135348*

*Bronze with square drive

Square Head Plug (male)

N.P.T.	Black Steel	Galvanized	Bronze
1/8"	146732	134536	132054
1/4"	146733	134537	117912
3/8"	146734	134538	117904
1/2"	131724	134539	117897
3/4"	131723	131585	117889
1"	146735	133403	117882
1 1/4"	146736	136434	117875
1 1/2"	134224	133412	117867
2"	132755	136435	146848

Hex Bushing

N.P.T. male x female	Black Steel	Galvanized	Bronze
1/4 x 1/8	134198	134860	132058
3/8 x 1/8	143685	147392	147427
3/8 x 1/4	132879	134497	117884
1/2 x 1/8	133475	134498	132057
1/2 x 1/4	132909	131584	117879
1/2 x 3/8	133486	134499	117871
3/4 x 1/8	146737	146665	132059
3/4 x 1/4	132911	136781	146851
3/4 x 3/8	131726	146666	117892
3/4 x 1/2	131725	134500	117900
1 x 1/4	131517	134501	146852
1 x 3/8	135414	134502	146853
1 x 1/2	132641	134503	117865
1 x 3/4	132642	131589	117863
1 1/4 x 1/4	143686	147393	147428
1 1/4 x 3/8	143687	147394	147429
1 1/4 x 1/2	133192	146667	146854
1 1/4 x 3/4	146738	136782	117887
1 1/4 x 1	131701	133399	117894
1 1/2 x 1/4	143688	147395	147430
1 1/2 x 3/8	143689	147396	147431

Hex Bushing (continued)

N.P.T. male x female	Black Steel	Galvanized	Bronze
1 1/2 x 1/2	143690	147397	147432
1 1/2 x 3/4	132694	134504	138159
1 1/2 x 1	132670	136783	117910
1 1/2 x 1 1/4	131784	129916	117902
2 x 3/8	143691	147398	N/A
2 x 1/2	143692	147399	147433
2 x 3/4	146739	146668	138152
2 x 1	132910	134505	146855
2 x 1 1/4	132758	134506	146856
2 x 1 1/2	132779	146669	146857
2 1/2 x 1/2	143693	147400	N/A
2 1/2 x 3/4	143694	147401	N/A
2 1/2 x 1	143695	147402	N/A
2 1/2 x 1 1/4	143696	147403	N/A
2 1/2 x 1 1/2	132686	146670	N/A
2 1/2 x 2	143697	147404	N/A

*RFQ=Request for Quote

Pipe Cap

N.P.T.	Black Steel	Galvanized	Bronze
1/8"	146740*	134532*	146858
1/4"	132881*	134533*	146859
3/8"	146741	134534	146860
1/2"	134948	134535	146861
3/4"	134949	146671	146862
1"	134950	136458	146863
1 1/4"	146742	136431	146864
1 1/2"	134225	136432	146865
2"	146743	136433	146866
2 1/2"	143698	147405	N/A

*hex style

Coupling

N.P.T.	Black Steel	Galvanized	Bronze
1/8"	133472	134528	143631
1/4"	133478	134529	143632
3/8"	133483	134530	147434
1/2"	132701	134531	146870
3/4"	132702	133400	146871
1"	132671	133402	146872
1 1/4"	132697	133407	146873
1 1/2"	132781	136436	146874
2"	132688	N/A	146875

continued on next page

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Fittings (Continued)

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Merchant Coupling

N.P.S.	Black Steel	Galvanized	Brass
1/8"	147325	147369	N/A
1/4"	147326	147370	N/A
3/8"	147327	147371	N/A
1/2"	147328	147372	N/A
3/4"	147329	147373	N/A
1"	147330	147374	N/A
1 1/4"	147331	147375	N/A
1 1/2"	N/A	147376	N/A
2"	147333	147377	N/A

Union

N.P.T.	Black Steel	Galvanized	Bronze
1/8"	147350	147416	147441
1/4"	133480	146706	146895
3/8"	133485	146707	146896
1/2"	132708	146708	146897
3/4"	132707	146709	146898
1"	132640	136459	146899
1 1/4"	147351	137401	146900
1 1/2"	132672	136443	146901
2"	131515	133414	146902

Reducing Coupling

N.P.T. female x female	Black Steel	Galvanized	Bronze
1/4 x 1/8	134967	133397	146876
1/4 x 3/8	134223	134507	146877
3/8 x 1/8	147334	147406	131118
1/2 x 1/8	133476	146673	146878
1/2 x 1/4	133481	134508	146879
1/2 x 3/8	133487	133398	146880
3/4 x 1/8	147335	147407	N/A
3/4 x 1/4	147336	146674	146881
3/4 x 3/8	147337	136761	146882
3/4 x 1/2	132703	134509	146883
1 x 1/4	147338	146675	N/A
1 x 3/8	147339	146676	146884
1 x 1/2	132704	134511	146885
1 x 3/4	131700	146677	146886
1 1/4 x 3/8	147340	147408	N/A
1 1/4 x 1/2	147341	147409	147435
1 1/4 x 3/4	147342	134242	146887
1 1/4 x 1	147343	134510	146888
1 1/2 x 3/8	147344	147410	N/A
1 1/2 x 1/2	147345	147411	147436
1 1/2 x 3/4	132695	137915	146889
1 1/2 x 1	132692	146678	146890
1 1/2 x 1 1/4	132693	146679	146891
2 x 1/2	147346	147412	147437
2 x 3/4	147347	147413	147438
2 x 1	134126	146680	146892
2 x 1 1/4	132753	146681	146893
2 x 1 1/2	147348	146682	147439
2 1/2 x 1 1/2	132687	147414	146894
2 1/2 x 2	147349	147415	147440

Female Elbow

N.P.T.	Black Steel	Galvanized	Bronze
1/8"	133471	134512	146923
1/4"	133477	134513	146924
3/8"	133482	134514	146925
1/2"	132699	134515	146926
3/4"	132696	131583	146927
1"	131516	134516	143639
1 1/4"	136797	129919	146929
1 1/2"	132676	133411	146930
2"	131513	147004	146931

Reducing Female Elbow

N.P.T. female x female	Black Steel	Galvanized	Bronze
1/4 x 1/8	N/A	N/A	147442
3/8 x 1/8	147352	147378	N/A
3/8 x 1/4	147353	147379	N/A
1/2 x 1/4	147354	147380	147443
1/2 x 3/8	147355	147381	147444
3/4 x 3/8	147356	147382	N/A
3/4 x 1/2	147357	147386	147445
1 x 1/2	147358	147387	N/A
1 x 3/4	147359	147388	147446
1 1/4 x 3/4	147360	147389	N/A
1 1/4 x 1	147361	147390	147447
1 1/2 x 3/4	147362	147391	N/A
1 1/2 x 1	147363	147417	147448
1 1/2 x 1 1/4	147364	147418	N/A
2 x 3/4	147365	147419	N/A
2 x 1	147366	147420	147449
2 x 1 1/4	147367	147421	N/A
2 x 1 1/2	147368	147422	N/A
2 1/2 x 1 1/2	147451	147423	N/A
2 1/2 x 2	147452	147424	N/A

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continued on next page

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Fittings (Continued)

Visit www.imscompany.com for current pricing

45° Female Elbow

N.P.T.	Black Steel	Galvanized	Bronze
1/8"	146751	134521	146932
1/4"	146752	134520	146933
3/8"	146753	146683	146934
1/2"	146754	146684	146935
3/4"	146755	146685	146936
1"	146756	146686	146937
1 1/4"	135294	142803	146938
1 1/2"	146757	146688	146939
2"	132759	146689	146940

Pipe Tee

N.P.T.	Black Steel	Galvanized	Bronze
1/8"	146765	134524	146914
1/4"	132880	134525	146915
3/8"	146766	134526	146916
1/2"	132698	146694	146917
3/4"	134903	134527	146918
1"	131518	135412	143640
1 1/4"	133693	134959	146920
1 1/2"	132665	134248	138153
2"	131511	133413	138169
2 1/2"	146767	146695	146921
3"	146768	146696	146922

Street elbow

N.P.T.	Black Steel	Galvanized	Bronze
1/8"	133479	134517	146903
1/4"	146758	134518	132920
3/8"	133484	134519	146904
1/2"	132706	146690	146905
3/4"	132705	133401	146906
1"	132643	135413	131587
1 1/4"	135295	136400	146907
1 1/2"	132677	147545	146908
2"	132689	136430	141763

Reducing Pipe Tee (Reducing On Branch)

N.P.T. run x branch	Black Steel	Galvanized	Bronze
1 1/2" x 1"	N/A	RFQ*	RFQ*
2" x 1"	133168	131588	RFQ*

*RFQ=Request for Quote

45° Street elbow

N.P.T.	Black Steel	Galvanized	Bronze
1/8"	146759	147546	146909
1/4"	146760	134522	146910
3/8"	146761	134523	146911
1/2"	146762	146691	146912
3/4"	146763	146692	138151
1"	146764	146693	146913
1 1/4"	147383	147425	146919
1 1/2"	147384	147426	146928
2"	147385	146687	147450

Pipe Cross

N.P.T.	Black Steel	Galvanized	Bronze
1/8"	146769	146697	N/A
1/4"	134128	146698	146941
3/8"	146770	146699	146942
1/2"	146771	146700	146943
3/4"	146772	146701	146944
1"	132709	146702	146945
1 1/4"	132690	146703	146946
1 1/2"	132789	146704	146947
2"	132691	146705	146948

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See Pipe Thread Sealant Compound on page 397

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Nipples

N.P.T.	Length	Black Steel	Galvanized	Brass
1/8"	CLOSE	132711	134546	132047
	1 1/2"	146773	134547	146949
	2"	132831	134548	146950
	2 1/2"	146774	134549	146951
	3"	132714	134550	146952
	3 1/2"	146775	134551	146953
	4"	132715	132919	132048
	4 1/2"	146776	146710	146954
	5"	146777	146711	146955
	5 1/2"	146778	134552	146956
	6"	146779	146712	132049
	8"	146787	131324	132050
	10"	RFQ*	RFQ*	142818
	12"	RFQ*	RFQ*	142852

N.P.T.	Length	Black Steel	Galvanized	Brass
1/4"	CLOSE	105938	131586	117874
	1 1/2"	146780	133404	138155
	2"	132844	134553	117898
	2 1/2"	146781	134554	138156
	3"	132712	134555	138157
	3 1/2"	146782	134556	138158
	4"	132713	134557	117890
	4 1/2"	146783	146713	146957
	5"	146784	134558	146958
	5 1/2"	146785	146714	146959
	6"	132845	131325	117881
	8"	146786	146715	132051

N.P.T.	Length	Black Steel	Galvanized	Brass
3/8"	CLOSE	105937	134559	117895
	1 1/2"	146788	134560	146960
	2"	146789	134561	117866
	2 1/2"	146790	146716	RFQ*
	3"	146791	146717	146962
	3 1/2"	146792	134562	146963
	4"	146793	146718	117911
	4 1/2"	146794	RFQ*	146964
	5"	146795	133409	146965
	5 1/2"	146796	146720	133142
	6"	146797	133410	117903

N.P.T.	Length	Black Steel	Galvanized	Brass
1/2"	CLOSE	105936	134563	117864
	1 1/2"	146799	134564	138160
	2"	146800	134565	117888
	2 1/2"	146801	RFQ*	138161
	3"	146802	136478	138162
	3 1/2"	146803	134566	138163
	4"	146804	136479	117880
	4 1/2"	146805	RFQ*	146966
	5"	146806	136481	146967
	5 1/2"	146807	136482	146968
	6"	146808	134567	117872
	8"	146809	146722	132052

*RFQ=Request for Quote

N.P.T.	Length	Black Steel	Galvanized	Brass
3/4"	CLOSE	105935	131590	117885
	1 1/2"	146810	134568	138164
	2"	146811	133405	117909
	2 1/2"	146812	133406	138165
	3"	134897	134569	138166
	3 1/2"	146813	134570	138167
	4"	146814	134571	117901
	4 1/2"	146815	146723	146969
	5"	146816	134572	146970
	5 1/2"	146817	146724	146971
	6"	146818	146725	117893

N.P.T.	Length	Black Steel	Galvanized	Brass
1"	CLOSE	105934	134573	117862
	2"	146825	136460	117886
	2 1/2"	146826	136461	144699
	3"	146827	136462	146973
	3 1/2"	146828	136463	146974
	4"	146829	136464	117878
	4 1/2"	146830	136465	146975
	5"	146831	136466	146976
	5 1/2"	146832	136467	146977
	6"	146833	136468	RFQ*

N.P.T.	Length	Black Steel	Galvanized	Brass
1 1/4"	CLOSE	108140	129917	117883
	2"	146834	133193	117907
	2 1/2"	146835	136437	146978
	3"	146836	136438	146979
	3 1/2"	146837	146726	146980
	4"	146838	136439	117899
	4 1/2"	146839	146727	146981
	5"	146840	136440	146982
	5 1/2"	146841	136441	146983
	6"	132757	136442	117891

N.P.T.	Length	Black Steel	Galvanized	Brass
1 1/2"	CLOSE	132669	134250	117905
	2"	146842	134249	117876
	2 1/2"	146843	136444	RFQ*
	3"	132730	136445	146985
	3 1/2"	146844	136446	146986
	4"	132731	136447	117868
	4 1/2"	146845	146728	146987
	5"	146846	136448	146988
	5 1/2"	146847	146729	146989
	6"	132790	136454	117861

N.P.T.	Length	Black Steel	Galvanized	Brass
2"	CLOSE	131514	136455	143674
	2 1/2"	143675	143679	138168
	3"	143676	136456	143681
	3 1/2"	143677	136457	143682
	4"	143678	143680	143683

N.P.T.	Length	Black Steel	Galvanized	Brass
3"	6"	RFQ*	RFQ*	141764

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e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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Full-Port Female/Female Ball Valves

Prevents Fluid Loss During Mold Changes

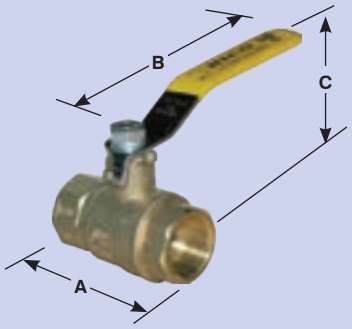
Certifications: NSF-61, CSA-AGA, UL, FM

Specifications and Prices

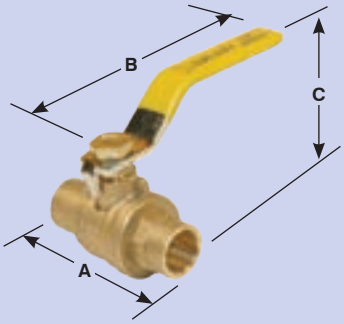
N.P.T.	Length (A)	Handle Length (B)	Height (C)	Item #
¼"	1.96"	3.43"	1.57"	103937
⅜"	1.96"	3.43"	1.57"	103778
½"	2.28"	3.35"	1.77"	101424
¾"	2.44"	3.35"	1.89"	103809
1"	3.03"	4.61"	2.20"	103803
1¼"	3.46"	4.61"	2.36"	105621
1½"	3.94"	6.30"	3.15"	105620
2"	4.45"	6.30"	3.15"	128071

Stainless Steel and Male x Female Valves Available — INQUIRE

- Durable forged brass construction
- Easy installation
- ¼ turn shut off
- Full-flow design
- Virgin PTFE seats and seals
- Blowout-proof stem
- Zinc-plated steel handle with plastic hand grip
- Chrome-plated ball
- Working pressure: 600 psi (water oil gas)
- Temperature range: 0°F to 300°F



Full-Port &
Full-Port Economy Female



Full-Port Economy
Solder

Full-Port Economy Female/Female Ball Valves

When Certification is Not Necessary

Specifications and Prices

N.P.T.	— Length — F x F (A)	Solder (A)	Handle Length (B)	Height (C)	Female x Female Item #	Solder Item #
¼"	1.69”	—	3.43”	1.83”	132668	N/A
⅜"	1.69”	—	3.43”	1.83”	132664	N/A
½"	1.89”	2.15”	3.43”	2.03”	135928	136104
¾"	2.28”	3.64”	3.70”	2.24”	135929	134240
1"	2.64”	3.27”	4.61”	2.48”	132666	136105
1¼"	3.11”	3.76”	4.61”	2.79”	132756	136106
1½"	3.58”	4.13”	5.59”	3.29”	132667	
2"	4.11”	4.84”	5.59”	3.62”	132729	136108

Stainless Steel and Male x Female Valves Available — INQUIRE

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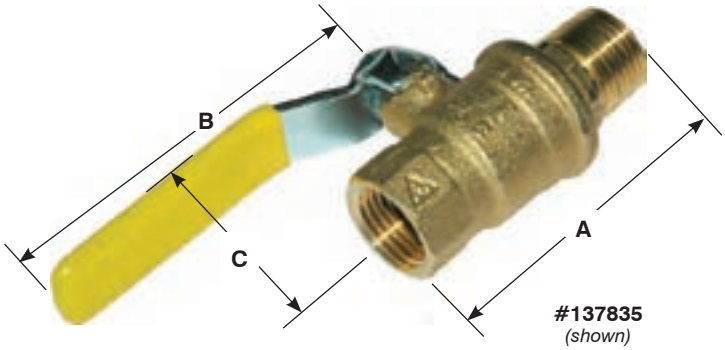
Full-Port Male/Female Ball Valves Standard

Prevents Fluid Loss During Mold Changes

- Deep threads
- Threaded ends conform to ANSI B 1.20.1
- Durable forged brass construction
- Easy installation
- ¼ turn shut off
- Full-flow design
- Virgin PTFE seats and seals
- Blowout-proof stem
- Zinc-plated steel handle with plastic hand grip
- Solid chrome plated ball
- Working pressure: 600 psi (water oil gas)
- Temperature range: 0° F to 300 F



#137835
(shown)

Specifications and Prices

N.P.T.	Length (A)	Handle Length (B)	Height (C)	Item #
¼"	2.05"	2.76"	1.69"	138279
⅜"	2.09"	3.54"	1.89"	138280
½"	2.34"	3.54"	2.05"	137835
¾"	2.62"	3.78"	2.20"	138281
1"	3.00"	4.53"	2.58"	138282
1¼"	3.56"	4.53"	2.95"	138283
1½"	3.97"	5.51"	3.35"	138284
2"	4.50"	5.51"	3.68"	138285

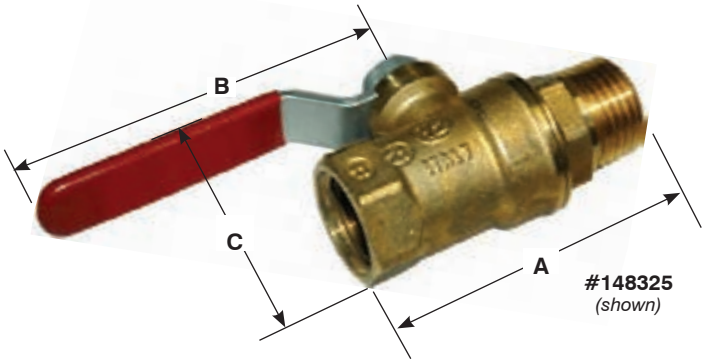
Stainless Steel Valves Available — INQUIRE

Low Profile Male/Female Ball Valves

Works Great When Port Clearance is an Issue With SmartFlow Aluminum Manifolds

Space Saving

- Heavy duty forged brass
- Threaded ends conform to ANSI B 1.20.1
- Great for steam, water, oil or gas applications
- Works great for IMS aluminum manifolds



#148325
(shown)

Specifications and Prices

N.P.T.	Pressure Rating	Length (A)	Handle Length (B)	Height (C)	Item #
⅛"	600 psi	1.87"	1.68"	1.44"	148323
¼"		1.95"	1.68"	1.44"	148321
⅜"		2.20"	3.01"	1.81"	148322
½"		2.50"	3.01"	1.91"	148325
¾"		2.87"	3.70"	2.51"	148324
1"	500 psi	3.37"	3.70"	2.87"	148326

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Mini Ball Valves

Ideal When Space is Restricted

- Chrome plated forged brass body
- Chrome plated brass ball
- NPT taper ANSI B1.20.1 threads
- 450 PSI working pressure
- 355 PSI @ 212°F
- 142 PSI @ 356°F
- ¼ turn alumzinc handle
- Not lead free

Specifications

Female x Female N.P.T.	Length (A)	Handle Length (B)	Height (C)	Item #
⅛"	1.57"	0.93"	1.46"	169514
¼"				167283
⅜"				169515
½"	1.77"		1.56"	169516

Male x Female N.P.T.	Length (A)	Handle Length (B)	Height (C)	Item #
⅛"	1.57"	0.93"	1.46"	169517
¼"				169518
⅜"				169519
½"	1.77"		1.56"	169520

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Self-Igniting Torch Heads

Brazing and Soldering

Item #168507

BERNZOMATIC® Torch Head

High Heat Model TS4000

Trigger-Activated Ignitor with
NON-Adjustable Flame Control

- Mapp/Propane Fuel
- Auto Start/Stop Ignition
- Standard Swirl Flame for Max Heat
- Trigger Lock to Keep Torch Burning
- Cast Aluminum Body

Item #168507

Item #168508

BERNZOMATIC® Torch Head

Premium Model TS8000

Trigger-Activated Ignitor with
Adjustable Flame Control

- Mapp/Propane Fuel
- Auto Start/Stop Ignition
- Ultra Swirl Flame for Max Heat
- Trigger Lock to Keep Torch Burning
- Pressure Regulated, Use Inverted
- Cast Aluminum Body

Item #168508

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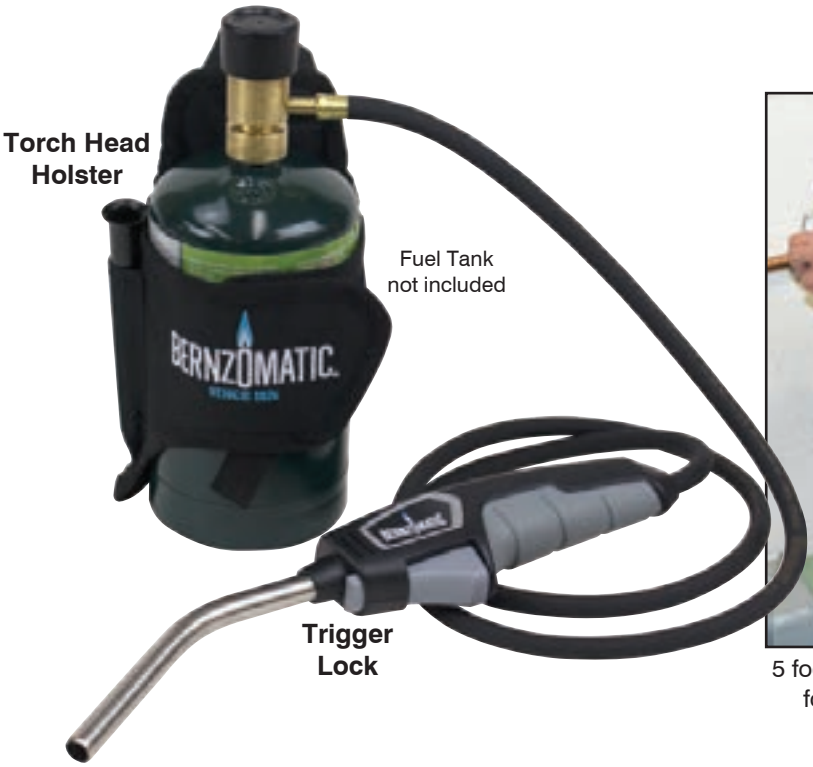
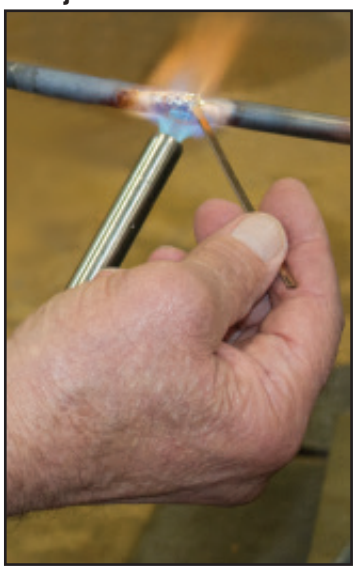
BERNZOMATIC®

Self-Igniting Torch Head Assembly for Maximum Accessability!



5 foot hose offers quick and maximum accessibility for hard to reach brazing and soldering areas

Adjustable flame control



Cylinder holster allows hands free convenience

Features:

- Mapp/Propane Fuel
- Auto Start/Stop Ignition
- Swirl Flame for Max Heat
- Trigger Lock to Keep Torch Burning
- Pressure Regulated, Use while Inverted
- Stainless Steel Burn Tube
- Cast Aluminum Body

BERNZOMATIC® Torch Head

Model BZ8250HT Assembly

Trigger-Activated Ignitor with
Adjustable Flame Control

Item #168509

Includes: 5' Hose and Fuel Holster*
*Fuel tank not included

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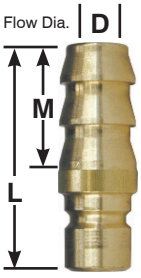
Quick Change Waterline Plugs

Specifications and Prices									
	200 Series (¼" passage)			300 Series (⅜" passage)			500 Series (½" passage)		
	Item #	Series	N.P.T.	Item #	Series	N.P.T.	Item #	Series	N.P.T.
Male Thread (Brass)									
	140201	250	1/16"	135360	351	1/8"	144525	552	1/4"
	105453	251	1/8"	105412	352	1/4"	144526	553	3/8"
	105549	252	1/4"	105519	353	3/8"	105376	554	1/2"
	105471	253	3/8"	105436	354	1/2"	105512	556	3/4"
Female Thread (Steel)									
	105421	251F	1/8"	105384	352F	1/4"	105538	554F	1/2"
	105525	252F	1/4"	105491	353F	3/8"	105484	556F	3/4"
	105445	253F	3/8"	144527	354F	1/2"			
Female Thread (Brass)									
	144528	250FB	1/16"	135366	351FB	1/8"	144529	551FB	1/8"
	112383	251FB	1/8"	112391	352FB	1/4"	144530	552FB	1/4"
	112389	252FB	1/4"	112388	353FB	3/8"	144531	553FB	3/8"
	135319	253FB	3/8"	105404	354FB	1/2"	144532	554FB	1/2"

*Valved Plugs require two-way valved sockets to operate — Inquire BSPT Available — Inquire

Tech Tips

When at all possible, waterlines on the mold should all enter and exit the rear of the mold (away from the operator). This saves on hoses looping under/over the mold as well as the time it takes to install them.



Combination Hose Inserts

Eliminates multiple fittings and assembly. Put a combination hose insert on one end of a hose and a coupler on the other. Hoses may then be snapped together in series.

For use with Push-Lok or standard hose

200 Series (¼" Passage)					300 Series (⅜" Passage)					500 Series (½" Passage)				
Item #	Hose I.D.	D	M	L	Item #	Hose I.D.	D	M	L	Item #	Hose I.D.	D	M	L
140584	1/4"	3/16"	7/8"	1 3/8"	140587	1/4"	3/16"	7/8"	1 13/16"	140589	1/2"	13/32"	11/16"	2"
140585	5/16"	1/4"	7/8"	1 3/8"	140588	5/16"	1/4"	7/8"	1 13/16"	140590	3/4"	1/4"	1 1/2"	2 1/2"
137990	3/8"	1/4"	1 1/16"	1 9/16"	135345	3/8"	9/32"	11/16"	1 13/16"					
					137989	1/2"	11/32"	11/16"	1 13/16"					

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Quick Change Waterline Extension Plugs

Brass Extension Plugs from IMS make mold setup and maintenance more convenient.

- Durable solid brass
- Rust-proof and leak-proof
- Quick to install, easy to remove

See IMSCompany.com for Pricing

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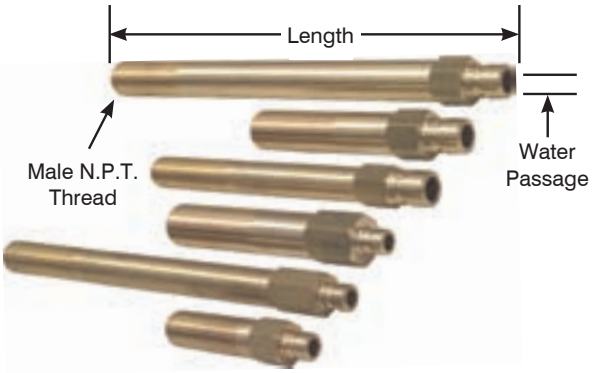

Specifications - Call for Prices

	200 Series (¼" Passage)			300 Series (⅜" Passage)			500 Series (½" Passage)		
	Item #	Series	Length	Item #	Series	Length	Item #	Series	Length
1/16" Male N.P.T. Thread	141736	250	2.5"	135376	350	2.5"	Available on Request		
	135342		4"	135363		4"			
	132157		5"						
	141737		5.5"	135364		5.5"			
	132156		7"	141739		7"			
	132155		8.5"						
⅛" Male N.P.T. Thread	122656	251	2.5"	129623	351	2.5"	Available on Request		
	122657		4"	129624		4"			
	122658		5.5"	135367		5.5"			
	122659		7"	137726		7"			
	122660		8.5"	134957		8.5"			
	135361		10"	141741		10"			
	141738		11.5"	141740		11.5"			
	144047		13"	144051		13"			
¼" Male N.P.T. Thread	122661	252	2.5"	122671	352	2.5"	Available on Request		
	122662		4"	122672		4"			
	122663		5.5"	122673		5.5"			
	122664		7"	122674		7"			
	122665		8.5"	122675		8.5"			
	135362		10"	134958		10"			
	137984		11.5"	141742		11.5"			
	144048		13"	138521		13"			
	163484		15"	138520		14"			
⅜" Male N.P.T. Thread	122666	253	2.5"	122676	353	2.5"	141746	553	2.5"
	122667		4"	122677		4"	137675		4"
	122668		5.5"	123493		5.5"			
	122669		7"	122679		7"	141748		7"
	122670		8.5"	122680		8.5"	141749		8.5"
				141744		10"			
	144049		11.5"	144052		11.5"			
				144053		13"	144057		13"
½" Male N.P.T. Thread	Available on Request			122681	354	2.5"	122686	554	2.5"
				122682		4"	122687		4"
				122683		5.5"	122689		5.5"
				122684		7"	122688		7"
				122685		8.5"	122690		8.5"
				141745		10"	141751		10"
				144054		11.5"	144058		11.5"
				144055		13"	144059		13"

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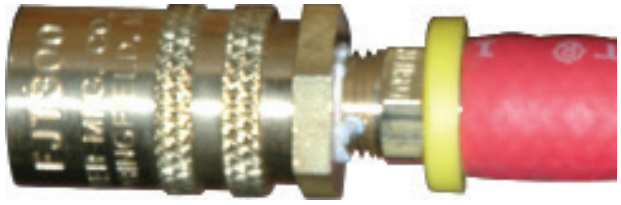
Quick Change, "Push-On" Barb-Type Waterline Hose Couplers

- Maximum pressure: 200 psi
- Temperature range: -90°F to 400°F
- Brass and stainless steel construction
- Compatible with all mold connectors
- Available with automatic shut-off to prevent fluid from draining out when disconnected

WARNING: Non-valved couplers offer no protection from fluids draining out when disconnected. Use extreme caution, especially with hot fluids.

No hose clamp needed
when used with "Push-On" Hose



Specifications and Prices

	200 Series (¼" Passage)		300 Series (⅜" Passage)		500 Series (½" Passage)	
	Item #	Hose I.D.	Item #	Hose I.D.	Item #	Hose I.D.
	Straight (Non-Valved)					
	101186	¼"	101203	⅜"	101150	½"
	101165	⅜"	101182	½"	134383	¾"
	Straight (Valved)*					
	101173	¼"	101195	⅜"		
	101154	⅜"	101169	½"		
	45° (Non-Valved)					
	101172	¼"	101189	⅜"	138875	½"
	101152	⅜"	101166	½"		
	45° (Valved)*					
	101163	¼"	101177	⅜"		
	101213	⅜"	101157	½"		
	90° (Non-Valved)					
	101214	¼"	101161	⅜"	128054	½"
	127741	⅜"	101209	½"	134962	¾"
	90° (Valved)*					
	101205	¼"	101148	⅜"		
	101185	⅜"	101200	½"		

*The valved couplers on this page are not compatible with valved plugs. 2-way valved couplers available - Inquire

See Standard Barb-Type Waterline Hose Couplers on next page

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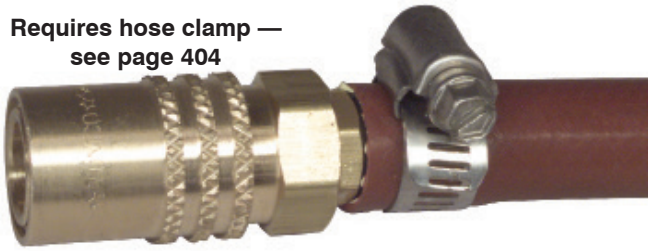
Standard Barb-Type Waterline Hose Couplers

Made in the U.S.A

- Maximum pressure: 200 psi
- Temperature range: -90°F to 400°F
- Brass and stainless steel construction
- Compatible with all mold connectors
- Available with automatic shut-off to prevent fluid from draining out when disconnected

WARNING: Non-valved couplers offer no protection from fluids draining out when disconnected. Use extreme caution, especially with hot fluids.



Requires hose clamp — see page 404

Specifications and Prices

	200 Series (¼" Passage)		300 Series (⅜" Passage)		500 Series (½" Passage)	
	Item #	Hose I.D.	Item #	Hose I.D.	Item #	Hose I.D.
	Straight (Non-Valved)					
	105496	¼"	105551	⅜"	122929	½"
	105382	⅜"	105502	½"	105540	¾"
			108205	½" HF		
	Straight (Valved)*					
	105467	¼"	105527	⅜"		
	105542	⅜"	105448	½"		
	45° (Non-Valved)					
	105536	¼"	105465	⅜"	123342	½"
	105424	⅜"	105407	½"	132044	¾"
			138876	½" HF		
	45° (Valved)*					
	105510	¼"	105439	⅜"		
	105393	⅜"	105379	½"		
	90° (Non-Valved)					
	105517	¼"	105414	⅜"	123187	½"
	105402	⅜"	105545	½"	132045	¾"
			108218	½" HF		
	90° (Valved)*					
	105489	¼"	105386	⅜"		
	105373	⅜"	105494	½"		

*The valved couplers on this page are not compatible with valved plugs. 2-way valved couplers available - Inquire

Tech Tips

When ordering water fittings, always match the coupler series with the plug series to ensure a proper fit.

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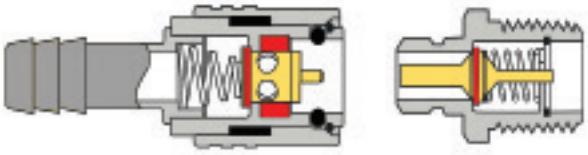
Two-Way Valved Mold Coolant Couplers and Plugs

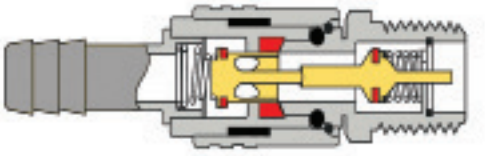
Automatic Shut-Off At Mold Minimizes Mold Coolant Leaks

Avoid Downtime

— Valves Closed —



— Valves Open —



Item #	Description	Series
Two-Way Valved Mold Coolant Couplers		
169998	200 Series, ¼" Straight Push-On Barb	204V2P
169999	200 Series, ⅜" Straight Push-On Barb	206V2P
148221	300 Series, ⅜" Straight Push-On Barb	306V2P
170000	300 Series, ⅜" 90° Push-On Barb	316V2P
147599	300 Series, ⅜" 45° Push-On Barb	326V2P
170001	300 Series, ½" Straight Push-On Barb	308V2P
167015	300 Series, ½" 90° Push-On Barb	318V2P
170002	500 Series, ½" Straight Push-On Barb	504V2P
170003	500 Series, ¾" Straight Push-On Barb	506V2P
Two-Way Valved Mold Coolant Plugs		
144672	200 Series, ¼" Male NPT	252V2
170010	200 Series, ⅜" Male NPT	253V2
170011	300 Series, ¼" Male NPT	352V2
138096	300 Series, ⅜" Male NPT	353V2
167016	300 Series, ½" Male NPT	354V2
170012	500 Series, ⅜" Male NPT	553V2
170013	500 Series, ½" Male NPT	554V2
Two-Way Valved Mold Coolant Extension Plugs Available — Inquire		

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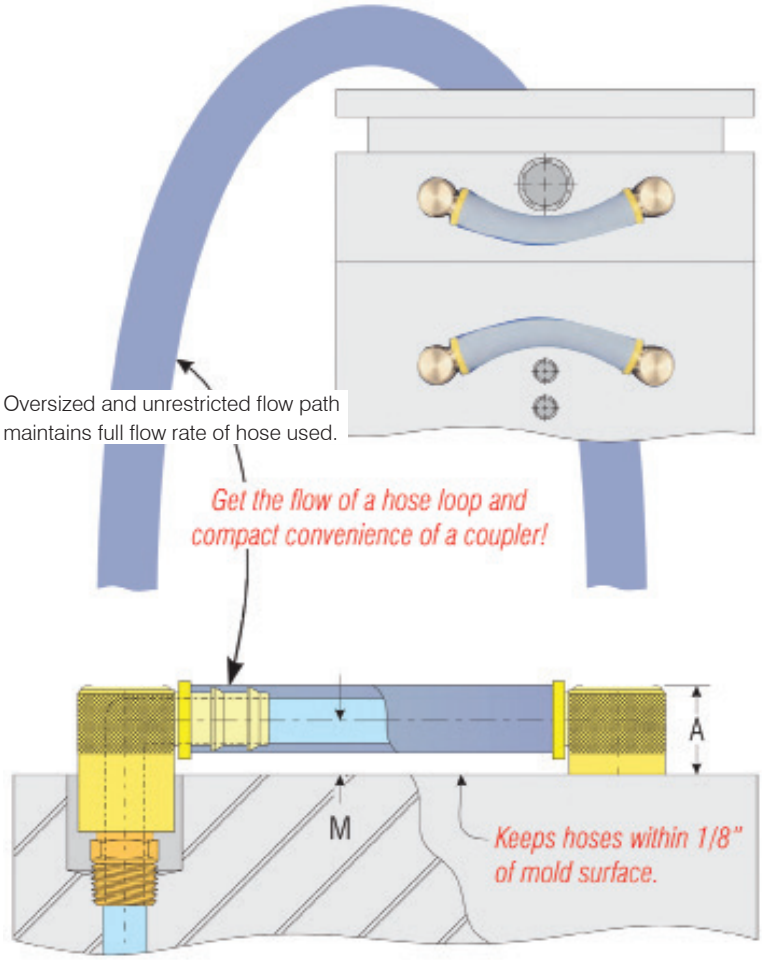
Quick-Coupler Type Water Jumpers

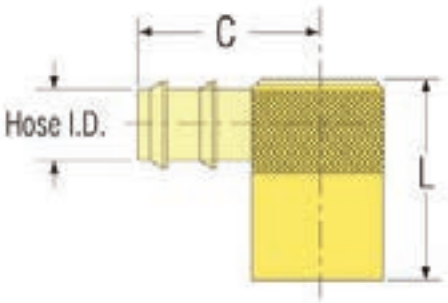
Get The Flow of a Hose Loop and Compact Convenience of a Coupler



Coupler sleeve twists to lock, preventing accidental disconnect

No hose clamp needed when used with "Push-On" Hose

- Compact design neatly and safely holds cooling lines close to the mold surface.
- Exclusive Locking Sleeve prevents accidental disconnect and ensures proper installation.
- Unlimited installation options. Fits around obstacles and installs in compact spaces.
- Viton® Seals provide for temperatures up to 400°F.
- All brass and stainless steel construction.
- Compatible with all major mold connection systems.



Specifications and Prices

200 Series (¼" Passage)

Item #	Hose I.D.	L	C	M	A
138045	¼"	1"	1¼"	⅜"	⅝"
135358	⅜"	1"	1¼"	⅜"	⅝"

300 Series (⅜" Passage)

Item #	Hose I.D.	L	C	M	A
135331	⅜"	1 7/16"	1 9/16"	½"	⅞"
135359	½"	1 7/16"	1 9/16"	½"	⅞"

500 Series (½" Passage)

Item #	Hose I.D.	L	C	M	A
142284	½"	2⅛"	2"	⅞"	1 5/16"
142285	¾"	2⅛"	2"	⅞"	1 5/16"

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Coupler Replacement Parts

Silicone Replacement Seal

For use with Water/Glycol (-90° F to 400°F)

Specifications and Prices		
200 Series (¼" Passage)	300 Series (⅜" Passage)	500 Series (½" Passage)
Item #	Item #	Item #
105438	105406	105378

Viton Replacement Seal

For use with Oil (-20° F to 400°F)

Specifications and Prices		
200 Series (¼" Passage)	300 Series (⅜" Passage)	500 Series (½" Passage)
Item #	Item #	Item #
134858	125403	165653

Coupler Accessory

Stop Plug

Specifications and Prices		
200 Series (¼" Passage)	300 Series (⅜" Passage)	500 Series (½" Passage)
Item #	Item #	Item #
133720	133605	133606

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IMS Hose and Fitting Sizer

Made Exclusively by IMS for Injection Molders

Made in the U.S.A

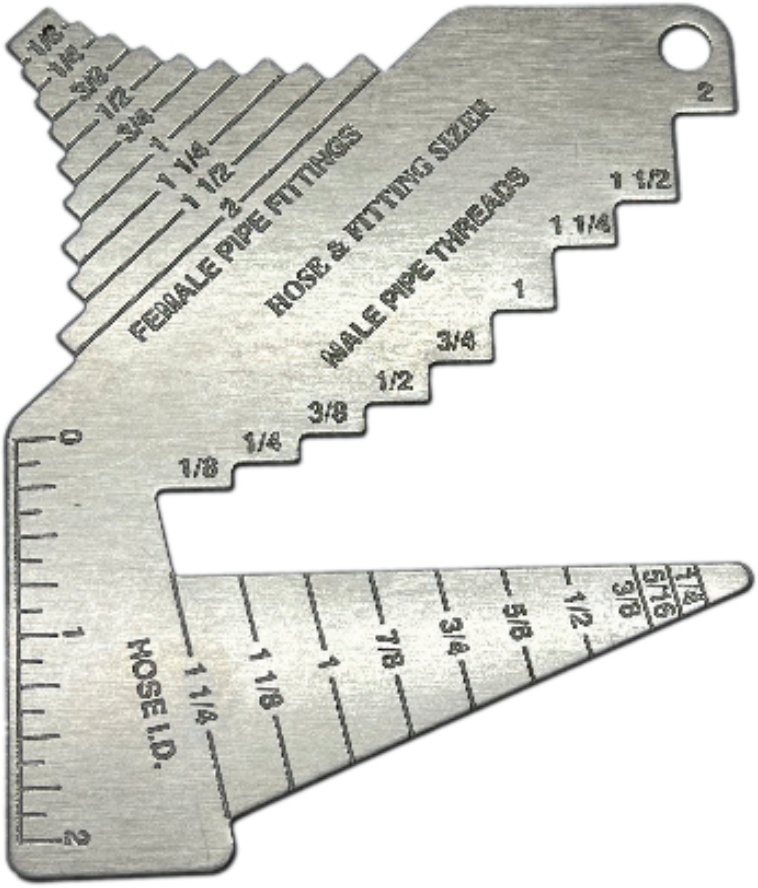
For fast, accurate hose I.D. and pipe thread identification

- Easy to use, compact
- Decrease Installation time
- Great for mold setup and maintenance

Durable 22 Gauge Stainless Steel

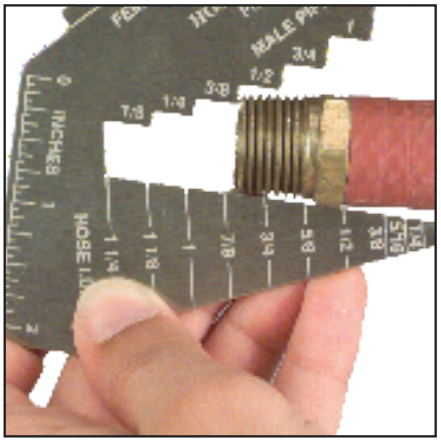
With etched numbers and lettering

Item No. 110658



Identify Hose I.D.

Identify Female Pipe Threads



Identify Male Pipe Threads

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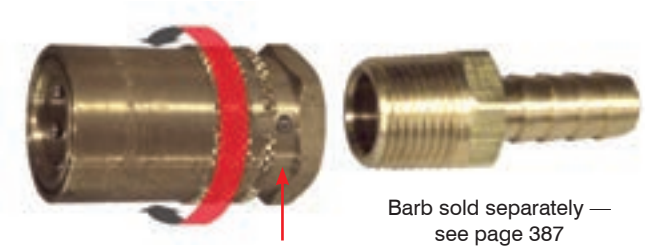
Quick Change, Positive, Sleeve-Lock Waterline Sockets

Prevents Injuries Caused By Accidental Disconnection

- Sleeve must be turned manually to lock or unlock
- Provides visual indication of lock
- Silicone seal resists destructive effects of water, glycol and air
- Durable brass construction resists corrosion
- 10 psi pressure drop at 68° F
- Non-valved*, straight-through style



Barb sold separately — see page 387

*WARNING: Non-valved sockets offer no protection from fluids draining out when disconnected. Use extreme caution, especially with hot fluids.

Sleeve detent must be turned (either direction) to line up with ball in socket body to unlock and allow socket to disconnect. Turn sleeve between 1/4 and 1/2 around for effective lock.

Specifications and Prices

Temperature Range: -90° F to 400° F (-68° C to 205° C)
Max. Pressure: 200 psi (14.06 Kg/sq.cm)

200 Series (¼" Passage)			300 Series (⅜" Passage)			500 Series (½" Passage)		
Item #	GPM at 10 psi	N.P.T. Thread	Item #	GPM at 10 psi	N.P.T. Thread	Item #	GPM at 10 psi	N.P.T. Thread
Sleeve-Lock, Non-Valved								
			120919	12.5	¼" female			
120922	3.9	⅛" female	125103*	17	⅜" female	120915	27	½" female
Ask about Viton® seals for higher chemical resistance								

* ⅜" high flow socket with Viton® seal allows 37% greater flow than standard ⅜" socket

Quick Change, Non-Lock Waterline Sockets

Specifications and Prices

Temperature Range: -90°F to 400°F (-68°C to 205°C)
Max. Pressure: 200 psi (14.06 Kg/sq.cm)

200 Series (¼" Passage)		300 Series (⅜" Passage)		500 Series (½" Passage)	
Item #	N.P.T. Thread	Item #	N.P.T. Thread	Item #	N.P.T. Thread
Non-Lock, Non-Valved					
107579	⅛" female	108189	¼" female	108219	½" female
138080	¼" female	136362*	⅜" female		
Non-Lock, Valved					
107577	⅛" female	108228	¼" female	RFQ**	
Ask about Viton® seals for higher chemical resistance					

*⅜" high flow socket allows 37% greater flow than standard ⅜" socket **Request for Quote

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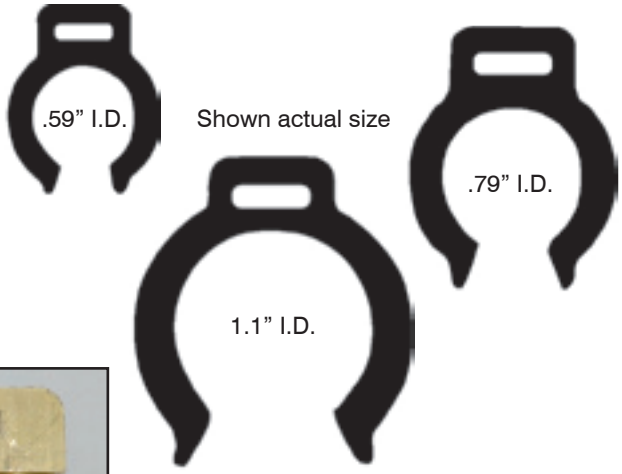
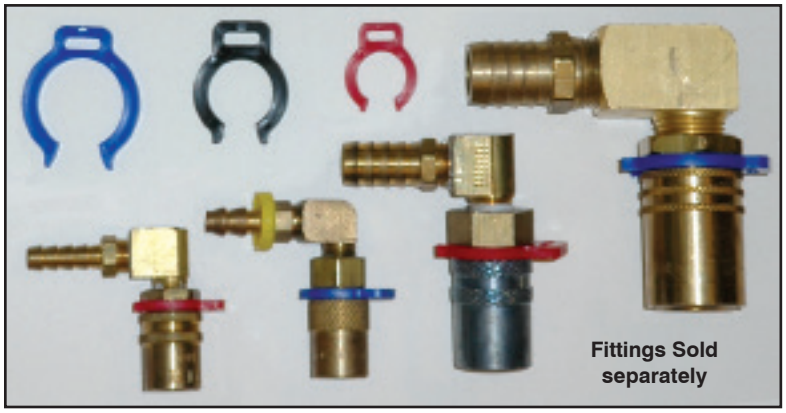
Quick Change Waterline Socket Locking Clips

Made in the U.S.A

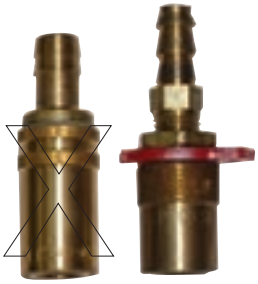
Simply slide clips into the groove behind the releasing sleeve to prevent accidental disconnection of quick change fittings.

- No tools necessary
- Polypropylene clips
- Fit D-M-E, Jiffy-Tite, Jiffy-Matic, Parker, OBAC, Foster, TOMCO and IMS Fittings



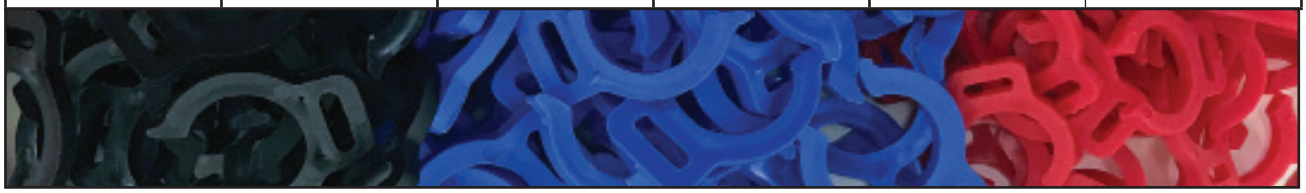


Note: Couplers must have a hex or rim to seat against for clips to be effective.



Specifications and Prices

Series	Coupler Size	ID	Thickness	Color	Item #
200	1/4"	0.560"	0.110"	Red	136469
				Blue	136472
				Black	136475
300	3/8"	0.790"	0.140"	Red	136470
				Blue	136473
				Black	136476
500	1/2"	1.050"	0.150"	Red	136471
				Blue	136474
				Black	136477



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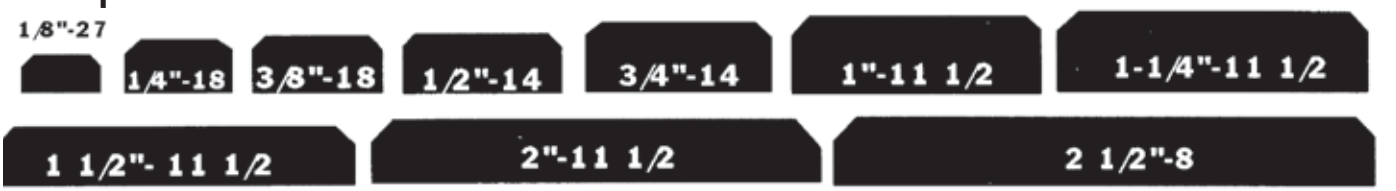
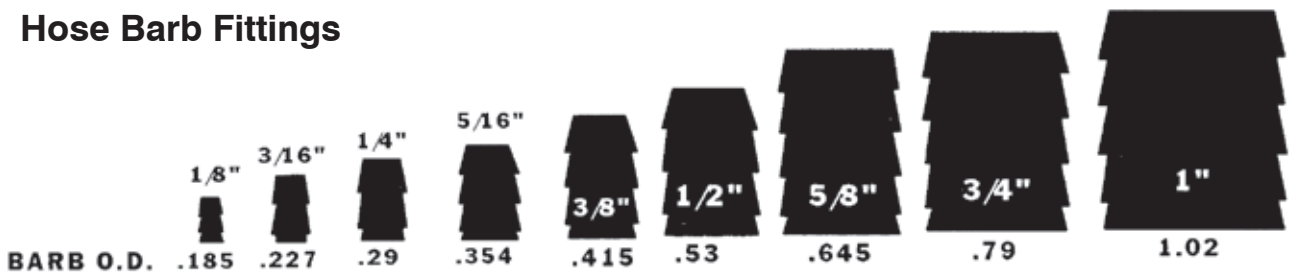
Thread Profiles

Pipe Threads



Hose Barb Fittings

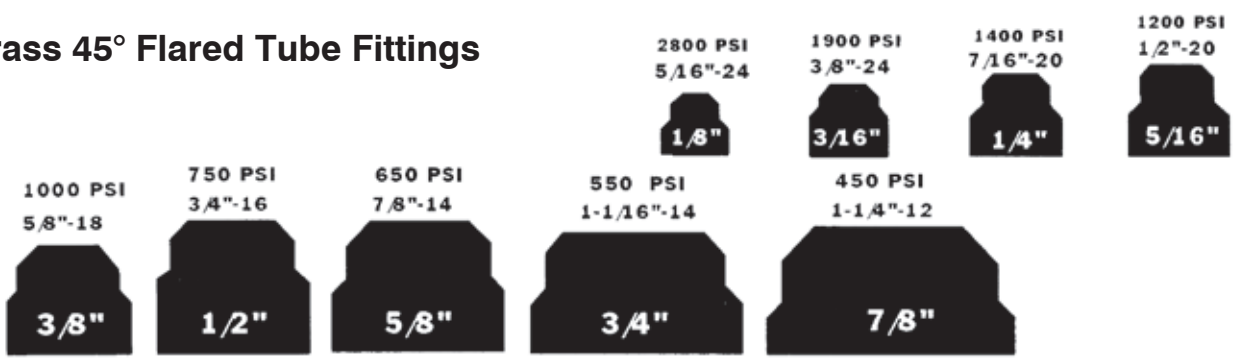


Push On Fittings

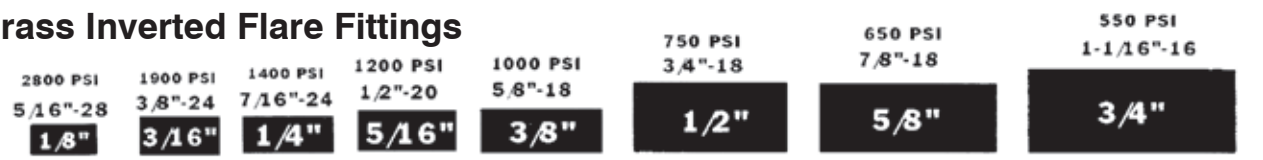
Garden Hose Fittings

Male garden hose threads are ¾" with O.D. of 1.0625 and 11½ threads per inch

Brass 45° Flared Tube Fittings



Brass Inverted Flare Fittings



Brass Compression Fittings

Tubing O.D. Size

Please refer to imscompany.com for current pricing

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Standard & Push-On Barbed Hose Fittings

Specifications and Prices

Hose I.D.	N.P.T. Male Thread (Brass)	Push-on Hose Fitting Item #	Standard Hose Fitting Item #
1/8"	1/8"	N/A	165504
1/4"	1/8"	136618	105521
1/4"	1/4"	101201	105466
1/4"	3/8"	136619	105394
3/8"	1/8"	136620	105495
3/8"	1/4"	101192	105440
3/8"	3/8"	101179	105552
3/8"	1/2"	101416	105503
1/2"	1/4"	107450	105425
1/2"	3/8"	101167	105528
1/2"	1/2"	101207	105474
1/2"	3/4"	130668	136600
5/8"	1/2"	136621	105449
5/8"	3/4"	136622	136601
3/4"	1/2"	136623	105415
3/4"	3/4"	136624	134019
3/4"	1"	N/A	136602
1"	3/4"	N/A	136603
1"	1"	135467	108188
1 1/4"	1"	N/A	128417
1 1/4"	1 1/4"	N/A	108227
Female Thread (Brass)			
1/4"	1/8"	136626	136604
1/4"	1/4"	101162	105374
1/4"	3/8"	136627	136605
3/8"	1/8"	136628	136606
3/8"	1/4"	136629	105537
3/8"	3/8"	101149	105511
3/8"	1/2"	136630	136607
1/2"	1/4"	136631	136608
1/2"	3/8"	136632	105482
1/2"	1/2"	101211	105457
1/2"	3/4"	136633	
5/8"	1/2"	136634	136609
3/4"	1/2"	136636	136610
3/4"	3/4"	136637	136611
1"	3/4"	N/A	136640
1"	1"	138287	123148
Hose Menders/Splicers (Brass)			
1/4"	N/A	101199	136612
3/8"	N/A	101187	136613
1/2"	N/A	101175	136614
5/8"	N/A	136638	136615
3/4"	N/A	136639	136616
1"	N/A	N/A	136617

Push-On Hose Fitting

Standard Hose Fitting
Requires hose clamp — see page 404

Push-On Hose Fitting

Standard Hose Fitting
Requires hose clamp — see page 404

Push-On Hose Mender

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Steel Barb-Type Hose Fittings

For Fluid Service Only

Combination Nipples are a versatile means of transitioning from hose to pipe, adaptors, valves or strainers!

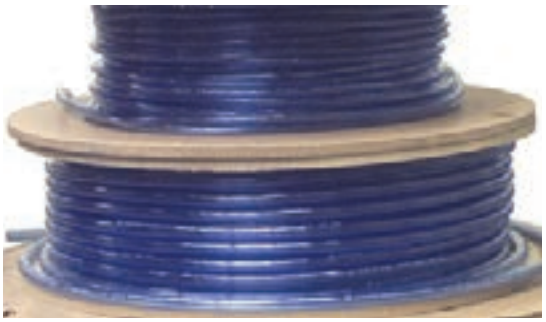
Plated to prevent rust

Specifications and Prices	
Item #	**Hose Barb / N.P.T. Thread**
132718	½"
132719	¾"
135411	1"
133195	1¼"
133194	1½"
134973	2"

Push-To-Connect Tubing

Use with IMS "Push-To-Connect" Brass Fittings. Select from three different materials, depending on the application temperature.

- Polyurethane: -40° F to 180° F
- Nylon: -65° F to 200° F
- Polyethylene: -40° F to 140° F



Specifications and Prices				
Item #	**Tube O.D.**	**Tube I.D.**	**Wall Thickness**	**Min. Burst at 73° F**
Flexible Polyurethane				
118052	¼"	0.156"	0.047"	428 psi
118050	⅜"	0.250"	0.063"	428 psi
118054	½"	0.328"	0.172"	428 psi
High Pressure Nylon				
105469	¼"	0.180"	0.035"	1000 psi
105443	⅜"	0.275"	0.050"	1000 psi
Instrument Grade Polyethylene				
107453	3⁄16"	0.127"	0.030"	400 psi
105524	⅜"	0.250"	0.062"	400 psi
105498	½"	0. 375"	0.125"	400 psi

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Please refer to imscompany.com for current pricing

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Barstock Brass Fittings

Visit www.imscompany.com for current pricing

45° STreet Elbow

N.P.T.	N.P.T.	Brass
1/8"	1/8"	147453
1/4"	1/4"	147454
3/8"	3/8"	147455
1/2"	1/2"	147456
3/4"	3/4"	147457

90° Street Elbow

N.P.T.	N.P.T.	Brass
1/8"	1/8"	135353
1/4"	1/4"	135352
3/8"	3/8"	132060
1/2"	1/2"	133389
3/4"	3/4"	147458

45° Elbow

N.P.T.	N.P.T.	Brass
1/8"	1/8"	147464
1/4"	1/4"	147465

90° Elbow

N.P.T.	N.P.T.	Brass
1/8"	1/8"	147459
1/4"	1/4"	147460
3/8"	3/8"	147461
1/2"	1/2"	147462
3/4"	3/4"	147463
1"	1"	168502

Tee

N.P.T.	N.P.T.	Brass
1/8"	1/8"	147466
1/4"	1/4"	147467
3/8"	3/8"	147468
1/2"	1/2"	147469
3/4"	3/4"	147470
1"	1"	168503

Branch Tee

N.P.T.	N.P.T.	Brass
1/8"	1/8"	147471
1/4"	1/4"	147472
3/8"	3/8"	147473
1/2"	1/2"	147474
3/4"	3/4"	147475

Street Tee

N.P.T.	N.P.T.	Brass
1/8"	1/8"	147476
1/4"	1/4"	147477
3/8"	3/8"	147478
1/2"	1/2"	147479
3/4"	3/4"	147480

Cross

N.P.T.	N.P.T.	Brass
1/8"	1/8"	147481
1/4"	1/4"	147482
3/8"	3/8"	147483
1/2"	1/2"	147484
3/4"	3/4"	147485

Hex Coupling

N.P.T.	N.P.T.	Brass
1/8"	1/8"	146867
1/4"	1/4"	146868
3/8"	3/8"	146869
1/2"	1/2"	146972
3/4"	3/4"	147486
1"	1"	168501

Extender-Adapter (Female x Male)

N.P.T.	N.P.T.	Brass
1/8"	1/8"	147487
1/4"	1/8"	147488
1/4"	1/4"	147489
3/8"	1/8"	147490
3/8"	1/4"	147491
3/8"	3/8"	147492
1/2"	1/4"	147493
1/2"	3/8"	147494
1/2"	1/2"	147495
3/4"	3/8"	147496
3/4"	1/2"	147497
3/4"	3/4"	147498

Hex Nipple

N.P.T.	N.P.T.	Brass
1/8"	1/8"	147499
1/4"	1/8"	147500
1/4"	1/4"	147502
3/8"	1/8"	147501
3/8"	1/4"	147503
3/8"	3/8"	135297
1/2"	1/4"	147504
1/2"	3/8"	147505
1/2"	1/2"	135296
3/4"	1/2"	147506
3/4"	3/4"	147507
1"	1"	147508

Barstock Brass Fittings
Quantity Discount

Order 25 or more Deduct 5%

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Straight Through Brass Couplers and Nipples

with Buna-N Seals

Comparable with Parker "ST Series"

NOTE: Mix and Match Couplers and Nipples by Body Size / Hose I.D.

Couplers (Female Thread)

Item #	Body Size	N.P.T.
135440	1/8"	1/8-27"
138613	1/4"	1/4-18"
138614	3/8"	3/8-18"
138615	1/2"	1/2-14"
134975	3/4"	3/4-14"
131321	1"	1-11 1/2"
132859*	1"	1-11 1/2"
129921	1 1/4"	1 1/4-11 1/2"
138616	1 1/2"	1 1/2-11 1/2"

* with Sleeve-Lock

Nipples (Male Thread)

Item #	Body Size	N.P.T.
138617	1/8"	1/8-27"
138618	1/4"	1/4-18"
138619	3/8"	3/8-18"
134977	1/2"	1/2-14"
136815	3/4"	3/4-14"
131323	1"	1-11 1/2"
128416	1 1/4"	1 1/4-11 1/2"
138620	1 1/2"	1 1/2-11 1/2"

Couplers (Male Thread)

Item #	Body Size	N.P.T.
138621	1/8"	1/8-27"
138622	1/4"	1/4-18"
138623	3/8"	3/8-18"
138624	1/2"	1/2-14"
138625	3/4"	3/4-14"
131429	1"	1-11 1/2"
Not Available		

Nipples (Female Thread)

Item #	Body Size	N.P.T.
138626	1/8"	1/8-27"
138627	1/4"	1/4-18"
138628	3/8"	3/8-18"
134976	1/2"	1/2-14"
134978	3/4"	3/4-14"
131431	1"	1-11 1/2"
129922	1 1/4"	1 1/4-11 1/2"
138629	1 1/2"	1 1/2-11 1/2"

Couplers with Standard Hose Barb

Item #	Hose I.D.
142231	1/4"
142232	3/8"
138076	1/2"
138077	3/4"
131430	1"

Nipples with Standard Hose Barb

Item #	Hose I.D.
142233	1/4"
142234	3/8"
142235	1/2"
142236	3/4"
131432	1"

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Pneumatic Couplers

Universal Interchange Automatic Couplers

Made in the U.S.A

- Automatic Couplers accept plugs/nipples without sleeve retraction like Manual Couplers
- Universal Couplers are compatible with Industrial Interchange and ARO 210/310 Series Plugs/Nipples (Pages 393/394) Also compatible with a variety of Plugs/Nipples by Parker, Hansen, Tomco and others
- Machined components manufactured using solid brass bar stock
- Stainless steel balls, retaining rings, and springs maximize corrosion resistance and extend service life
- Seals are Nitrile (Buna-N) pneumatically energized seals are standard, temperature range of -40°F to +250°F (-40°C to +121°C)

UF Series

Brass Couplers (Female Thread)		
Item #	**Body Size**	**N.P.T.**
137966	1/4"	1/4" - 18
132838	1/4"	3/8" - 18
132839	3/8"	3/8" - 18

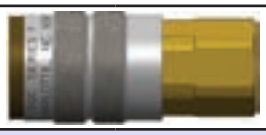
UM Series

Brass Couplers (Male Thread)		
Item #	**Body Size**	**N.P.T.**
135434	1/4"	1/4" - 18
133996	1/4"	3/8" - 18
133998	3/8"	3/8" - 18

General Purpose Industrial Interchange Manual Couplers

- Manual Couplers must have sleeve manually retracted to accept and eject plug/nipple
- Industrial Interchange Couplers are compatible with Industrial Interchange Plugs/Nipples (Page 437)
- Stainless steel balls, retaining rings, and springs maximize corrosion resistance and extend service life
- 1/4" manual couplers constructed of brass with steel sleeve and steel tubular valve as standard
- 3/8" and 1/2" manual couplers constructed of steel as standard with steel tubular valve
- Seals are Nitrile (Buna-N) seals are standard, providing a temperature range of -40°F to +250°F (-40°C to +121°C)

FF Series

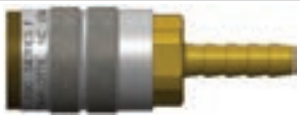


Manual Coupler (Female Thread)			
Item #	**Body Size**	**N.P.T.**	**Material**
138600	1/4"	1/8" - 27	Brass
129960		1/4" - 18	
129962		3/8" - 18	
138601	3/8"	1/4" - 18	Steel
135385		3/8" - 18	
135307		1/2" - 14	
136820	1/2"	3/8" - 18	
136819		1/2" - 14	
138606		3/4" - 14	

FM Series

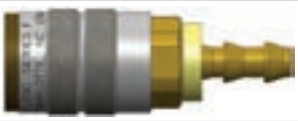
Manual Coupler (Male Thread)			
Item #	**Body Size**	**N.P.T.**	**Material**
138602	1/4"	1/8" - 27	Brass
129961		1/4" - 18	
129963		3/8" - 18	
138603	3/8"	1/4" - 18	Steel
138214		3/8" - 18	
138605		1/2" - 14	
138607	1/2"	3/8" - 18	
135308		1/2" - 14	
138608		3/4" - 14	

FS Series



Manual Coupler w/Standard Hose Barb			
Item #	**Body Size**	**Hose I.D.**	**Material**
143641	1/4"	1/4"	Brass
138609		3/8"	
135384	3/8"	3/8"	Steel
135465		1/2"	
138610	1/2"	3/8"	
136818		1/2"	
138611		3/4"	

FB Series



Manual Coupler w/Push-On Hose Barb*			
Item #	**Body Size**	**Hose I.D.**	**Material**
138245	1/4"	1/4"	Brass
129964		3/8"	
135415	3/8"	1/4"	Steel
138612		3/8"	
135416	1/2"	1/2"	
135417		3/8"	
135418		1/2"	

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Made in the U.S.A

Pneumatic Couplers

General Purpose Industrial Interchange Automatic Couplers

- Automatic Couplers accept plugs/nipples without sleeve retraction like Manual Couplers
- Industrial Interchange Couplers are compatible with Industrial Interchange Plugs/Nipples (Page 393)
- Stainless steel balls, retaining rings, and springs maximize corrosion resistance and extend service life
- Automatic couplers constructed of brass with steel sleeve and steel tubular valve as standard (⅜" to ¾" couplers have steel prong valves)
- Seals are Nitrile (Buna-N) seals are standard, providing a temperature range of -40°F to +250°F (-40°C to +121°C)

DF Series

Automatic Coupler (Female Thread)			
Item #	Body Size	N.P.T.	Material
142249	¼"	⅛" - 27	Brass
128055		¼" - 18	
142250		⅜" - 18	
142251	⅜"	¼" - 18	
142252		⅜" - 18	
142253		½" - 14	
142254	½"	⅜" - 18	
142255		½" - 14	
142256		¾" - 14	

DM Series

Automatic Coupler (Male Thread)			
Item #	Body Size	N.P.T.	Material
142264	¼"	⅛" - 27	Brass
142265		¼" - 18	
142266		⅜" - 18	
142268	⅜"	⅜" - 18	
142269		½" - 14	
142270		⅜" - 18	
142271	½"	½" - 14	
142272		¾" - 14	

DS Series

Automatic Coupler w/Standard Hose Barb			
Item #	Body Size	Hose I.D.	Material
142257	¼"	¼"	Brass
142259		⅜"	
142820	⅜"	¼"	
142260		⅜"	
142261		½"	
165183	½"	⅜"	
142262		½"	
142263		¾"	

DB Series

Automatic Coupler w/Push-On Hose Barb*			
Item #	Body Size	Hose I.D.	Material
138246	¼"	¼"	Brass
142274		⅜"	
142275	⅜"	⅜"	
142276	½"	½"	

*Push-On Barbs are for use with Push-On Hose which if used in conjunction eliminates the need for a hose clamp. **See Page 400** for IMS High Quality Push-On Hose.

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General Purpose Industrial Interchange Plugs/Nipples

Made in the U.S.A

For use with all Industrial Interchange Couplers Series – UF, UM, FF, FM, FS, FB, DF, DM, DS and DB.
Not compatible with ARO Series Couplers, refer to page 394 for ARO Plugs and Couplers

Specifications

Temp Range: -40°F to +250°F (-40°C to +121°C)

Body Size	Coupler/Plug Combination		
	Brass Coupler/Steel Plug	Brass Coupler/Brass Plug	Steel Coupler/Steel Plug
	Max Working PSI		
¼"	500	300	500
⅜"			
½"			
¾"			

DFP Series

Nipple/Plug (Female Thread)

Item #	Body Size	N.P.T.	Material
138814	¼"	⅛" - 27	Steel
129954		¼" - 18	
129955		⅜" - 18	
138815	⅜"	¼" - 18	
138816		⅜" - 18	
138817		½" - 14	
138818	½"	⅜" - 18	
138819		¾" - 14	

DMP Series

Nipple/Plug (Male Thread)

Item #	Body Size	N.P.T.	Material
138820	¼"	⅛" - 27	Steel
129957		¼" - 18	
134895		⅜" - 18	
135470	⅜"	¼" - 18	
135309		⅜" - 18	
136753		½" - 14	
165184	½"	¼" - 18	
138821		⅜" - 18	
138822		½" - 14	
138823		¾" - 14	

DSP Series

Nipple/Plug w/Standard Hose Barb

Item #	Body Size	Hose I.D.	Material
134353	¼"	¼"	Steel
133233		⅜"	
165185	⅜"	¼"	
135312		⅜"	
135466		½"	
138824	½"	⅜"	
129959		½"	
138825		¾"	

DBP Series

Nipple/Plug w/Push-On Hose Barb*

Item #	Body Size	Hose I.D.	Material
138826	¼"	¼"	Steel
129956		⅜"	
138827	⅜"	⅜"	
136821	½"	½"	

*Push-On Barbs are for use with Push-On Hose which if used in conjunction eliminates the need for a hose clamp.
See Page 400 for IMS High Quality Push-On Hose.

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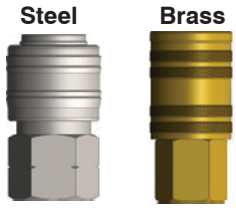
Made in the U.S.A

General Purpose ARO Series Manual & Automatic Couplers, Plug/Nipples

- Automatic Couplers accept plugs/nipples without sleeve retraction like Manual Couplers
- ARO 210 (1/4") and ARO (3/8") Interchange
- Machined components are manufactured using solid steel or brass bar stock
- Automatic couplers constructed of brass
- Stainless steel balls, retaining rings, pins and springs maximize corrosion resistance and extend service life
- Manual couplers constructed of steel
- Seals are Nitrile (Buna-N) seals are standard, providing a temperature range of -40°F to +250°F (-40°C to +121°C)

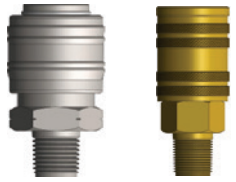
ARO Coupler (Female Thread)

Item #	Series	Body Size	N.P.T.	Material	Sleeve
132770	210	1/4"	1/4" - 18	Brass	Manual
131326				Steel	Auto
138598			3/8" - 18		
135311	310	3/8"			



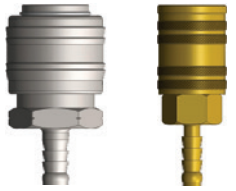
ARO Coupler (Male Thread)

Item #	Series	Body Size	N.P.T.	Material	Sleeve
125644	210	1/4"	1/4" - 18	Brass	Manual
138209				Steel	Auto
138599			3/8" - 18		
142819	310	3/8"			



ARO Coupler w/Standard Hose Barb

Item #	Series	Body Size	Hose I.D.	Material	Sleeve
135339	210	1/4"	1/4"	Brass	Manual
132837				Steel	Auto
131387			3/8"		
129918	310	3/8"			



ARO Nipple/Plug (Female Thread)

Item #	Series	Body Size	N.P.T.	Material	Sleeve
131328	210	1/4"	1/4" - 18	Steel	—
134022	310	3/8"	3/8" - 18		—

ARO Nipple/Plug (Male Thread)

Item #	Series	Body Size	N.P.T.	Material	Sleeve
134018	210	1/4"	1/8" - 27	Steel	—
131327			1/4" - 18		—
129995	310	3/8"	3/8" - 18		—

ARO Nipple/Plug w/Standard Hose Barb

Item #	Series	Body Size	Hose I.D.	Material	Sleeve
137039	210	1/4"	1/4"	Steel	—
134592			3/8"		—
131319	310	3/8"			—

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Hydraulic Quick Couplings

Manual Sleeve Poppet Valves

Double Shut-Off - Compatible with Parker 60 Series

NOTE: Match Couplers and Plugs by Body/NPTF Size

— Standard Size —

Stainless Steel Coupler

Stainless Steel Nipple

Zinc Plated Steel Coupler

Zinc Plated Steel Nipple

Zinc Plated Steel Coupler

Zinc Plated Steel Nipple

Specifications

ISO 7241, Series B Interchange

	Buna Seal*			Viton Seal**			
Temp Range	-40 Deg F to +225° F			-15 Deg F to +400° F			
Material Rated Pressure PSI							
Body Size	⅛"	¼"	⅜"	½"	¾"	1"	1½"
ZP Steel	5000	5000	4000	4000	2500	2000	1000
Brass	1000	1000	1000	1000	1000	1000	800
Stainless Steel	2000	2000	1500	1500	1500	1000	1000

*For use with petroleum based oil or water **For use with petroleum based oil only
To use couplers and plugs up to 300° F water temp, request EPDM seals - INQUIRE

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Standard Size Hydraulic Couplers

Body/ NPTF Size	Rated Flow GPM	Zinc Plated Steel w/Buna	Zinc Plated Steel w/Viton	Brass w/Buna	Brass w/Viton	Stainless Steel 303 w/Viton
⅛"	1	134106	163289	163293	163302	143600
¼"	3	133971	147622	163294	163303	126257
⅜"	6	133502	147620	163295	163304	126258
½"	12	131917	128421	163296	163305	126259
¾"	28	137035	163131	150559	163270	126260
1"	50	131787	163290	161551	163306	147551

Standard Size Hydraulic Nipples

Body/ NPTF Size	Rated Flow GPM	Zinc Plated Steel w/Buna	Zinc Plated Steel w/Viton	Brass w/Buna	Brass w/Viton	Stainless Steel 303 w/Viton
⅛"	1	134107	163291	163297	163307	143659
¼"	3	133972	147621	163298	163308	126253
⅜"	6	133503	147619	163299	163309	126254
½"	12	131916	128422	163300	163310	126255
¾"	28	137036	163130	150560	163271	126256
1"	50	131786	163292	163301	163311	147552

Large Size Hydraulic Couplers

Body/ NPTF Size	Rated Flow GPM	Zinc Plated Steel w/Buna	Zinc Plated Steel w/Viton	Brass w/Buna	Brass w/Viton	Stainless Steel 303 w/Viton
1-½" x 1-¼"	100	137033	163323	163327	163331	RFQ
1-½" x 1-½"	100	137034	163324	163328	163332	RFQ

Large Size Hydraulic Nipples

Body/ NPTF Size	Rated Flow GPM	Zinc Plated Steel w/Buna	Zinc Plated Steel w/Viton	Brass w/Buna	Brass w/Viton	Stainless Steel 303 w/Viton
1-½" x 1-¼"	100	137037	163325	163329	163333	RFQ
1-½" x 1-½"	100	137038	163326	163330	163334	RFQ

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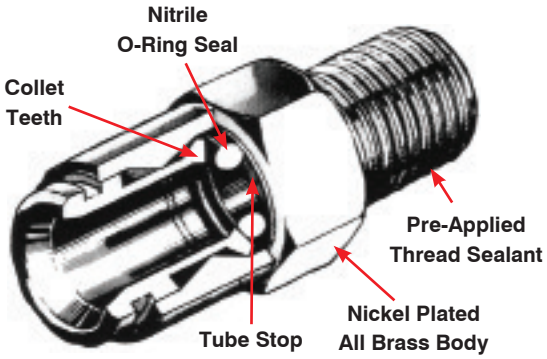
"Push-To-Connect" Tube Fittings

For Permanent Tubing and Manifolding

- Pre-applied thread sealant and Nitrile O-ring seal prevents leaks
- Durable, nickel plated, all brass body
- Nitrile O-ring seal
- Maximum temperature: 200° F
- Maximum pressure: 270 psi



Purchasers also order:

- Push-to-Connect Tubing, page 388

To connect: Push tubing into the fitting until it will go no further. This will secure and seal the tube.

To disconnect: Push the tube in all the way with one hand. With the other hand, push in release collet with thumb and index finger. Pull tube out.

Specifications and Prices

Item #	Tube O.D.	N.P.T. Thread
Male Connector (Tube to Male Pipe)		
147288	1/4"	1/8"
147289	1/4"	1/4"
147290	3/8"	1/8"
147291	3/8"	1/4"
147292	3/8"	3/8"
147293	1/2"	1/4"
147294	1/2"	3/8"
147295	1/2"	1/2"
Male Elbow (Tube to Male Pipe)		
147305	1/4"	1/8"
147306	1/4"	1/4"
147307	3/8"	1/4"
147308	3/8"	3/8"
147309	1/2"	3/8"
147310	1/2"	3/8"
147311	1/2"	1/2"
Manifolding Elbow Tee (Tube to Male Pipe)		
147312	1/4"	1/8"
147313	1/4"	1/4"
147314	1/4"	3/8"
147315	3/8"	1/4"
147316	3/8"	3/8"
147317	1/2"	3/8"
147318	1/2"	1/2"

Specifications and Prices

Item #	Tube O.D.	N.P.T. Thread
Manifolding Tee (Tube to Male Pipe)		
147319	1/4"	1/8"
147320	1/4"	1/4"
147321	3/8"	1/4"
147322	3/8"	3/8"
147323	1/2"	3/8"
147324	1/2"	1/2"
Union (Tube to Tube)		
147302	1/4" to 1/4"	
147303	3/8" to 3/8"	
147304	1/2" to 1/2"	
Elbow Union (Tube to Tube)		
147299	1/4" to 1/4"	
147300	3/8" to 3/8"	
147301	1/2" to 1/2"	
Tee Union (Tube to Tube)		
147296	1/4" to 1/4"	
147297	3/8" to 3/8"	
147298	1/2" to 1/2"	

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

IMS Company

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fax order toll-free (USA & Canada) 1.888.288.6900 | phone order toll-free (Mexico) 001.888.304.1307 | tech support toll-free (USA & Canada) 1.866.467.9001 | e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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Sealants

Keep Fasteners and Pipe Joints Tight! Help Prevent Costly Down Time!

Pipe Thread Sealant Compound

- Contains PTFE
- Non-hardening
- Non-toxic
- Positive seal
- Prevents corrosion
- Withstands hydraulic pressures up to 10,000 psi

Specifications and Prices

Temperature Range: -35°F to 550°F Color: White
Density (specific gravity): 1.2

Item #	Description
132710	Pipe Thread Sealant Compound (16 oz.)

Thread Sealant Tape with PTFE

- Mil-Spec # MIL-T-27730A
- Meets USDA and FDA requirements
- Seals against gas, air, oil and water
- Resists chemicals, corrosives, caustics and solvents
- Prevents leakage
- Resists high heat
- Seals effectively in 2 or 3 wraps
- Withstands hydraulic pressures up to 10,000 psi

Specifications and Prices

Temperature Range: -400°F to 550°F Color: White
Width: ½"

Item #	Description	Density	Length
105579	Medium Density Thread Sealant Tape with PTFE	0.7 to 0.8	108’
101180	Low Density Thread Sealant Tape with PTFE	0.4 to 0.5	108’

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Cam & Groove Couplings

Perfect for Applications Requiring Quick Disconnect, Positive Sealing Couplers

Features

- Positive, leak-free sealing action
- Works well with dry bulk or low pressure liquids* (-20° to 200° F)
- Interchangeable with other brands
- Complies with MIL-C-27487 specifications

Variety of Sizes: ¾" to 4"

We Have Them All!

Aluminum, Brass or Stainless Steel
Styles: A, B, C, D, E, F, DP, DC, FC, BC

Specifications

Rated Working Pressure: 150 PSI (tested at 300 PSI)

Construction:

- Handles: 1. Brass on Brass and Aluminum Couplers
  2. Steel on Stainless Steel Couplers
- Handle Pins: 316 Stainless Steel
- Handle Rings: Cadmium Plated Spring Steel

Style A

Male Adapter x
Female N.P.T. Thread

Size	Aluminum Item #	Brass Item #	Stainless Steel Item #
¾"	130020	130021	130022
1"	130023	130024	130025
1¼"	130026	130027	130028
1½"	130029	130030	130031
2"	130032	130033	130034
2½"	130035	130036	130037
3"	130038	130039	130040
4"	130041	130042	130043

Style C

Female Coupler x
Hose Shank

Size	Aluminum Item #	Brass Item #	Stainless Steel Item #
¾"	130078	130079	130080
1"	130081	130082	130083
1¼"	130084	130085	130086
1½"	130087	130088	130089
2"	130090	130091	130092
2½"	130093	130094	130095
3"	130096	130097	130098
4"	130099	130100	130101

Style B

Female Coupler x
Male N.P.T. Thread

Size	Aluminum Item #	Brass Item #	Stainless Steel Item #
¾"	130050	130051	130052
1"	130053	130054	130055
1¼"	130056	130057	130058
1½"	130059	130060	130061
2"	130062	130063	130064
2½"	130065	130066	130067
3"	130068	130069	130070
4"	130071	130072	130073

Style D

Female Coupler x
Female N.P.T. Thread

Size	Aluminum Item #	Brass Item #	Stainless Steel Item #
¾"	130108	130109	130110
1"	130111	130112	130113
1¼"	130114	130115	130116
1½"	130117	130118	130119
2"	130120	130121	130122
2½"	130123	130124	130125
3"	130126	130127	130133
4"	130128	130129	130130

*Special seals may be required for oils and aromatics – please consult us when ordering.

WARNING: Under NO circumstances should Cam and Groove Couplings be used for compressed air or steam service!

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

IMS Company

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Please refer to imscompany.com for current pricing

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Style E
Male Adapter x
Hose Shank

Size	Aluminum Item #	Brass Item #	Stainless Steel Item #
3/4"	130136	130137	130138
1"	130139	130140	130141
1 1/4"	130142	130143	130144
1 1/2"	130145	130146	130147
2"	130148	130149	130150
2 1/2"	130151	130152	130153
3"	130154	130155	130156
4"	130157	130158	130159

Style F
Male Adapter x
Male N.P.T. Thread

Size	Aluminum Item #	Brass Item #	Stainless Steel Item #
3/4"	130165	130166	130167
1"	130168	130169	130170
1 1/4"	130171	130172	130173
1 1/2"	130174	130175	130176
2"	130177	130178	130179
2 1/2"	130180	130181	130182
3"	130183	130184	130185
4"	130186	130187	130188

Style DP
Adapter Dust Plug
(NOT for use in pressure applications)

Size	Aluminum Item #	Brass Item #	Stainless Steel Item #
3/4"	130219	130220	130221
1"	130222	130223	130224
1 1/4"	130225	130226	130227
1 1/2"	130228	130229	130230
2"	130231	130232	130233
2 1/2"	130234	130235	130236
3"	130237	130238	130239
4"	130240	130241	130242

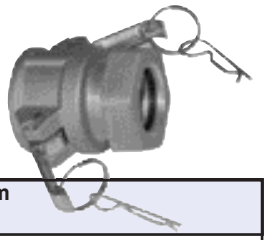
Style DC
Coupler Dust Cap
(NOT for use in pressure applications)

Size	Aluminum Item #	Brass Item #	Stainless Steel Item #
3/4"	130192	130193	130194
1"	130195	130196	130197
1 1/4"	130198	130199	130200
1 1/2"	130201	130202	130203
2"	130204	130205	130206
2 1/2"	130207	130208	130209
3"	130210	130211	130212
4"	130213	130214	130215

Style FC
Male Adapter x
Compression

Size	Aluminum Item #
1 1/2"	136216
2"	133705
2 1/2"	136217
3"	136218

Style BC
Female Coupler x
Compression



Size	Aluminum Item #
1 1/2"	136219
2"	136220
2 1/2"	136221
3"	136222

Replacement Gaskets

Size	EPDM* Item #	BUNA** Item #
3/4"	—	136229
1"	136223	135014
1 1/4"	136224	136230
1 1/2"	136225	133556
2"	134496	135013
2 1/2"	136226	136231
3"	136227	136232
4"	136228	136233

* 300° Outdoor Use ** 250° Oil Resistant

Replacement Handle Kits

Size	Brass Item #	Stainless Steel Item #
1/2"- 3/4"	136236	136241
1"	136237	136242
1 1/4"- 2 1/2"	136238	136243
3" - 5"	136239	136244

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

WARNING: Under NO circumstances should Cam and Groove Couplings be used for compressed air or steam service!

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Parker Push-Lok Jiffy Hose 7212

No hose clamp needed when used with Push-On Fittings

Specifications

Working Pressure:	300 psi
Min Burst Pressure:	1000 psi
Temp Range:	-40° F to 212° F
Cover:	Neoprene
Reinforcement:	1 braid synthetic
Tube:	Nitrile

Hose I.D.	Hose O.D.	Item #	Color	Std Reel Size*
¼"	0.50"	101151	Black	700'
		104317	Red	
		118484	Blue	
		165864	Yellow	
⅜"	0.62"	101194	Black	700'
		104366	Red	
		118480	Blue	
½"	0.75"	101160	Black	600'
		104434	Red	
		118475	Blue	
⅝"	0.91"	136171	Red	400'
¾"	1.03"	136151	Black	400'
		125328	Red	400'
		123000	Blue	

* Due to hose manufacturing, reel lengths may vary slightly from standard reel size and may contain more than one continuous length

Hose I.D.	Hose O.D.	Item #	Color	Std Reel Size*
1"**	1.28"	131371	Red	200'
		131370	Blue	

** Parker 801 Push-Lok Plus: 200 PSI / -40° to + 185° F

Hydraulic Hose

Made to Order

Got a slow leak? Re-doing a machine next week? Tired of paying too much at your local supplier?

Let IMS Build Your Hoses and Ship Them to Your Door! We can do almost every size hose with whatever fittings you might need.

All we need to know:

- Working pressure
- Hose I.D.
- Length
- Fitting type (Straight/45°/90°)
- and in some cases the phase angles

Save Big with IMS Hydraulic Hose

Call for a Quote Today!

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Please refer to imscompany.com for current pricing

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Waterline Hose

Made in the U.S.A

For use with barb-type waterline hose sockets.

- EPDM tube and cover resist chemicals
- Spiral synthetic cord reinforcement prevents rupturing

Specifications and Prices

H Working Pressure: 300 psi
Minimum Burst Pressure: 1200 psi
Temperature Range: -40°F to 212°F
Cover: EPDM (ethylene-propylene-dienemonomer rubber)
Reinforcement: Multiple textile spirals
Tube: EPDM

Hose I.D.	Hose O.D.	Item #	Color	Std Reel Size**
¼"	0.55”	105504	Red	**800'**
⅜"	0.688”	105476	Red	**700'**
½"	0.844”	127414	Black	**500'**
	0.875”	105450	Red	**500'**
	0.844”	136392	Blue	**550'**
⅝"	1.06”	105418	Red	**450'**
¾"	1.156”	105389	Red	**400'**
	1.156”	124209	Blue	**400'**
1"	1.438”	108185	Red	**300'**
	1.438”	128413	Black	**300'**

H Working Pressure: 200 psi
Minimum Burst Pressure: 800 psi
Temperature Range: -40°F to 212°F
Cover: EPDM (ethylene-propylene-dienemonomer rubber)
Reinforcement: Multiple textile spirals
Tube: EPDM

Hose I.D.	Hose O.D.	Item #	Color	Std Reel Size**
¼"	0.55”	136154	Black	**800'**
⅜"	0.688”	127908	Black	**700'**
⅝"	1.06”	128313	Black	**400'**
¾"	1.156”	114970	Black	**400'**
1"	1.438”	134894*	Blue	**400'**
		134245	Black	**300'**
1¼"	1.74”	119271	Black	**250'**
		108221	Red	**250'**
1½"	1.74”	132716	Black	**200'**
		133174	Red	**200'**
2"	2.45”	148450	Red	**250'**

*Working Pressure: 250 psi / Burst Pressure: 1000 psi

** Due to hose manufacturing, reel lengths may vary slightly from standard reel size and may contain more than one continuous length

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High-Heat Resistant Hose with PTFE

Resists Mold Fluid Circulating Temperatures to 450°F

IMS High-Heat Hose with fluoropolymer (PTFE) resin is a smooth bore, medium pressure hose for circulating fluids at temperatures **up to 450°F**. The hose is suitable for water, ethylene glycol, oil and other heat transfer fluids such as IMS PG-1.

The PTFE inner tube and braided stainless steel outer cover offer unlimited shelf life, excellent flex life, vibration absorption and corrosion protection. Additionally, you can steam clean this hose. Male fittings swaged onto both ends accept optional swivel and stainless steel disconnect fittings.

Specifications

Temperature Range:	Continuous service: -65° to 450° F (-54° to 232° C) Intermittent service: -100° to 500° F (-73° to 260° C)
Construction:	Smooth inner core of extruded white resin with PTFE, with Type 304 stainless steel wire braid reinforcement (meets requirements of SAE 100R5)

N.P.T. Nominal Size	¼"	⅜"	½"	¾"
Fitting I.D.	.153”	.270”	.360”	.590”
Nominal I.D.	.187”	.312”	.406”	.625”
Nominal O.D.	.312”	.445”	.549”	.778”
Operating Pressure psi	3,000	2,500	2,000	1,200
Min. Burst Pressure psi	12,000	10,000	8,000	4,800
Min. Bend Radius	2”	4”	5.2”	7.7”
Hose Weight lb./ft.	.070	.110	.123	.170

Custom hose and/or fittings available

Prices

N.P.T.	Item #	Length
¼"	110796	1'
	129753	2'
	109676	4'
	109660	6'
	109672	8'
	109675	10'
	109662	12'
⅜"	116589	1'
	116009	2'
	109674	4'
	109679	6'
	109667	8'
	109681	10'
	109713	12'
½"	111522	1'
	134085	2'
	117554	3'
	109697	4'
	109703	6'
	109694	8'
	109696	10'
	109707	12'
¾"	122436	3'
	105577	4'
	105588	6'
	105605	8'
	105571	10'
	105591	12'

Optional Swivel Fittings and Quick Disconnect

Specifications

N.P.T.	Working Pressure	Typical Flow at 10 psi pressure drop
¼"	1500	3.6
⅜"	1000	6.7
½"	900	11.0
¾"	800	26.3

Notice: In order to avoid any possibility of leakage and/or thread seizing, IMS highly recommends the use of high heat thread tape or lube on all high heat fittings.

Viton® is a registered trademark of E. I. du Pont de Nemours and Company or its affiliates

Prices

Zinc Plated Steel Swivel Fittings

Female to Female	NPT
109626	¼"
109698	⅜"
109695	½"
105570	¾"

Male to Female	NPT
135377*	⅛"
109622	¼"
109710	⅜"
109704	½"
105589	¾"

* ¼" Male x ⅛" Female

Stainless Steel Quick Disconnect with Viton® Seal (Usable up to 400°F)

2-Way Shut Off Plugs	NPT
143659	⅛"
126253	¼"
126254	⅜"
126255	½"
126256	¾"

2-Way Shut Off Sockets	NPT
126257	¼"
126258	⅜"
126259	½"
126260	¾"

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Firesleeve™ High Heat Insulation Products

Protect Continuously to 500°F

GREEN Products

Great for:
- Insulating against energy loss in piping & hose
- Protecting hoses, wires and cables from high heat and occasional flame
- Protecting employees from burns
- Bundling wires, hoses and cables

Made of knitted/braided fiberglass yarns in a flexible substrate and coated with a high-grade silicone rubber
Resistant to hydraulic fluids, lubricating oils and fuels

Common Specifications

Fiberglass
Fiber Type: E Class
Resistance to:
Acids: FAIR
Alkalis: GOOD
Effect of:
Bleaches and Solvents: NONE
Melt Temp.: 2,050°F

Silicone Rubber
Flammability Rating: UL94

Sleeve Style Insulation		
Item No.	**I.D.**	**Weight (per 100 ft.)**
138328	½"	10.5 lbs.
138329	¾"	15.8 lbs.
138330	1"	17.9 lbs.
138331	1⅝"	32.1 lbs.
138332	2"	35.3 lbs.
Tape Style Insulation		
Item No.	**Width**	**Weight** (per 100 ft. roll)
138340	1"	5.0 lbs.

Firesleeve™ is a trademark of Davlyn Manufacturing Inc.

Hose and Plastic Pipe Cutters

Made in the U.S.A

Use these to safely make clean square cuts on hose and plastic pipe.
- NEW spring loaded and locking option
- Tough injection molded nylon handles
- Replaceable blade, A-2 steel (coated with PTFE) (stainless steel standard on 113265 & 136528)

CAUTION: Do not attempt to cut anything harder than plastic with these cutters.

Item #136528 shown

Specifications and Prices		
Item #	**For Use on Multipurpose Hose & Tubing**	**For Use on Schedule 40 PVC & CPVA**
Standard Cutter		
109191 (1" dia.) (PTFE Coated Blade)	up to 1" I.D.	up to 1" I.D.*
116102 (1½" dia.) (PTFE Coated Blade)	up to 1½" I.D.	up to 1¼" I.D.*
113265 (2" dia.) (Stainless Steel Blade)	up to 2" I.D.	up to 1¼" I.D.
Spring Loaded and Locking Cutter		
158406 (1" dia.)	up to 1" I.D	up to 1" I.D.*
136527 (1½" dia.)	up to 1½" I.D.	up to 1¼" I.D.*
136528 (2" dia.)	up to 2" I.D.	up to 1¼" I.D.
Spare Parts and Accessories		
109186	2 15/16" blade for 1" dia. cutter	
116099	3 3/16" blade for 1½" dia. cutter	
113270	4¼" blade for 2" dia. cutter — stainless steel	

*Stainless Steel Blades are Recommended for PVC and CPVC

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Made in the U.S.A

Worm Gear Hose Clamps

Micro Hose Clamps

Precision-engineered clamps for use in small hose applications

- 300 Stainless Steel Band
- Rust Resistant Plated Carbon Steel Screw with ¼" Hex Head
- 5/16" Width

Specifications and Prices

Item#	Clamp #	Size in Inches	Size in mm
108587	4	5/16" to 5/8"	08-16
108591	6	7/16" to 25/32"	11-22

Standard Hose Clamps

Clamps for use in most hose applications

- 200 Stainless Steel Band
- Rust Resistant Plated Carbon Steel Screw with 5/16" Hex Head
- ½" Width (unless otherwise noted)

Specifications and Prices

Item#	Clamp #	Size in Inches	Size in mm
108209	6	3/8" to 7/8"	10-22
108201	8	7/16" to 1"	11-25
108196	10	½" to 1 1/16"	13-27
108192	12	½" to 1¼"	14-32
108223	16	11/16" to 1½"	17-38
108214	20	¾" to 1¾"	19-44
108207	24	1" to 2"	21-51
108200	28	1¼" to 2¼"	32-57
108195	32	1½" to 2½"	38-63
108191	36	1¾" to 2¾"	46-70
108186	40	1" to 3"	26-76
108222	44	1¼" to 3¼"	32-82
108212	48	2½" to 3½"	65-89
108206	52	2¾" to 3¾"	70-95
108199	56	3" to 4"	78-101
108127	88	4" to 6"	102-152
109111*	128	1¾" to 8½"	45-216

* 9/16" Width

Lined, Super Strong Flex Gear, Oetiker and other Specialty Clamps available upon Request

Nylon Hose Clamps

Specifications and Prices

Item#	Clamp Range (dia.)
108204	0.702” to 0.801”

- Low cost
- Corrosion resistant nylon 6/6
- Reusable
- Maximum temperature: 250°F

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IMS Select Millepede QuickStrip

One Million Uses — Use Anywhere You Need to Fasten, Fix or Hold

UV Resistant makes the Mille-Tie QuickStrip suitable for all conditions.

- Reusable - Undo to use again.
- No Sharp Edges - Ready to use or cut there are no sharp edges to snag or injure.
- Quick Fitting - Needs no orientation — works in any direction.
- No Waste - Once latched - the cut off tail becomes another tie.

1. Loop around hoses to be tied. (NOTE: Actual color is black.)

2. Slide end of strap into head slot as shown. Pull hoses tight.

3. To Lock: Pull end up to lock in place.
To Release: Put end of strap through same head slot and pull through.

Specifications and Prices

Item	Overall Length*	Width	Diameter Min	Diameter Max	Qty per Bag	Color
147234	12½"	0.4"	0.02"	3.3"	20	Black

*QuickStrips are semi-elasticated and will exceed their nominal length during use.

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Colored Plastic Wire Ties

Help Identify and Organize Wires

- Self-locking design

Nylon

Specifications and Prices

Item #	Length	Color	Width	Tensile Strength
121257	4"	Red	0.094"	18 lbs.
121246	4"	Blue	0.094"	18 lbs.
117736	4"	Natural	0.094"	18 lbs.
121247	5.7"	Red	0.140"	40 lbs.
121236	5.7"	Blue	0.140"	40 lbs.
117743	5.7"	Natural	0.140"	40 lbs.
117742	7.5"	Natural	0.140"	50 lbs.
121237	8.8"	Red	0.140"	40 lbs.
121226	8.8"	Blue	0.140"	40 lbs.
121208	11.2"	Blue	0.178"	50 lbs.
121198	15.1"	Red	0.300"	120 lbs.

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High Heat Hose Insulation

For Continuous Temperatures up to 1,000° F

GREEN Products

- High quality fiberglass
- Saturated with synthetic rubber
- Highly flexible at any temperature
- Expands over joints and around turns
- Light brown

I.D.	Item Number
1⅞" — 2"	*108373
2½" — 4"	108699

* Fits IMS HAD & MD Series Hopper Dryers

Therma Sleeve™ Modular Dryer Hose Insulation

For Hose Temperatures up to 600°F

GREEN Products

- Modular 2' long sleeves let you insulate different hose lengths
- 36.84% BTU reduction SAVES YOU MONEY
  Payback in energy savings in as little as 5½ months
- Provide better process heat control to mold quality parts
- Protects employees from accidental contact with hot hose
- Easy to install — No machine downtime, No tools needed
- Vinyl exterior repels dust and oil — Protects hose
- Overlapping cuffs for maximum heat retention

Fits Hose O.D.	Item Number
1½"	121428
2"	121421
2½"	121449
3"	121441
3½"	121436
4"	121452
4½"	121445
5"	121437
5½"	121432
6"	121447

2' Stock Lengths

VELCRO® is a registered trademark of VELCRO Companies
Therma Sleeve™ is a trademark of Uni-Therm Insulation Systems

Custom Sizes Available — Call for Price and Delivery

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Made in the U.S.A

Hopper Dryer Air Hose (Orange)

For Process/Output Line from Dryer to Hopper

For Continuous Use -95°F up to 500°F (540°F Intermittent)

- Great Industrial Ducting Hose for use with Dust Removal, Exhaust and Ventilation, Chemical Fumes, etc.
- Economical 1 Ply or Rugged 2 Ply Construction
- Silicone coated fiberglass with wire helix
- Highly flexible, UV and Weather Resistant
- Light Weight - easy to install and non-kinking
- Standard 13 Foot Lengths
- Not recommended for liquids or abrasives

	1 PLY			2 PLY		
ID	Item #	Working PSI*	Vacuum HG*	Item #	Working PSI*	Vacuum HG*
1"	173666	21.756	17.127	173680	40.60	20.95
1¼"	173667	21.756	17.127	173681	39.16	19.20
1½"	173668	21.756	17.127	173682	37.71	17.72
2"	173669	21.756	14.765	173683	37.71	15.36
2¼"	173670	18.855	14.765	173684	36.26	14.17
2½"	173671	18.855	14.765	173685	34.81	13.58
3"	173672	15.954	11.517	173686	30.46	12.70
3½"	173673	15.954	11.221	173687	29.01	11.81
4"	173674	15.954	8.859	173688	27.56	10.34
5"	173675	13.054	6.201	173689	20.31	6.80
6"	173676	11.603	5.315	173690	17.41	5.02
8"	173677	8.702	2.953	173691	10.15	2.66
10"	173678	5.802	2.953	173692	7.25	2.07
12"	173679	1.450	2.067	173693	7.25	2.06

*Technical data based on tests at 68°F and are approx. values

Purchasers also order:

- Worm Gear Hose Clamps, page 404
- Dryers, Desiccant, Dewpoint Meters and other Drying Accessories, pages 684-715

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Hopper Dryer Air Hose (Black)

For Return/Input Line From Hopper to Dryer

Made in the U.S.A

Great Industrial Ducting Hose for use with Dust Removal, Exhaust and Ventilation, Chemical Fumes, etc.

Neoprene Hose

- Rugged 2 Ply Construction
- Neoprene Coated Fiberglass with Wire Helix
- UV and Weather Resistant
- Light Weight - easy to install and non-kinking
- Temperature Range -30°F to +275°F
- Intermittent to 300°F
- Standard 13 Foot Lengths
- Not recommended for liquids or abrasives

ID	Item#	Working PSI*	Vacuum HG*
1¼"	173694	39.15	19.20
1½"	173695	37.70	17.70
1¾"	173696	37.70	17.15
2"	173697	37.70	15.35
2¼"	173698	36.25	14.15
2½"	173699	34.80	13.60
3"	173700	30.45	12.70
3½"	173701	29.00	11.80
4"	173702	27.55	10.35
5"	173703	20.30	20.30
6"	173704	17.40	5.00
8"	173705	10.15	2.65

*Technical data based on tests at 68°F and are approx. values

Thermoplastic Rubber Hose

For Continuous Temperatures up to 275°F (300°F Intermittent)

- Steel Wire Helix
- UV, Ozone and Abrasion Resistant
- Superior Chemical Resistance
- Temperature Range -60°F to +275 F
- 25 and 50 Foot Lengths

25 FOOT				50 FOOT	
ID	Item #	Working PSI*	Vacuum HG*	ID	Item #
1½"	136532	24	>29	1½"	136533
1¾"	136534	22	>29	1¾"	136535
2"	136536	17	>29	2"	136537
2½	136540	13	28	2½	136541
3"	136542	10	28	3"	136543
3½"	136544	10	20	3½"	136545
4"	136546	10	25	4"	136547
5"	136550	9	15	5"	136551
6"	136552	9	11.5	6"	136553

*Pressure and Vacuum data is based on straight lenghts of hose at ambient temperature of 72°F

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Loader Hose Comparison

	Heavy Duty PVC Loader Hose	Light Weight Food Grade Loader Hose	IMS Food Grade Polyurethane Wired Hose	IMS Anti-Static Polyurethane Wired Hose
Material	PVC	PVC	Polyurethane	Polyurethane
Rating	Heavy Duty	Light Weight	Heavy Duty	Heavy Duty
Uses	Intended for conveying of high volume of powder, bulk material, granulate	For food and pharmaceutical industries intended for conveying of high volume of powder, bulk material, granulate, gases and dry foods	For food and pharmaceutical industries intended for conveying of high volume of abrasive powder, bulk material, granulate, gases, dry foods, and waste	Intended for conveying of high volume of abrasive powder, bulk material, granulate, gases and waste
Temperature Range	-4°F - 150°F	-5° to 160°F	-40° to 195°F	-40° to 195°F
Intermittant To	175°F	175°F	250°F	250°F
Classifications		Food grade, FDA 21, microbe and hydrolysis resistant	Food grade, FDA 21, microbe and hydrolysis resistant, flame-retardant	Permanently anti-static, ISO 8031, microbe resistant, flame-retardant
Ground Wire	No	No	Yes	Yes
Interior	Smooth Bore	Smooth Bore	Highly Abrasion Resistant	Highly Abrasion Resistant
Exterior	Smooth Cover	Corrugated Cover	Corrugated Cover	Corrugated Cover
Vacuum	28 Hg	4-7 Hg	16-26.6 Hg	10-29.5 Hg
Catalog Page	411	412	413	414

Check out these other useful IMS products!

IMS Portable Resin Bins

See pages 692 - 693

75-lb
#137951

158-lb
#122649

368-lb
#122650

800-lb
#132633

1,200-lb
#129902

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Heavy Duty PVC Loader Hose

Reinforced for a Long Service Life

Made in the U.S.A

Specifications

Wall: Clear
Helix: White nylon
Inside: Smooth bore
Outside: Smooth cover
Material: PVC
Vacuum Rating*: 28 in/Hg
Max. Temp. Rating: 150°F

Specifications and Prices

Item #:	136135	136136	106028	106009
Inside Diameter:	¾" I.D.	1" I.D.	1¼" I.D.	1½" I.D.
Outside Diameter:	1.01"	1.26"	1.50"	1.875"
Minimum Bend Radius*:	3"	3"	3"	4"
Weight (lbs./ft.):	.19	.26	.30	.40

Item #:	108834	130613	123204	135777
Inside Diameter:	2" I.D.	2½" I.D.	3" I.D.	4" I.D.
Outside Diameter:	2.375"	2.875"	3.43"	4.5"
Minimum Bend Radius*:	5"	8"	10"	15"
Weight (lbs./ft.):	.60	.87	1.24	1.85

* at 70° F †100' Rolls Only

Available up to 8" — Inquire

Zinc Plated Carbon Steel Spiral Double Bolt Clamps

For Counterclockwise Spiral

Specially designed to fit corrugated suction hose.
Also works well on rubber suction hose. Ideal for proper mounting of Cam & Groove couplings and couplers.

Item #	Size	Weight
135764	1½"	0.18 lbs.
135765	2"	0.36 lbs.
135766	2¼"	0.40 lbs.
135767	2½"	0.48 lbs.
135768	3"	0.66 lbs.
135769	3½"	0.70 lbs.
135770	4"	1.02 lbs.

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Light Weight Food Grade Loader Hose

Best Value, Food Grade PVC

Specifications

Wall: Clear

Helix: White, rigid PVC spiral integrated in wall

Inside: Smooth interior; wall: special premium ether-polyurethane

Outside: Smooth cover

Material: PVC

Temp. Range: -5°F to 160°F, short time to 175°F

Complies with FDA 21 CFR 177.2600

Specifications and Prices		
Item #:	**173706**	**173707**
Inside Diameter:	1¼" I.D.	1½" I.D.
Outside Diameter:	1.50"	1.77"
Bend Radius*:	0.75"	1.22"
Vacuum (in HG):	5.9"	5.9"
Weight (lbs./ft.):	0.42	0.64

- Light Weight
- Abrasion-Resistant
- Odorless And Tasteless
- Microbe And Hydrolysis Resistant
- Good Resistance To Oil, Gasoline, And Chemicals
- Very Good Low Temperature Flexibility

Available in 50 ft. rolls. Order by the foot or by the roll.

Conveniently stamped with IMS part number and phone number throughout the hose

Check Out These Other Useful IMS Products!

Material Loaders

See Pages 650-671 for all options

IMS Series Stainless Steel Material Loaders

IMS Whisper Loader Series

IMS Compressed Air Loader

NEW Shini Single Station Hopper Loader Systems

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Please refer to imscompany.com for current pricing

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IMS Food Grade Polyurethane Loader Hose

Heavy Duty, Microbe Resistant, with Ground Wire – Food Grade

Specifications

Wall: Transparent
Helix: Spring steel wire firmly embedded in wall
Inside: Smooth bore
Outside: Permanently antistatic premium ether-polyurethane
Material: Antistatic Polyurethane Hose
Temp. Range: -40°F to 195°F, short time to 255°F

Complies with: FDA 21 CFR 177.2600 and 178.2010

Embedded static wire prevents the build-up of static electricity and helps to keep material flowing smoothly.

Specifications and Prices

Item #:	172220	172222	172224	172226
Inside Diameter:	1" I.D.	1¼" I.D.	1½" I.D.	1¾" I.D.
Outside Diameter:	1.25”	1.65"	1.89"	2.17"
Bending Radius*:	0.750"	1.02"	1.14"	1.30"
Vacuum (in HG):	26.58 in/Hg	25.84 in/Hg	29.53 in/Hg	24.95 in/Hg
Weight (lbs./ft.):	0.190	0.295	0.350	0.403

Item #:	172227	172231	172233
Inside Diameter:	2" I.D.	2½" I.D.	3" I.D.
Outside Diameter:	2.36"	2.95"	3.39"
Bending Radius*:	1.36"	1.67"	2.58"
Vacuum (in HG):	24.66 in/Hg	19.93 in/Hg	16.39 in/Hg
Weight (lbs./ft.):	0.445	0.565	0.705

* at 68°F

Available up to 6" — Inquire

NOTE: Static wire loader hose needs to be grounded to work. Simply strip away the jacketing of the loader hose to expose the wire and ground it. If grounding to the loader body, make sure your loader controls are grounded; otherwise the charge may blow the board.

- Heavy Duty
- Highly Abrasion Resistant
- Increased Pressure And Vacuum Resistance
- Odorless And Tasteless
- Microbe And Hydrolysis Resistant
- Good Resistance To Oil, Gasoline, And Chemicals
- Very Good Low Temperature Flexibility

Available in 50 ft. rolls. Order by the foot or by the roll.

Conveniently stamped with IMS part number and phone number throughout the hose

Tech Tips

IMS recommends using static wire hose to ground all its loaders.

We carry everything for your material handling needs:

• Elbows • Clamps • Joiners • Reducers

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IMS Anti-Static Polyurethane Wired Hose

Heavy Duty, Microbe Resistant, with Ground Wire – Anti-Static

Specifications

Wall: Transparent
Helix: Spring steel wire firmly embedded in wall
Inside: Smooth bore
Outside: Permanently antistatic premium ester-polyurethane
Material: Antistatic Polyurethane Hose
Temp. Range: -40°F to 195°F, short time to 255°F

Embedded static wire prevents the build-up of static electricity and helps to keep material flowing smoothly.

Specifications and Prices

Item #:	172221	172223	172215	172225
Inside Diameter:	1" I.D.	1¼" I.D.	1½" I.D.	1¾" I.D.
Outside Diameter:	1.26"	1.65"	1.89"	2.17"
Bending Radius*:	0.79	1.02"	1.14"	1.30"
Vacuum (in HG):	29.53 in/Hg	29.53 in/Hg	29.53 in/Hg	27.02 in/Hg
Weight (lbs./ft.):	0.190	0.295	0.350	0.403

Item #:	172216	172230	172232
Inside Diameter:	2" I.D.	2½" I.D.	3" I.D.
Outside Diameter:	2.36"	2.95"	3.39"
Bending Radius*:	1.36"	1.67"	2.58"
Vacuum (in HG):	24.36 in/Hg	18.75 in/Hg	14.91 in/Hg
Weight (lbs./ft.):	0.445	0.565	0.705

* at 68°F

Available up to 6" — Inquire

NOTE: Static wire loader hose needs to be grounded to work. Simply strip away the jacketing of the loader hose to expose the wire and ground it. If grounding to the loader body, make sure your loader controls are grounded; otherwise the charge may blow the board.

- Heavy Duty
- Highly Abrasion Resistant
- Increased Pressure And Vacuum Resistance
- Odorless And Tasteless
- Microbe Resistant
- Good Resistance To Oil, Gasoline, And Chemicals
- Very Good Low Temperature Flexibility
- Permanently Antistatic Wall

Available in 50 ft. rolls. Order by the foot or by the roll.

Conveniently stamped with IMS part number and phone number throughout the hose

IMS Company

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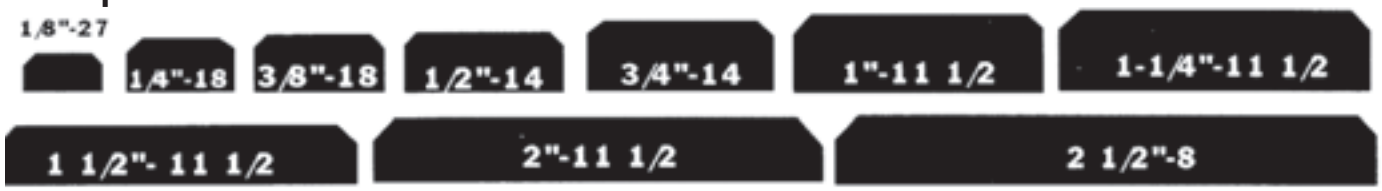
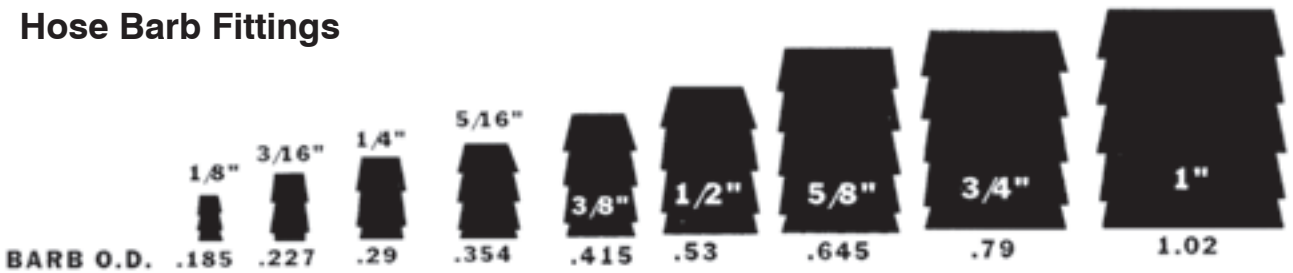
Thread Profiles

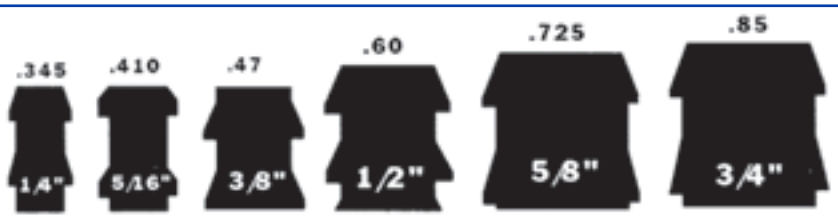
Pipe Threads



Hose Barb Fittings



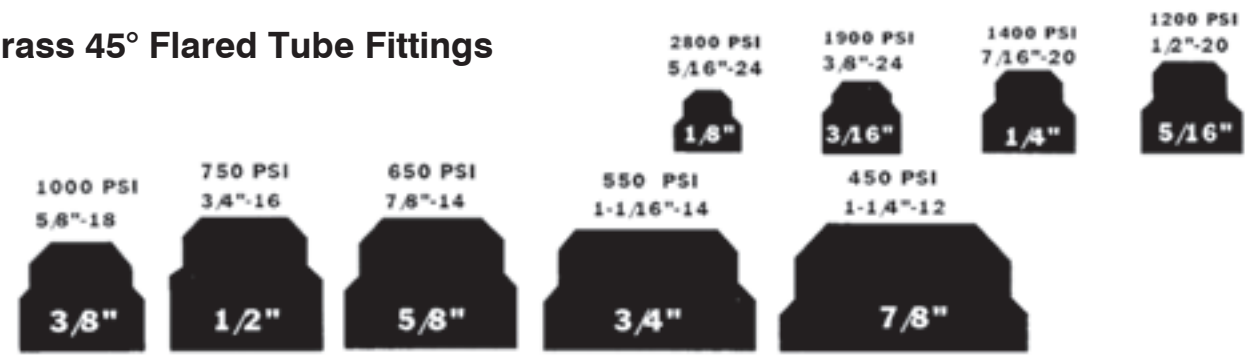
Push On Fittings



Garden Hose Fittings

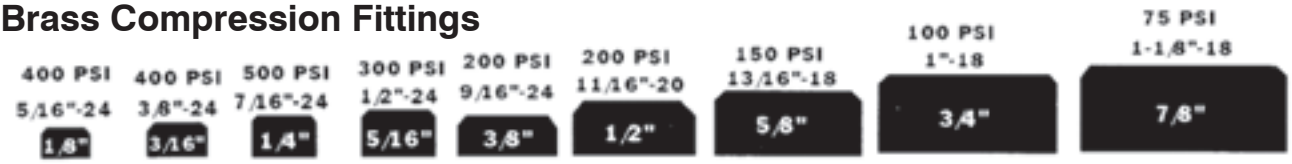
Male garden hose threads are ¾" with O.D. of 1.0625 and 11½ threads per inch

Brass 45° Flared Tube Fittings



Brass Inverted Flare Fittings

Brass Compression Fittings



Tubing O.D. Size

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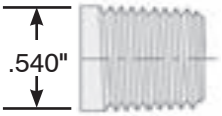
Quick Change Fittings & Thread Profile Sizing

All Fittings Shown Actual Size

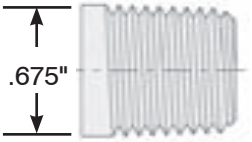
Simply hold your fitting up to the appropriate profile to determine the NPT, Series or Barb Size.

Common Pipe Thread

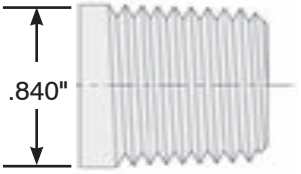
¼" NPT



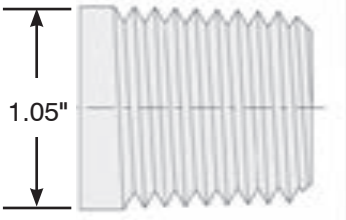
⅜" NPT



½" NPT



¾" NPT



Coupler / waterline / thread Quick reference charts

Coupler specifications

Series - Body Size	200 - ¼"	300 - ⅜"	500 - ½"
Rated Pressure (PSI)	200	200	200
Rated Flow (GPM)	3	6	12

Coupler seals

Material	Temperature Range
Standard Silicone Seal	-90° to +400° F
Optional Flourocarbon Seal*	-15° to +400° F

**For use with oil based fluids only*

Water Capacity (gpm)

Pipe Size	P_2 Variation	Differential Pressure (P_1-P_2) PSI			
		10	25	50	100+
½" & ¾"	5 PSI	1.8	2.3	2.4	2.8
	10 PSI	4.8	5.3	6.0	8.9
	15 PSI	9.1	10.1	10.9	11.8
	20 PSI	14.3	15.8	16.5	16.6
1"	5 PSI	1.5	2.0	2.7	6.9
	10 PSI	8.7	12.8	13.6	17.5
	15 PSI	14.2	20.9	27.3	28.0
	20 PSI	17.3	25.7	30.9	42.8
1¼" 1½" & 2"	5 PSI	18.5	20.0	25.4	25.7
	10 PSI	43.2	45.5	48.6	50.4
	15 PSI	64.8	67.4	69.5	70.5
	20 PSI	77.7	80.3	87.8	95.2

Pipe Thread Data

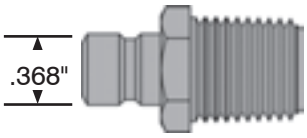
Pipe Size	Threads Per Inch	Outside Dia. of Pipe	Inside Diameter of Pipe	Tap Drill Size	
				Without Ream	With Ream
¼	18	.540	.364	7/16	27/64
⅜	18	.675	.493	9/16	9/16
½	14	.840	.622	45/64	1 1/16
¾	14	1.050	.824	29/32	53/64

500 Series Coupler

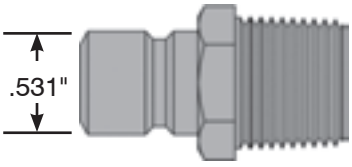
300 Series Coupler

200 Series Coupler

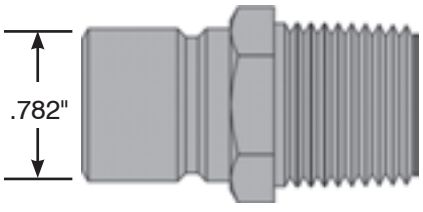
200 Series Plug



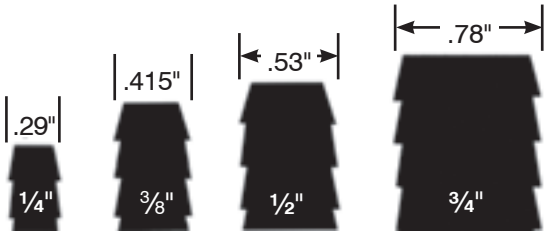
300 Series Plug



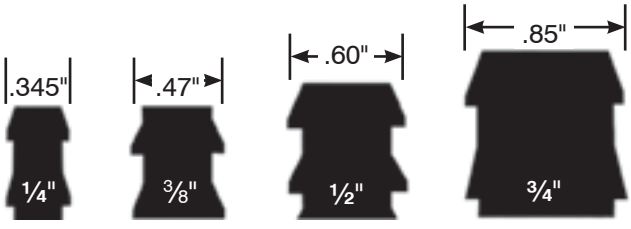
500 Series Plug



Common Standard Hose Barbs



Common Push-On Hose Barbs



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Since
1949

IMS®

Industrial

Molding Supplies

General Industrial Supplies

Misc. Shop Access.
418 – 421

Bench Top Scales
422 – 424

Stopwatches
425 – 427

Air Guns, Tips & Hose
428 – 432

Static Eliminators
433 – 444

Hand, Arm & Finger Protection
445 – 450

Hairnets, Ear Plugs & Respirators
451 – 452

Eye & Face Protection
453 – 454

Absorbent Products
455 – 456

Hand & Power Tools
458 – 461

Tape Measures
462 – 463

Part Removal Systems
464 – 468

Most items IN STOCK for Same Day Shipment

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GREEN Products

Wiping & Polishing Rags

For General Molding Shop Use

Perfect for Cleaning and Polishing:

Presses, Tools, etc

- Made of recycled cotton material
- Super soft
- Low lint
- Washable
- Mixed colors and sizes

25 lb box - approximately 200 rags

Item #149055

Punchout Hole (perforated) for easy rag removal

Now take advantage of quantity breaks to lower your cost.

Carton Clips

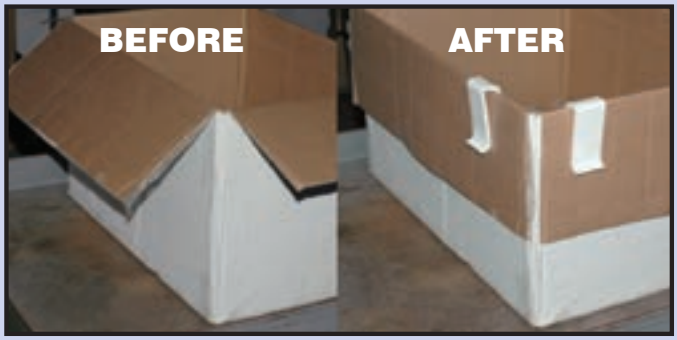
Many Molding Shop Uses

- **Hold box flaps down**
  Allow closer box to personnel placement – eliminate leaning and reaching

  Help prevent conveyed boxes from snagging / tipping
- **Great for holding gaylord liners in place**

Removable and Reusable!

#137148



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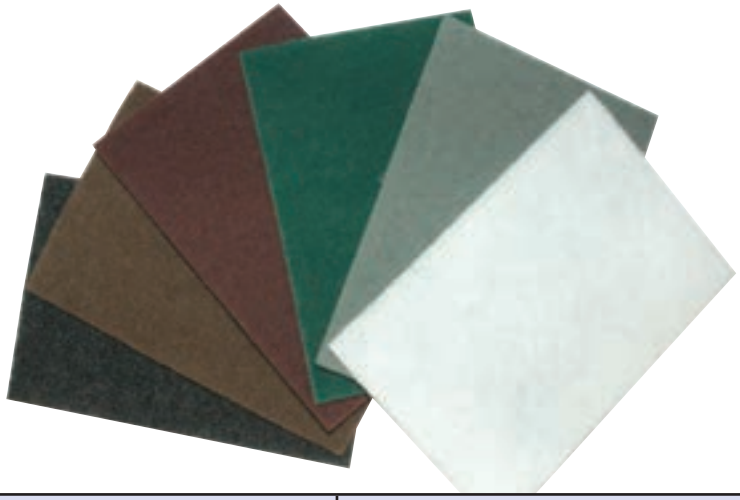
Industrial Cleaning Pads

6" X 9", Nylon-Based Pads Can be Used to Clean, Polish or Finish Just About Anything!

6 Grades! (fine to coarse)

The darker the color, the more abrasive the pad

All pads measure 6" x 9"



Item #	Color	Grade	For	From
137309	Black	Blending & Finishing	Paint Removal	Stainless Steel and Metal
137305	Brown	Heavy Duty	Removing heavy rust & cleaning welds	Metal
137307	Maroon	General Purpose	Cleaning and brightening	Metal
137311	Green	General Cleaning	Stripping paint and varnish	Metal and Wood
137313	Gray	Ultra Fine	Sanding before/ between finish coats	Metal and Wood
137315	White	Light Duty	Light Cleaning and Polishing	Fiberglass, Vinyl Plastic, Formica, Ceramic

137318 Sampler Pack, One of Each Pad Above

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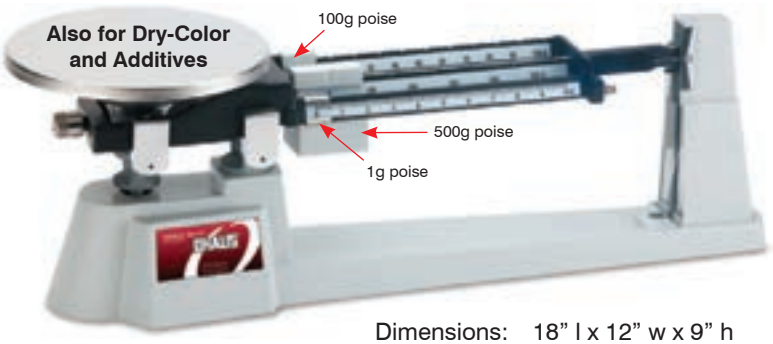
OHAUS Triple-Beam Mechanical Balance Scale

Controlling Molded Part Quality and Your Cost Begins With Accurate Part Weight!

- Magnetic damper for faster weighing
- Stainless steel plate
- Spring loaded zero adjustor compensator
- 3 notched and tiered beams with center reading



Capacity:	610g (with weights) 2,610g
Capacity x Readability:	(front beam) 10g x 0.1g (middle beam) 500g x 100g (rear beam) 100g x 10g

Dimensions: 18" l x 12" w x 9" h

5 Year Warranty

Item #	OHAUS #	Description
103793	750-S0, 707-00	Triple-Beam Balance complete with #103814 weights
103800	750-S0	Triple-Beam Balance (weights are not included)
Optional Accessories		
103814	707-00	Weights (set of 3; 2–1000g, 1–500g)

Compact Scales

2,000 Gram Capacity

- Displays oz, g, ozt and dwt
- Includes 500g calibration weight
- Parts-counting mode
- Energy-saving auto shut off
- Large weighing bow and cover/tray
- Easy to read backlit LCD display

Item #164031

5 Year Warranty

Capacity x Readability:	2000g x 0.1g (72 oz./0.035 oz.)
Power Requirements:	6V Includes 4 AAA Batteries (AC adapter not included)
Platform Size:	5.8" dia. stainless steel
Dimensions:	6.75"W x 7.5"L x 1.5"H
Shipping Weight:	4 lb. (1.8 kg)

5,000 Gram Capacity

- Weighing Modes: Grams and Ounces w/Tare
- Backlit LCD Display
- Large Weighing Bowl
- Tested to comply with FCC standards
- Unit can be calibrated in-house

Item #146525

5 Year Warranty

Capacity x Readability:	5000g x 1g
Power Requirements:	AA batteries (included)
Color:	Black
Platform Size:	4.7" dia.
Dimensions:	7.4" dia. x 2.25"H (without bowl)

Note: The primary reasons for inaccuracy and malfunction are low batteries, incorrect calibration, overload or operating on an unstable surface. Overloading the scale will void the warranty.

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OHAUS Electronic Scales

For Fast, Accurate Weighing Of Small Parts (Also For Dry-Color And Additives)

220 Gram Capacity

- 6 application modes - weighing, parts counting, % weighing, check weighing, totalization, display hold
- Displays kt, gr, g, kg, n, oz, ozt, dwt, lb, lb:oz
- Determines density and specific gravity
- Includes a standard 200g mass for easy calibration
- Easy-to-use 4 button operation
- Weight below hook allows for density determination or specific gravity calculation. Hook stores in battery compartment
- Mechanical and software protection provides superior resistance against shock and overloading
- Built-in security bracket, lock-switch and shipping lock
- High contrast LCD display

Item #168495

Stabilization Time:	1 sec.
Power Requirements:	5V AC adapter (included) or (4) AA batteries
Operating Temp.:	50° F to 104° F (10° C to 40° C)
Display:	LCD with 6 digits 0.78in/20mm high
Platform Size:	4.7" dia. (stainless steel)
Dimensions:	8.0"W x 8.8"L x 2.1"H
Shipping Weight:	3.3 lb. (1.0 kg)

3 Year Warranty

Item #	OHAUS #	Capacity x Readability (grams)	Linearity	Repeatability (std. dev.)
168495	SPX222	2000g x 0.01g	±1.0g	0.01g

2,200 Gram Capacity

- Displays oz, g, lb:oz
- Easy-to-use 2 button operation
- Stainless steel weighing pan
- High contrast LCD display
- Energy-saving auto shut off
- Low battery indicator
- Optional AC adapter: 173191

Item #173190

Stabilization Time:	3 sec.
Power Requirements:	AC adapter (optional) or 3 AA batteries (included)
Operating Temp.:	65°F to 77°F (18°C to 25°C)
Display:	LCD 0.7"/18mm high
Dimensions:	5.3"W x 7.9"L x 1.6"H
Weight:	1.1 lb. (0.51 kg)

1 Year Warranty

2,200 Gram Capacity

- Displays oz, g, lb:oz, pennyweight
- Easy-to-use 2 button operation
- ABS weighing pan
- High contrast LCD display
- Energy-saving auto shut off
- Low battery indicator
- Optional AC adapter: 173192

Item #171758

Stabilization Time:	3 sec.
Power Requirements:	3 AA batteries (included) or AC adapter (optional)
Operating Temp.:	65°F to 77°F (18°C to 25°C)
Display:	LCD 0.6"/15mm high
Dimensions:	5.5"W x 8.1"L x 1.6"H
Weight:	0.9 lb. (0.4 kg)

1 Year Warranty

Item #	OHAUS #	Capacity x Readability (grams)	Linearity	Repeatability (std. dev.)
173190	CX2200	2200g x 0.01g	±1.0g	1g
171758	CR2200	2200g x 0.01g	±1.0g	1g

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All Purpose, Vac-u-Gun™ System

A Low Cost Solution To A Wide Variety Of Industrial Housekeeping Problems

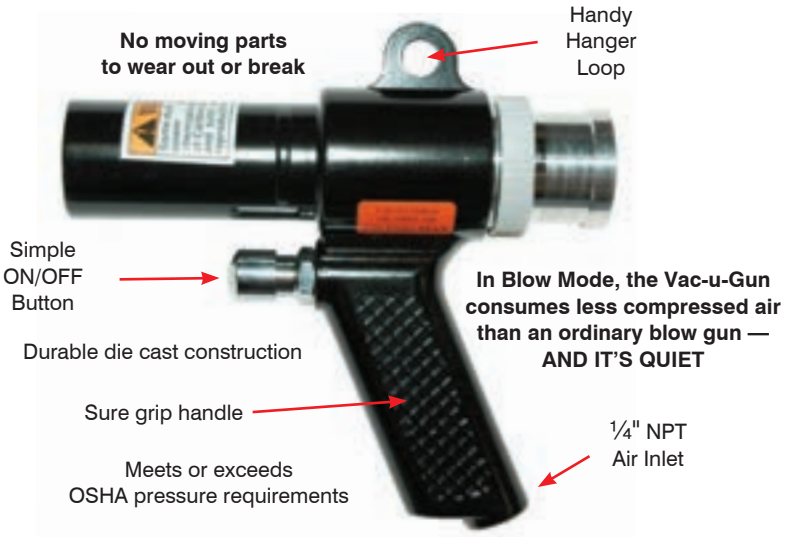
Can be used as a powerful vacuum gun, as an efficient blow gun or as a transfer tool for lightweight material

Great for:

- Vacuuming shavings, chips, absorbent, sawdust, spills
- Blowing shavings, chips, scrap, coolant, water
- Transferring small parts, pellets, trim, dust

How it Works

Injects a small amount of compressed air through directed nozzles to produce a vacuum on one end and an output flow (*12 times the air consumption rate*) on the other.



Specifications

- Pressure Supply required: 80 psi
- Air Consumption: 13 SCFM, 368 SLPM
- Air Inlet: ¼" NPT

Item #138472 - Includes: Air Gun, Re-usable Collection Bag, 10 foot Vacuum Hose, Brush, Crevice Tool, Skimmer Tool and (2) 19¼" Extension Wands.

Low Cost Safety Air Gun

Unique Design Provides a Full Flow Volume Stream of Air at a Safe 30 PSI or Less

Quiet

Built-in air silencer

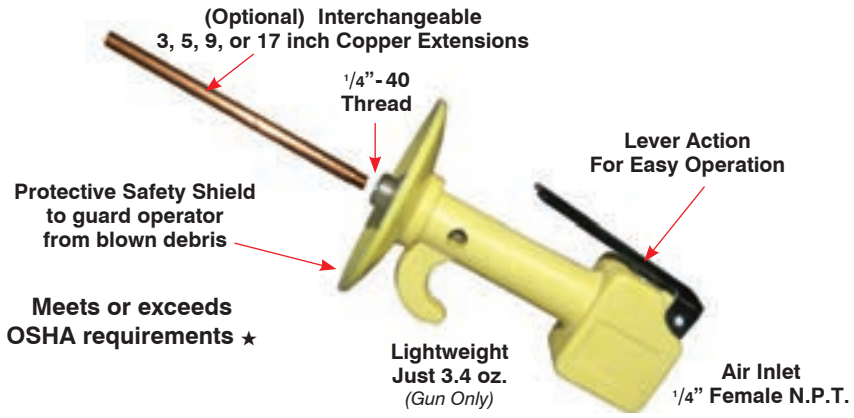
Rugged

Made of super tough Molded nylon

Lightweight

Tamper Resistant

Maintenance-free



★ **OSHA -** Meets or exceeds requirements of OSHA 1910.95 (noise level) and 1910.242 (b). (Compressed air shall not be used for cleaning purposes except where reduced to less than 30 PSI and then only with effective chip guarding and personal protective equipment.)

Item #	Description
101197	Safety Air Gun (Extension pipe not included)
Optional Accessories	
101153	5" Copper Extension Pipe
116558	9" Copper Extension Pipe
116557	17" Copper Extension Pipe

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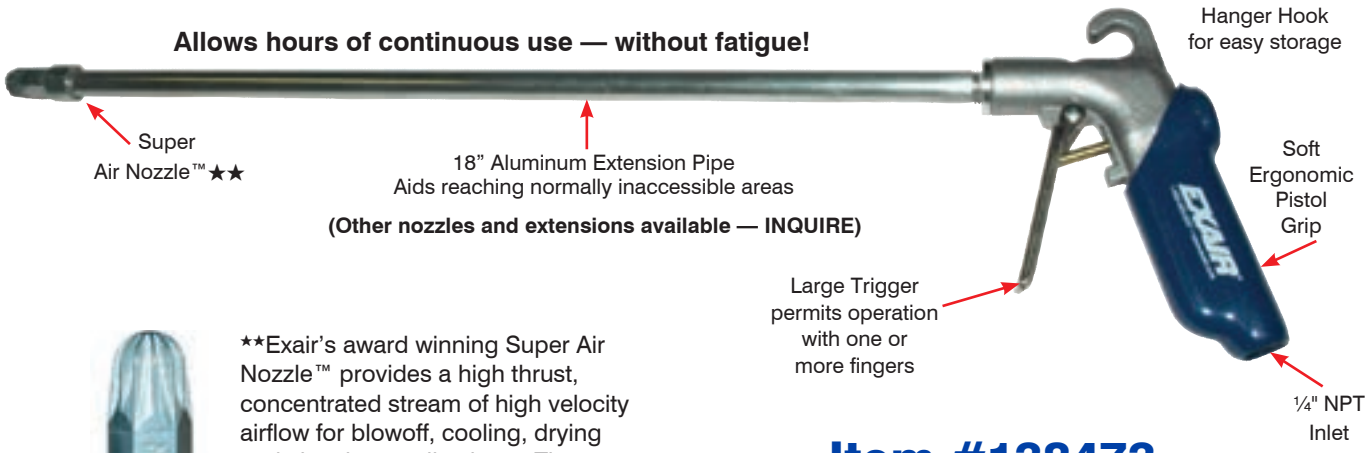
Heavy Duty, Cast Aluminum Air Guns

Designed for Quiet, Safe and Efficient Use of Compressed Air and Long Service Life

Soft Grip, Safety Air Gun

Complete with 18" extension and Super Air Nozzle

Allows hours of continuous use — without fatigue!



★★Exair's award winning Super Air Nozzle™ provides a high thrust, concentrated stream of high velocity airflow for blowoff, cooling, drying and cleaning applications. The sound level is extremely low (74 dBA) and air consumption is minimal.

Super Air Nozzle™ is a trademark of Exair Corp.

Item #138473

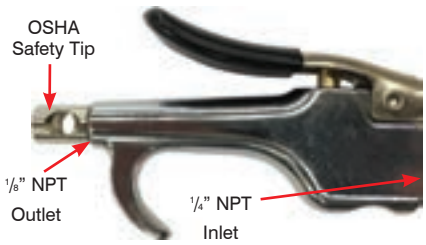
#144370 with 6" Extension

Economical, Lever-Action Air Guns

Heavy Duty Die Cast Construction

with OSHA Safety Tip

Reduces 125-lb. line pressure to 30 lbs. It also features an air cone chip guard and pressure relief holes specified by law.



Item #130814

with Rubber Tip

Great for blowing water out of mold passages

Item #121361

Remember! Always use eye protection when cleaning with air!

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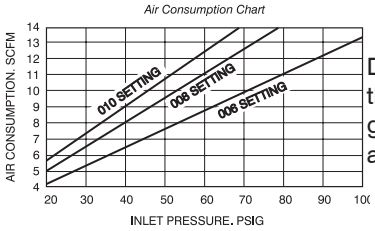
Tips and Accessories

For Use on Heavy Duty Die Cast Air Guns

Specifications and Prices

Item #	Description
118327	**Cleaning Tip:** Wide open tip pressures: 100 - 125 lbs. ⅛ male N.P.T.
118352	**Rubber Cleaning Tip** Wide open tip pressures: 100 - 125 lbs. ⅛ male N.P.T. Great for Blowing Out Mold Passages
118353	**OSHA Safety Tip** Reduces 125-lb. line pressure to 30 lbs.; features air cone chip guard and pressure relief holes specified by law. ⅛ male N.P.T.
104439	**Adjustable Air Saver Tip**  Delivers 25 times greater air flow than actual compressed air input; greatly decreases energy costs and noise levels. ⅛ male N.P.T.
104396	**12" Aluminum Extension Tube** (⅛" N.P.T.)
104321	**Female Quick Disconnect Fitting** Easy tip changing, shuts off air flow on tip removal ⅛ male N.P.T.

Quick disconnect fittings and tips sold separately

Tech Tips

To prevent accidents, always leave a 30 psi safety tip in guns not being used for specific authorized cleaning jobs.

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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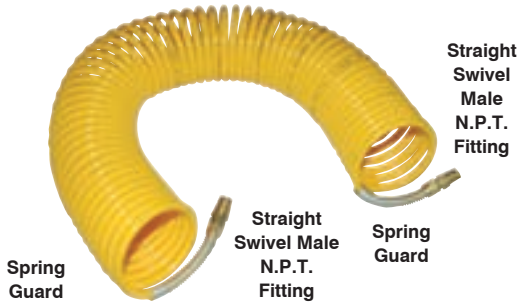
Self-Coiling Air Hoses

IMS Self-Coiling Air Hose Assemblies are Compatible With Most Air Tools That Have N.P.T. Female Thread or Quick-Disconnect Fittings

Nylon Recoil Assemblies

4” coils with male swivel fittings



- Durable Nylon Tubing - Yellow
- 4” Coil Diameter - Compact and easy to maneuver
- Swivel Fittings on Both Ends

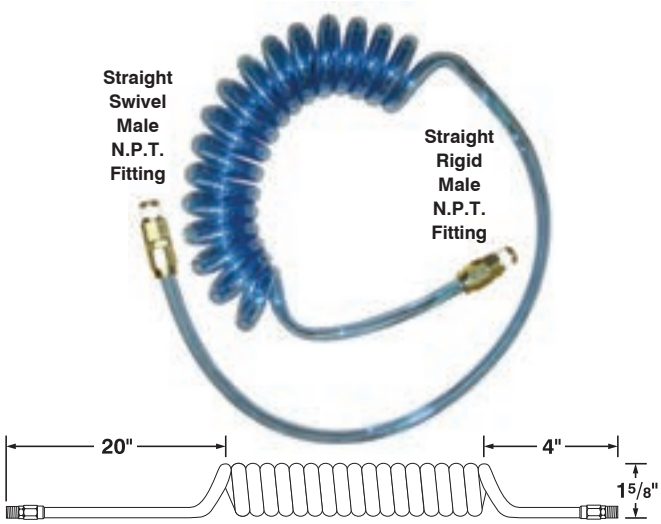
Specifications and Prices

Maximum safe operating pressure: 180 psi

Item #	Hose I.D.	Length
Straight Swivel Male Fittings On Each End		
135039	¼"	50’
135041	⅜"	25’
135042	⅜"	50’
135043	½"	12’
135045	½"	50’

Polyurethane Recoil Assemblies

2” coils with rigid and swivel fittings



- Durable Kink Resistant Polyurethane Tubing - Clear
- 2” Coil Diameter - Compact and easy to maneuver
- Swivel and Rigid Fittings on Either Ends

Specifications and Prices

Working Pressure: 125 psi at 75° F

Item #	Hose I.D.	Length
Straight Swivel Male Fittings On Each End		
118197	¼"	10’
135032	¼"	25’
135034	⅜"	25’
135035	½"	10’
135036	½"	25’

Note: To comply with OSHA Regulation 1910.242(b), select a hose and air gun combination designed to reduce your tip pressure to less than 30 psi when using compressed air for cleaning.

For Air Guns see pages 428-430

For Quick Disconnect Fittings see page 431

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Tech Tips

Eliminate Static and Dust!

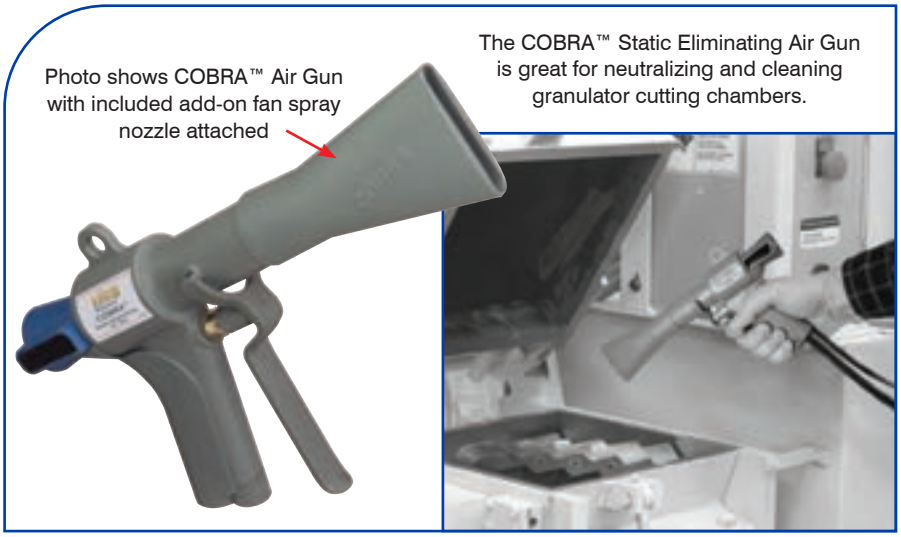
When the air is dry, passing objects strip electrons from each other and develop a static charge. It can cause shocks up to 10,000 volts in people - painful, but not lethal. In plastics production, static can be lethal … to profits. Parts can jam up and dust attraction can ruin the product appearance.

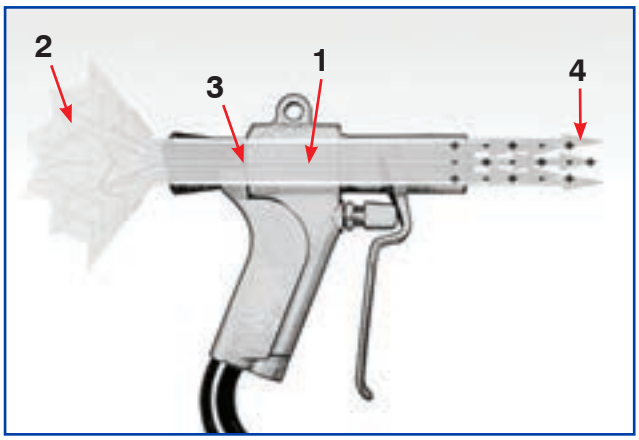
The COBRA™ Air Gun solves the problem by removing the static charge and blowing off dust at the same time.

It is also great for cleaning mixers, hoppers, grinders, storage containers and loaders - anywhere that plastic tends to stick to your machinery. The COBRA™ breaks the static-electric bond between the metal and the dust and fines, then easily blows them away.

At a normal line pressure of 80 PSI, the air gun's high volume stream of ionized air can drop an object's voltage from 5,000 volts to 500 volts in 0.4 seconds at a distance of 3". That is fast.

To minimize air consumption, the COBRA™ uses airflow amplification to induce surrounding room air through the gun at a 3:1 ratio.





Here Is How It Works

Compressed air is released into the barrel of the gun (1) inducing a high volume flow of surrounding air (2) to pass through it. The shockless emitter point (3) ionizes the entire airstream. The result is a high volume flow of ionized air (4) capable of neutralizing high static charges in fractions of a second.

The COBRA™ Air Gun is lightweight and includes a hanger hook for easy storage. The 20 foot power cable is extremely flexible and designed for rugged industrial use. An ergonomic grip allows hours of continuous use without fatigue.

Other advantages include:

- Strong blowoff force and flow
- Shockless, non-radioactive
- Meets OSHA pressure and noise level requirements

If you need help with a static problem, contact our Technical Support Hotline at 1-866-467-9001. IMS has a complete line of static eliminators and will be glad to help you select the appropriate model for your application.

CAUTION: Wear proper safety equipment and follow safety procedures when using compressed air guns.

COBRA™ is a trademark of Simco Industrial Static Control

IMS Company

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Please refer to imscompany.com for current pricing

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COBRA™ Static-Neutralizing Air Gun

Eliminates Static-Caused Particle Attraction on Large and Hard-To-Reach Surfaces

GREEN Products

Simply point and shoot — neutralizes and cleans surfaces at the same time!

Specifications	
Air Gun	
Maximum Pressure:	100 psi*; ¼" N.P.T. connector
Air Consumption:	14 SCFM at 50 psi; 22 SCFM at 100 psi
Outlet Air Pressure:	Pressure relief in gun body complies with OSHA requirements
Outlet Air Flow:	80 CFM at 50 psi; 130 CFM at 100 psi
Ion Balance:	±100 v at 6"
Discharge Time (gun only)):	0.6 seconds at 6" and 30 psi (1,000v to 100v) 0.5 seconds at 6" and 100 psi (5,000v to 500v)
Discharge Time (gun w/ accessory nozzle):	0.7 seconds at 6" and 30 psi (1,000v to 100v 0.5 seconds at 6" and 100 psi (5,000v to 500v)
Noise Level (measured 2 ft. from unit):	92 dB at 30 psi; 96 dB at 60 psi; 101 dB at 100 psi
Weight (gun with 20' cable):	1.5 lbs.
Power Supply	
Input:	120 v, 50/60 Hz., 0.25 A
Output:	5.1 KVAC, 5mA max short circuit current, floating secondary
Size:	5⅜" l x 3⅞" w x 4½" h
Weight:	6.6 lbs.

*Filter/Separator required to remove dirt, compressor oil and water.

Item #130679

Includes: Air Gun with 20 ft. cable, Add-On Fan Spray Nozzle, Storage Hook, Cable Strain Relief and G165 (120v) Power Supply

#134997	Same as above (with 40 ft. cable)
Optional Accessories	
#133242	G165 (120v) Power Supply
#133035	G255 (230v) Power Supply
#133036	Air Gun with 40 ft. Cable
#133037	Air Gun with 20 ft. Cable

COBRA™ is a trademark of Simco Industrial Static Control

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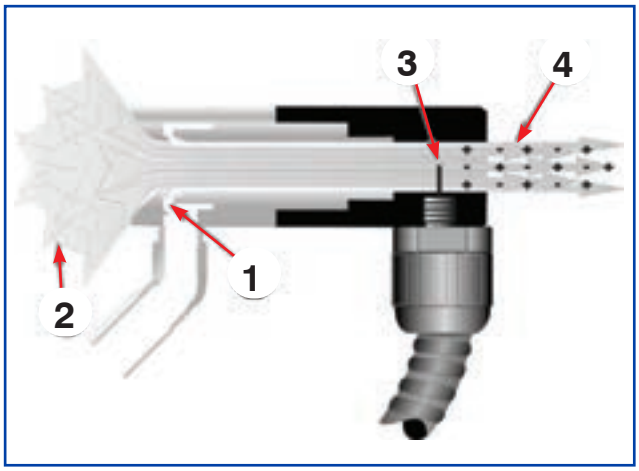
Tech Tips

Eliminate Static and Dust!

When the relative humidity is low (below 40%), your feet strip electrons off the carpet and you eventually experience a painful discharge, often near 10,000 volts. The current is too low to kill people, but can be lethal to machines where parts and materials jam up or where dust attraction ruins the product appearance.

The Ion Air Gun is the solution! It effectively removes the static charge that causes the attraction of dust, plastic particles and fines as well as eliminating static electricity shocks. In addition to cleaning the finished product, it's the easy way to clean molds, mixers, hoppers, grinders, storage containers and loaders.

The Silencer Static Eliminating Air Gun is great for neutralizing and cleaning granulator cutting chambers.



This hand-held ionizer gives you the benefits of rapid static decay along with low compressed air consumption. Surrounding room air is induced through the gun at a ratio of 5:1, minimizing compressed air use and maximizing airflow. The force can be adjusted from a "blast" to a "breeze". At a normal line pressure of 80 PSIG, the high volume stream of ionized air is capable of neutralizing a 5,000 volt charge in 0.18 seconds! That's incredibly fast!

The Ion Air Gun incorporates a High Velocity Air Jet and electrically energized emitter point. A small amount of compressed air is injected into the barrel of the gun (1) inducing a high volume flow of surrounding air (2) to pass through it. The emitter point (shockless) at the discharge end of the gun (3) ionizes the entire airstream. The result is a high volume flow of ionized air (4) capable of neutralizing high static charges in fractions of a second. An optional filter and regulator cleans the compressed air and allows infinite adjustment of airflow and velocity.

The Ion Air Gun is quiet, lightweight and features a hanger hook for easy storage. The 10 foot shielded power cable is extremely flexible, designed for rugged industrial use. A comfortable grip and hand position allows hours of continuous use without fatigue.

Other advantages include:

- Strong blowoff force and flow
- Quiet (less than 80 dBA)
- Shockless, non-radioactive
- Meets OSHA pressure and noise level requirements
- Attractively priced

If you need help with a static problem, contact our Technical Support Hotline at 1-866-467-9001. IMS has a complete line of static eliminators and will be glad to help you select the appropriate model for your application.

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Static Eliminating Ion Air Gun

Effectively Eliminates Static-Caused Particle Attractions Through the Entire Molding Plant!

- Neutralize Static Electricity - point and shoot
- Integrated Ground Design - requires no separate ground connection
- 5:1 Air Amplification - strong adjustable blow-off force and flow
- Shockless, Non-radioactive
- Meets OSHA Pressure & Noise Level Requirements
  - Replaceable emitter point
  - Hanger hook for easy storage
  - Includes 10' extremely flexible, electromagnetically shielded, high voltage cable that protects against abrasion and cuts

Use Wherever Static Electricity is a Problem!

Caution: Wear proper safety equipment and follow safety procedures when using compressed air guns

Pressure Supply		Air Consumption		Sound Level	Dissipates 5kV*
PSIG	BAR	SCFM	SLPM	dBA	Seconds
26	1.4	7.4	209	67	0.45
40	2.8	11.5	325	74	0.33
60	4.1	15.8	447	79	0.24
80	5.5	22.0	622	82	0.18
100	6.9	24.0	679	85	0.18

*6" from target

Compressed Air Consumption: requires 10 PSIG for most applications

Specifications and Prices

Input Voltage:	115/230 VAC (switching)	Air Supply:	
Input Current:	.2/.1 amps max	Connection:	¼" N.P.T. inlet
Frequency:	50/60 Hz	Air Amplification:	5:1 increase in air flow
Output Voltage:	5000 Vrms	Cable Length:	10' long, shielded
Max Ambient Temp:	165°F (74°C)	Electical Hazard:	Shockless (<40 mA short circuited)
Max Range:	Cleans upto 15'	Electrical:	For use with 5 kVrms, 5 mA (max)
Metal Construction:	Brass, zinc and stainless steel	Certifications:	UL, CE and RoHS
Plastic Construction:	UL rated 94 HB	Weight (Air Gun):	2.6 lbs (with cable)

WARNING: DO NOT use near flammable materials or gases

Item #	Model	Description
167261	8193	Static Eliminating Air Gun complete with 10' cable and 1' air supply hose with quick disconnect
167311	8293	Static Eliminating Air Gun Kit complete with 10' cable and 1' air supply hose with quick disconnect and 120 VAC power supply
		Power Supply
167853	7960	2 Outlet 115V Power Supply with 6' Power Cord and Lighted Power Switch
168634	7961	4 Outlet 115V Power Supply with 6' Power Cord and Lighted Power Switch

NOTE: Old style guns (118158 and 121182) must use old style power supplies

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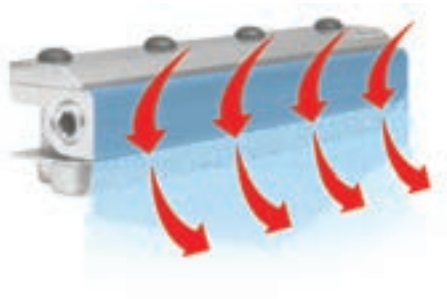
GREEN Products

Gen4 Air-Operated Air Knife Ionizer

Neutralize Static Charges



30% improved performance at lower pressures – saves compressed air and money!

The EXAIR-Ionizer™ solves the problems of static charge build-up. Use on parts conveyors, parts discharge chutes, machine beds and worktables. Quickly and safely neutralizes static electricity on plastic parts, eliminating sticking parts, dust attraction and static shock hazards. Easy to install and use. Simply connect clean air and a power supply and mount close to the parts.

- Ionizing range: up to 20'
- Cleans parts as it neutralizes
- Bar lengths from 6" to 48"
- Duplex outlet for use with two bar assemblies. Quadruple outlet optional.
- 6' grounded power cord with plug
- Ionizing bar with 5' connector cable
- Switchable power supply (115/230/60/1)
- ¼"-18 N.P.T. air supply inlet

Note: Do not use near flammable materials or gases. Power supply, ionizing bar, and mounting surface must be well grounded.

The EXAIR-Ionizer™ has no moving parts. With proper filtration, it will operate for years with no maintenance required. (Proper filter must be used to maintain warranty.)

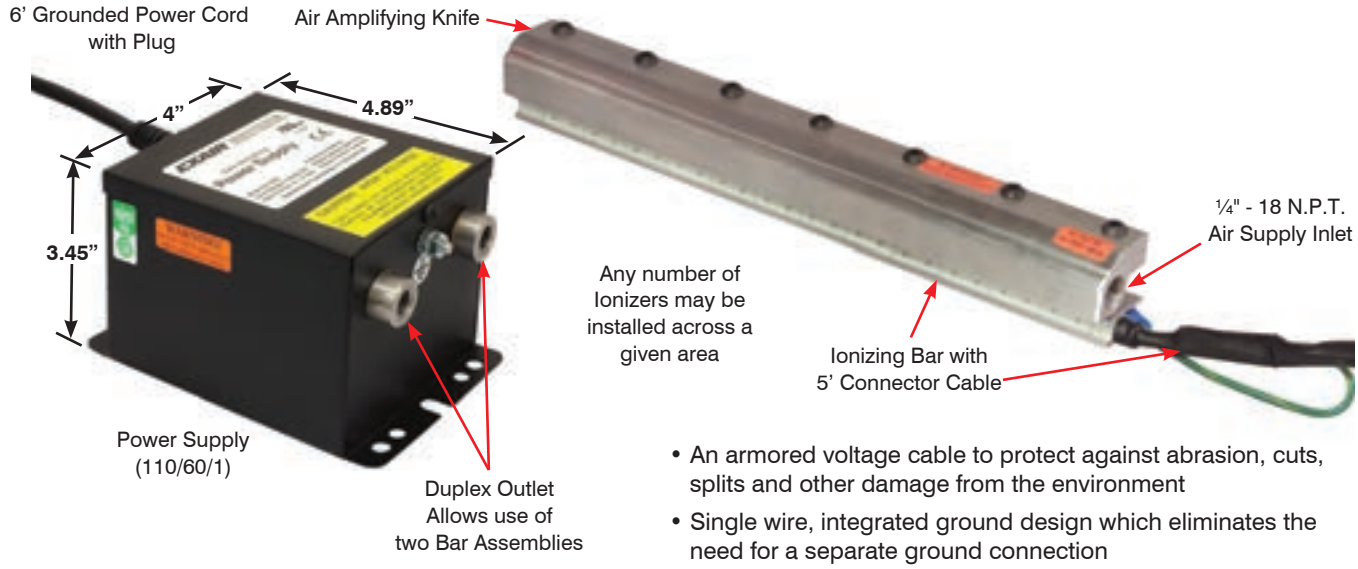
How the EXAIR-Ionizer™ works

The EXAIR-Ionizer™ consists of an EXAIR-Knife™ (see page 490) an electrically operated, air-ionizing bar, which creates a curtain of ionized air. This charged field of both positive and negative ions, imparts a balancing charge to any material passing near it. Though positive and negative ions recombine quickly, the air knife's high velocity air stream delivers the ion cloud to the work surface before the ions have an opportunity to recombine. Thus, the EXAIR-Ionizer™ can achieve effective neutralization at distances not possible before. The high velocity air stream from the EXAIR-Knife™ also blows loose dust and dirt from the neutralized surface.

Gen4 Standard Ion Air Knife Performance

Pressure Supply		Air Consumption*		Sound Level	Dissipates 5kV**
PSIG	BAR	SCFM	SLPM	dBA	Seconds
5	0.3	6	170	66	0.38
10	0.7	8	227	68	0.28
20	1.4	15	453	69	0.29
40	2.8	24	679	78	0.21
60	4.1	32	905	84	0.21
80	5.5	41	1160	87	0.21
100	6.9	49	1387	90	0.21

*per foot of length **6" from target



- An armored voltage cable to protect against abrasion, cuts, splits and other damage from the environment
- Single wire, integrated ground design which eliminates the need for a separate ground connection
- Electromagnetic shielding in all cables to protect electronics

EXAIR® and EXAIR-Ionizer™ are trademarks of EXAIR Corp.

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Please refer to imscompany.com for current pricing

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Specifications and Prices

Construction: Knife - aluminum (stainless steel available)
Ionizing bar:
– emitters - stainless steel
– bar channel - aluminum
– plastic parts - UL rated 94HB
Ionizing bar cable will withstand 50kV peak for 5 min.

Max. Ambient Temperature: 165°F (73°C)

Certifications: Ionizing bars are UL component recognized (CSA certified)

Output: 5 kVrms for a sine wave or 7kVpeak for other wave forms (Use power supply limited to 5 mA max.)

Electrical Hazard: Shockless (less than 0.04 mA per point short circuited)

Air Inlets: ¼" NPT on both ends

	Air Knife and Ionizing Bar	Air Knife, Ionizing Bar and Power Supply	
Air Flow Length*	Item #	Item #	Air Consumption† at 80 psi
3"	170563	170573	10.20 CFM
6"	170564	170574	20.40 CFM
9"	170565	170575	30.60 CFM
12"	170566	170576	40.80 CFM
18"	170567	170577	61.20 CFM
24"	170568	170578	81.60 CFM
30"	170569	170579	102 CFM
36"	170570	170580	122.40 CFM
42"	170571	170581	142.80 CFM
48"	170572	170582	163.20 CFM

Special length Ionizing Bars up to 119" are available — Inquire

Spare Parts

	Ionizing Bar and Cable Only	Standard Air Knife Only
Air Flow Length*	Item #	Item #
3"	170553	144313
6"	170554	104468
9"	170555	144314
12"	170556	104467
18"	170557	104471
24"	170558	104470
30"	170559	104469
36"	170560	144310
42"	170561	144311
48"	170562	144312

*Actual length of knife is 1" greater than air flow length

NOTE: Air Knives can be combined for longer lengths. Due to the ½" of dead-space on each end of the knife, end to end mounting leaves 1" gaps in the air curtain. See Super Air Knife (page 443) for continuous end to end coverage.

See Optional Accessories on next page
(Shim Kits, Multiple Outlet Power Supplies, etc.)

Warning: Do not use near flammable materials or gases. Power supply, ionizing bar, and mounting surface must be well grounded.

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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GREEN Products

Air-Operated Air Knife Ionizer

Optional Accessories

Optional Accessories	
144315	3” Air Knife Shim Kit
134267	6” Air Knife Shim Kit
144316	9” Air Knife Shim Kit
134268	12” Air Knife Shim Kit
134269	18” Air Knife Shim Kit
144317	24” Air Knife Shim Kit
144318	30” Air Knife Shim Kit
144319	36” Air Knife Shim Kit
144320	42” Air Knife Shim Kit
144321	48” Air Knife Shim Kit
104454	Air Filter for #104450, #104447
104452	Air Filter for#104446, #104445, #104455
104451	Air Regulator for #104450, #104447
104448	Air Regulator for #104446, #104445, #104455
167853	2 Outlet Power Supply 115V
168634	4 Outlet Power Supply 115V
144339	Universal Air Knife Mounting System (use 2 mounting kits for knives over 24” long)

Tech Tips

Install a pressure gauge right before your air knife to insure you are receiving an accurate pressure reading. Use a tooth brush to keep Static Air Knife Ionizer clean for consistent operation.

Upgrade to a Super Air Knife

Greater air amplification with less noise.

Quiet (Approx. 69 dBA for most applications)
20-30 dBA less than wide open blow-offs

¼” N.P.T. Compressed Air Inlets on both ends PLUS two more on bottom which can also be used for mounting
NOTE: Lengths 24” and longer should be supplied with compressed air at each end to maintain uniform air flow

5 Year Warranty

Body

Cap

40:1 Air Amplification
Compressed air savings of 40 to 90% over drilled or slotted pipe

Aluminum Construction
(For corrosive and/or high temperature environments or for food processing applications, ***ask about our stainless steel super air knives)***

Safe To Operate At Higher Pressures
Cannot Be “Dead-Ended”

Variable Velocity
Thickness of Plastic Shim between cap and body (.002” standard) determines force and flow of air stream. Thicker and thinner Shims (sets available below) can be used to increase or decrease airflow. A pressure regulator on the compressed air supply provides infinite control of flow, force and air consumption.
NOTE: Use of an Air Filter Separator is essential for proper operation.

Recessed hardware for easier mounting

Air Flow Across Entire Length
6”, 12”, 18”, 24” or 30”

Compact Easy To Mount
Can be supported by the compressed air supply pipe.

Any number of knives may be installed across a given area

See page 443 for details

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High Volume Ion-Air Cannon™

Neutralizes Static at Distances up to 15 Feet!

22:1 Air Amplification

Stainless Steel Connections

115/230V Selectable Power Supply -
to operate the ionizing point

Integrated Ground Design -
requires no separate ground connection

Shockless, Non-radioactive

Meets OSHA Pressure & Noise Level Requirements

- Replaceable emitter point
- Includes 5' extremely flexible, electro-magnetically shielded, high voltage cable

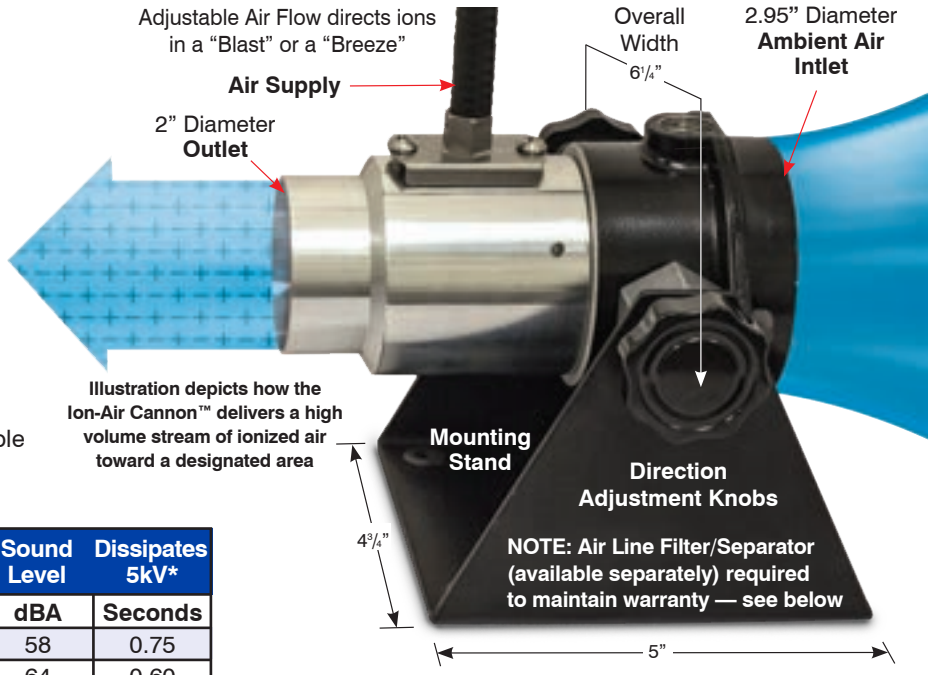

Illustration depicts how the Ion-Air Cannon™ delivers a high volume stream of ionized air toward a designated area

Pressure Supply		Air Consumption		Sound Level	Dissipates 5kV*
PSIG	BAR	SCFM	SLPM	dBA	Seconds
26	1.4	5.7	161	58	0.75
40	2.8	11.5	255	64	0.60
60	4.1	12.2	345	70	0.50
80	5.5	15.5	439	72	0.43
100	6.9	18.7	529	74	0.37

*12" from target

Compressed Air Consumption: requires 10 PSIG for most applications

Specifications and Prices

Input Voltage:	115/230 VAC (switching)	Air Supply Connection:	⅜ N.P.T. inlet
Input Current:	.2/.1 amps max	Air Amplification:	22:1 increase in air flow
Frequency:	50/60 Hz	Cable Length:	5' long, shielded
Output Voltage:	5000 Vrms	Electical Hazard:	Shockless (<40 mA short circuited)
Max Ambient:Temp:	165° F (74° C)	Electrical:	For use with 5 kVrms, 5 mA (max)
Max Range:	Cleans upto 15'	Certifications:	UL, CE and RoHS
Metal Construction:	Brass, zinc and stainless steel	Weight (Air Gun):	3.5 lbs (model 8192)
Plastic Construction:	UL rated 94 HB		

WARNING: DO NOT use near flammable materials or gases

Item #	Model	Description
170051	8292	Ion Air Cannon includes Super Air Amplifier, Emmitter, Stand and 5' length of armored and electromagnetically shielded cable
		Power Supply
167853	7960	2 Outlet 115V/230V Power Supply with 6' Power Cord and Lighted Power Switch
168634	7961	4 Outlet 115V/230V Power Supply with 6' Power Cord and Lighted Power Switch
		Accessory
104454		Air Line Filter/Separator (3/8" N.P.T.)

Ion-Air Cannon™ is a trademark of EXAIR Corp.

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GREEN Products

Standard Air Knife™

Produces a Linear, High Velocity Curtain of Air

For non-contact blow-off, cleaning, drying and cooling of molded parts on conveyors, work tables, etc.

30:1 Air Amplification

Compressed air savings of 40 to 90% over drilled or slotted pipe

Quiet

(Approx. 83 dBA for most applications)

10-20 dBA less than wide open blow-offs

Aluminum Construction

(For corrosive and/or high temperature environments or for food processing applications, ask about our stainless steel air knives)

- Any number of knives may be installed across a given area
- A great alternative to bulky, noisy, high maintenance electric blowers!
- Compact - easy to mount
- Can be supported by compressed air supply pipe.

Variable Velocity

Thickness of Plastic Shim between cap and body (.002" standard) determines force and flow of air stream. Thicker and thinner Shims (sets available below) can be used to increase or decrease airflow. A pressure regulator on the compressed air supply provides infinite control of flow, force and air consumption.

NOTE: Use of an Air Filter Separator is essential for proper operation. ***See below if needed.***

5 Year Warranty

Item #	Air Flow Length*	Item #	Air Flow Length*
144313	3"	104470‡	24"
104468	6"	104469‡	30"
144314	9"	144310‡	36"
104467	12"	144311‡	42"
104471	18"	144312‡	48"

Air Knives may be combined for added length. Non-standard lengths up to 48" can be custom made.
‡ Length of 24" or more not recommended for use with IMS Air Differential Blow-Off System. Can be used with solenoid or other actuator methods with larger air supply lines.

**NOTE: Actual length of knife is 1" greater than air flow length. Due to the ½" of dead-space on each end of the knife, end to end mounting leaves 1" gaps in the air curtain.*

Optional Accessories

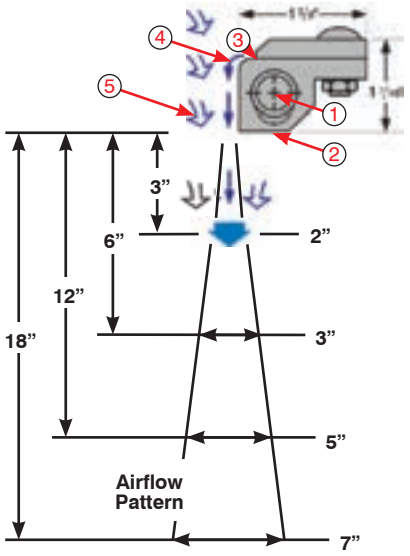
Standard Air Knife Shim Sets

(include 1", 3" and 4" thick plastic shims - 1 of each)

144315	for 3" Air Knife	144317	for 24" Air Knife
134267	for 6" Air Knife	144318	for 30" Air Knife
144316	for 9" Air Knife	144319	for 36" Air Knife
134268	for 12" Air Knife	144320	for 42" Air Knife
134269	for 18" Air Knife	144321	for 48" Air Knife
Pressure Regulator			
104451	¼" N.P.T.		
134259	½" N.P.T.		
104448	¾" N.P.T.		
Auto Drain Filter Separator			
104454	⅜" N.P.T		
134260	½" N.P.T.		
104452	¾" N.P.T.		
144339	Universal Air Knife Mounting System		

(use 2 mounting kits for knives over 24" long)

How It Works



Compressed air flows through an inlet (1) into a plenum chamber (2). It is then throttled through a thin nozzle (3) extending the length of the Standard Air Knife. This primary airstream adheres to the coanda profile (4), which turns it 90° and directs the flow down the face of the unit. The primary stream immediately begins to entrain surrounding air (5), for amplification ratios of 30:1 at 6" (152 mm) away.

No moving parts — nothing to wear out or break!

Standard Air Knife™ *is a Trademark of EXAIR Corp.*

For even greater performance and savings, see the Super Air Knife on the next page

IMS Company

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Please refer to imscompany.com for current pricing

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Super Air Knife™

Produces a Quiet, Hard Hitting Curtain of Air

For non-contact blow-off, cleaning, drying and cooling of molded parts on conveyors, work tables, etc.

GREEN Products

40:1 Air Amplification

Compressed air savings of 40 to 90% over drilled or slotted pipe

Quiet

(Approx. 69 dBA for most applications)

20-30 dBA less than wide open blow-offs

Aluminum Construction

(For corrosive and/or high temperature environments or for food processing applications, ask about our stainless steel air knives)

Safe to operate at higher pressures
Cannot be "dead-ended"

- Any number of knives may be installed across a given area
- Recessed hardware for easier mounting
- Compact - easy to mount
- Can be supported by compressed air supply pipe.

Item #	Air Flow Length*	Item #	Air Flow Length*
144340	3"	133924‡	24"
133921	6"	144342‡	36"
144341	9"	144343‡	42"
133922	12"	144344‡	48"
133923	18"		

Air Knives may be combined for added length.
Non-standard lengths up to 48" can be custom made.
‡ Length of 24" or more not recommended for use with IMS Air Differential Blow-Off System. Can be used with solenoid or other actuator methods with larger air supply lines.

Optional Accessories

Standard Air Knife Shim Sets
(include 1", 3" and 4" thick plastic shims - 1 of each)

144345	for 3" Air Knife	144347	for 30" Air Knife
134272	for 6" Air Knife	144348	for 36" Air Knife
144346	for 9" Air Knife	144349	for 42" Air Knife
134273	for 12" Air Knife	144350	for 48" Air Knife
134274	for 18" Air Knife		
Pressure Regulator			
104451	¼" N.P.T.		
134259	½" N.P.T.		
104448	¾" N.P.T.		
Auto Drain Filter Separator			
104454	⅜" N.P.T		
134260	½" N.P.T.		
104452	¾" N.P.T.		
Coupling Bracket Kit (Aluminum)			
134277	Joins two Super Air Knives together		
144339	Universal Air Knife Mounting System (use 2 mounting kits for knives over 24" long)		
147559	Mounting bracket required for use w/ Ionizing Bars* (2 brackets for knives up to 24" long. 3 brackets for 25"+)		

*Convert your Super Air Knife to a Static Eliminating Ionizing Super Air Knife by adding an Ionizing Bar (see page 438). Match the air flow lengths of the Super Air Knife and the Ionizing Bar and then add mounting brackets.

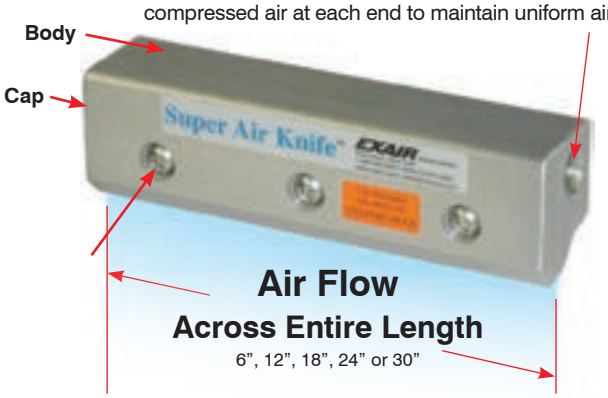
Super Air Knife™ *is a Trademark of EXAIR Corp.*

Variable Velocity

Thickness of Plastic Shim between cap and body (.002" standard) determines force and flow of air stream. Thicker and thinner Shims (sets available below) can be used to increase or decrease airflow. A pressure regulator on the compressed air supply provides infinite control of flow, force and air consumption.

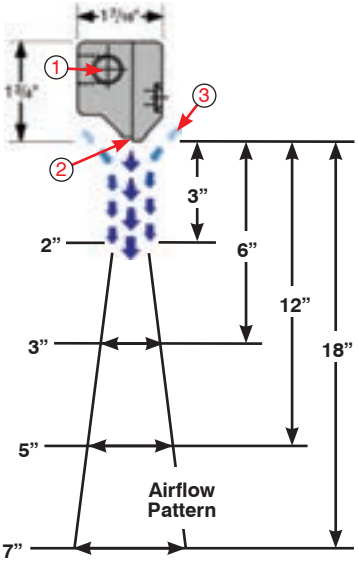
NOTE: Use of an Air Filter Separator is essential for proper operation. ***See below if needed.***

¼" N.P.T. Compressed Air Inlets on both ends + two more on bottom which can also be used for mounting
NOTE: Lengths 24" and longer should be supplied with compressed air at each end to maintain uniform air flow



5 Year Warranty

How It Works



Compressed air flows through an inlet (1) into the plenum chamber of the Super Air Knife. The flow is directed to a precise, slotted orifice. As the primary airflow exits the thin slotted nozzle (2), it follows a flat surface that directs the airflow in a perfectly straight line. This creates a uniform sheet of air across the entire length of the Super Air Knife. Velocity loss is minimized and force is maximized as the room air (3) is entrained into the primary airstream at a ratio of 40:1. The result is a well defined sheet of laminar airflow with hard-hitting force and minimal wind shear.

No moving parts — nothing to wear out or break!

The Universal Air Knife Mounting System is used to provide secure, precise positioning for any Air Knife. The Air Knife can quickly and easily be moved within close proximity of the part to improve effectiveness. It has durable, stainless steel construction.
(Maximum extension is 30" and requires a ½" dia. hole for mounting or ½"-13 tapped hole to be threaded into.)

#144339
Universal Air Knife
Mounting System

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Static Meter

Detects and Measures Static Charges

Helps You Identify Where Static Is Most Prevalent

Facilitates The Positioning Of Static-Eliminating Ionizers

- Lightweight, Portable
- Hand Held, One-Button Operation
- Non-Contact Measurement
- Battery Operated
- Factory Set — No Adjustments

Range: 0 to ± 20 kV at 1”
Distance: Meter reads true at 1” from the test surface
Accuracy: ±10% of full scale
Dimensions: 4.14” (10.6cm) long, 2.4” (6.1cm) wide, 875” (2.2cm) thick
Weight: 4 oz. (113g)
Battery: 9 volt (Eveready 216)

Photo shows how easy it is to use the Static Meter. Just point it at test part. Meter detects both the intensity and polarity of static charges.

Item #122691
Includes: Battery and Carrying Case

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fax order toll-free (USA & Canada) 1.888.288.6900 | phone order toll-free (Mexico) 001.888.304.1307 | tech support toll-free (USA & Canada) 1.866.467.9001 | e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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High Volume Static Eliminators

Neutralize Molded Parts up to 10 Feet Away!

Perfect for Molding Room and Packaging Applications!

Mount directly above:

- Parts Conveyors
- Part Discharge Chutes
- Machine Beds
- Work Tables, etc.

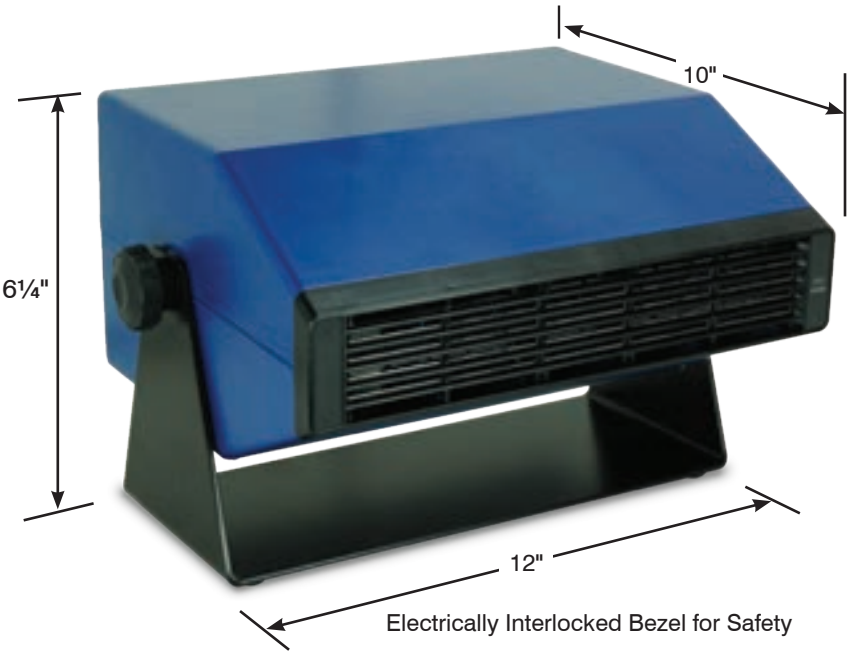
STOP

- Static cling, dust attraction, shock hazard

Self-Contained — easy to install and use

Simple Angle Adjustment and Variable Speed Fan Maximize Coverage Area

UL and CUL Certified

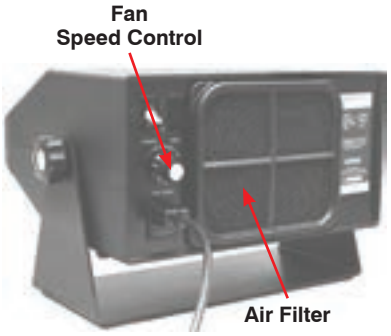


Electrically Interlocked Bezel for Safety

Specifications

- Line Voltage: 115/60/1
- Power: 45 Watts
- Fuse: 1.0 amp
- Air Volume: Variable 100-255 cfm
- Air Velocity: 850 fpm at 2 ft. distance (maximum fan speed setting)
- EMI/RFI: Complies with FCC Part 15 requirements for Class A equipment

OPTIONAL
Adjustable stand for easy positioning and optimum effectiveness



High Volume Static Eliminator
Item #104453

Complete with Filter Housing, 5 Filters and Instructions

Optional	
112718	Adjustable Stand
Spare Parts	
123198	Air Filter (Packs of 10)
137928	Replacement Clip for Filter

Tech Tips

Check filters at the beginning of each shift.

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Heavy Duty Gloves

Protect Fingers From Burns, While Keeping Hands Cool, Prevent Finger Marks on Molded Parts

• Stretchable • Seamless • Washable

Heavy Duty Cotton Gloves

- Knitted elasticized wrist
- Fit either hand
- Three sizes fit all

NOTE: actual color may vary

#101068	#101100	#165012
Small	Large	Extra Large

Sold by the dozen

Heavy Duty Open Finger Safety Gloves

Allow greater dexterity to hold tools, writing instruments, etc.

- Heavy weight cotton and polyester knit
- Keep hands cool
- Reversible
- Elasticized wrist band
- Fit either hand
- One size fits most

NOTE: actual color may vary

Item #133885

Sold by the dozen

Medium Duty Gloves

Medium Duty Gloves with PVC Grips

- Anti-slip PVC dots on both sides improve grip
- 60% cotton / 40% polyester
- Can be worn on either hand
- One size fits all

NOTE: actual color may vary

Item #130255

Sold by the dozen

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Please refer to imscompany.com for current pricing

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Hot Nozzle Gloves

Help Prevent Accidental Burns!

Use them for quick transfer of hot Nozzles, Screws, Screw Tips, Molds, Water Lines, Heater Bands, etc.

Hot Nozzle Gloves With Anti-Slip Coating

- Heat resistant up to 400°F (short duration)
- Special nitrile rubber coating improves grip — prevents slipping
- Comfortable and breathable 100% cotton
- Extra thick inner liner resists heat
- Can be worn on either hand
- One size fits all

NOTE: actual color may vary

Item #110671

Sold in pairs

Hot Nozzle Gloves With Extra Long Cuff

- Heat resistant up to 450°F (short duration)
- 5” gauntlet cuff for wrist protection
- Beige with black binding
- 28 oz. jumbo 100% cotton knit, terrycloth
- Reversible — can be worn on either hand
- One size fits all

NOTE: actual color may vary

Item #164767

Sold in pairs

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IMS Select Cut-Resistant Gloves

Shield Hands From Lacerations and Hot Surface Contact

These gloves are especially useful around granulators and grinders to resist cuts from blades.

- Patented stainless steel, nylon and Kevlar® material
- Lightweight material "breathes" to dissipate heat
- Long cuff for added wrist protection
- Gloves fit either hand
- USDA approved
- Machine washable (drip dry)

Protect Workers & Minimize Lost Man-Hours

NOTE: actual color may vary

Warning:
Gloves are cut-resistant but NOT cut-proof or puncture-resistant. Do not use with power driven or serrated blades.

#106044	#106043	#106041
Small	Medium	Large

Kevlar® is a registered trademark of E. I. du Pont de Nemours and Company or its affiliates

Check Out These Other Useful IMS Products!

Utility Knives

5½" Flash-Trimming Knife with extra thick, heavy duty handle. Includes one 15A, 45° angled blade.

Item #137579

ALLWAY 6⅜" Retractable, Break-Away-Blade Utility Knife. With lightweight, durable ABS Handle. Includes one, 7 point break-away blade

Item #108651

See Pages 315 - 324 for more information

Work Gloves

Quality Hand Protection at Economical Prices!

Suede Work Gloves

For Heavy Duty Jobs

- Reinforced sewn knuckle straps
- 3" band topped cuff
- White with Gray and Red Striped Cuff
- One size fits all

NOTE: actual color may vary

Item #137537

Jersey Work Gloves

For Light Duty Jobs

- Stretch for comfort
- Elasticized wrist
- Washable
- Brown
- One size fits all

NOTE: actual color may vary

Item #137612

Sold by the dozen

Other hand, arm, ear, and eye safety equipment available — Inquire

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Please refer to imscompany.com for current pricing

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Light Duty Gloves

Help Keep Molded Parts Clean and Free of Finger Oils

Lint-Free Gloves

- Soft, lightweight and lint-free
- Comfortable and stretchable
- Can be worn on either hand

NOTE: actual color may vary

#105701	#134486	#105702
Polyester (Small)	Nylon (Medium)	Nylon (Large)

Sold by the dozen

Light Duty Cotton Gloves

- Soft, lightweight and stretchable
- 100% white cotton
- Reversible - can be worn on either hand

NOTE: actual color may vary

#100979	#100947
(Small)	(Large)

Sold by the dozen

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Cut-Resistant Arm Guards

Shield Arms From Lacerations

Heavy Duty, Cut-Resistant Arm Guards

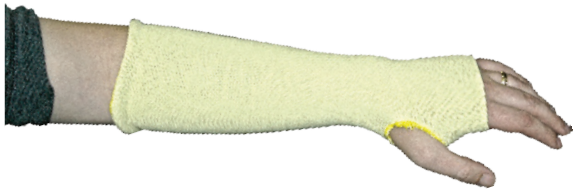
- Maximum arm cut resistance
- Made from high strength fibers and stainless steel
- 10” and 22” lengths
- 22” guard clips to shirt-sleeves
- USDA approved
- Machine washable (drip dry)

Medium Duty, Cut Resistant Arm Guards

- Made from stainless steel and cut-resistant fibers
- 10” length
- USDA approved
- Machine washable (drip dry)

Low cost, Cut-Resistant Forearm Sleeves

- Made from 100% Kevlar® fibers
- Extend to provide partial hand protection
- Available with non-slip top
- Guards fit either arm



Warning: Cut-Resistant Arm Guards are cut-resistant but NOT cut-proof or puncture-resistant. Do not use with power driven or serrated blades.

Item #	Description
116864	Heavy Duty Arm Guards (10” forearm sleeve)
116879	Heavy Duty Arm Guards (22” forearm sleeve with clip)
108041	Medium Duty Arm Guards (10” forearm sleeve)
121964	Low Cost Forearm Sleeves with thumb hole (14” with nonslip top)

Kevlar® is a registered trademark of E. I. du Pont de Nemours and Company or its affiliates

Made in the U.S.A

Leather Finger Cots

Use To Protect Specific Fingers From Scratches and Cuts

Perfect when full gloves are too prohibitive

Soft, Split Leather - Comfortable and pliable

Wide Elastic Band - Holds cot securely in place

Open Ended - One Size fits all!

Item #116526

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Finger Safety Tape

Makes Handling Parts Easier — Safer

16 rolls per package

#101120

"Improves Grip!"

Easy to apply

Simply pinch together...

...Then wrap around

Finger Safety Tape is a self-adhering safety tape made of surgical gauze and natural rubber particles. It will stick only to itself, not to hair, skin or clothing because of the composition of the non-adhesive material. Finger Safety Tape is dry to the touch and is not affected by moisture.

- Basic finger protection - Maximum dexterity
- Helps prevent burns, cuts & abrasions
- Cleaner parts handlingmeans fewer rejects
- Low cost - use & discard

Finger Safety Tape Each Roll: ¾" wide x 30 yards long	
Item #	**Color**
100975	White
108428	Peach
101120	Green
108429	Blue

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Particulate Respirators

Help Keep Your Operators Safe and Productive

- PeakFit, N95 Approved, Vent For Exhalation
- Certification: NIOSH 42 CFR 84 N95
- Adjustable metal nose piece provides a custom fit and secure seal
- Non-latex, elastic head straps
- 95% Efficient for Non-Oil
- Disposable

- TruAir® Mask by Gateway Safety
- Meets NIOSH 42CFR84 N95 requirements *TC-84A-0007
- Adjustable metal nose piece provides a custom fit and secure seal
- Non-latex, elastic head straps
- 95% efficient for Non-Oil
- Disposable

- Certification: NIOSH 42 CFR 84 N95
- Electrostatic Media
- Welded strap attachment for durability
- Soft nose form for comfort
- Nose clip to ensure custom seal

WARNING: These Dust Masks do not supply oxygen. Use in atmospheres containing at least 19.5% oxygen. Change mask if breathing becomes difficult, mask is physically damaged, or if you can smell or taste the contaminant.

Do Not Use These Respirators For: Paint spray, oil aerosols, gases, vapors, asbestos or sandblasting.

*At least 95% filtration efficiency when subjected to a 0.3μm MMAD Sodium Chloride particle challenge. Filter performance will be greater against larger non-oil based particles.

Item #	Description
173338	Particulate Respirator with Exhalation Valve
173333	Particulate Respirator with Exhalation Valve
121677	Particulate Respirator

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Process Trouble-Shooting Guidelines

Problem	CRYSTALLINE MATERIALS Lower/Reduce	CRYSTALLINE MATERIALS Raise/Increase	AMORPHOUS MATERIALS Lower/Reduce	AMORPHOUS MATERIALS Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

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Process Trouble-Shooting Guidelines

Problem	CRYSTALLINE MATERIALS Lower/Reduce	CRYSTALLINE MATERIALS Raise/Increase	AMORPHOUS MATERIALS Lower/Reduce	AMORPHOUS MATERIALS Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

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Universal Absorbent Roll in 2-Roll Bale

Use it like a:

- Pad
- Roll
- Strip
- Sock
- Wipe

- Absorbs: Oil, water and non-aggressive petroleum and water-based products
- Scuff resistant top surface improves durability and appearance
- Floor-hugging bottom surface helps hold mat in place

	Size	Absorb
Mat	15” w x 150’ l	28 gal./roll

Item #	Description
173234	Universal Absorbent Roll in 2-Roll Bale

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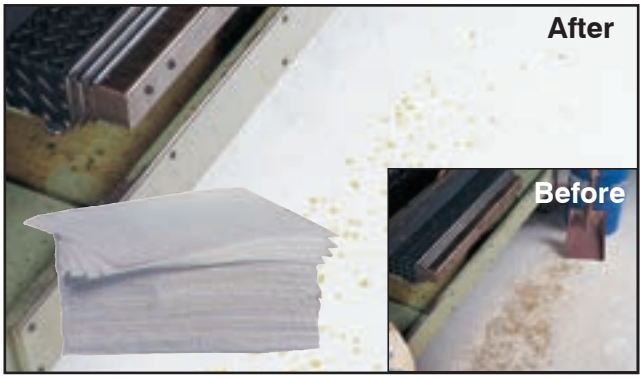
Oil-Only Economy Absorbent Pads

For Everyday Drips, Leaks and Overspray

- Effectively absorb petroleum-based liquids
- Can be used to skim oil off water
- Incinerable to less than .02% ash: high BTU value, 22,000 BTU's per pound



	Size	Absorb
Pads	16" w x 20" l	37 gal./bag (100 pads)

Item #	Description
131343	Double Weight Oil-Only Economy Pads (100 pads)

Universal Economy Absorbent Pads and Rolls

Suitable For Controlling/Cleaning Most Any Leak, Spill or Drip

Absorb just about everything!

- Oil
- Water
- Coolants
- Solvents
- Acids
- Bases
- Fuels
- and more

Ultrasonic Bonding

- Hastens absorption
- Increases durability
- Prevents linting

Medium Gray Color

- Hides grime

DAWG is a registered trademark of DAWG Corp.

	Size	Absorb
Pads	16" w x 20" l	25 gal./bag (100 pads)
Rolls	30" x 200' l	60 gal./roll

Item #	Description
131340	Universal Economy Pads (100 pads)
131341	Double-Weight, Universal Economy Roll (1 roll)

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tech support toll-free (USA & Canada) 1.866.467.9001
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WD-40® The Original Multipurpose Spray

Use on Molds, Machinery and All Around Your Shop

- Frees rusted metal parts
- Provides positive rust protection
- Non conductive

Specifications	
Appearance:	Clear or slightly cloudy
Color:	Light amber
Odor:	Very slight pleasant odor
Flash Point:	110°F open cup (min.)
Boiling Point:	300°F (min.)

Bulk Liquid

Item #	Description
105341	WD-40® (1-gal. container)
105347	16 oz. Refillable Spray Bottle (empty)

Aerosol Spray with Smart Straw™

- Never lose another nozzle extension tube
- Smart Straw permanently attached

Item #	Description
137084	WD-40® (12 oz. spray)

Attention California Customers:
Due to California laws and regulations, this standard formula WD-40 cannot be sold into California.
You must purchase the Low-VOC formula locally.

Smart Straw™ are a trademarks of WD-40 Company WD-40® is a registered trademark of WD-40 Company

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Process Trouble-Shooting Guidelines

Problem	CRYSTALLINE MATERIALS Lower/Reduce	CRYSTALLINE MATERIALS Raise/Increase	AMORPHOUS MATERIALS Lower/Reduce	AMORPHOUS MATERIALS Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

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Process Trouble-Shooting Guidelines

Problem	CRYSTALLINE MATERIALS Lower/Reduce	CRYSTALLINE MATERIALS Raise/Increase	AMORPHOUS MATERIALS Lower/Reduce	AMORPHOUS MATERIALS Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

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Process Trouble-Shooting Guidelines

Problem	CRYSTALLINE MATERIALS Lower/Reduce	CRYSTALLINE MATERIALS Raise/Increase	AMORPHOUS MATERIALS Lower/Reduce	AMORPHOUS MATERIALS Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

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Dura-Driver™ 7 in 1

This hand tool drives a variety of fasteners and nuts.

- Rear taper tri-oval handle permits effective handling
- Extra long, tri-oval shape reduces tension at pressure points, improving comfort
- Non-slip grip allows higher torque
- Interchangeable bits provide power and versatility
- Strong S2 steel bits offer long service
- Handle Length: 5”
- Overall Length: 8¼"

Item #	Description
122720	DURA-DRIVER™ 7 in 1

Brass Screwdriver

- SAFE — Will not scratch molds
- ⅜" diameter
- Straight with flared tip
- Oversized plastic grip for easier handling

Item #	Description
141788	Brass Screwdriver

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Lufkin® Yellow Clad Tape

- Large, easy action winding drum with friction washers
- Manufactured to US standard Department of Commerce .005" thick
- 3/8" wide, yellow clad steel blade
- Fitted with folding hook ring
- 1/8" at 1' increment

Item #	Description
161393	50' Tape Measure
161394	100' Tape Measure

Quikread Decimal/Fraction Measuring Tape

- 25' tape length
- End hook with built-in shock absorber
- Clear coat tape protection with non-glare finish
- Positive toggle lock holds blade for measurement
- Durable ABS high-impact case with 3" base
- Ergonomic shape for operator comfort
- Fully inspected for accuracy
- Easy read design — all measurements marked

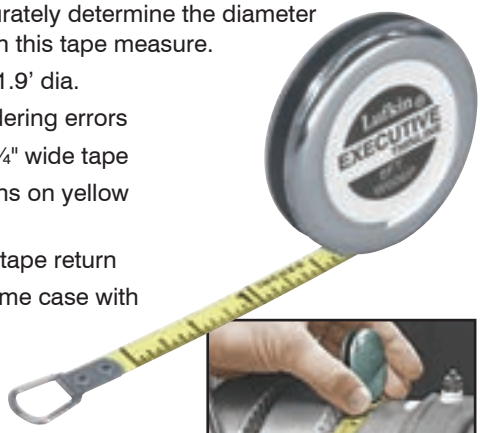
Easy to read vertical numbering

Item #	Description
122725	Quikread Measuring Tape

Circumference Tape Measure

Quickly and accurately determine the diameter of your barrel with this tape measure.

- Standard: 6', 1.9' dia.
- Eliminates ordering errors
- Replaceable ¼" wide tape
- Bold gradations on yellow background
- Spring action tape return
- Polished chrome case with non-slip grip



TOP

Regular Tape

BOTTOM

Diameter Tape

Item #	Description
120125	Lufkin® Tape Measure (standard, 6', 1.9' dia.)

Radius or Orifice Gauge

See Page 511

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Magnetic Tape Measure

- Dual sided tape — read either side
- Dual sided hook — grabs either way
- Color: green and black
- 1” wide blade
- Slide lock

Dual sided magnetic hook

Item #	Description
160229	30’ Magnetic Tape Measure

Feeler Gauges

Measure the gap between materials

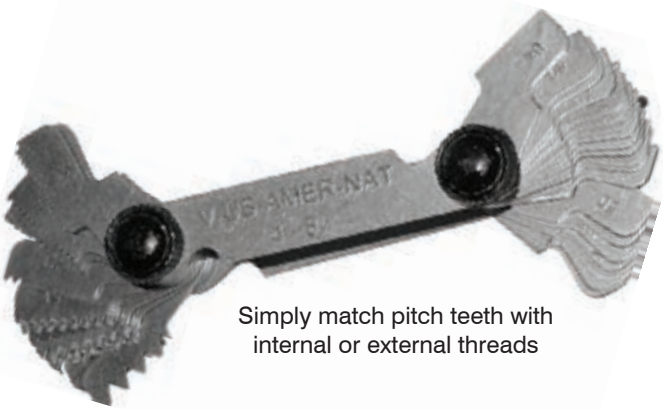
- **Thumbwheel locking**

Item #	Description
136488	20 Leaf Feeler Gauge (Metric)
136489	26 Leaf Feeler Gauge (SAE)

Pitch Gauges

Determine pitch quickly and easily

- **Thumbwheel locking**



Simply match pitch teeth with internal or external threads

Item #	Description
136490	28 Leaf Pitch Gauge (Metric)
136492	31 Leaf Pitch Gauge (SAE)
136491	51 Leaf Pitch Gauge (SAE)

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Process Trouble-Shooting Guidelines

Problem	CRYSTALLINE MATERIALS Lower/Reduce	CRYSTALLINE MATERIALS Raise/Increase	AMORPHOUS MATERIALS Lower/Reduce	AMORPHOUS MATERIALS Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

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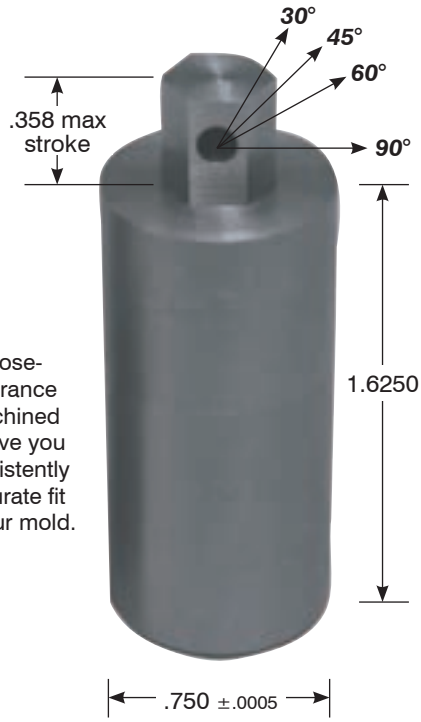
Fixed-Angle Air Ejectors

For Faster, More Effective Molded Part Blow-Off

Made in the U.S.A



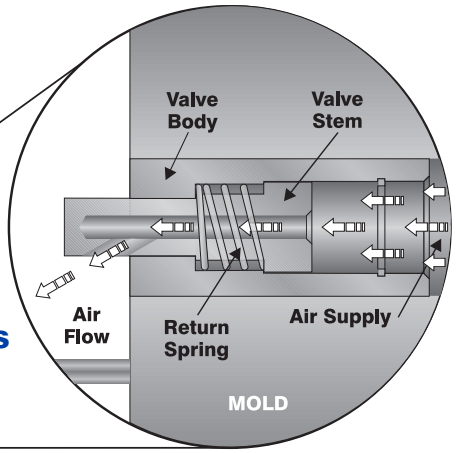
Close-tolerance machined to give you consistently accurate fit in your mold.

Air Supply required 30-150 psi

30°, 45°, 60° or 90° Internal Air Jets

let you select the angle best suited to eject your plastic part

- Reduce Cycle Times
- Flashproof, non-clogging
- Inexpensive, versatile, trouble-free
- Easily installed outside, on or within parting line of mold



Fixed-Angle Air Ejectors

Opened Position

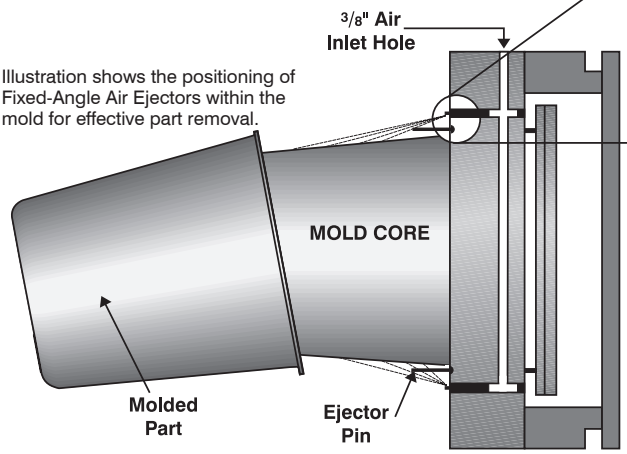


Illustration shows the positioning of Fixed-Angle Air Ejectors within the mold for effective part removal.

Type 303 Stainless Steel

Simple Installation Instructions Included

Fixed-Angle Air Ejectors

Item #	Angle
106541	30°
106540	45°
106538	60°
106536	90°

(Other Diameters and Lengths to Special Order — Inquire)

Optional Air Actuator System Priced Separately Beyond

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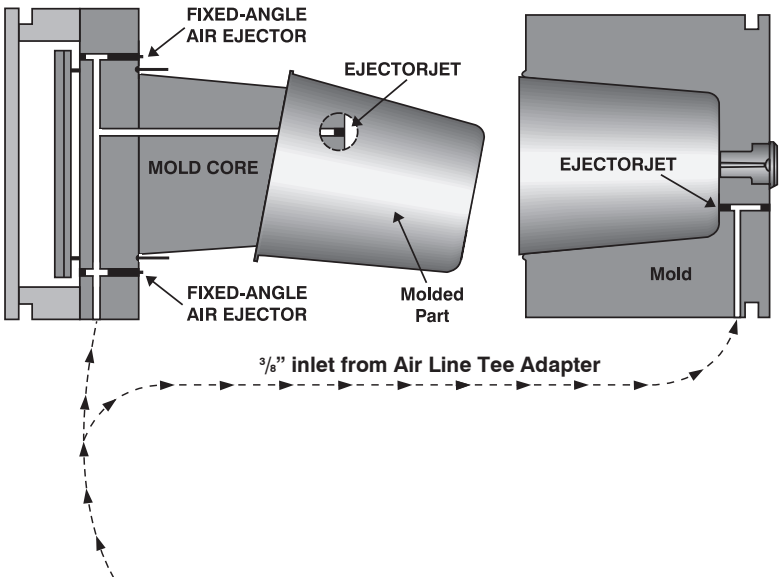
Air Actuator System

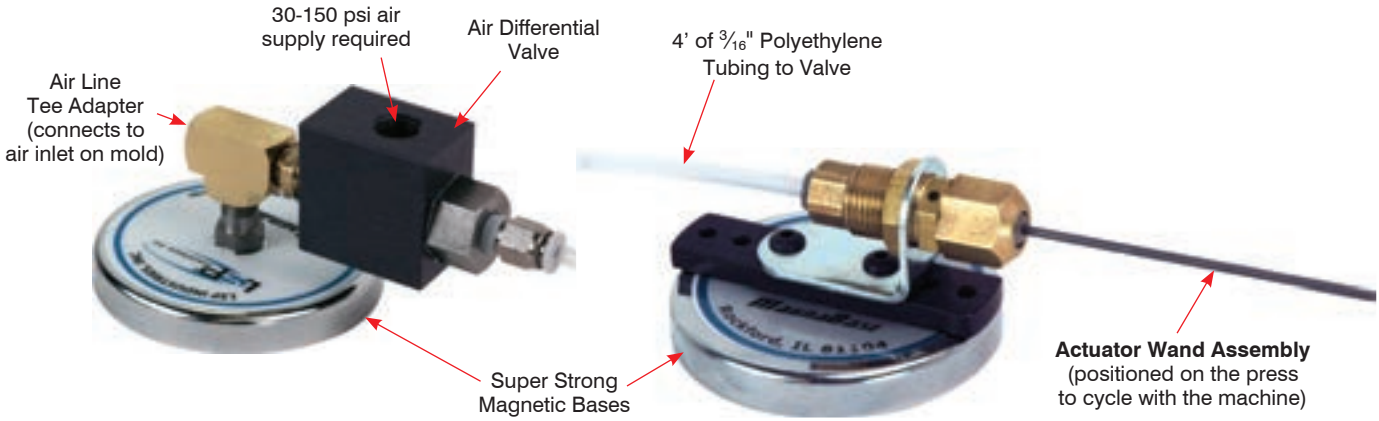
For Use With Vacuum Break/Air Ejectors, Fixed-Angle Air Ejectors or Your Existing Internal Air Ejectors

- Air operated - No electrical connections required
- Versatile - Magnetic bases easily moved for different molds
- Simple

How It Works

The Air Actuator method is a pneumatic control system which can be magnetically attached to any injection molding machine. When the Actuator Wand is moved one inch in any direction, the Air Differential Valve opens, supplying air to the Vacuum Break and/or Fixed-Angle Air Ejectors, or other air blow-off devices listed on these pages.





Air Actuator System Only

For direct connection to mold already equipped with a blow-off device or vacuum break

Includes: Actuator Wand Assembly, Two Magnetic Bases, 4' of 3/16" Polyethylene Tubing, Air Line Tee Adapter and Air Differential Valve.

Item #106604

Optional accessories

Installation

Select a position on the press which can be used to move the Ejection System Actuator Wand at least 1" and cycle with the machine. Position the Actuator's Magnetic Base at this location. Position the Air Differential Valve's Magnetic Base at any convenient spot within 4' of the Actuator Wand. Connect a 3/8" plant air supply line and a 3/8" air line to mold ports.

This Actuator System can also be used for External Part Blow-Off.
See next page for accessory equipment & kit pricing.

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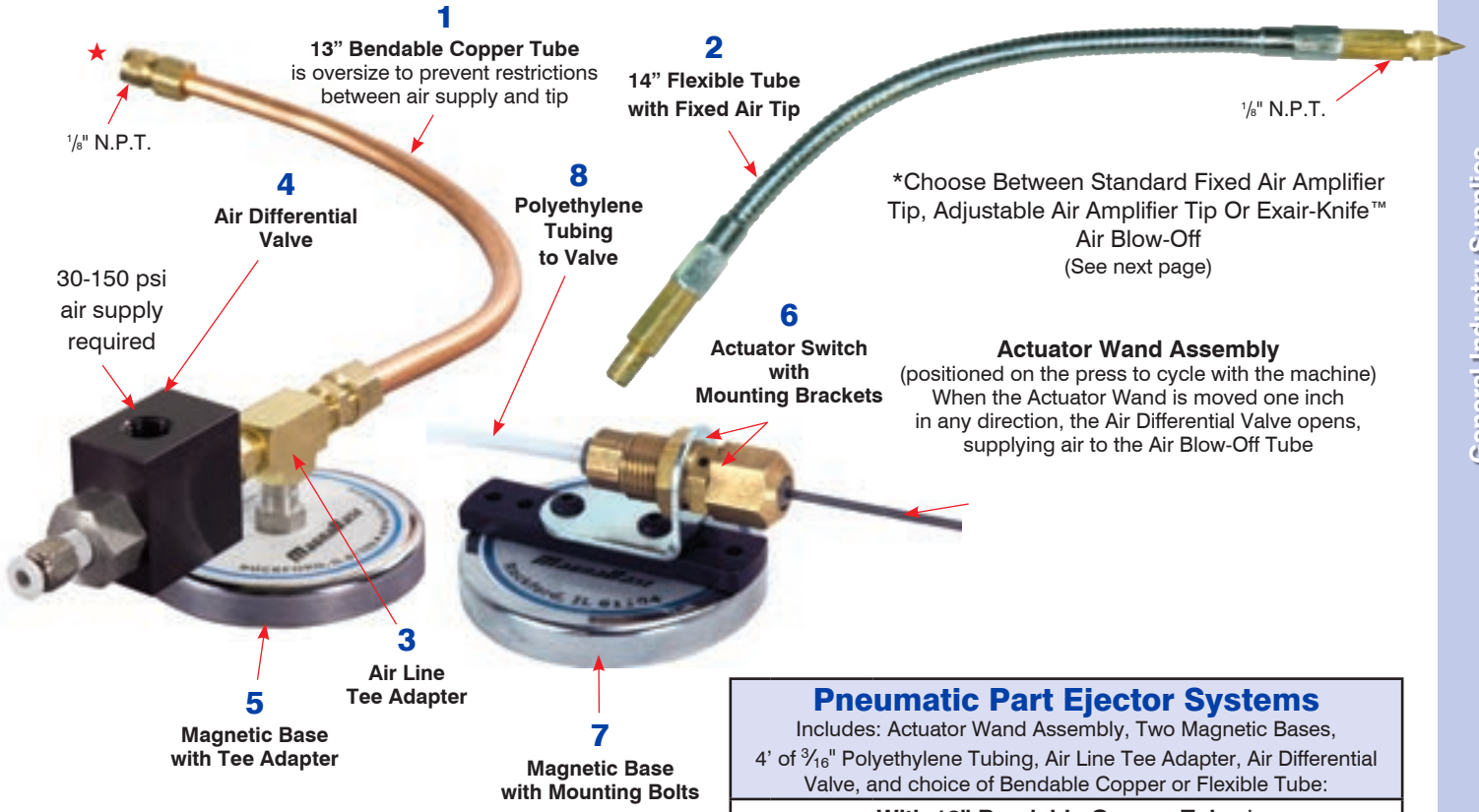
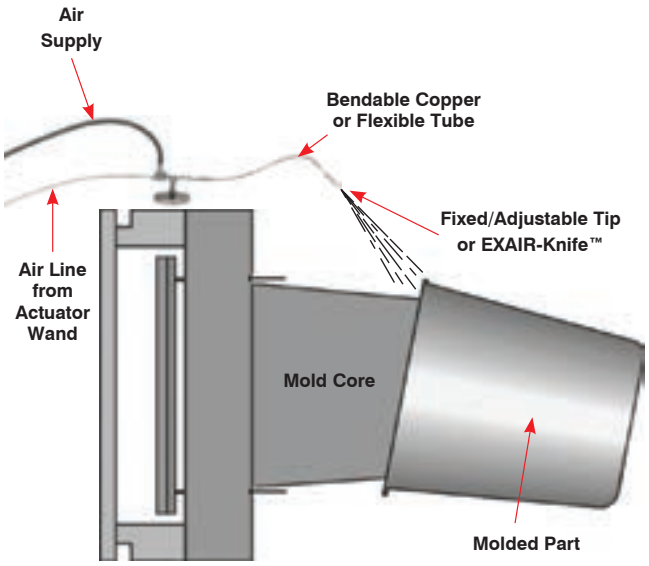
Pneumatic Part Ejector Systems

- Protect your mold - improves part and runner ejection
- Reduce cycle time - can eliminate multiple ejection strokes
- Versatile - magnetic bases easily moved for different molds and difficult cavities
- Air operated - no electrical connections required





Pneumatic Part Ejector Systems Includes: Actuator Wand Assembly, Two Magnetic Bases, 4’ of 3/16" Polyethylene Tubing, Air Line Tee Adapter, Air Differential Valve, and choice of Bendable Copper or Flexible Tube:		
With 13” Bendable Copper Tube *		
	107653	
With 14” Flexible Tube and Fixed Air Tip		
	107654	
Components		
	Item #	**Description**
1	106602	13” Bendable copper Tube (with 1/8" N.P.T. fittings)
2	107460	14” Flexible Tube (with 1/8" N.P.T. fittings, close nipple and fixed air tip)
3	107459	Air Line Tee Adapter
4	107461	Air Differential Valve
5	107457	Magnetic Base (with Tee Adapter)
6	107456	Actuator Switch (with mounting bracket)
7	107455	Magnetic Base (with mounting bolts)
8	107453	Polyethylene Tubing 3/16" O.D
Optional Accessories		
	104454	Filter
	104451	Regulator

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Air Amplifier Tips

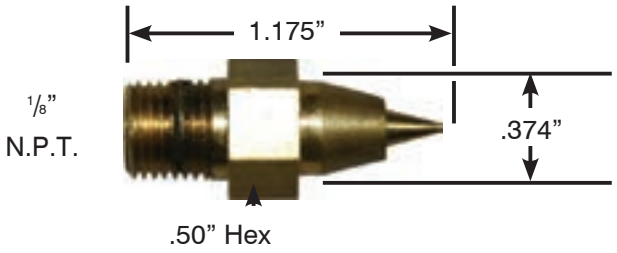
For Use With Air Differential Blow-Off Systems

2 Styles

Reduce: Shop Noise
Energy Consumption
Compressor Loading

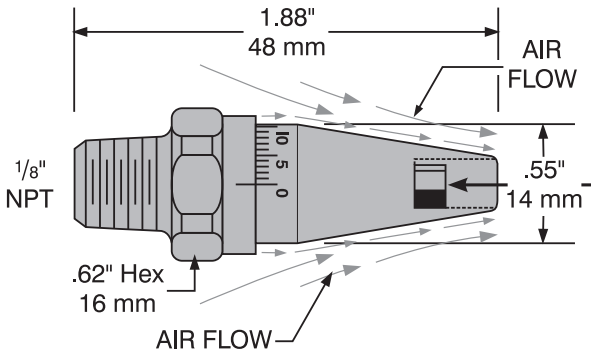
Fixed Air Amplifier Tip

Focuses and intensifies the air stream for greater impact



Item #106605

Adjustable Air Amplifier Tip

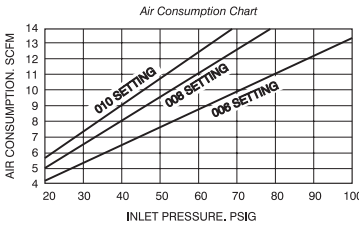


SET SCREW
NOTE: Factory set at a .800 gap. To change this setting, loosen the internal set screw with 3/32” hex wrench and rotate nozzle tip to desired setting. Tighten set screw to secure new setting.

How The Air Saver Nozzle Tip Works

This Air Saver Nozzle Tip uses Vortec’s TRANSVECTOR™ air flow amplification principle to deliver 25 times greater air flow than the actual compressed air input. In operation, compressed air is released at extremely high velocity through a ring-shaped orifice. This high-speed air entrains a large mass of surrounding still air, resulting in a much larger total air flow. The blow-off effect (sometimes called thrust or “punch”) per SCFM of compressed air consumed, is much larger than open compressed air jets, and noise is much lower.

Easily Disassembled for Cleaning!



Adjustable Air Amplifier Tip
Air stream can be easily adjusted for different part sizes

Item #104439

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Dura-Driver™ 7 in 1

This hand tool drives a variety of fasteners and nuts.

- Rear taper tri-oval handle permits effective handling
- Extra long, tri-oval shape reduces tension at pressure points, improving comfort
- Non-slip grip allows higher torque
- Interchangeable bits provide power and versatility
- Strong S2 steel bits offer long service
- Handle Length: 5”
- Overall Length: 8¼"

Item #	Description	Unit Price
122720	DURA-DRIVER™ 7 in 1	$15.20

Brass Screwdriver

- SAFE — Will not scratch molds
- ⅜" diameter
- Straight with flared tip
- Oversized plastic grip for easier handling

Item #	Description	Unit Price
141788	Brass Screwdriver	$23.40

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Lufkin® Yellow Clad Tape

- Large, easy action winding drum with friction washers
- Manufactured to US standard Department of Commerce .005" thick
- 3/8" wide, yellow clad steel blade
- Fitted with folding hook ring
- 1/8" at 1' increment

Item #	Description	Unit Price
161393	50' Tape Measure	**$37.90**
161394	100' Tape Measure	**54.60**

Quikread Decimal/Fraction Measuring Tape

- 25' tape length
- End hook with built-in shock absorber
- Clear coat tape protection with non-glare finish
- Positive toggle lock holds blade for measurement
- Durable ABS high-impact case with 3" base
- Ergonomic shape for operator comfort
- Fully inspected for accuracy
- Easy read design — all measurements marked

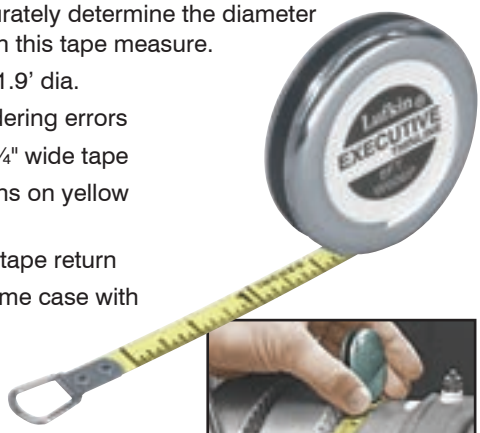
Easy to read vertical numbering

Item #	Description	Unit Price
122725	Quikread Measuring Tape	**$15.52**

Circumference Tape Measure

Quickly and accurately determine the diameter of your barrel with this tape measure.

- Standard: 6', 1.9' dia.
- Eliminates ordering errors
- Replaceable ¼" wide tape
- Bold gradations on yellow background
- Spring action tape return
- Polished chrome case with non-slip grip



TOP

Regular Tape

BOTTOM

Diameter Tape

Item #	Description	Unit Price
120125	Lufkin® Tape Measure (standard, 6', 1.9' dia.)	**$27.42**

Radius or Orifice Gauge

See Page 511

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Magnetic Tape Measure

- Dual sided tape — read either side
- Dual sided hook — grabs either way
- Color: green and black
- 1” wide blade
- Slide lock

Dual sided magnetic hook

Item #	Description	Unit Price
160229	30’ Magnetic Tape Measure	**$27.22**

Feeler Gauges

Measure the gap between materials

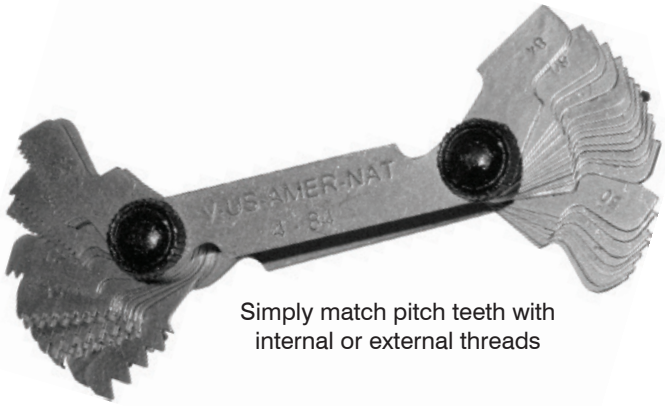
- **Thumbwheel locking**

Item #	Description	Unit Price
136488	20 Leaf Feeler Gauge (Metric)	**$10.70**
136489	26 Leaf Feeler Gauge (SAE)	**10.70**

Pitch Gauges

Determine pitch quickly and easily

- **Thumbwheel locking**



Simply match pitch teeth with internal or external threads

Item #	Description	Unit Price
136490	28 Leaf Pitch Gauge (Metric)	**$8.20**
136492	31 Leaf Pitch Gauge (SAE)	**8.20**
136491	51 Leaf Pitch Gauge (SAE)	**16.00**

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Process Trouble-Shooting Guidelines

Problem	CRYSTALLINE MATERIALS Lower/Reduce	CRYSTALLINE MATERIALS Raise/Increase	AMORPHOUS MATERIALS Lower/Reduce	AMORPHOUS MATERIALS Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

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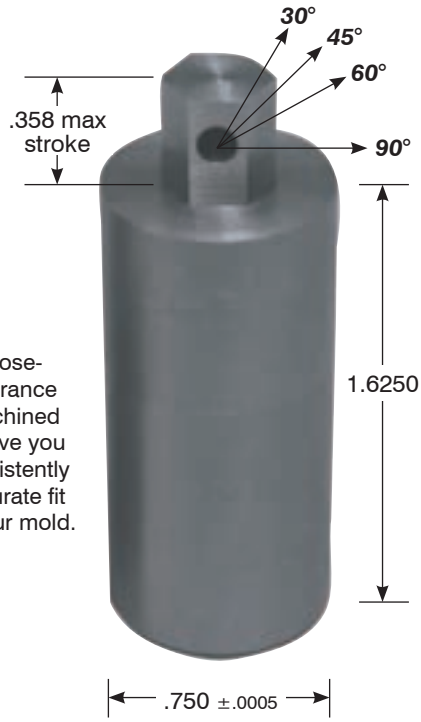
Fixed-Angle Air Ejectors

For Faster, More Effective Molded Part Blow-Off

Made in the U.S.A



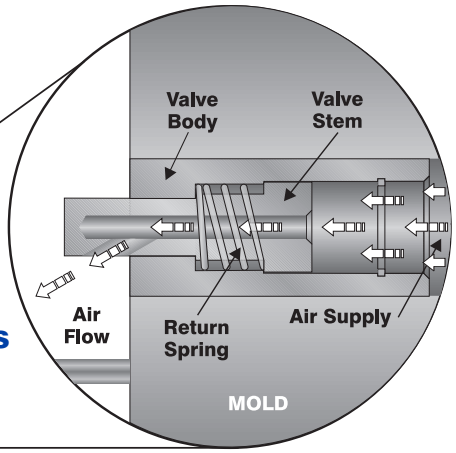
Close-tolerance machined to give you consistently accurate fit in your mold.

Air Supply required 30-150 psi

30°, 45°, 60° or 90° Internal Air Jets

let you select the angle best suited to eject your plastic part

- Reduce Cycle Times
- Flashproof, non-clogging
- Inexpensive, versatile, trouble-free
- Easily installed outside, on or within parting line of mold



Fixed-Angle Air Ejectors

Opened Position

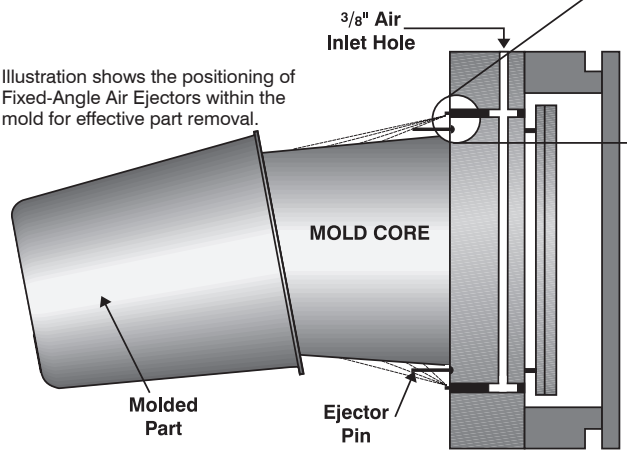


Illustration shows the positioning of Fixed-Angle Air Ejectors within the mold for effective part removal.

Type 303 Stainless Steel

Simple Installation Instructions Included

Fixed-Angle Air Ejectors

Item #	Angle	Unit Price
106541	30°	**$83.65**
106540	45°	**109.68**
106538	60°	**100.01**
106536	90°	**83.65**

(Other Diameters and Lengths to Special Order — Inquire)

Optional Air Actuator System Priced Separately Beyond

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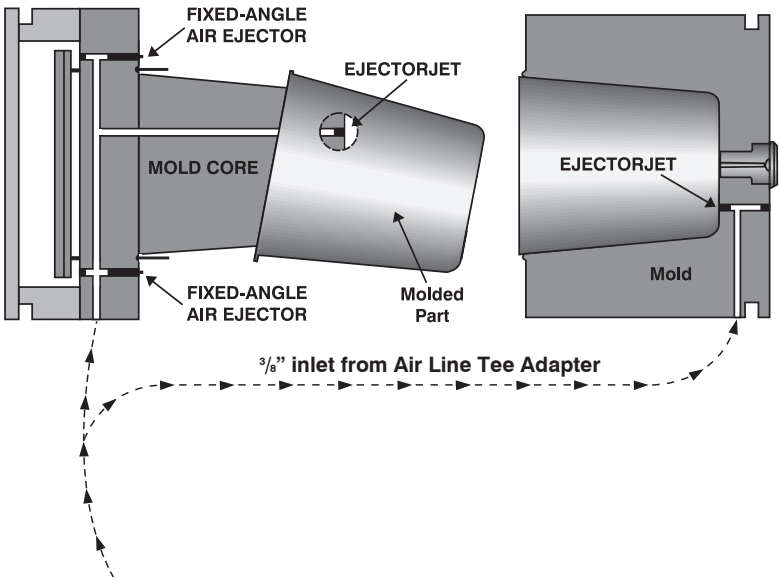
Air Actuator System

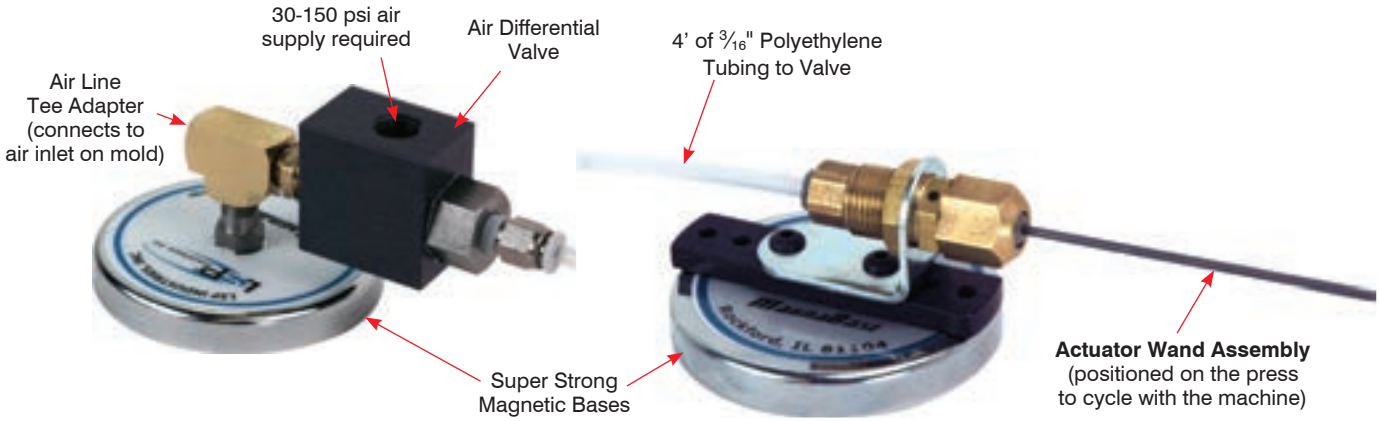
For Use With Vacuum Break/Air Ejectors, Fixed-Angle Air Ejectors or Your Existing Internal Air Ejectors

- Air operated - No electrical connections required
- Versatile - Magnetic bases easily moved for different molds
- Simple

How It Works

The Air Actuator method is a pneumatic control system which can be magnetically attached to any injection molding machine. When the Actuator Wand is moved one inch in any direction, the Air Differential Valve opens, supplying air to the Vacuum Break and/or Fixed-Angle Air Ejectors, or other air blow-off devices listed on these pages.





Air Actuator System Only

For direct connection to mold already equipped with a blow-off device or vacuum break

Includes: Actuator Wand Assembly, Two Magnetic Bases, 4' of 3/16" Polyethylene Tubing, Air Line Tee Adapter and Air Differential Valve.

Item #106604

$348.40

Optional accessories

Installation

Select a position on the press which can be used to move the Ejection System Actuator Wand at least 1" and cycle with the machine. Position the Actuator's Magnetic Base at this location. Position the Air Differential Valve's Magnetic Base at any convenient spot within 4' of the Actuator Wand. Connect a 3/8" plant air supply line and a 3/8" air line to mold ports.

This Actuator System can also be used for External Part Blow-Off.

See next page for accessory equipment & kit pricing.

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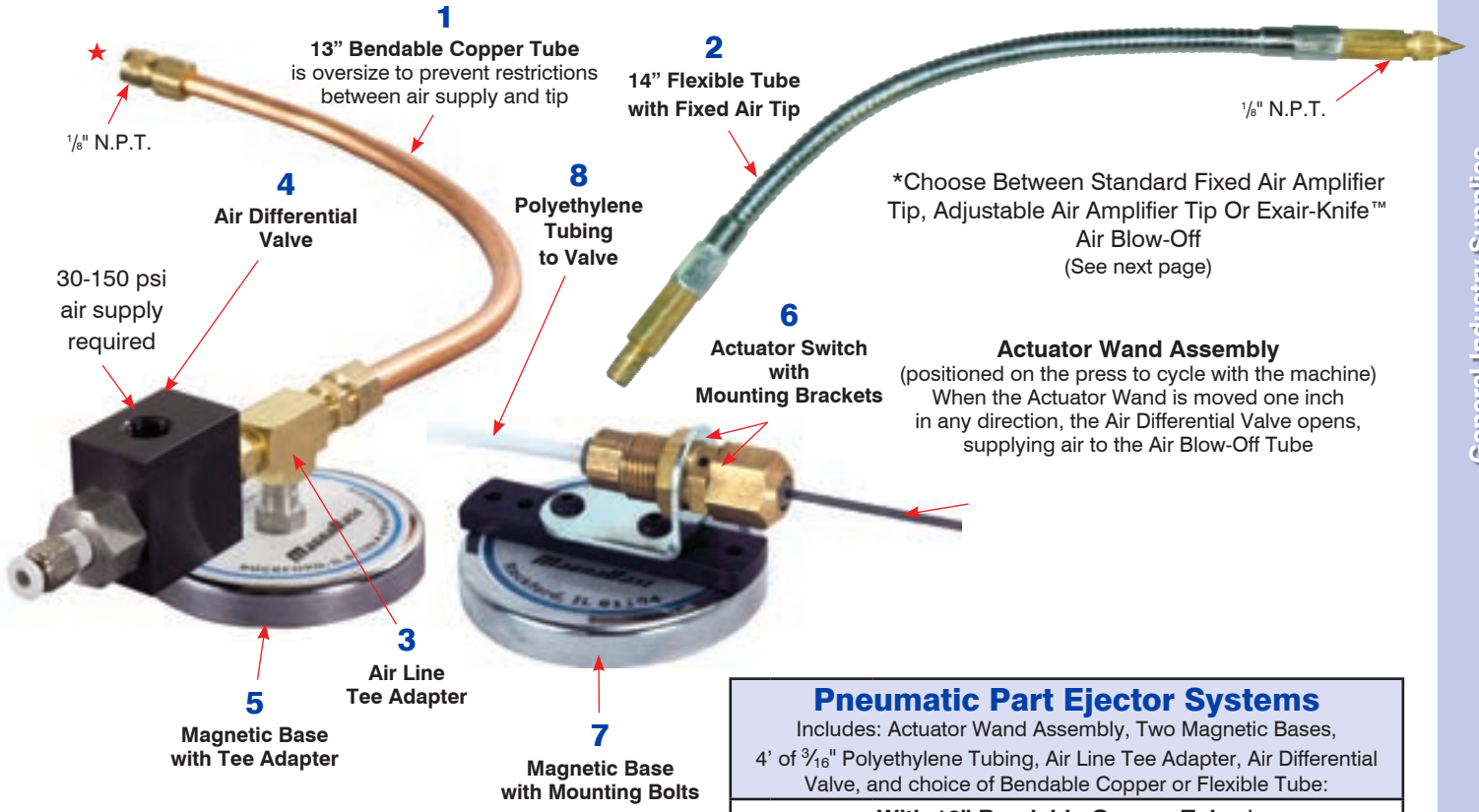
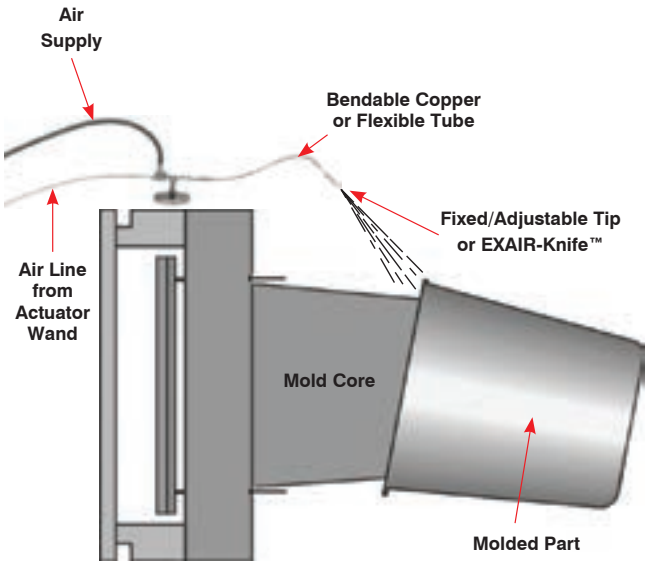
Pneumatic Part Ejector Systems

- Protect your mold - improves part and runner ejection
- Reduce cycle time - can eliminate multiple ejection strokes
- Versatile - magnetic bases easily moved for different molds and difficult cavities
- Air operated - no electrical connections required





Pneumatic Part Ejector Systems

Includes: Actuator Wand Assembly, Two Magnetic Bases, 4' of 3/16" Polyethylene Tubing, Air Line Tee Adapter, Air Differential Valve, and choice of Bendable Copper or Flexible Tube:

With 13" Bendable Copper Tube *			
	107653		**$406.90**
With 14" Flexible Tube and Fixed Air Tip			
	107654		**642.70**
Components			
	Item #	**Description**	**Price**
1	106602	13" Bendable copper Tube (with 1/8" N.P.T. fittings)	**$58.50**
2	107460	14" Flexible Tube (with 1/8" N.P.T. fittings, close nipple and fixed air tip)	**294.40**
3	107459	Air Line Tee Adapter	**19.08**
4	107461	Air Differential Valve	**189.54**
5	107457	Magnetic Base (with Tee Adapter)	**153.62**
6	107456	Actuator Switch (with mounting bracket)	**165.80**
7	107455	Magnetic Base (with mounting bolts)	**Inquire**
8	107453	Polyethylene Tubing 3/16" O.D	**0.30/ft.**
Optional Accessories			
	104454	Filter	**$114.00**
	104451	Regulator	**58.00**

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Air Amplifier Tips

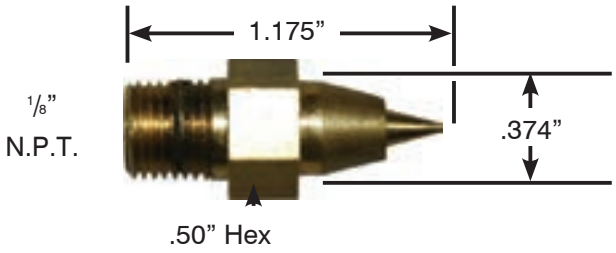
For Use With Air Differential Blow-Off Systems

2 Styles

Reduce: Shop Noise
Energy Consumption
Compressor Loading

Fixed Air Amplifier Tip

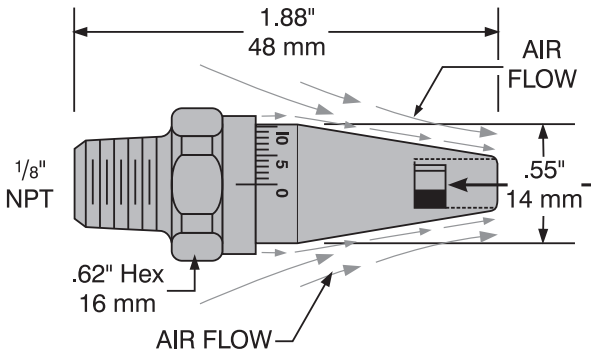
Focuses and intensifies the air stream for greater impact



Item #106605

$15.70 ea.

Adjustable Air Amplifier Tip



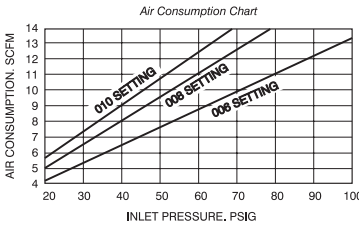
SET SCREW

NOTE: Factory set at a .800 gap. To change this setting, loosen the internal set screw with 3/32” hex wrench and rotate nozzle tip to desired setting. Tighten set screw to secure new setting.

How The Air Saver Nozzle Tip Works

This Air Saver Nozzle Tip uses Vortec’s TRANSVECTOR™ air flow amplification principle to deliver 25 times greater air flow than the actual compressed air input. In operation, compressed air is released at extremely high velocity through a ring-shaped orifice. This high-speed air entrains a large mass of surrounding still air, resulting in a much larger total air flow. The blow-off effect (sometimes called thrust or “punch”) per SCFM of compressed air consumed, is much larger than open compressed air jets, and noise is much lower.

Easily Disassembled for Cleaning!



Adjustable Air Amplifier Tip

Air stream can be easily adjusted for different part sizes

Item #104439

$27.04 ea.

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Since
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Engineered
Components & Supplies

Nozzles, Nozzle Tips & Supplies
Pages 472 - 522

Screw Tips, Screws & Barrels
Pages 524 - 592

Mold & Die Maintenance
Pages 594 - 614

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Most items IN STOCK for Same Day Shipment

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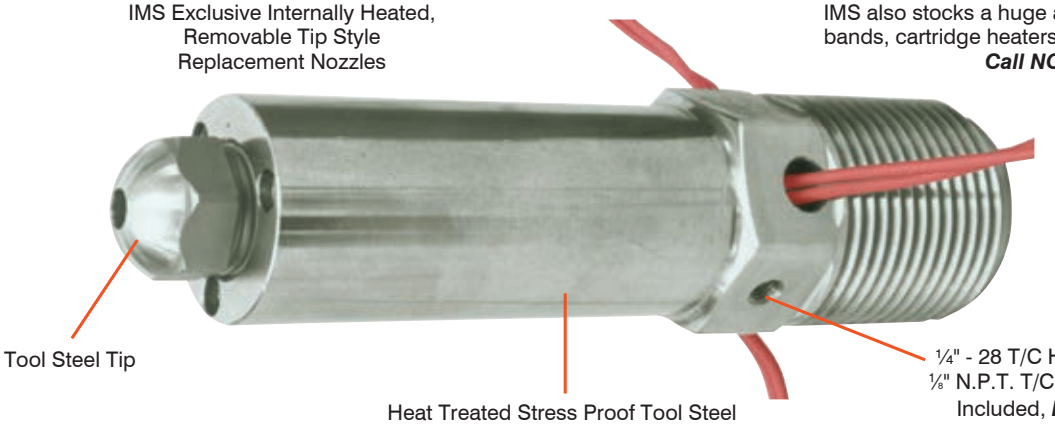
Made in the U.S.A

Injection Machine Nozzles

IMS Exclusive Internally Heated, Removable Tip Style Replacement Nozzles

IMS also stocks a huge assortment of heater bands, cartridge heaters and thermocouples ***Call NOW!***



Why buy IMS Nozzles? Here are seven reasons:

#1 High quality steel. Unlike some nozzle suppliers who use lower grade, re-sulfurized or pre-heat treated steels that tend to chip and/or fail prematurely, we use only premium quality steels for all of our nozzle components.

#2 Quality control. We insist that every bar of steel is inspected and thoroughly tested.

#3 Machining. Our nozzles are made in a state-of-the-art machine shop with tools capable of repeat accuracy in the millions of the inch. Operators each have 10 to 20 years of experience.

#4 Finishing. After being expertly machined, our nozzles are vacuum heat treated under computer control to maximize wearability. They're also hand polished at critical surfaces for the smoothest finish possible.

#5 Testing. IMS uses all the latest computerized measuring and hardness checking equipment. When you buy an IMS nozzle, you can be sure you're getting the same consistent quality every time.

#6 Stock.

IMS stocks their exclusive replacement nozzles in most popular sizes and styles.
Call for availability or check online at www.Imscompany.Com

#7 Custom Nozzles.

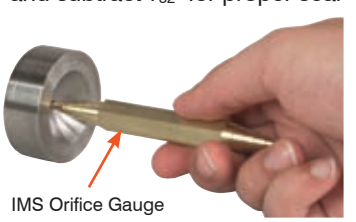
IMS can also design, manufacture and ship most custom nozzles.
Use the request for quotation form on page 478

Before Ordering, Please Gather The Following Dimensions:

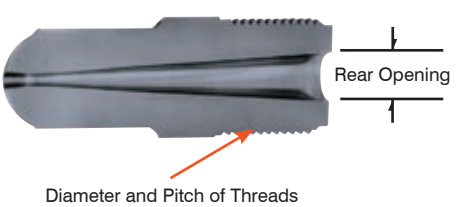
OVERVIEW

1 Measure Radius Of Sprue Bushing

2 Measure Sprue Bushing Orifice "O" Dimension
and subtract 1/32" for proper seal



3 Measure Thread Size & Rear Opening
and advise machine make & model



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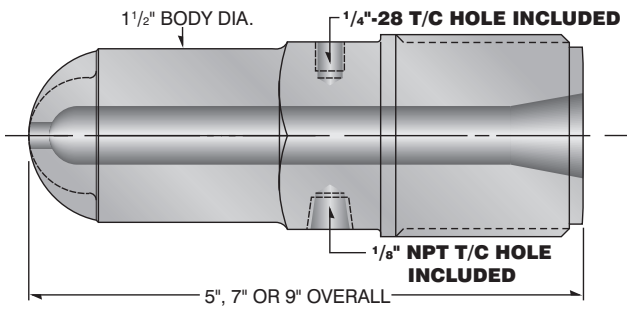
IMS Externally Heated, One-Piece Style Standard Replacement Nozzles

Made in the U.S.A

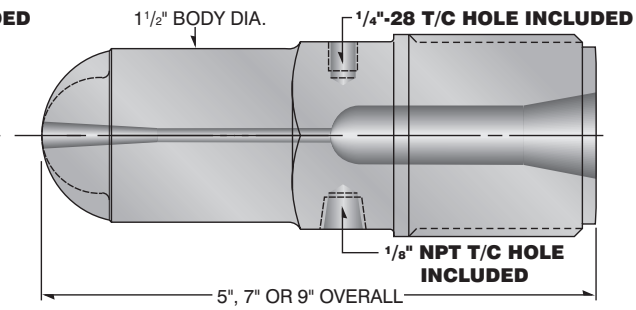
Ims Nozzles Come Standard with Two Different T/C Holes for Your Convenience

- Heat Treated Stress Proof Tool Steel

General Purpose
For use with styrene, polyethylene and other general-purpose materials



Nylon
Minimizes drool when molding with nylon



Length	Thread Size	Rear Opening	Radius	Orifice	Item #	Recommended Heater Band 120 V / 240V
General Purpose						
5"	1¼"-12	¾"	½"	⅛"	104533	#134619 / #134620
				3⁄16"	104505	#134619 / #134620
				¼"	104478	#134619 / #134620
			¾"	⅛"	104627	#134619 / #134620
				3⁄16"	104601	#134619 / #134620
				¼"	104576	#134619 / #134620
	1½"-12	½"	½"	⅛"	104552	#134619 / #134620
				3⁄16"	104526	#134619 / #134620
				¼"	104498	#134619 / #134620
			¾"	⅛"	104472	#134619 / #134620
				3⁄16"	104621	#134619 / #134620
	1¾"-8	¾"	½"	⅛"	104570	#134619 / #134620
				3⁄16"	104545	#134619 / #134620
				¼"	104518	#134619 / #134620
			¾"	⅛"	104493	#134619 / #134620
				3⁄16"	104613	#134619 / #134620
				¼"	104589	#134619 / #134620
		1¼"	½"	⅛"	104565	#134619 / #134620
				3⁄16"	104540	#134619 / #134620
				¼"	104511	#134619 / #134620
			¾"	⅛"	104485	#134619 / #134620
7"	1¼"-12	¾"	½"	⅛"	104532	#134627 / #134628
				3⁄16"	104503	#134627 / #134628
				¼"	104476	#134627 / #134628

Custom Parts Available — Inquire

continued on next page

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Made in the U.S.A

IMS Externally Heated, One-Piece Style Standard Replacement Nozzles

Length	Thread Size	Rear Opening	Radius	Orifice	Item #	Recommended Heater Band 120 V / 240V
General Purpose						
7"	1¼"-12	¾"	¾"	⅛"	104625	#134627 / #134628
				3⁄16"	104600	#134627 / #134628
				¼"	104574	#134627 / #134628
	1½"-12	½"	½"	⅛"	104550	#134627 / #134628
				3⁄16"	104525	#134627 / #134628
				¼"	104497	#134627 / #134628
			¾"	⅛"	104640	#134627 / #134628
				3⁄16"	104619	#134627 / #134628
				¼"	104595	#134627 / #134628
	1¾"-8	¾"	½"	⅛"	104517	#134627 / #134628
				3⁄16"	104491	#134627 / #134628
			¾"	⅛"	104612	#134627 / #134628
				3⁄16"	104588	#134627 / #134628
				¼"	104564	#134627 / #134628
		1¼"	½"	⅛"	104538	#134627 / #134628
				3⁄16"	104509	#134627 / #134628
				¼"	104484	#134627 / #134628
			¾"	⅛"	104632	#134627 / #134628
				3⁄16"	104580	#134627 / #134628
9"	1¼"-12	¾"	½"	⅛"	104531	#134631 / #134632
				3⁄16"	104502	#134631 / #134632
				¼"	104475	#134631 / #134632
			¾"	3⁄16"	104599	#134631 / #134632
	1½"-12	½"	½"	⅛"	104549	#134631 / #134632
				3⁄16"	104524	#134631 / #134632
				¼"	104496	#134631 / #134632
			¾"	⅛"	104639	#134631 / #134632
				3⁄16"	104618	#134631 / #134632
				¼"	104594	#134631 / #134632
	1¾"-8	¾"	½"	⅛"	104568	#134631 / #134632
				3⁄16"	104544	#134631 / #134632
				¼"	104515	#134631 / #134632
			¾"	⅛"	104489	#134631 / #134632
				3⁄16"	104611	#134631 / #134632
				¼"	104586	#134631 / #134632
		1¼"	½"	⅛"	104562	#134631 / #134632
				3⁄16"	104536	#134631 / #134632
				¼"	104508	#134631 / #134632
			¾"	⅛"	104482	#134631 / #134632
				3⁄16"	104605	#134631 / #134632
				¼"	104578	#134631 / #134632

continued on next page

Custom Parts Available — Inquire

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IMS Externally Heated, One-Piece Style Standard Replacement Nozzles

Made in the U.S.A

Length	Thread Size	Rear Opening	Radius	Orifice	Item #	Recommended Heater Band 120 V / 240V
General Purpose						
5"	1¼"-12	¾"	½"	3/16"	104523	#134619 / #134620
			¾"		105306	#134619 / #134620
		½"	½"		104593	#134619 / #134620
	1¾"-8	¾"			104488	#134619 / #134620
			¾"		104610	#134619 / #134620
		1¼"	½"		104561	#134619 / #134620
7"	1¼"-12	¾"	½"	3/16"	104630	#134627 / #134628
	1¾"-8				104500	#134627 / #134628
				¼"	113569	#134627 / #134628
			¾"	3/16"	105237	#134627 / #134628
		1¼"	½"		104546	#134627 / #134628
9"	1¾"-8	1¼"	½"	3/16"	104567	#134631 / #134632

Custom Parts Available — Inquire

IMS Internally Heated, One-Piece Style Standard Replacement Nozzles

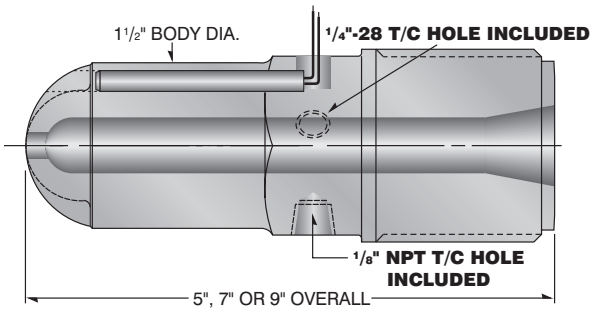
Heated internally, these nozzles can go deeper into die clearance holes for shorter sprues.

- Heat Treated Stress Proof Tool Steel

General Purpose

For use with styrene, polyethylene and other general purpose materials

IMS Nozzles come standard with two different T/C holes for your convenience



Length	Thread Size	Rear Opening	Radius	Orifice	Item #	Recommended Cartridge Heater (3 required) 120 V / 240V
General Purpose						
5"	1¾"-8	¾"	½"	⅛"	104506	#135881 / #135882
			¾"		104628	#135881 / #135882
7"	1¾"-8	¾"	½"	⅛"	104553	#135886 / #135887
			¾"		104527	#135886 / #135887
9"	1¼"-12	¾"	½"	3/16"	109348	#135890 / #135891
	1¾"-8		½"		109222	#135890 / #135891
			¾"		104519	#135890 / #135891

Call for pricing and other sizes

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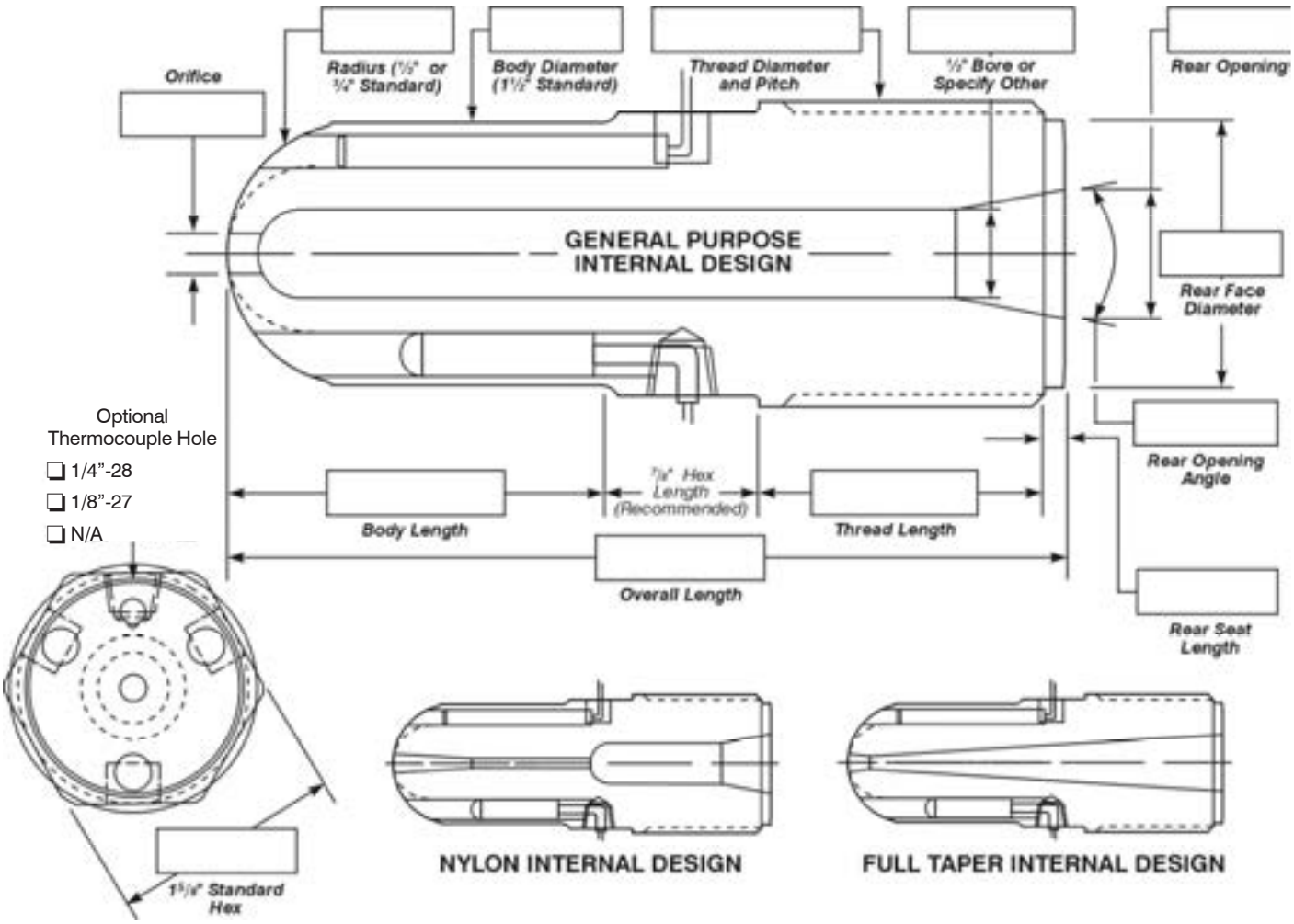
Custom One-Piece Nozzle Form

Specify:

1. Internal Design:
   ❑ General Purpose ❑ Nylon ❑ Full-Taper

2. Heating:
   ❑ External Only

Fill in the following basic dimension blanks



Optional:

3. Press Make _____
   and Model _____
4. Material To Be Molded _____
5. Operating Temperature _____
6. Thermocouple Thread Size and Location _____
   _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Please refer to imscompany.com for current pricing

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Made in the U.S.A

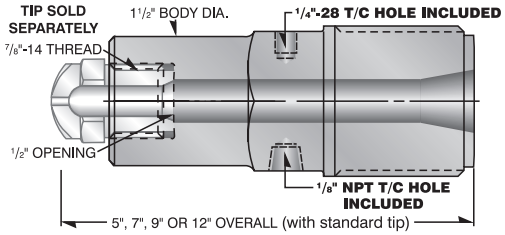
IMS Externally Heated, Removable Tip Style Standard Replacement Nozzles

IMS Nozzles Come Standard with Two Different T/C Holes for Your Convenience

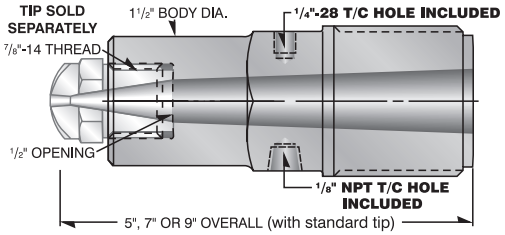
Rather than buy a variety of expensive nozzles, just buy different tips for these nozzles.

- Heat Treated Stress Proof Tool Steel

General Purpose
For use with styrene, polyethylene and other general-purpose materials



Full-Taper
For use with ABS, acrylics, polycarbonate, sulfone and other engineering materials



Length	Thread Size	Rear Opening	Item #	Recommended Heater Band
General Purpose				120 V / 240V
4¼"	M40 x 2.0	20MM	141795	#134619 / #134620
	1¼"-10	¾"	104483	#134619 / #134620
	1¼"-12	¾"	104631	#134619 / #134620
	1½"-12	½"	104606	#134619 / #134620
	1½"-12	.59"	104579	#134619 / #134620
	1½"-12	¾"	104556	#134619 / #134620
	1½"-12	27/32"	104530	#134619 / #134620
	1¾"-8	¾"	104501	#134619 / #134620
	1¾"-8	15/16"	105360	#134619 / #134620
	1¾"-8	1¼"	104623	#134619 / #134620
	1¾"-12	¾"	104598	#134619 / #134620
6¼"	1¼"-10	¾"	104572	#134627 / #134628
	1¼"-12	¾"	104547	#134627 / #134628
	1½"-12	½"	104522	#134627 / #134628
	1½"-12	.59"	104495	#134627 / #134628
	1½"-12	¾"	104638	#134627 / #134628
	1½"-12	27/32"	104616	#134627 / #134628
	1¾"-8	¾"	104592	#134627 / #134628
	1¾"-8	15/16"	105363	#134627 / #134628
	1¾"-8	1¼"	104542	#134627 / #134628
	1¾"-12	¾"	104513	#134627 / #134628
8¼"	1¼"-10	¾"	104487	#134631 / #134632
	1¼"-12	¾"	104633	#134631 / #134632
	1½"-12	½"	104609	#134631 / #134632

Custom Parts Available — Inquire

continued on next page

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IMS Externally Heated, Removable Tip Style Standard Replacement Nozzles

Thermocouple Holes Included — No Additional Charge

Length	Thread Size	Rear Opening	Item #	Recommended Heater Band 120 V / 240V
General Purpose				
8¼"	1½"-12	.59"	104584	#134631 / #134632
	1½"-12	¾"	104560	#134631 / #134632
	1½"-12	27/32"	104535	#134631 / #134632
	1¾"-8	¾"	104507	#134631 / #134632
	1¾"-8	1¼"	104480	#134631 / #134632
	1¾"-12	¾"	104629	#134631 / #134632
11¼"	1¼"-10	¾"	108169	#134629 / #134630
	1¼"-12	¾"	104516	#134629 / #134630
	1½"-12	½"	104490	#134629 / #134630
	1½"-12	.59"	105302	#134629 / #134630
	1½"-12	¾"	109269	#134629 / #134630
	1½"-12	27/32"	104587	#134629 / #134630
	1¾"-8	¾"	104563	#134629 / #134630
	1¾"-8	1¼"	104537	#134629 / #134630
	1¾"-12	¾"	107809	#134629 / #134630
Full-Taper				
4¼"	1¼"-10	¾"	107557	#134619 / #134620
	1¼"-12	¾"	104520	#134619 / #134620
	1½"-12	.59"	113470	#134619 / #134620
	1½"-12	¾"	110306	#134619 / #134620
	1½"-12	27/32"	104614	#134619 / #134620
	1¾"-8	¾"	104590	#134619 / #134620
	1¾"-8	1¼"	104566	#134619 / #134620
	1¾"-12	¾"	110314	#134619 / #134620
6¼"	1¼"-10	¾"	107647	#134627 / #134628
	1¼"-12	¾"	104486	#134627 / #134628
	1½"-12	.59"	110826	#134627 / #134628
	1½"-12	¾"	113199	#134627 / #134628
	1½"-12	27/32"	104583	#134627 / #134628
	1¾"-8	¾"	104559	#134627 / #134628
	1¾"-8	1¼"	104534	#134627 / #134628
	1¾"-12	¾"	110489	#134627 / #134628
8¼"	1¾"-8	1¼"	113233	#134623 / #134624

Custom Parts Available — Inquire

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IMS Internally Heated, Removable Tip Style Standard Replacement Nozzles

IMS Nozzles Come Standard with Two Different T/C Holes for Your Convenience

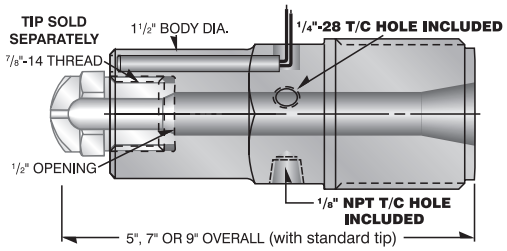
Rather than buy a variety of expensive nozzles, just buy different tips. Heated internally, these nozzles can go deeper into die clearance holes for shorter sprues.

- Heat Treated Stress Proof Tool Steel

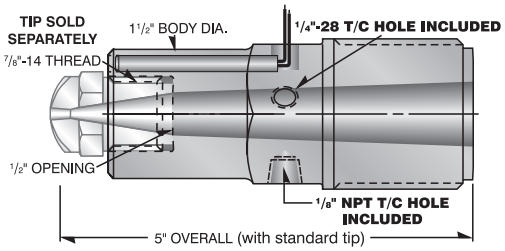
Purchasers also order:

- Cartridge Heaters, pages 206-212
- Nozzle Tips, page 489-497

General Purpose
For use with styrene, polyethylene and other general-purpose materials



Full-Taper
For use with ABS, acrylics, polycarbonate, sulfone and other engineering materials



Length	Thread Size	Rear Opening	Item #	Recommended Cartridge Heater (3 required) 120 V / 240V
General Purpose				
4¼"	1¼"-12	¾"	104608	#135881 / #135882
	1½"-12	½"	104582	#135881 / #135882
	1½"-12	.59"	106067	#135881 / #135882
	1¾"-8	¾"	104477	#135881 / #135882
	1¾"-8	1¼"	104626	#135881 / #135882
6¼"	1¼"-10	¾"	105295	#135886 / #135887
	1¼"-12	¾"	104575	#135886 / #135887
	1¾"-8	¾"	104620	#135886 / #135887
	1¾"-8	1¼"	104569	#135886 / #135887
8¼"	1¼"-12	¾"	104492	#135890 / #135891
	1¾"-8	¾"	104539	#135890 / #135891
	1¾"-8	1¼"	104510	#135890 / #135891
Full-Taper				
4¼"	1¼"-12	¾"	104604	#135881 / #135882
6¼"	1¾"-8	1¼"	104571	#135886 / #135887

Ask about other sizes

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e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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Custom Removable Tip Nozzle Form

Specify:

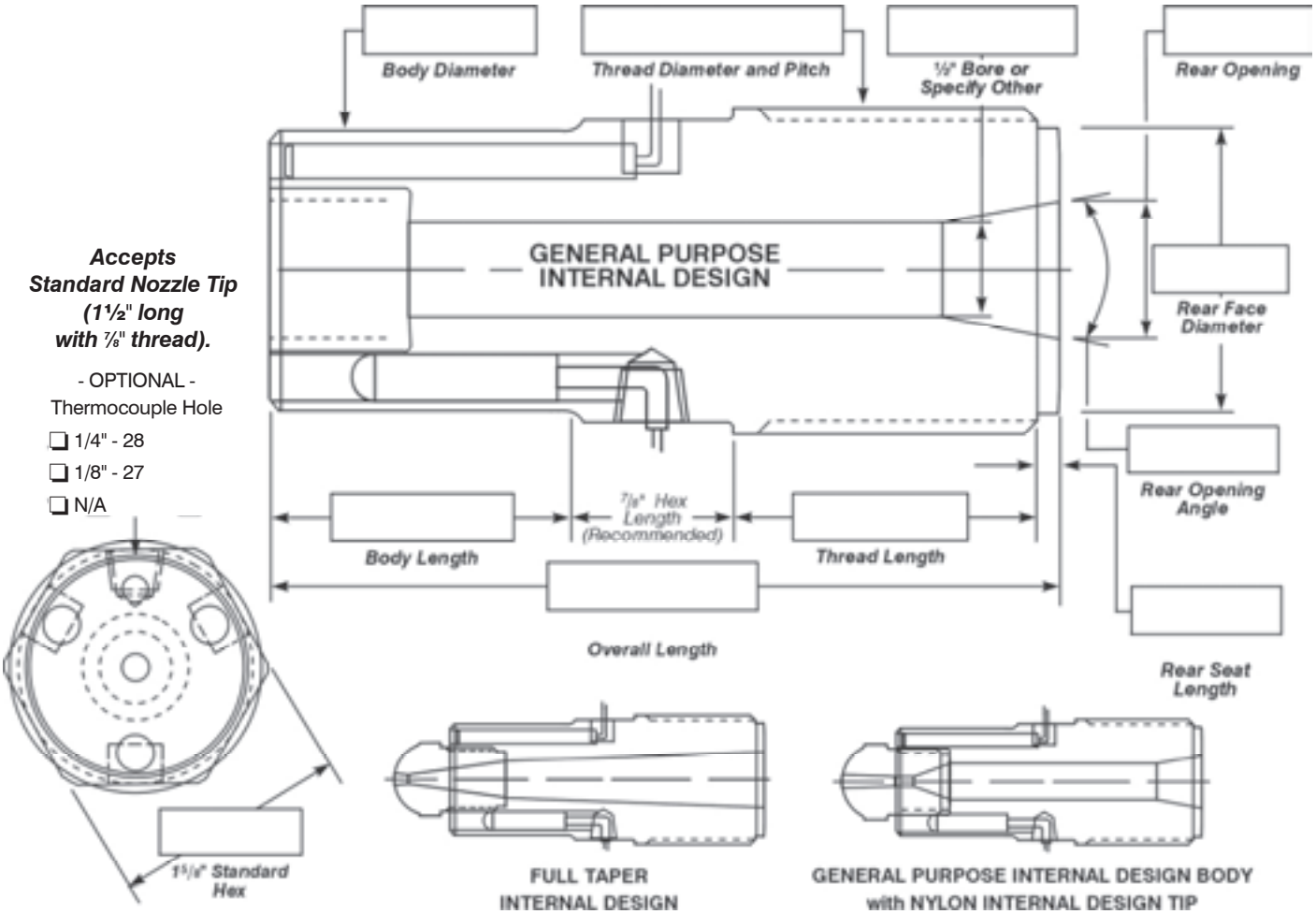
1. Internal Design:
   ❑ General Purpose ❑ Nylon ❑ Full-Taper

2. Heating:
   ❑ External

Fill in the following basic dimension blanks

Accepts Standard Nozzle Tip (1½" long with ⅞" thread).

- OPTIONAL -
Thermocouple Hole
❑ 1/4" - 28
❑ 1/8" - 27
❑ N/A



Optional:

3. Press Make _____
   and Model _____
4. Material To Be Molded _____
5. Operating Temperature _____
6. Thermocouple
   Thread Size and Location _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Made in the U.S.A

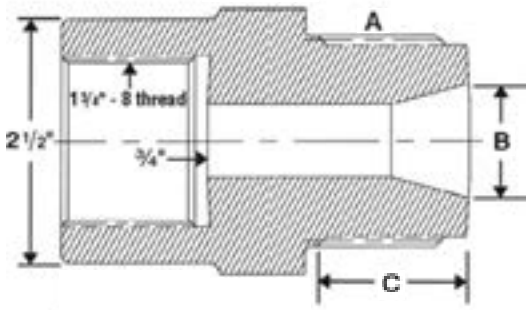
IMS Standard Nozzle Thread Adapters

Converts All Metric or Nonstandard Threads to 1¾" - 8

Makes Machine Upkeep Easy!

Save Money — Avoid Special Threads

Eliminates expense and saves time waiting for special size nozzles



Make of Press	Dimensions			Recommended Heater Bands	
Item #	Thread Size (A)	Rear Opening (B)	Thread Length (C)	120 Volt	240 Volt
Arburg					
105138	M24x1.5 RH	7.5mm	28mm	134652	134653
109524	M45x1.5	25mm	35mm		
105206	M52x2.0	35mm	32mm		
Battenfeld					
105207	M35x2.0	21mm	30mm	134652	134653
105172	M40x2.0	25mm	38mm		
105233	M40x2.0	30mm	38mm		
105231	TR65x3.0	48mm	45mm		
Beloit					
131909	1-¼"-12	.750"	1.250"	134652	134653
Cincinnati					
105196	1-½"-12	1/2"	2"	134652	134653
105225	1-¾"-8	.750"	1-¾"		
124395	2"-8	.79"	1-½"		
Demag					
170854	M60x3.0	19mm	36mm	134652	134653

continued on next page

Call 866-467-9001 or email sales@imscompany.com for ordering information

www.imscompany.com phone order toll-free (USA & Canada) **1.800.537.5375**

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Please refer to imscompany.com for current pricing

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IMS Standard Nozzle Thread Adapters

Make of Press	Dimensions			Recommended Heater Bands	
Item #	Thread Size (A)	Rear Opening (B)	Thread Length (C)	120 Volt	240 Volt
Farrel					
105130	1-¾”-8	½”	1-¾”	134652	134653
120052	1-½”-12	1”	1-¾”		
Fellows					
105183	1-¼”-10	3/4”	1-⅜”	134652	134653
105139	1-¾”-12	3/4”	1-¾”		
HPM					
105225	1-¾"-8	.750”	1-¾"	134652	134653
105208	2-½"-8	1”	1-½"		
105173	3-⅛"-8	1”	1-¼"		
105158	3-⅛"-8	1”	2-3/16"		
Husky					
121024	M45x3.0	22mm	40mm	134652	134653
Impco					
105236	1-¾"-12	3/4”	1-3/16"	134652	134653
JSW					
105137	M50x3.0	15mm	57mm	134652	134653
144523	M55x3.0	8mm	40mm		
122385	M55x3.0	8mm	55mm		
Kawaguchi					
105177	1-¾"-8	15/16"	1-¼"	134652	134653
105150	M30x3.0	12.7mm	28.7mm		
105161	M38x3.0	14mm	28.7mm		
105184	M45x3.0	16mm	38mm		
Klockner					
105232	1’ BST	.394”	1.41”	134652	134653
124271	M58x3.0	14.5mm”	43mm		
Krauss-Mafei					
136897	M48x3.0 Female	12.7mm	30mm	134652	134653

continued on next page

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IMS Standard Nozzle Thread Adapters

Make of Press / Item #	Dimensions			Recommended Heater Bands	
	Thread Size (A)	Rear Opening (B)	Thread Length (C)	120 Volt	240 Volt
Lester					
105144	1-½"-12	7/8"	1-$^{21}/_{32}$"	134652	134653
105127	1-¾"-8	1.3"	1-$^{5}/_{8}$"		
Mir					
123152	M75x3.0	45mm	52.5mm	134652	134653
Mitsubishi					
140618	1-½"-12	¾"	1.1"	134652	134653
129847	2-¼"-8	¾"			
Natco					
105151	2-¼"-8	.60"	1.075"	134652	134653
120890	2-¼"-8	.60"	1.075"		
105220	3"-8	1-¾"	1-$^{7}/_{16}$"		
New Britain					
105160	M55x3.0	19mm	43mm	134652	134653
105219	M55x3.0	32mm	43mm		
Newbury					
105205	1-½"-12	$^{27}/_{32}$"	1.44	134652	134653
Niigata					
138593	M40x3.0	20mm	37mm	134652	134653
170853	M50x2.0	36mm	52mm		
Nissei					
110906	M40x2.0	20mm	37mm	134652	134653
105197	M50x2.0	26mm	42mm		
132335	M80x2.0	40mm	82mm		
Stokes					
105190	1-¾"-8	1-¼"	1-¾'	134652	134653
Sumitomo					
127748	M68x3.0	25mm	33mm	134652	134653

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IMS Standard Nozzle Thread Adapters

Make of Press	Dimensions			Recommended Heater Bands	
Item #	Thread Size (A)	Rear Opening (B)	Thread Length (C)	120 Volt	240 Volt
Toshiba					
105148	1-½"-12	.59”	1-⅜"	134652	134653
105185	3-¼"-8	2.04”	2-¼"		
105171	M60x4.0	32mm	42mm		
136424	M80x4.0	53mm	74mm		
125014	M80x4.0	55mm	80mm		
Van Dorn					
105136	1-¼"-12	¾"	1-⅝"	134652	134653
105190	1-¾"-8	1-¼"	1-¾"		
105213	1-¾"-8	⅜"	1-¾"		

Check Out These Other Useful IMS Products!

Heat Resistant Gloves

Use Them For Quick Transfer Of Hot Nozzles, Screws, Screw Tips, Molds, Water Lines, Heater Bands, Etc.

- Heat resistant up to 400°F (short duration)
- Special nitrile rubber coating improves grip — prevents slipping
- Comfortable and breathable 100% cotton
- Extra thick inner liner resists heat
- One size fits all

Hot Nozzle Gloves

with anti-slip coating

Item No. 110671

- Maximum Use Temperature: 190°F
- Heat resistant dots leave NO MARKS on product
- Dots on both sides
- One size fits all

High Heat PVC Dot Gloves

Item No. 136368

See Pages 446 - 449 for More Gloves and Pricing

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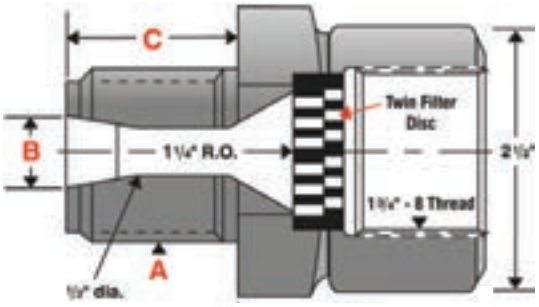
Made in the U.S.A

IMS Nozzle Thread Adapters with Metal Trap

Help Stop Tramp Metal From Entering Mold

For use only with 1¾"-8 thread, 1¼" rear opening nozzles (Should only be used with twin filter disc in place)



CAUTION: Only use with filter disc in place

Make of Press	Dimensions			Recommended Heater Bands	
Item #	Thread Size (A)	Rear Opening (B)	Thread Length (C)	120 Volt	240 Volt
Arburg					
105228	M24/1.5	7.5mm	28mm	134652	134653
135240	M52/2.0 RH	35mm	32mm		
Battenfeld					
105157	M40/2.0	25mm	38mm	134652	134653
105216	M41/2.0	30mm	38mm		
105214	M65/3.0	48mm	51mm		
Cincinnati					
105179	1-½"-12	1/2”	2”	134652	134653
105210	1-¾"-8	3/4”	1-¾"		
Farrel					
105222	1-¾"-8	1"	1-¾"	134652	134653
Fellows					
105166	1-¼"-10	¾"	1-⅜"	134652	134653
HPM					
105141	1-⅝"-12 Fem	¾"	⅝"	134652	134653
105210	1-¾"-8	¾"	1-¾"		
105195	2-½"-8	1”	1-½"		
105217	3-⅛"-8	1”	1-¼"		
105142	3-⅛"-8*	1”	2-3/16"		

continued on next page

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Make of Press	Dimensions			Recommended Heater Bands	
Item #	Thread Size (A)	Rear Opening (B)	Thread Length (C)	120 Volt	240 Volt
Impco					
105226	1-¼"-12	¾"	1-⅝"	134652	134653
105854	1-¾"-12	¾"	1-3/16"		
JSW					
105227	M50/3.0	15mm	57mm	134652	134653
Kawaguchi					
105163	1-¾"-8	1-5/16"	1-¼"	134652	134653
105167	M45/3.0	16mm	32mm		
Klockner					
105215	1" B.P.T.	0.394”	1.41"	134652	134653
Mitsubishi					
140619	1-½"-12	¾"	1.1"	134652	134653
Natco					
105134	2-¼"-8 Fem	0.6"	1.075"	134652	134653
Newbury					
105191	1-½"-12	27/32"	1.44"	134652	134653
Nissei					
114777	M40/2.0	20mm	37mm	134652	134653
105180	M50/2.0	26mm	42mm		
Reed					
105210	1-¾"-8	¾"	1-¾"	134652	134653
Stokes					
105175	1-¾"-8	1-¼"	1-¾"	134652	134653
Toshiba					
105131	1-½"-12	0.59"	1-⅜"	134652	134653
105168	3-¼"-8	2.047"	2-¼"		
105843	M60/4.0	32mm	42mm		
Van Dorn					
105226	1-¼"-12	¾"	1-⅝"	134652	134653
105200	1-¾"-8	⅜"	1-¾"		
105175	1-¾"-8	1-1/4”	1-¾"		

Filter Discs	
105194	Twin filter disc with .031 av. opening
132336	Twin filter disc with .060 openings
112600	Press pin (for twin filter disc) — 2 required for each filter disc

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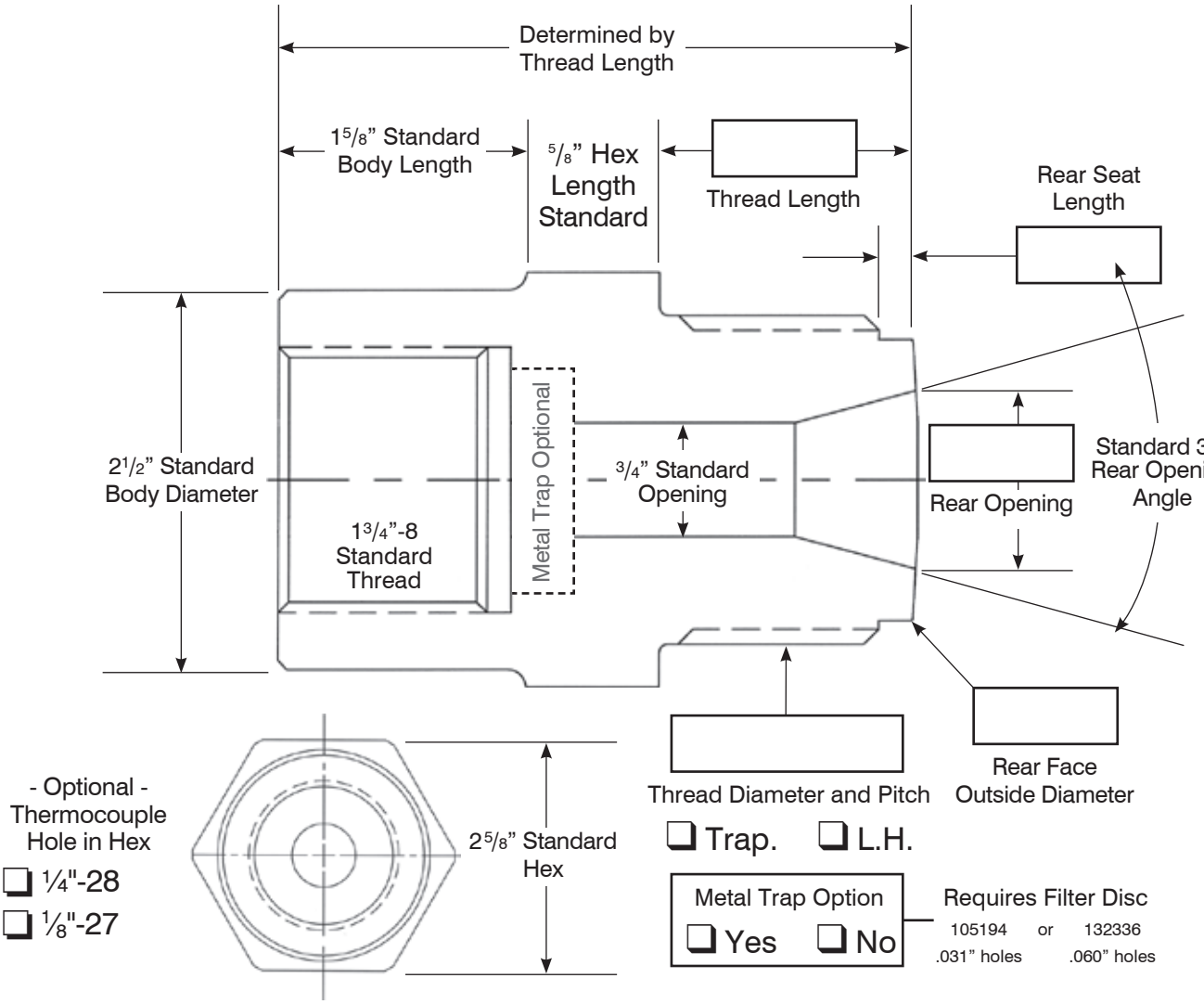
REQUEST FOR QUOTE: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

Custom Nozzle Thread Adapter Form

Converts Any Thread To Industry Standard 1¾" - 8

Fill in the following basic dimension blanks



Required:

1. Press Make _____
   and Model _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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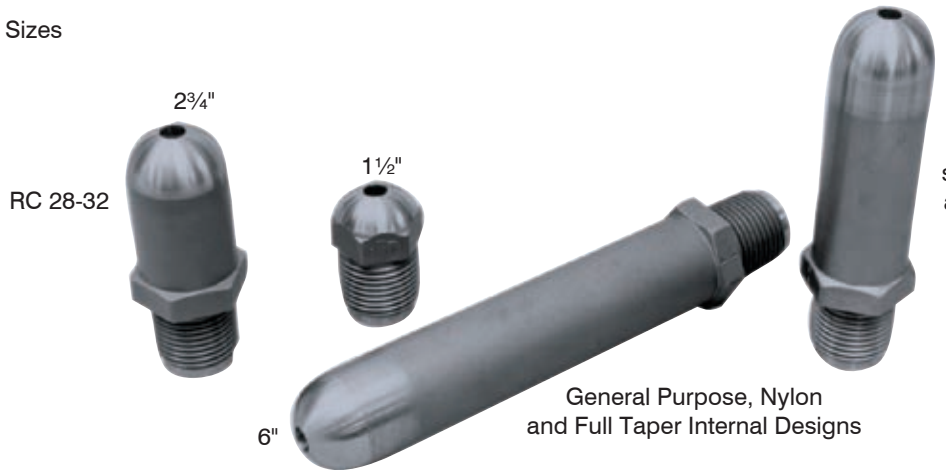
IMS Injection Molding Nozzle Tips

Made in the U.S.A

IMS Exclusive Replacement Nozzle Tips

4 Stock Sizes



IMS also stocks a huge assortment of heater bands

General Purpose, Nylon and Full Taper Internal Designs

IMS precision made nozzle tips are designed from high quality, heat-treated tool steel and are perfect for everyday use in the molding shop. The technicians at IMS have worked hard to bring you quality at an affordable price.

At IMS, we put our customers' satisfaction as the highest priority. When it comes to our nozzle tips, we think you will agree that they are a great value.

Here are 10 reasons to buy IMS nozzles:

1. All IMS Tips are guaranteed to meet our certified material and hardness requirements.
2. All IMS Tips are machined using state-of-the-art machines by experienced technicians who use the most up-to-date practices so you can be assured they are made with care and quality.
3. All IMS Tips are finished to perfection using hand polishing.
4. All IMS Tips are protected from rust and corrosion.
5. All IMS Tips are protected from thread damage and nicks.
6. All IMS Tips are stamped with sizes and styles for easy re-ordering.
7. All IMS Tips are tested using the latest computerized measuring and checking equipment.
8. All IMS Tips are warrantied against premature failure and defects in workmanship.
9. All IMS Tips are quality inspected in our facility using the strictest approval practices.
10. Your satisfaction is guaranteed!

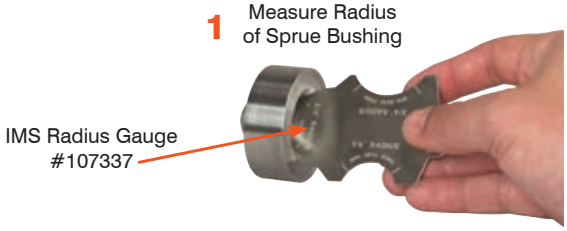
If your application requires higher wear resistance, sizes not listed, etc. please contact an IMS technician for a prompt quote, see the "Request for Quotation Form" on page 553 of the catalog, or fill out a digital form at imscompany.com

Beryllium Copper: Nozzle tips made of heat treated beryllium copper ensure maximum heat transfer plus strength and toughness. Beryllium Copper nozzle tips will help prevent tip freeze-ups, will let you lower nozzle temperature, and will enable electrical use reduction while shortening cycle times.

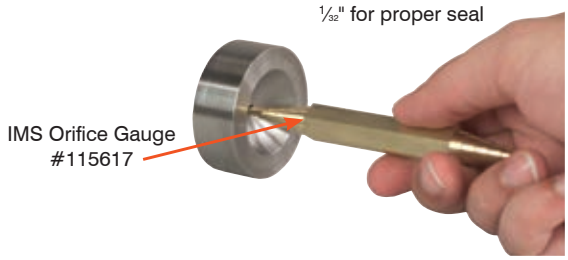
NOTE: Beryllium Copper Nozzle Tips are not recommended for use with abrasive materials.

Before Ordering, Please Gather The Following Dimensions:

1 Measure Radius of Sprue Bushing



2 Measure Sprue Bushing Orifice "O" Dimension and subtract 1/32" for proper seal



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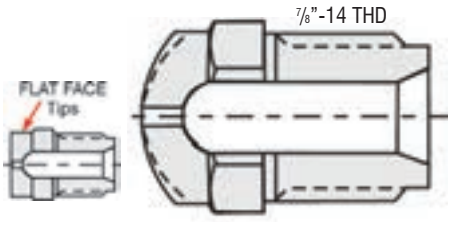
IMS Standard Nozzle Tips

Heat Treated Tool Steel and Beryllium Copper Nozzle Tips

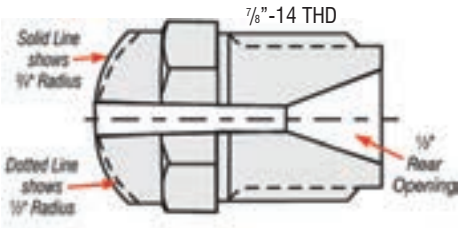
General Purpose Internal Design

Used for Styrene, Polyethylene and other General Purpose Materials



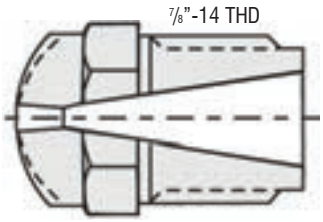
Nylon Internal Design

Minimizes Drool when molding with Nylon



Full Taper Internal Design

Used with Acrylics, ABS, Sulfone and other engineering materials



General purpose nozzle tips

Used for styrene, polyethylene and other general purpose materials

High Quality, Heat Treated Tool Steel

1½" Length

Orifice	½" Radius	¾" Radius
1/16"	101527	101529
3/32"	116602	136160
1/8"	101440	101444
1/8"	108390 (Flat Face)	
5/32"	101448	101442
3/16"	101446	101441
7/32"	132046	121078
1/4"	101445	101439
9/32"	143733	143735
5/16"	101443	101447
11/32"	143734	143736
3/8"	105244	105246
7/16"	144242	143737
1/2"	109012	121081

2¾" Length (1" x 1" Heater Band Recommended)

Orifice	½" Radius	¾" Radius
1/16"	109627	108343
3/32"	108347	108341
1/8"	101491	101453
5/32"	101477	101518
3/16"	101467	101506
7/32"	108338	108344
1/4"	101522	101482
9/32"	108348	108342
5/16"	108346	108339
11/32"	143738	143739
3/8"	105288	105272
1/2"	129042	143740

4" Length (1" x 2" Heater Band Recommended)

Orifice	½" Radius	¾" Radius
1/16"	108396	112107
3/32"	108406	112103
1/8"	101493	101457
5/32"	108402	112115
3/16"	101468	101510
7/32"	108399	112110
1/4"	101524	101486
9/32"	108407	112105
5/16"	108404	112017
3/8"	108403	112098

6" Length (1" x 3" Heater Band Recommended)

Orifice	½" Radius	¾" Radius
1/16"	108397	112109
3/32"	108395	112104
1/8"	101495	101459
5/32"	108392	109157
3/16"	101470	101512
7/32"	108388	112112
1/4"	101449	101490
9/32"	108408	112106
5/16"	108405	112102
3/8"	108394	112100

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General Purpose Nozzle Tips

Used for styrene, polyethylene and other general purpose materials

High Quality, Heat Treated Tool Steel

8" Length (Two 1" x 3" Heater Band Recommended)

Orifice	½" Radius	¾" Radius
1/16"	145554	145566
3/32"	145555	145567
1/8"	145556	145568
5/32"	145557	145569
3/16"	145558	145570
7/32"	145559	145571
1/4"	145560	145572
9/32"	145561	145573
5/16"	145562	145574
11/32"	145563	145575
3/8"	145564	145576
1/2"	145565	145577

Beryllium Copper

1½" Length

Orifice	½" Radius	¾" Radius
1/16"	161958	170327
3/32"	119019	170328
1/8"	101501	101466
3/16"	101489	101456
1/4"	101476	101521

Nylon Nozzle Tips

Minimizes drool when molding nylon

High Quality, Heat Treated Tool Steel

1½" Length

Orifice	½" Radius	¾" Radius
3/32"	143744	143750
1/8"	101479	101511
5/32"	110366	112111
3/16"	101458	101488
7/32"	143745	143751
1/4"	101523	101475
9/32"	143746	143752
5/16"	129336	143753
11/32"	143747	143754
3/8"	143748	143755

4" Length (1" x 2" Heater Band Recommended)

Orifice	½" Radius	¾" Radius
1/8"	106559	110073
3/16"	108571	110072
1/4"	147989	168601

2¾" Length (1" x 1" Heater Band Recommended)

Orifice	½" Radius	¾" Radius
3/32"	108322	108325
1/8"	101455	101472
5/32"	108327	108321
3/16"	101508	101451
7/32"	143758	143764
1/4"	101498	101517
9/32"	143759	143765
5/16"	143760	143766
11/32"	143761	143767
3/8"	143762	143768

Tech Tips

Nozzle orifice size should be 10% smaller than the sprue bushing.

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Nylon Nozzle Tips

Minimizes drool when molding nylon

Beryllium Copper

1½" Length

Orifice	½" Radius	¾" Radius
1/8"	101509	101473
3/16"	101499	101464
1/4"	101485	101452

Full Taper Nozzle Tips

Used with acrylics, ABS, sulfone and other engineering materials

High Quality, Heat Treated Tool Steel

1½" Length

Orifice	½" Radius	¾" Radius
3/32"	143777	143783
1/8"	101520	101463
5/32"	143778	116810
3/16"	101497	101516
7/32"	143779	143785
1/4"	101484	101505
9/32"	143780	143786
5/16"	107509	107512
11/32"	143781	143787
3/8"	142793	143788

2¾" Length (1" x 1" Heater Band Recommended)

Orifice	½" Radius	¾" Radius
3/32"	143791	143799
1/8"	101481	101525
5/32"	143792	143800
3/16"	101469	101513
7/32"	143793	143801
1/4"	101460	101502
9/32"	143794 - **$62.90**	143802
5/16"	143795	143803
11/32"	143796	143804
3/8"	143797	143805

Beryllium Copper

1½" Length

Orifice	½" Radius	¾" Radius
1/8"	101461	101503
3/16"	101526	101492
1/4"	101514	101478

Test Blanks

- Solid stress proof steel
- **⅞"-14 Threads**

Orifice	½" Radius	¾" Radius
—	136499	136486

Tech Tips

If you are having shear problems with Acrylic materials try a Full Taper nozzle.

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phone order toll-free (Mexico) 001.888.304.1307
tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

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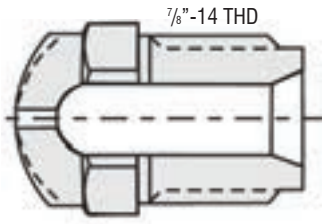
IMS Metric Nozzle Tips

High Quality, Heat Treated Tool Steel Nozzle Tips

Made in the U.S.A

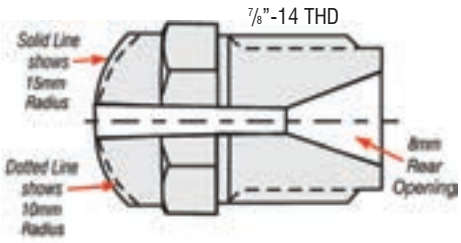
General Purpose Internal Design

Used for Styrene, Polyethylene and other General Purpose Materials



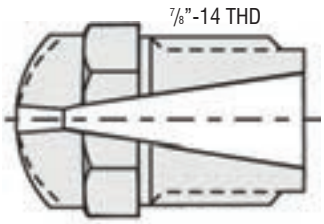
Nylon Internal Design

Minimizes Drool when molding with Nylon



Full Taper Internal Design

Used with Acrylics, ABS, Sulfone and other engineering materials



General Purpose Nozzle Tips

1½" Length

Orifice	10mm Radius	15mm Radius
2mm	143741	143810
2.5mm	143742	143811
3mm	143826	143812
4mm	143809	143813
5mm	144241	144265
6mm	144254	134489

Nylon Nozzle Tips

1½" Length

Orifice	10mm Radius	15mm Radius
2mm	143774	143815
2.5mm	143775	143816
3mm	124322	143817
4mm	143814	143818
5mm	122907	145295
6mm	123064	145296

Full Taper Nozzle Tips

1½" Length

Orifice	10mm Radius	15mm Radius
2mm	143806	143820
2.5mm	143807 - **$24.50**	143821
3mm	143808	143822
4mm	143819	143823

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IMS Arburg Nozzle Tips

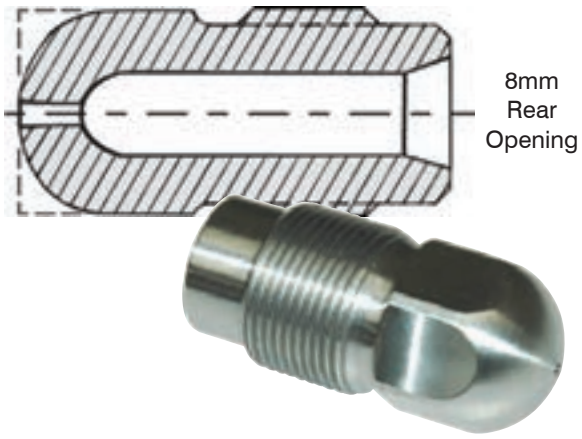
Heat Treated Tool Steel Nozzle Tips

General Purpose Arburg Nozzle Tips

Used for styrene, polyethylene and other general purpose materials

High Quality, Heat Treated Tool Steel

M24x1.5mm THD



2.08" Length

Orifice	½" Radius	¾" Radius	Flat Face
1/16"	145544	144266	145370
3/32"	145322	144267	145371
1/8"	144178	144268	145372
5/32"	144233	144269	145373
3/16"	144234	144270	145374
7/32"	144235	144271	145375
1/4"	144236	144272	145376
9/32"	144237	144273	145377
5/16"	144238	144274	145378

2¾" Length

Orifice	½" Radius	¾" Radius	Flat Face
1/16"	144239	144278	145382
3/32"	144243	144279	145383
1/8"	144244	144280	145384
5/32"	144245	144281	145385
3/16"	144246	144282	145386
7/32"	144247	144283	145387
1/4"	144248	144284	145388
9/32"	144249	144285	145389
5/16"	144250	144286	145390

3¾" Length

Orifice	½" Radius	¾" Radius	Flat Face
1/16"	144240	144290	145394
3/32"	144255	144291	145395
1/8"	144256	144292	145396
5/32"	144257	144293	145397
3/16"	144258	144294	145398
7/32"	144259	144295	145399
1/4"	144260	145506	145400
9/32"	144261	145293	145401
5/16"	144262	145294	145402

continued on next page

Optional Accessory

Arburg Nozzle Tip Adapter

Adapts OEM Arburg thread to a standard IMS 7/8"-14 tip

Item #	Style	OAL	Rear Thread	Rear Opening
121345	General Purpose	2.07"	M24 x 1.5	.315
135204	General Purpose	2.07"	M36 x 2.0	.315

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tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

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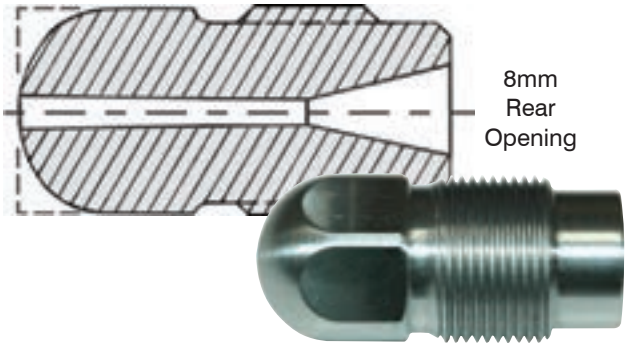
Nylon Arburg Nozzle Tips

Minimizes drool when molding nylon

High Quality, Heat Treated Tool Steel

M24x1.5mm THD



2.08" Length

Orifice	½" Radius	¾" Radius	Flat Face
1/8"	145300	145336	160856
5/32"	145301	145337	160857
3/16"	145306	145338	160858
7/32"	145303	145339	160859
1/4"	145304	145340	160860
9/32"	145305	145341	160861
5/16"	145302	145342	160862

2¾" Length

Orifice	½" Radius	¾" Radius	Flat Face
1/8"	145312	145348	160866
5/32"	145313	145349	160867
3/16"	145314	145350	160868
7/32"	145315	145351	160869
1/4"	145316	145352	160870
9/32"	145317	145353	160871
5/16"	145318	145354	160872

3¾" Length

Orifice	½" Radius	¾" Radius	Flat Face
1/8"	145324	145360	160876
5/32"	145325	145361	160877
3/16"	145326	145362	160878
7/32"	145327	145363	160879
1/4"	145328	145364	160880
9/32"	145329	145365	160881
5/16"	145330	145366	160882

IMS Maxx Flow Tips

Maxx Flow Nozzle Tips

Used for styrene, polyethylene and other general purpose materials

High Quality, Heat Treated Tool Steel

1¾" Length (1¼"-12 THD and ¾" Rear Opening)

Orifice	½" Radius	¾" Radius
1/8"	148728	160020
5/32"	150532	160021
3/16"	148565	148559
7/32"	160025	160022
1/4"	138477	148518
9/32"	160026	160023
5/16"	160027	150490
11/32"	160028	160024
3/8"	160029	145701
1/2"	160030	149896

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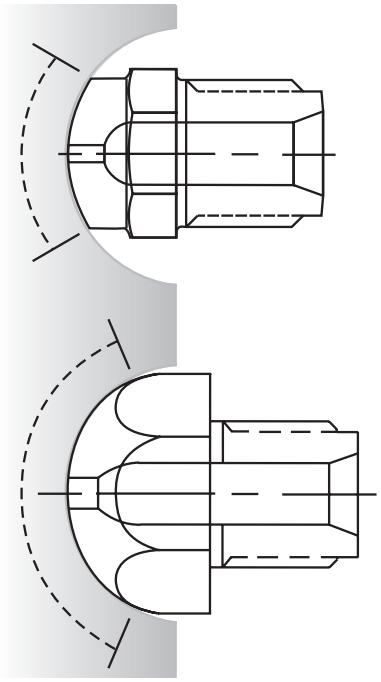
Maximum Contact "Mushroom" Tips

Made in the U.S.A

Extended radius surface allows greater contact between nozzle and sprue bushing —

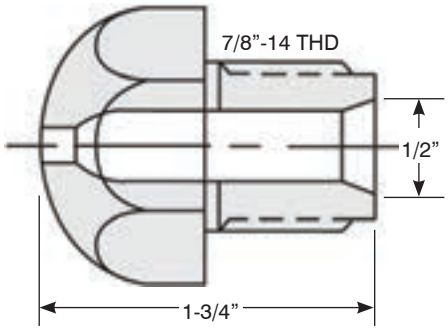
Helps Stop Leakage



- ¾" Radius
- 1¼" Hex
- ⅞"-14 Thread
- ½" Rear Opening
- 1¾" Long

General Purpose Internal Design

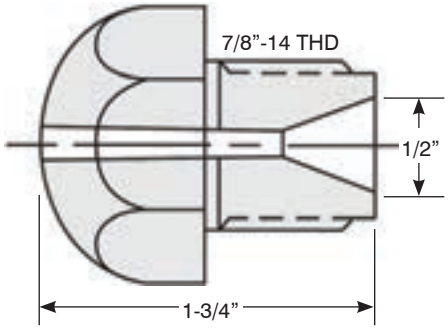
Used for styrene, polyethylene and other general purpose materials



Item #	Orifice
144118	1/8"
144119	3/16"
144120	1/4"
144121	5/16"
144122	3/8"
144123	1/2"

Nylon Internal Design

Minimize drool when molding with Nylon



Item #	Orifice
144124	1/8"
144125	3/16"
144126	1/4"
144127	5/16"
144128	3/8"

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Custom Nozzle Tip Form

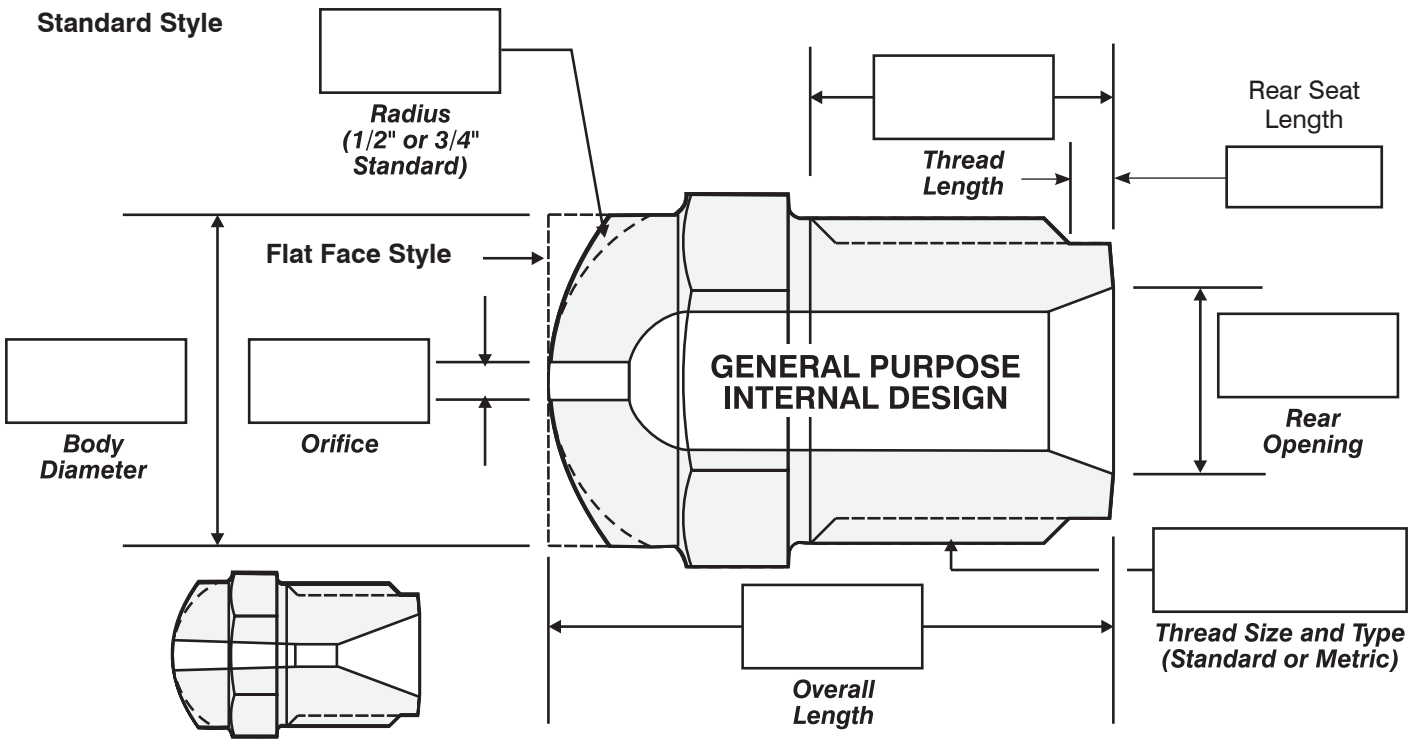
Made in the U.S.A

Specify:

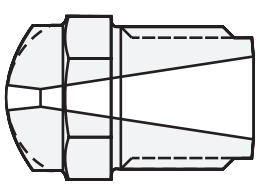
1. External Style of Nozzle Tip:
   ❑ Standard ❑ "Mushroom" ❑ Flat Face*
   *Diameter (if other than standard)_____

2. Internal Design of Nozzle Tip:
   ❑ General Purpose ❑ Nylon ❑ Full-Taper

Fill in the following basic dimension blanks

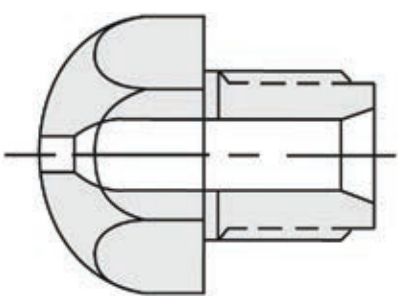


NYLON INTERNAL DESIGN



FULL TAPER INTERNAL DESIGN

"Mushroom" Style



Optional:

3. Material To Be Molded _____

4. Operating Temperature _____

Date:_____ Quantity:_____ Phone:(_____)_____ Fax: (_____)_____

Name:_____ Title:_____

Company Name: _____ Email: _____

Address:_____

City: _____ State:_____ Zip:_____

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Made in the U.S.A

IMS Metric to Standard Nozzle Tip Thread Adapters

Saves You Money - No need to buy expensive, special tips or special adapters

Increase Nozzle Versatility - Lets you use ANY standard nozzle tip with ⅞" -14 thread

Specifications

- 1-⅜" Body Diameter
- 1-¼" Wrench Flats
- ½" Opening at back of female nozzle tip threads
- Adds 0.94" to overall length of assembled nozzle body and tip

4140 Alloy Steel

Nozzle Tip (shown) sold separately

Make of Press	Dimensions		
Item #	Thread Size	Rear Opening	Overall Length
Arburg			
121345	M24 x 1.5mm RH	.315”	2.07”
135204	M36 x 2.0mm RH	.315”	2.07”
Boy			
120623	M24 x 1.5mm RH	14mm	2.07”
121073	M24 x 1.5mm LH	14mm	2.07”
Engel			
126882	M28 x 1.5mm RH	.472”	2.07”
Kawaguchi			
137258	M30 x 1.5mm RH	.315”	2.07”
121349	1”-12 RH	.625”	2.07”
Toyo			
142715	M36 x 2.0mm RH	23mm	1.75”

Need a different size? Call our techs and we will find it!

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

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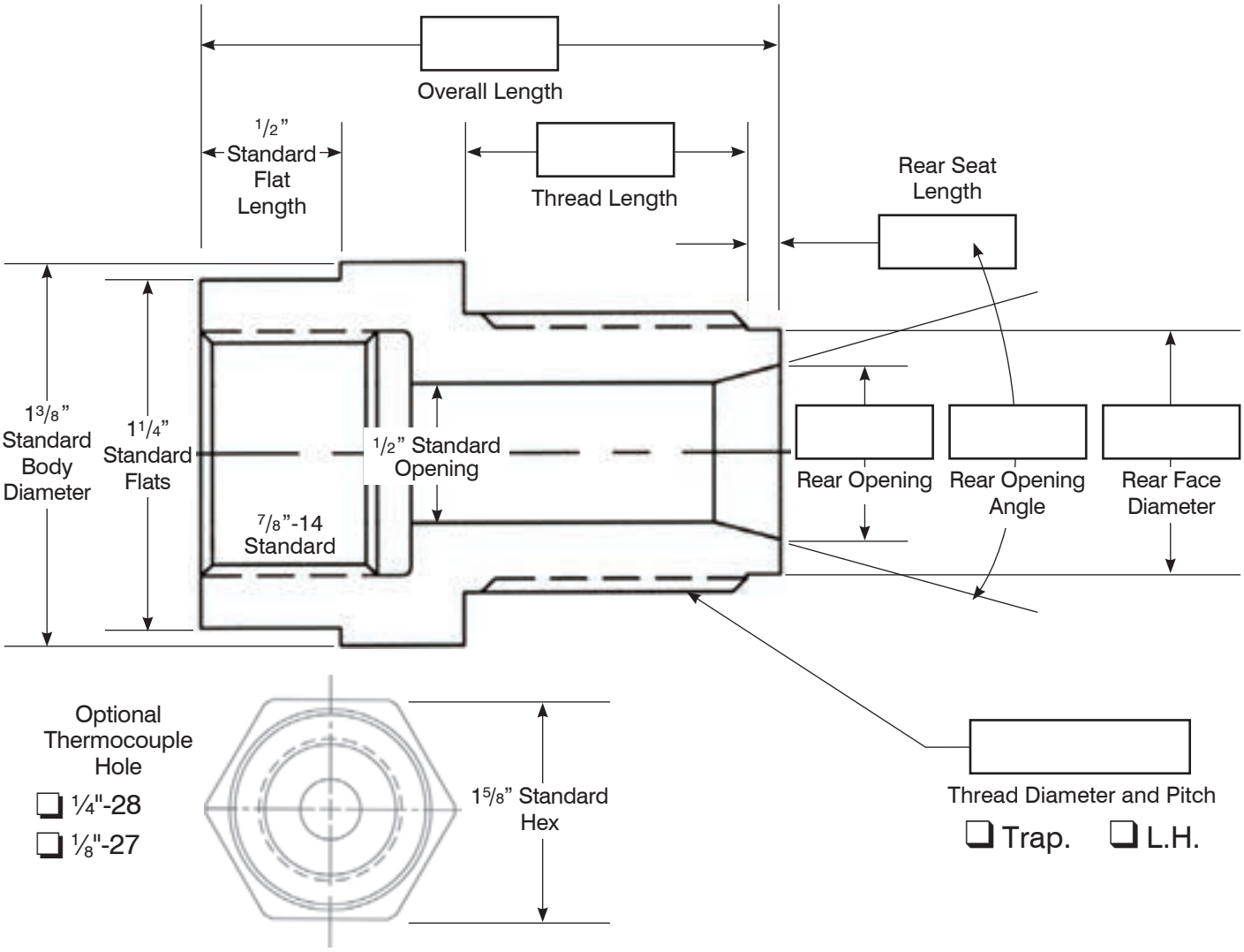
Custom Nozzle Tip Thread Adapter Form

Converts Any Thread to Industry Standard ⅞"-14

Made in the U.S.A

Fill in the following basic dimension blanks



Optional:

1. Press Make _____
   and Model _____

2. Optional Thermocouple
   Thread Size and Location _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Made in the U.S.A

IMS Radius Refacing Tools

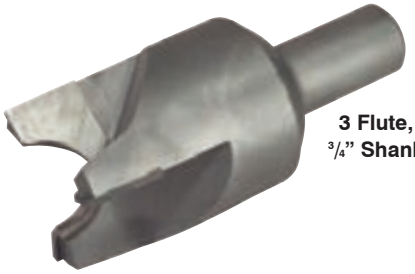
Extend Nozzle and Bushing Life

Put Your Damaged Parts Right Back on the Line • Quickly and Easily with Our Refacing Tools

- Create good sealing surfaces that stop leaks — Cut costs
- Cut clean, new radii and shoulders — Extend nozzle and bushing life
- Ensure a good nozzle seat — Stop sprue sticking
- Improve sprue pull-out — Reduce contamination
- Carbide cutting tips (C-2)
- Durable 4140 hot rolled, heat-treated steel

Note: For resurfacing only. Not for cutting radii from blank steel.

Standard Sizes



3 Flute, ¾" Shank

Item #	Radius	# of Flutes	Shank Dia.
Nozzle Radius Refacing Tools			
126252	½"	3	¾"
127806	¾"	3	¾"

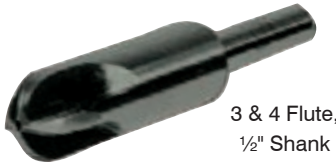
3 Flute, ¾" Shank

Item #	Radius	# of Flutes	Shank Dia.
Sprue Bushing Radius Refacing Tools			
127488	½"	3	¾"
127399	¾"	3	¾"

Metric Sizes

3 Flute, ½" Shank

Item #	Radius	# of Flutes	Shank Dia.
Nozzle Radius Refacing Tools			
169501	10mm	3	½"
121727	15mm	3	½"
169332	20mm	3	½"



3 & 4 Flute, ½" Shank

Item #	Radius	# of Flutes	Shank Dia.
Sprue Bushing Radius Refacing Tools			
121731	10mm	4	½"
175583	15mm	3	½"
165278	20mm	3	½"

Buy Kits and Save!

Item #	Radius	# of Flutes	Shank Dia.
Nozzle and Bushing Tool Combination Offer			
126639	½"	3	¾"
127807	¾"	3	¾"

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Anti-Drool Nylon Nozzle Tips with Spreader Insert

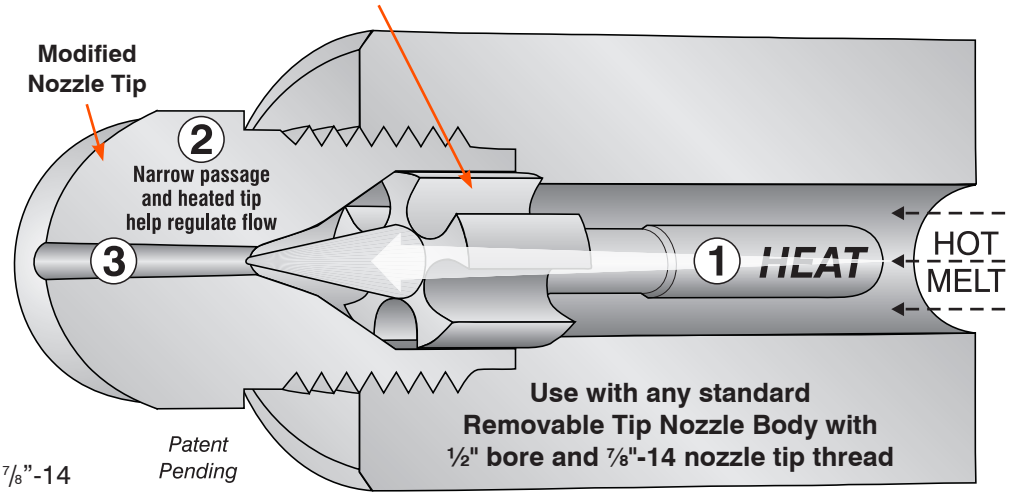
Made in the U.S.A

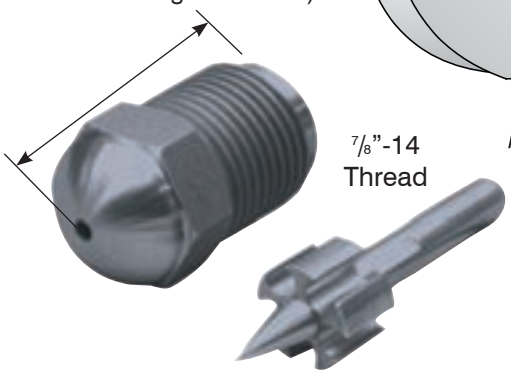
Lets You Reduce Nozzle Temperatures

Stop drooling, stringing and freeze-offs – run faster cycles • Prevent material degradation – mold better parts

Unique Spreader Insert

• Eliminates Dangerous and Troublesome Cold Slugs • Provides Clean, String-Free Breaks





Spreader Insert
#111454

Here's How It Works *(See diagram above)*:

Spreader body (**1**) extracts heat from plastic in nozzle body and transfers it to spreader tip (**2**). Tip narrows passage at rear of nozzle orifice. Size of passage and heat from spreader let you precisely control melt temperature through that critical area, avoiding both freeze-offs and drooling. The rest of the nozzle orifice (**3**) cools freely, allowing a clean break with minimal stringing.

1-½" OAL Nylon Nozzle Tips ONLY (Spreader Sold Separately)

Orifice	½" Radius	¾" Radius
⅛"	111447	111452
5/64"	136660	162822
3/32"	159755	162823
5/32"	140320	162814
3/16"	111444	111448
7/32"	149852	162824
¼"	125162	147894

Same Insert fits all Special, Modified Nylon Nozzle Tips

For best results, clean seat before installing tip and insert.

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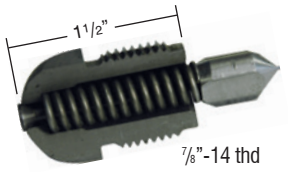
Made in the U.S.A

Shutoff Nozzle Tips

Use In Any Nozzle Body with ½" Bore

1/16" orifice requires 7/32" minimum sprue bushing
1/8" orifice requires 9/32" minimum sprue bushing
3/16" orifice requires 5/16" minimum sprue bushing

Spring Cracking Pressure: 1000 psi



— NOTE —

The spring loaded valve in nozzle tip restricts movement of material until activated by pressure.

Berylium Copper Tips Available - Inquire

Nozzle Assemblies

Item #	Radius	Orifice	
142351	½"	1/16"	
142353	½"	1/8"	
142355	½"	3/16"	
142352	¾"	1/16"	
142354	¾"	1/8"	
142356	¾"	3/16"	
Spare Parts			
½" Radius Tips	147872 (1/16")	147873 (1/8")	147874 (3/16")
¾" Radius Tips	147875 (1/16")	147876 (1/8")	148266 (3/16")
Stems	147865 (1/16")	147866 (1/8")	142357 (3/16")
Torpedo	142358		
Spring	142359		

Minimize nozzle drool and sink patterns

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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EZ Flow Mixing Nozzles

The most common use of mixing nozzles is to *improve the distribution of color concentrates,* improving the appearance or reducing the scrap rate due to poor color distribution. Mixing nozzles can provide benefits often overlooked that improve the quality of the molded part as well as improve the performance and output of the machine.

Improved Overall Cycle Time — Overcoming mixing problems by use of the machine's back pressure slows the screw recovery and in many cases increases the total cycle time. Increased temperature settings often result in improved melt quality but increases the required part cooling time. The use of an effective mixing nozzle will allow for *faster screw recovery* and *lower temperature settings* that results in *faster cycle times.*

Part Surface Finish — Variations in the melt temperature of the plastic from the layered flow effect in both the barrel and nozzle can result in "Seams" or "Flow Lines" in the molded part. Blending the molten polymer just prior to the mold improves thermo homogeneity and results in improved flow into and through the mold.

EZ Flow 20 Mixing Nozzle Tip

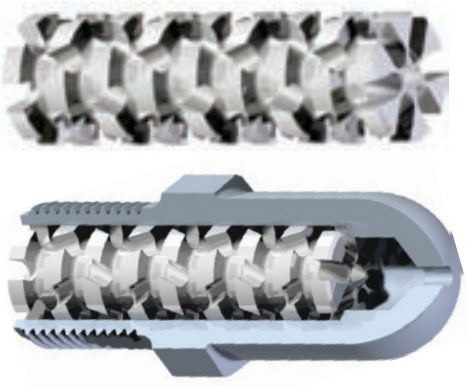
The EZ Flow 20 custom nozzle tip is recommended for smaller injection units with 20 oz. shot sizes or less. Because this mixing tip uses the common ⅞"-14 thread, simply remove your current nozzle tip and thread the EZ Flow 20 into place. It's that simple.

#143018 EZ Flow 20 Mixing Element Only: 0.650" OD, 2.275" OAL, 17-4PH Stainless Steel $230.47

Nozzle Tip Only: 3-½" OAL

Orifice	1/2" Radius	3/4" Radius
1/16"	162838	162849
3/32"	162840	162850
1/8"	162839	162851
5/32"	162841	-
3/16"	162842	150265
7/32"	162843	162853
1/4"	162844	162854
9/32"	162845	162855
5/16"	162846	162856
11/32"	162859	162861
3/8"	162847	162857
7/16"	162860	162862
1/2"	162848	162858

NOTE: For use in applications using less than 15,000 psi injection pressure



— Recommended Heater Band —
#134604 (120V) or **#134605** (240V)

Tech Tips

Still can't quite get the mix you need? Consider placing a Color Dispersion Disc (Pages 514-515) behind the nozzle tip for added agitation.

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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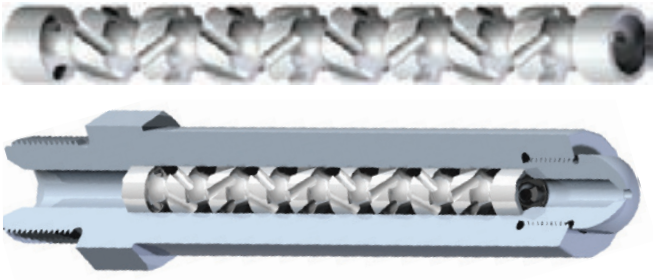
EZ Flow 95 Mixing Nozzle

EZ Flow 95 is a one piece drop-in insert held in place with standard nozzle tip. The design offers very aggressive mixing action in an easy-to-use and clean design. The EZ Flow 95 nozzle tip is recommended for injection units with 95 oz. shot size or less.

(1) ¼"-28NPT & (1) ⅛"-27NPT Installed On Hex. Uses standard ⅞"-14 Nozzle Tips.

Minimum 8" OAL with Tip

OAL with Tip	Heated Area	Heaters Required
8"	4-½"	(1) 1-½" x 4"
9"	5-½"	(1) 1-½"x 5"
10"	6-½"	(2) 1-½" x 3"
12"	8-½"	(2) 1-½" x 4"
14"	10-½"	(2) 1-½" x 5"
16"	12-½"	(2) 1-½" x 6"
18"	14-½"	(2) 1-½" x 6"
20"	16-½"	(3) 1-½" x 5"



EZ Flow 95 Mixing Element Only; ⅝" OD, 6.100" OAL, 17-4PH Stainless Steel
#138352

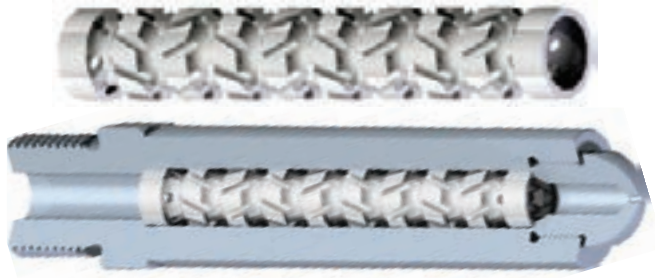
EZ Flow 180 Mixing Nozzle

The large EZ Flow 180 is a one piece drop-in insert held in place with a large standard 1-¼"- 12-thread tip. The design offers very aggressive mixing action in an easy-to-use and clean design. The EZ Flow 180 nozzle tip is recommended for injection units with 180 oz. shot sizes or less.

(1) ¼"-28NPT & (1) ⅛"-27NPT Installed On Hex. Uses standard 1-¼"-12 Nozzle Tip.

Minimum 9" OAL with Tip

OAL with Tip	Heated Area	Heaters Required
9"	5-½"	(1) - 2" x 5"
10"	6-½"	(2) - 2" x 3"
12"	8-½"	(2) - 2" x 4"
14"	10-½"	(2) - 2" x 5"
16"	12-½"	(2) - 2" x 6"
18"	14-½"	(2) - 2" x 6"
20"	16-½"	(3) - 2" x 5"



EZ Flow 180 Mixing Element, 0.937" OD, 6.10" OAL, 17-4PH Stainless Steel
#144166

EZ Flow 260 Mixing Nozzle

The large EZ Flow 260 is a one piece drop-in insert held in place with a custom nozzle tip adapter. The design offers very aggressive mixing action for improved color homogeneity in an easy-to-use and clean design. The EZ Flow 260 nozzle tip is recommended for injection units with 260 oz. shot sizes or less.

(1) ¼"-28NPT & (1) ⅛"-27NPT Installed On Hex. Uses 1-¼"-12 Nozzle Tips.

Minimum 10" OAL with Tip

OAL with Tip	Heated Area	Heaters Required
8"	4-½"	(1) - 2-½" x 4"
9"	5-½"	(1) - 2-½" x 5"
10"	6-½"	(2) - 2-½" x 3"
12"	8-½"	(2) - 2-½" x 4"
14"	10-½"	(2) - 2-½" x 5"
16"	12-½"	(2) - 2-½" x 6"
18"	14-½"	(2) - 2-½" x 6"
20"	16-½"	(3) - 2-½" x 5"

EZ Flow 260 Mixing Element, 1.250" OD, 7.00" OAL, 17-4PH Stainless Steel
#144167

continued on next page

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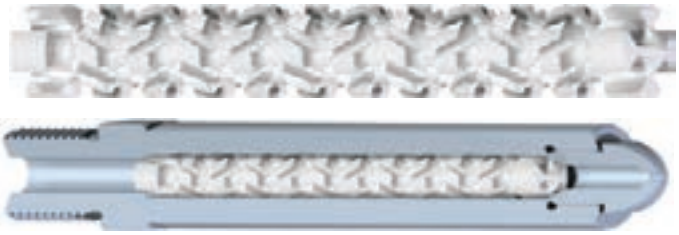
EZ Flow 360 Mixing Nozzle

The super large EZ Flow 360 is a one piece drop-in insert held in place with a custom nozzle tip adapter or a nozzle body to provide added length as required. This unit offers very aggressive mixing action in an easy-to-use and easy-to-clean design. It also provides a blending action for greatly improved color mixing. The EZ Flow 360 nozzle tip is recommended for injection units with 360 oz. shot sizes or less.

(1) ¼"-28NPT & (1) ⅛"-27NPT Installed On Hex. Uses 1-¼"-12 Nozzle Tips.

Minimum 15" OAL with Tip

OAL with Tip	Heated Area	Heaters Required
14"	10-½"	(2) - 2-½" x 5"
16"	12-½"	(2) - 2-½" x 6"
18"	14-½"	(2) - 2-½" x 6"
20"	16-½"	(3) - 2-½" x 5"



EZ Flow 360, Mixing Element, 1.250" OD, 10.50" OAL, 17-4 Stainless Steel
#144168

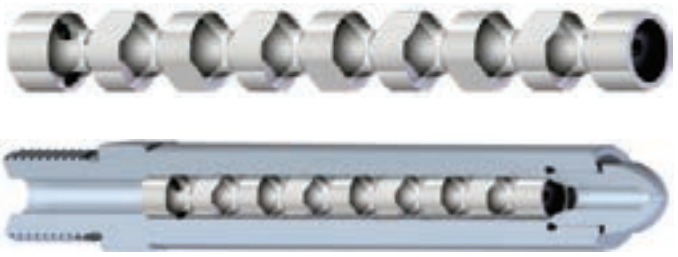
EZ Flow Xtra 80 Mixing Nozzle

EZ Flow Xtra 80 is a one piece drop-in insert held in place with standard nozzle tip. The design offers a very specialized mixing action for flow restrictive or shear sensitive materials. The EZ Flow 80 nozzle tip is recommended for injection units with 80 oz. shot sizes or less.

(1) ¼"-28NPT & (1) ⅛"-27NPT Installed On Hex. Uses standard ⅞"-14 Nozzle Tip.

Minimum 8" OAL with Tip

OAL with Tip	Heaters Required
8"	(1) - 1-½" x 4"
9"	(1) - 1-½" x 5"
10"	(2) - 1-½" x 3"
12"	(2) - 1-½" x 4"
14"	(2) - 1-½" x 5"
16"	(2) - 1-½" x 6"
18"	(2) - 1-½" x 6"
20"	(3) - 1-½" x 5"



#144169 EZ Flow RSS 80 Mixing Element, ⅝" OD, 4.70" OAL, 17-4 Stainless Steel

continued on next page

EZ Flow RSS 80 Mixing Element, 5⁄8" OD, 4.70" OAL, 17-4 Stainless Steel
#144169

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EZ Groove 95 Mixing Nozzle

EZ Groove 95 is a one piece drop-in insert held in place with standard nozzle tip. The design offers very aggressive mixing action in an easy-to-use and clean design. The EZ Groove 95 nozzle tip is recommended for injection units with 95 oz. shot sizes or less.

(1) ¼"-28NPT & (1) ⅛"-27NPT Installed On Hex. Uses standard ⅞"-14 Nozzle Tips.

Minimum 8" OAL with Tip

OAL with Tip	Heaters Required
8"	(1) - 1-½" x 4"
9"	(1) - 1-½" x 5"
10"	(2) - 1-½" x 3"
12"	(2) - 1-½" x 4"
14"	(2) - 1-½" x 5"
16"	(2) - 1-½" x 6"
18"	(2) - 1-½" x 6"
20"	(3) - 1-½" x 5"

#148517 EZ Flow RSS 80 Mixing Element, ⅝" OD, 6.100" OAL, 17-4 Stainless Steel

In-Line Mixing Elements, ½" OD, 5" OAL, H-13 Steel, Set of 7 Helix
#105084

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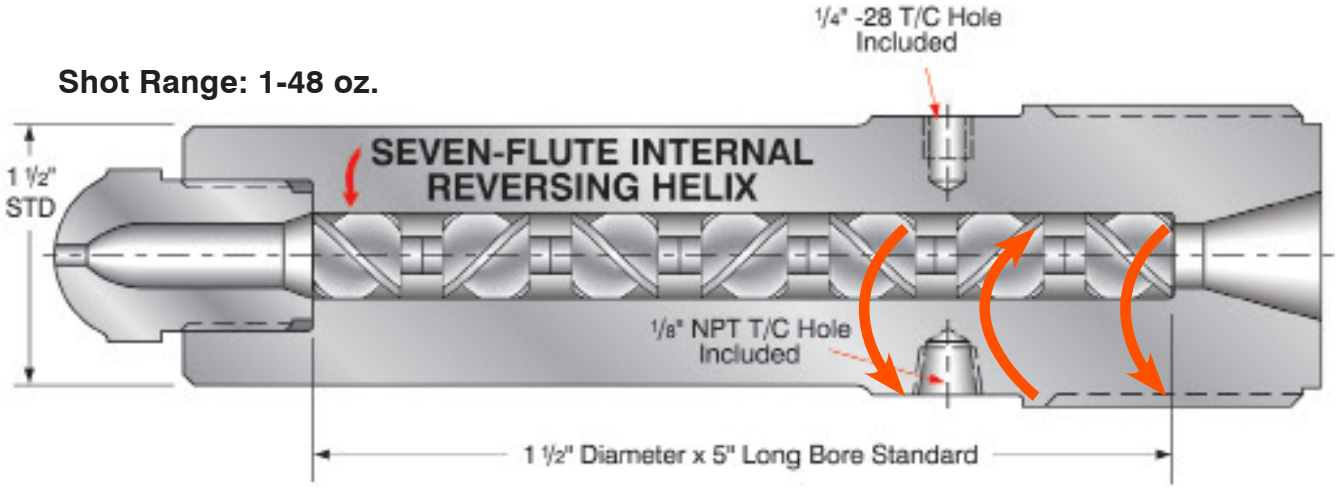
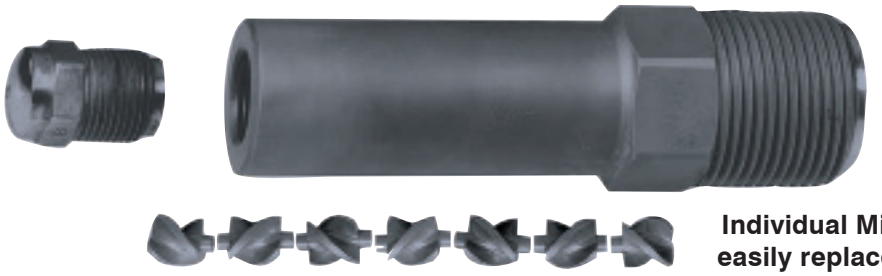
IMS In-Line Color Mixing Nozzle

Provides Optimum Color Mixing with Minimum Flow Restriction

Shot Range: 1-48 oz.





Individual Mixing Segments easily replaced at Low Cost!

Why buy an IMS In-Line Color Mixing Nozzle?

IMS exclusive In-Line Color Mixing Nozzles with their unique, individual mixing segments perform exceptionally well, and for a lot less money than similar units.

Flow restriction is minimal. These mixers let you use less colorant, and they reduce maintenance time and expense. The original IMS In-Line Color Mixing Nozzle — you can't buy a comparable mixing nozzle for less!

See price list on next page

Non-Stock Nozzles

IMS can manufacture Custom In-Line Color Mixing Nozzles

Use The Request For Quotation Form On Page 510.

Tech Tips

Do NOT exceed 48 oz. May create excess pressure build up. See EZ Flow Mixing Nozzles on pages 506-509

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IMS In-Line Color Mixing Nozzles

Standard with ¼"-28 and ⅛ NPT T/C Holes in Hex.

Use Standard ⅞"-14 Nozzle Tips - See pages 489-497 for Tips

Mixing Bodies (see mixing elements below)			
Item #	Length With Tip	Thread Size	Rear Opening
160928	7"	1¼"-12	¾"
115220	7-⅜"		
160929	8"		
160930	9"		
160931	10"		
160932	12"		
160933	14"		
115212	7-⅜"	1½"-12	27/32"
160935	8"		
160936	9"		
160937	10"		
160938	12"		
160939	14"		
160940	7"	1¾"-8	¾"
104742	7-⅜"		
160941	8"		
160942	9"		
160943	10"		
160944	12"		
160945	14"		
160947	8"	1¾"-8	1¼"
105034	8-¼"		
160948	9"		
160949	10"		
160950	12"		
160951	14"		

Required Heater Band		
I.D. x Width (Qty)	Item # 120 Volt	240 Volt
1-½" x 3"	134625	134626
1-½" x 4"	134629	134630
1-½" x 4"	134629	134630
1-½" x 5"	134631	134632
1-½" x 3" (2)	134625	134626
1-½" x 4" (2)	134629	134630
1-½" x 5" (2)	134631	134632
1-½" x 4"	134629	134630
1-½" x 4"	134629	134630
1-½" x 5"	134631	134632
1-½" x 3" (2)	134625	134626
1-½" x 4" (2)	134629	134630
1-½" x 5" (2)	134631	134632
1-½" x 3"	134625	134626
1-½" x 4"	134629	134630
1-½" x 4"	134629	134630
1-½" x 5"	134631	134632
1-½" x 3" (2)	134625	134626
1-½" x 4" (2)	134629	134630
1-½" x 5" (2)	134631	134632
1-½" x 4"	134629	134630
1-½" x 4"	134629	134630
1-½" x 5"	134631	134632
1-½" x 3" (2)	134625	134626
1-½" x 4" (2)	134629	134630
1-½" x 5" (2)	134631	134632

Mixing Elements	
105084	60 oz color mixing helix set (2 flat face, 2 right and 3 left flutes)
104921	Flat face helix
104785	Right flute helix
104855	Left flute helix
107331	Helix set (2 flat face, 2 right and 3 left flutes) CVD coated for abrasion and corrosion resistant surface

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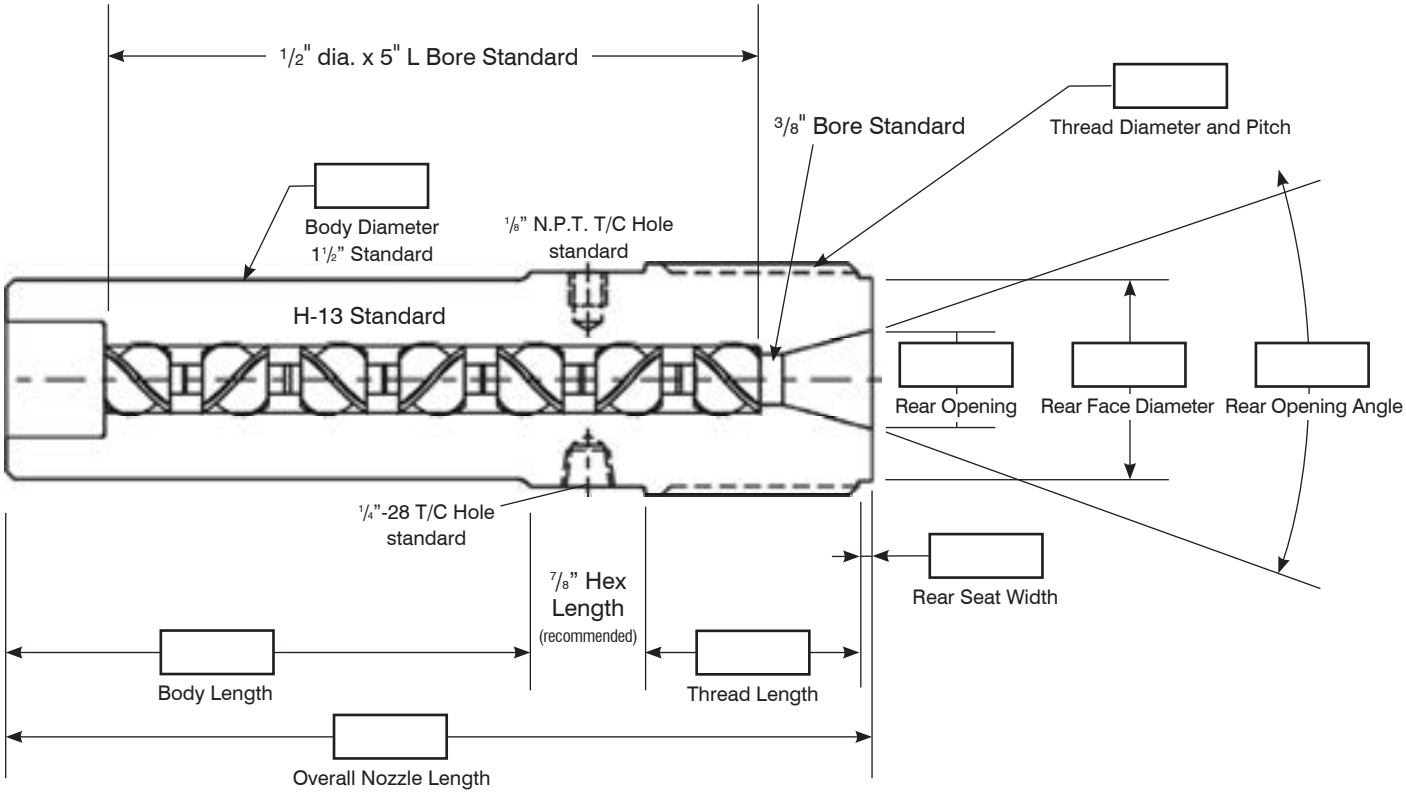
Non-Stock In-Line Color Mixing Nozzle Body Form

Fill In The Following Basic Dimension Blanks



Specify:

Note: External heating standard

1. Press Make _____

   and Model _____

2. Thermocouple

   Thread Size and Location _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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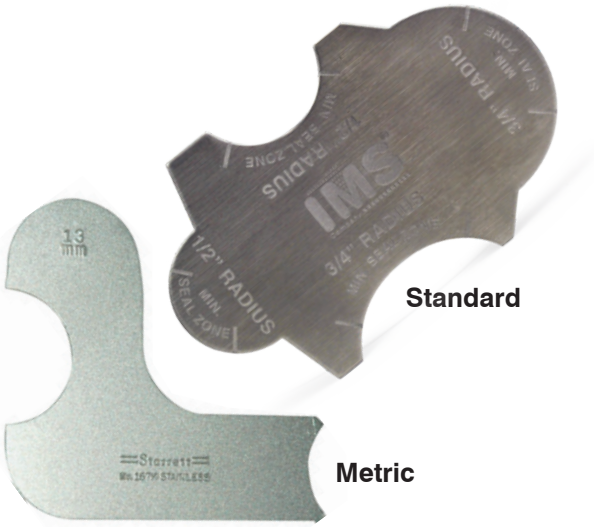
IMS Radius Gauges

Measure Nozzle and Sprue Bushings

Made in the U.S.A

Gauge is marked to show the Sealing Zone as well as the Radius. Correctly matching radius and seal stops drooling and extends nozzle and sprue bushing life.

- Avoid leaks from too little relief
- Avoid nozzle tip crushing from too much relief
- Avoid leaks from mismatched nozzle/bushing surface



Standard

Metric

The IMS Advantage

- Measures BOTH nozzle and sprue
- Simplifies checking of sealing zones
- Standard Radius Gauge is permanently etched (no guessing) to show both the radius and the approximate sealing zone
- Helps prevent leaks and mismatched nozzle/bushing surfaces
- 100% Stainless steel
- Accuracy: ±0.005”

Item #	Description
107337	Standard Radius Gauge ½" and ¾" radius
119111	Metric Radius Gauge (10mm)
132852	Metric Radius Gauge (15mm)

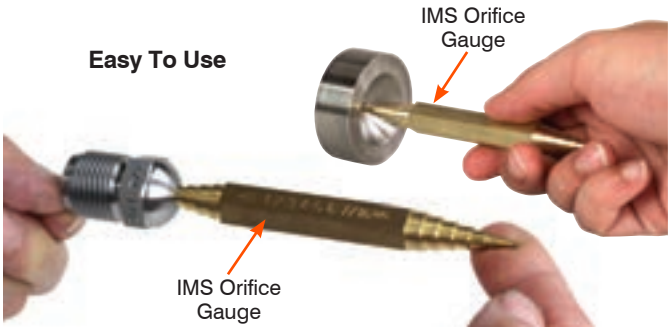
IMS Orifice Gauges

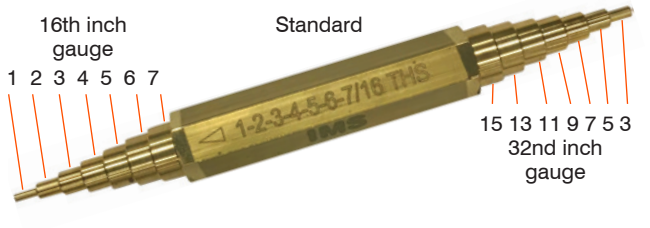
Measures Both Nozzle And Sprue Bushings

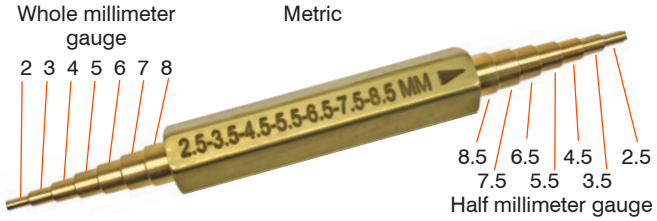
Made in the U.S.A

Use IMS Orifice Gauges to measure the hole size of your nozzle and sprue bushings. The standard gauge measures in 1/16" and 1/32" and the metric gauge measures in whole and half millimeters. These gauges are machined from brass to avoid nozzle damage.

Easy To Use







Item #	Description
115617	Standard Orifice Gauge
117755	Metric Orifice Gauge

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IMS Color Dispersion Plug

For Use In Modified Nozzles

Provides Good Color Dispersion with Minimum Pressure Drop at an Economical Price!

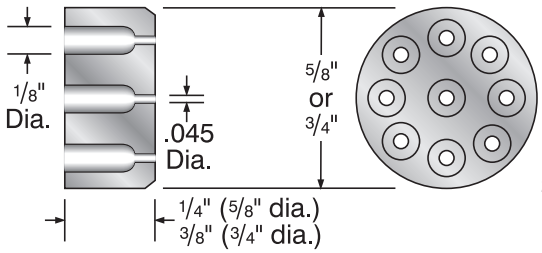
IMS Color Dispersion Plugs provide consistent color blending, minimum pressure drop and less chance of blockage from foreign matter.

⅝" Dia. Plugs fit in a special recess machined into the nozzle tip seat. (See below)

¾" Dia. Plugs fit in a special recess machined into the rear opening. (See below)

Easily removed for cleaning!

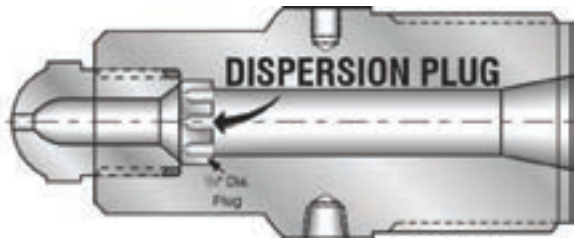
Specifications



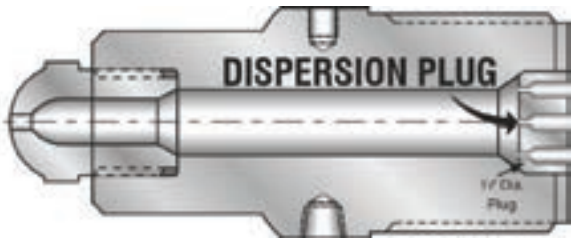
4140 tool steel, 28-32 Rockwell C

Item #	Description
105029	⅝" dia. Color Dispersion Plug
104958	¾" dia. Color Dispersion Plug

Body modified to accept ⅝" dia. plug



Body modified to accept ¾" dia. plug



Buy any RT body and we retrofit it for a dispersion plug — Inquire for Price

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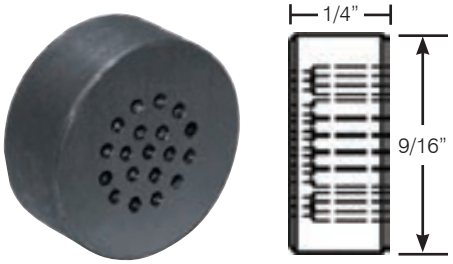
IMS Color Dispersion Plug

For Use In Modified Nozzle Tips

Color Dispersion Plugs

for use in modified Nozzle Tips

IMS #	Diameter	Depth	Hole Count	Hole Size
144182	9/16"	1/4"	19	.025”
144183	9/16	1/4"	19	.050”

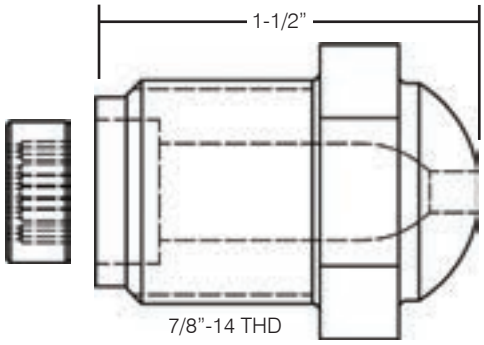


Nozzle tip needs to be counterbored to receive plug

Special Color Dispersion Nozzle Tips

Pre-Counterbored to accept
Color Dispersion Plugs 144182 & 144183

Orifice	½" Radius	¾" Radius
1/16	145520	145531
3/32	145521	145532
1/8	145522	145533
5/32	145523	145534
3/16	145524	145535
7/32	145525	145536
1/4	145526	145537
9/32	145527	145538
5/16	145528	145539
11/32	145529	145540
3/8	145530	145541



IMS Color Dispersion Disc

For Use with Standard Nozzle Tips

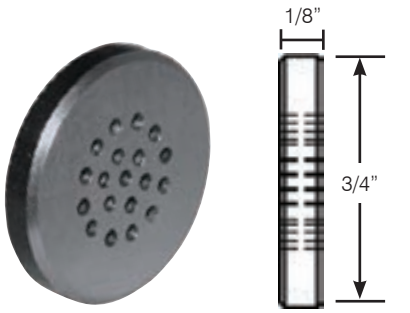
Color Dispersion Disc

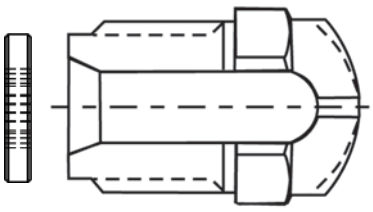
for external application

IMS #	Diameter	Depth	Hole Count	Hole Size
144173	¾"	1/8"	19	.025”
144174	¾"	1/8"	19	.050”

No tip modification necessary

Goes between nozzle body and nozzle tip!





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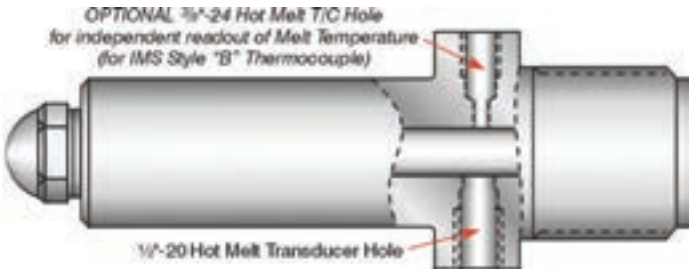
Direct Melt Pressure-Reading Nozzles

Expressly Made with Oversize Hex To Withstand High Injection Pressures

Externally Heated Only

Specify Overall Nozzle Length (without tip attached), Thread Size/Type (standard, metric or trapezoidal) and Rear Opening

- ⅜"-24 T/C hole available if required
- Plugs available for 1/2"-20 transducer hole and ⅜"-24 T/C hole

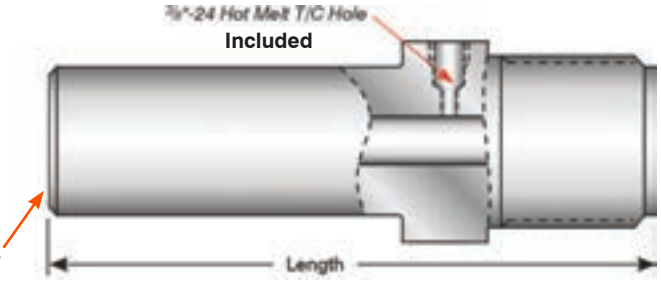


Item #	Description
105115	Plug for transducer hole (½"-20 THD)
104720	Plug for Style B thermocouple hole (⅜"-24 THD)

Direct Melt Temperature-Reading Nozzles

Externally Heated, Removable Tip Style Nozzle with General-Purpose Internal Design standard. Inquire about other internal designs. Other lengths, thread sizes and rear openings available to order.

For One-Piece and Internally Heated Nozzles, inquire for price and specify Nozzle Thread, R.O., Length, Radius and Orifice.



Nozzle Tips sold separately

Length With Tip	Thread Size	Rear Opening	Item #	Recommended Heater Band
5"	1¼"-12"	¾"	104834	#134619 / #134620
	1½"-12"	½"	104762	#134619 / #134620
	1¾"-8"	¾"	105276	#134619 / #134620
	1¾"-8"	1¼"	105093	#134619 / #134620
7"	1¼"-12"	¾"	105026	#134627 / #134628
	1½"-12"	½"	104955	#134627 / #134628
	1¾"-8"	¾"	104885	#134627 / #134628
	1¾"-8"	1¼"	104818	#134627 / #134628
9"	1½"-12"	½"	104681	#142084 / #110042
	1¾"-8"	¾"	105073	#142084 / #110042
	1¾"-8"	1¼"	105008	#142084 / #110042

See form on page 481 for Custom Removable Tip Nozzles

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Converting Fractional Inches To Decimals And Millimeters

Fraction	Decimal	MM
1/64"	.015625”	.3969
1/32"	.03125”	.7938
3/64"	.046875”	1.1906
1/16"	.0625”	1.5875
5/64"	.078125”	2.3812
3/32"	.09375”	2.3812
7/64"	.109375”	2.7781
1/8"	125”	3.175
9/64"	.140625”	3.5719
5/32"	.15625”	3.9688
11/64"	.171875”	4.3656
3/16"	.1875”	4.7625
13/64"	.203125”	5.1594
7/32"	.21875”	5.5562
15/64"	.234375”	5.9531
1/4"	.25”	6.35
17/64"	.265625”	6.7469
9/32"	.28125”	7.1438
19/64"	.296875”	7.5401
5/16"	.3125”	7.9375
21/64"	.328125”	8.3344
11/32"	.34375”	8.7312
23/64"	.359375”	9.1281
3/8"	.375”	9.525
25/64"	.390625”	9.9219
13/32"	.40625”	10.3188
27/64"	.421875”	10.7156
7/16"	.4375”	11.1125
29/64"	.453125”	11.5094
15/32"	.46875”	11.9063
31/64"	.484375”	12.3031
1/2"	.5”	12.7

Fraction	Decimal	MM
33/64"	.515625”	13.0969
17/32"	.53125”	13.4938
35/64"	.546875”	13.8906
9/16"	.5625”	14.2875
37/64"	.578125”	14.6844
19/32"	.59375”	15.0812
39/64"	.609375”	15.4781
5/8"	.625”	15.875
41/64"	.640625”	16.2719
21/32"	.65625”	16.6688
43/64"	.671875”	17.0656
11/16"	.6875”	17.4625
45/64"	.703125”	17.8594
23/32"	.71875”	18.2563
47/64"	.734375”	18.6531
3/4"	.75”	19.05
49/64"	.765625”	19.4469
25/32"	.78125”	19.8438
51/64"	.796875”	20.2406
13/16"	.8125”	20.6375
53/64"	.828125”	21.0344
27/32"	.84375”	21.4312
55/64"	.859375”	21.8281
7/8"	.875”	22.225
57/64"	.890625”	22.6219
29/32"	.90625”	23.0188
59/64"	.921875”	23.4156
15/16"	.9375”	23.8125
61/64"	.953125”	24.2094
31/32"	.96875”	24.6062
63/64"	.984375”	25.0031
1"	1.0”	25.4

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31/32"	.96875”	24.6062
63/64"	.984375”	25.0031
1"	1.0”	25.4

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Feeler Gauges

Measure The Gap Between Materials

Thumbwheel locking

Sizes

136488 (mm): .05, .10, .15, .20, .25, .30, .35, .40, .45, .50, .55, .60, .65, .70, .75, .80, .85, .90, .95, 1.00

136489 (inches): .0015, .002, .0025, .003, .004, .005, .006, .007, .008, .009, .010, .011, .012, .013, .014, .015, .016, .017, .018, .019, .020, .021, .022, .023, .024, .025

Item #	Description
136488	20 Leaf Feeler Gauge (Metric)
136489	26 Leaf Feeler Gauge (SAE)

Pitch Gauges

Determine Pitch Quickly and Easily

Thumbwheel locking

Sizes

#136490 (mm between threads): .25, .30, .35, .40, .45, .50, .55, .6, .65, .70, .75, .8, .85, .9, 1.0, 1.1, 1.2, 1.25, 1.3, 1.4, 1.5, 1.6, 1.7, 1.75, 1.8, 1.9, 2.0, 2.5

#136492 (threads per inch): 4, 4½, 5, 5½, 6, 7, 8, 9, 10, 11, 11½, 12, 13, 14, 15, 16, 18, 20, 22, 24, 25, 26, 27, 28, 30, 32, 34, 36, 38, 40, 42

#136491 (threads per inch): 4, 4½, 5, 5½, 6, 7, 8, 9, 10, 11, 11½, 12, 13, 14, 15, 16, 18, 20, 22, 24, 26, 27, 28, 30, 32, 34, 36, 38, 40, 42, 44, 46, 48, 50, 52, 54, 56, 58, 60, 62, 64, 66, 68, 70, 72, 74, 76, 78, 80, 82, 84

Simply match pitch teeth with internal or external threads

Item #	Description
136490	28 Leaf Pitch Gauge (Metric)
136492	31 Leaf Pitch Gauge (SAE)
136491	51 Leaf Pitch Gauge (SAE)

Tech Tips

For faster setups, ensure you have the proper tools at hand.

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e-mail sales@imscompany.com

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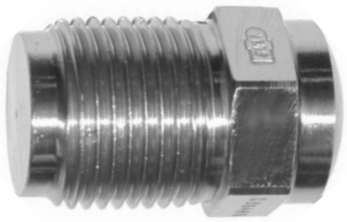
Nozzle Tip Blanks

Great For Testing Equipment

Made in the U.S.A

- Solid stress proof steel
- 7/8"-14 Threads



Item #	Description
136499	½" Nozzle Tip Blank
136486	¾" Nozzle Tip Blank

See Also Combination Wrenches on Page 57

Heat Treated Chrome Vanadium Alloy Steel

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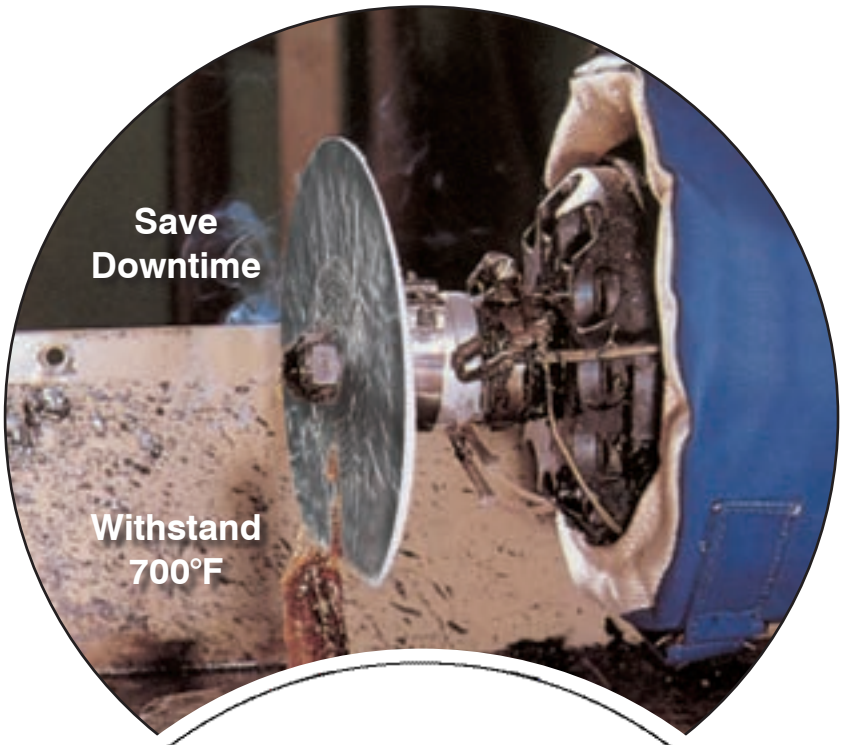
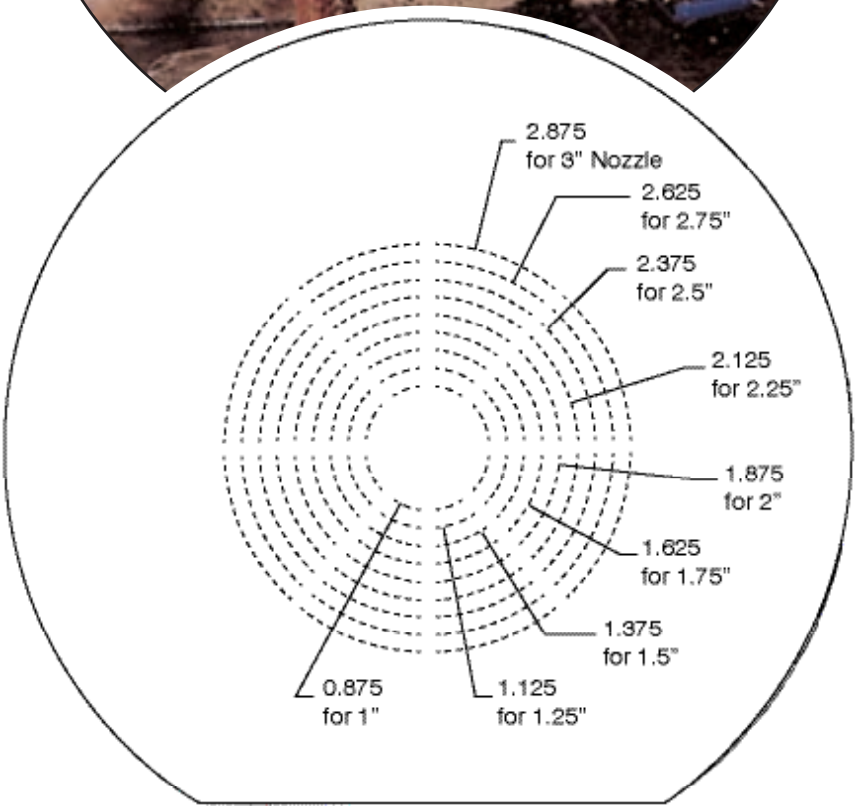
IMS Drool Disc™

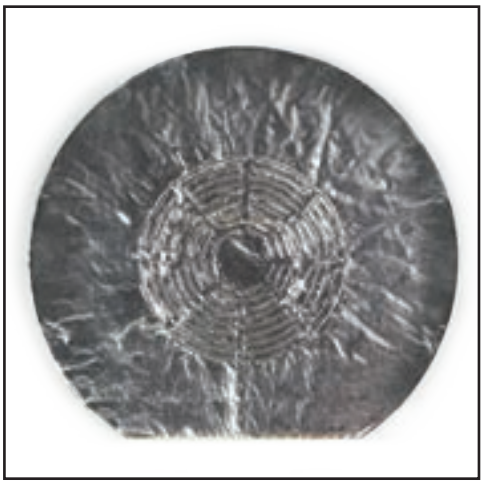
Stops Drool from Damaging Heater Bands and Wiring

IMS Drool Disc™ Heater Band Protectors protect your equipment by preventing material drool from oozing back onto your heater bands, wiring and insulation blankets. The disc obstructs the path of the drool and keeps it in front of the nozzle. IMS Drool Discs™ are inexpensive enough to place on every machine.





Perforated inside diameter to fit most nozzles — just trim to size!



Fiberglass Core with Adhesive Bonded Foil

Designed and engineered expressly for this application

Specifications

Max. Temperature: 700° F
Size: 6" dia. by ⅛" thick

IMS Drool Disc™
Heater Band Protectors

Item #174431
(Perforated)

Item #174432 (Blank)*
*User cuts to size

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Please refer to imscompany.com for current pricing

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IMS High Heat — Copper Flake Thread Lube

Anti-Seize Compound

An excellent anti-seize compound for use on end cap bolts, and nozzle and screw tip threads. It consists of copper and graphite powders blended into a grease carrier to allow it to be applied. The grease carrier will break down at 350° F, but the product will continue to lubricate up to the listed temperature limits of the copper and graphite powders.

Helps Prevent Seizing And Galling

Facilitates Removal

A limited use Anti-Seize Compound formulated for continuous use up to 350° F

Specifications	
Melting point of Copper:	1981° F
Melting point of Graphite:	in air, 750° F to 1100°F in a reduced oxygen environment, 6700°F

Item #	Description
107280	2-oz. jar Copper Flake Thread Lube with brushtop
103783	16-oz. jar Copper Flake Thread Lube with brushtop

Tech Tips

Copper Flake Thread Lube is the preferred compound for nozzle threads, but you can also use High Heat Tape with PTFE — see page 195

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Nozzle Leak Detector

Detect Nozzle Leaks Before They Cause Damage and Extensive Down Time

- Prevent Heater Band and Thermocouple damage
- Perfect for all unattended machines or lean manufacturing shops
- Use as just an audible alarm or connect to your machine to stop injection immediately
- Reduce machine clean up time by inhibiting unchecked leakage

How It Works

The sensor assembly mounts easily using a single worm gear style clamp (can be mounted directly on top of a heater band). The other end connects to the receptacle on the control box.

Adjust control box set point approximately 100 to 150°F below nozzle zone temperature. If leaking plastic comes into contact with the sensor, the audible alarm will sound and the alarm light will come on.

If connected to your injection machine with supplied plugs, the internal relay can set off a remote alarm and light or if wired to the purge guard circuit will stop the machine.

Detects Drool caused by:

- Misaligned nozzle
- Cracked tip
- Plugged gates

Nozzle and Hose Clamp (sold separately)

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Bracket Assembly

Thermocouple Sensor

Available in 3", 6" and 9" thermocouple length

Item #	Description	Price
171707	Control Box ONLY with Alarm, Relay and Power Cord (115V)	**$875.00**
170895	Bracket Assembly ONLY (requires thermocouple sensor below)	
170896	**Thermocouple Sensor** Straight x 3" - for medium nozzles such as 6", 7" or 8" long. Complete with 60" stainless steel armored leads and mini plug.	
170897	**Thermocouple Sensor** Straight x 6" - for long nozzles such as 8", 9", or 10" long. Complete with 60" stainless steel armored leads and mini plug.	
170898	**Thermocouple Sensor** Straight x 9" - for extra long nozzles such as 12" and longer. Complete with 60" stainless steel armored leads and mini plug.	

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1949

IMS®

Engineered

Components & Supplies

Screw Tips, Screws & Barrels

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Free Flow Screw Tips
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Purgers & other Maintenance Products
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Most items IN STOCK for Same Day Shipment

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Pin-Type One-Piece Ball Check Screw Tips

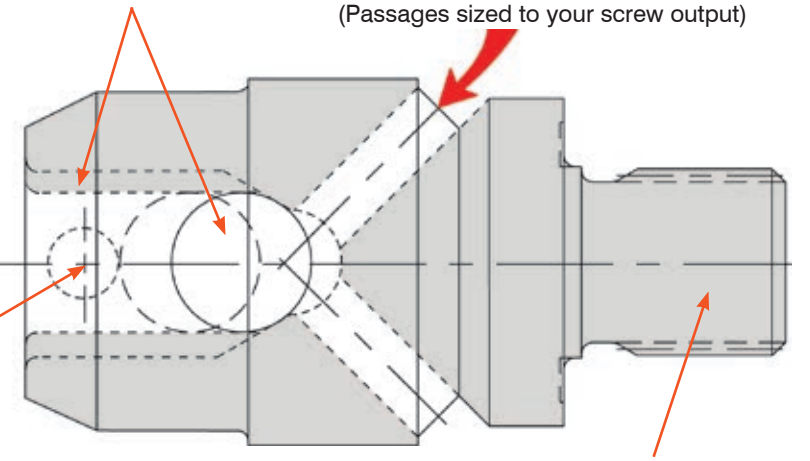
With Welded-In Pin

The Original Ball Valve Tip! Modified For Today's Materials!

Guided Ball

Large, Angled Inlet Holes
(Passages sized to your screw output)

Style BC-Pt
Ball Check with Pin-Type Ball Stop



Heavy-Duty Ball Stop-Pin
(Welded in place)

Shanks To Suit Your Screw

The Only Free-Flowing Ball Checks sized to exceed your screw output

Always use Copper-Flake Thread Lube on Threads!

Features

- **Guided Ball -** Ball travels in a straight line - shuts off faster
- **Heavy Duty Pin -** Welded in place, H-13 Tool Steel Pin. gelps minimize contamination and failure.
- **Passages Sized Right -** Inlet, outlet, ball and openings are sized to your screw capacity.
- **Hard Outer Wear-Surface -** Tool-Steel Screw Tips outlast other types many times over. Wear-resistant coatings are available at extra cost.

For all-around use

For most general-purpose work, the IMS Style BC-PT tip should be specified. It is joint-free and provides long-life, proven in hundreds of plants as the sure way to cut sliding ring valve costs.

MATERIAL: High-Quality H-13 Steel. IMS uses special wear resistant tool steel in all tips. Chromium 5.00, Vanadium 1.00, Silicon 1.00, Carbon .40, Molybdenum 1.00. Heat Treated to 46-48 Rockwell "C".

This steel machines 40% slower than cheaper types like 4140. But the extra cost gives you extra life and less down-time due to wear and shank failures - SO YOU SAVE!

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Insert-Type Ball Check Screw Tips

With Replaceable Ball Seat and Pin-Free Retainer

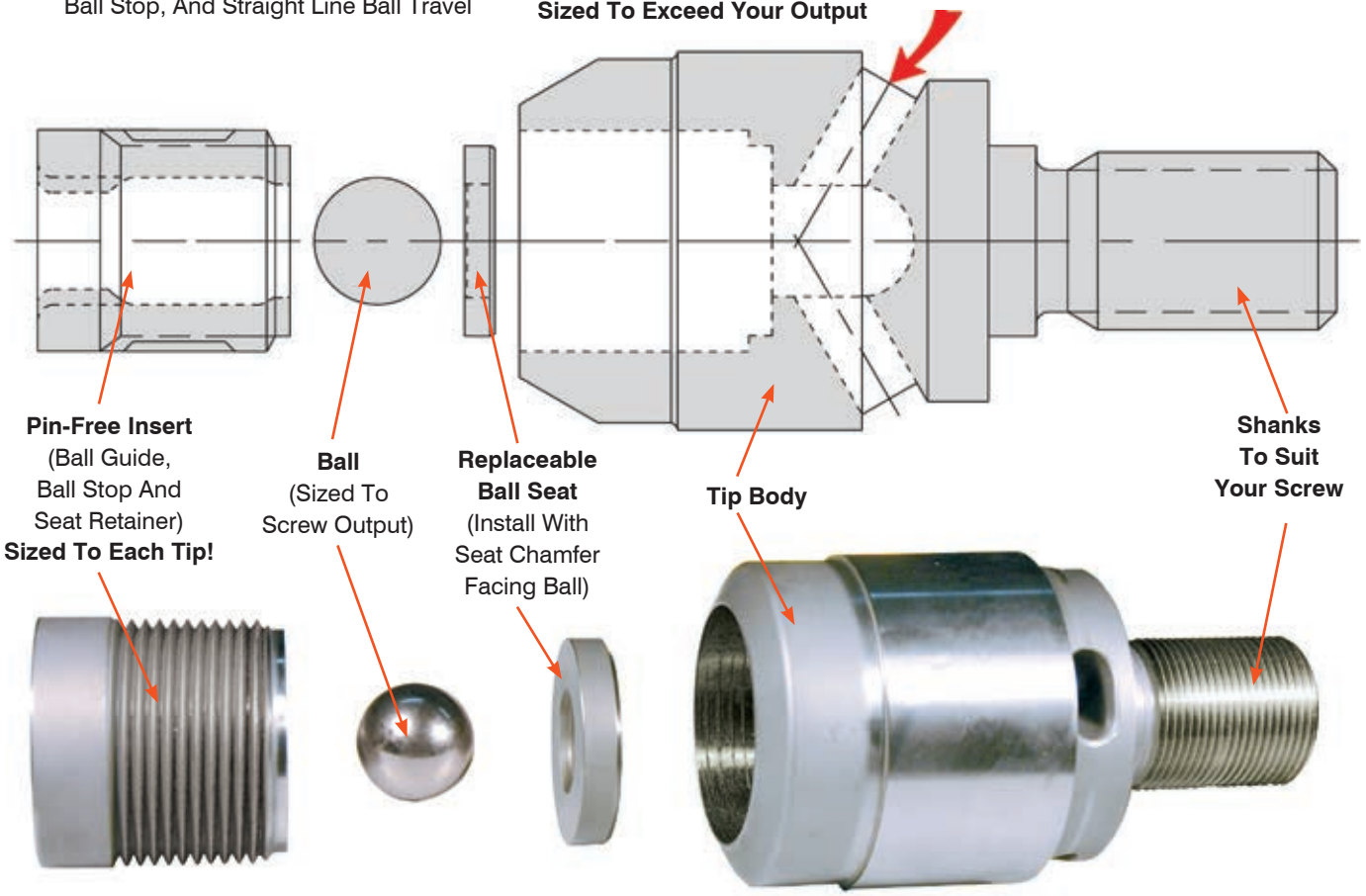
Style BC-RS

Ball Check With Replaceable Ball Seat Pin-Free Ball Stop, And Straight Line Ball Travel

Large, Angled Inlet Holes

(Passages Sized To Your Screw Output)

Sized To Exceed Your Output



Features

- **Guided Ball -** Ball travels in a straight line - shuts-off faster.
- **Pin-Free Ball Retainer -** Allows unrestricted material flow.
- **Replaceable Seat -** Hardened Ball Seat easily replaced when worn.
- **Passages Sized Right** - Each insert, ball and seat is sized to your screw capacity (unlike cheap designs, where one size of ball and insert is used on many sizes of screw tips).
- **Hard Outer-Wear Surface -** Tool Steel Screw Tips outlast other types many times over. Wear-resistant coatings are available at extra cost.

Ideal For Filled Plastics

IMS Style BC-RS insert tips are for use on plastics with more than 10% abrasive filling or where much tramp metal is found. Tip can have external surfaces hard coated with PVD or CVD (both titanium nitride coatings). Inquire for prices of specially treated tips for filled plastics.

The Original Ball-Type Screw Tip

IMS Tool Steel Tips were the first American-made ball-type, non-return valves to replace old-style sliding rings. Avoid cheap imitations! Look for the genuine IMS mark on the end of the shank! You'll cut your press downtime costs with IMS Chrome-Vanadium Tool-Steel Screw Tips.

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Ball Check Screw Tips

Make of Press Screw Tip OD	Screw Tip Thread	IMS Item # With Welded in Pin	IMS Item # With Replaceable Seat
Arburg			
25mm	M12 x 1.75mm RH	102430	RFQ*
30mm	M12 x 1.75mm RH	102479	RFQ*
35mm	M18 x 1.5mm RH	113471	124020
40mm	M18 x 1.5mm RH	125193	124019
Autojector			
1”	½"-13 LH	122082	RFQ*
Battenfeld			
18mm	M8 x 1.25mm LH	120982	RFQ*
18mm	M18 x 1.25mm LH	RFQ*	127089
25mm	M10 x 1.5mm LH	102679	102507
35mm	M16 x 1.5mm LH	RFQ*	102716
45mm	M20 x 2.0mm LH	102497	102753
70mm	M30 x 3.5mm LH	RFQ*	102707
70mm	M40 x 2.0mm LH	RFQ*	102743
75mm	M40 x 2.0mm LH	RFQ*	102691
75mm	M30 x 3.5mm LH	RFQ*	102682
Beloit			
1-½"	¾"-16 LH	102454	RFQ*
1-½"	¾"-16 LH	RFQ*	102610
2-¼"	⅞"-9 LH	RFQ*	102721
2-½"	1-⅛"-7 LH	RFQ*	115465
2-½"	1"-8 LH	102404	102695
3”	1-¼"-7 LH	102538	RFQ*
Boy			
24mm	M12 x 1.75mm LH	113852	119788
28mm	M14 x 2.0mm LH	RFQ*	136407
38mm	M16 x 2.0mm LH	116073	RFQ*
Cincinnati			
28mm	M12 x 1.75mm LH	RFQ*	137370
40mm	M20 x 2.5mm LH	125115	RFQ*
55mm	M27 x 3.0mm LH	110870	112117
90mm	M48 x 5.0mm LH	124120	143343
100mm	M52 x 5.0mm LH	137757	RFQ*
110mm	M56 x 5.5mm LH	131641	137806

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Ball Check Screw Tips

Make of Press Screw Tip OD	Screw Tip Thread	IMS Item # With Welded in Pin	IMS Item # With Replaceable Seat
Cincinnati			
1-3/4"	3/4"-16 LH	RFQ*	102681
1-5/8"	3/4"-10 LH	RFQ*	RFQ*
2"	1"-8 LH - 30° Nose	102458	102613
2"	1"-8 LH - 45° Nose	113302	RFQ*
2"	3/4"-16 LH	RFQ*	102740
2-1/4"	1"-8 LH	110283	RFQ*
2-1/2"	1-1/4"-7 LH	RFQ*	102751
2-1/2"	1-1/4"-12 LH	102398	102713
2-1/2"	1-1/4"-7 LH	144139	RFQ*
2-3/4"	1-1/4"-12 LH	102534	102688
2-3/4"	1-1/4"-7 LH	102409	142137
3-1/4"	1-1/2"-6 LH	RFQ*	102701
3-1/4"	1-1/2"-12 LH	102513	RFQ*
3-1/2"	1-1/2"-12 LH	RFQ*	102641
3-1/2"	1-1/2"-6 LH	102525	RFQ*
3-1/2"	1-1/2"-12 LH	102489	RFQ*
4-1/2"	2"-6 LH	130827	102653
4-1/2"	2"-12 LH	102465	102757
5-1/4"	2-1/4"-6 LH	102476	102630
6"	2-1/2"-6 LH	102452	102768
6"	2-1/2"-12 LH	102415	RFQ*
Egan			
1-3/4"	3/4"-10 LH	102532	102762
2"	7/8"-9 LH	102519	115465
2-1/2"	1-1/8"-7 LH	102487	RFQ*
2-1/2"	1-3/4"-6 LH	102470	RFQ*
3"	1-5/8"-6 LH	129353	102669
3-1/2"	1-3/4"-6 LH	RFQ*	102645
4-1/2"	2-1/4"-6 LH	102495	102711
5-1/4"	2-3/4"-6 LH	102463	RFQ*
6"	3"-6 LH	102396	RFQ*

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Ball Check Screw Tips

Make of Press Screw Tip OD	Screw Tip Thread	IMS Item # With Welded in Pin	IMS Item # With Replaceable Seat
Engel			
25mm	M12 x 1.75mm RH	112792	RFQ*
30mm	M12 x 1.75mm RH	112797	RFQ*
35mm	M12 x 1.75mm RH	111034	119166
40mm	M16 x 2.0 RH	RFQ*	119161
60mm	M30 x 3.5 RH	136426	115440
70mm	M36 x 4mm RH	RFQ*	122969
Farrel			
2.1"	1"-8 LH	102481	102612
2.8"	1-3/8"-8 LH	RFQ*	102725
3"	1-5/8"-6 LH	112879	RFQ*
3-1/4"	1-1/2"-8 LH	102408	102676
4-1/4"	2"-8 LH	102499	RFQ*
4-3/4"	2-1/4"-8 LH	102475	102700
5-1/4"	2-3/4"-6 LH	RFQ*	137144
Fellows			
1-3/4"	5/8"-11 LH	RFQ*	102745
2"	3/4"-10 LH	102427	RFQ*
3"	1-5/8"-6 LH	102537	RFQ*
3-1/2"	1-3/4"-8 LH	102518	RFQ*
HPM			
1-1/2"	5/8"-11 LH	RFQ*	102731
1-3/4"	3/4"-10 LH	102494	102710
2"	7/8"-9 LH	102531	102761
2-1/4"	1"-8 LH	RFQ*	118990
2-1/2"	1-1/8"-7 LH	102420	102756
3"	1-5/8"-6 LH	102445	102737
3-1/2"	1-3/4"-6 LH	102395	102685
4"	2"-6 LH	102510	142078
4-1/2"	2-1/4"-6 LH	102486	102618
5-1/4"	2-3/4"-6 LH	RFQ*	102660
6"	3"-6 LH	RFQ*	141674
7"	3-1/2"-6 LH	RFQ*	109809

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Ball Check Screw Tips

Make of Press Screw Tip OD	Screw Tip Thread	IMS Item # With Welded in Pin	IMS Item # With Replaceable Seat
Husky			
55mm	M27 x 2.0mm LH	102438	RFQ*
70mm	M36 x 4.0mm LH	125363	RFQ*
85mm	M48 x 4.5mm LH	123995	RFQ*
85mm	M48 x 5.0mm LH	RFQ*	RFQ*
100mm	M52 x 5.0mm LH	144148	144714
110mm	M52 x 5.0mm LH	123932	123994
IMPCO			
2”	7/8"-9 LH	102432	RFQ*
2-1/4"	1-1/4"-7 LH	102811	RFQ*
2-1/2"	1-1/8"-7 LH	102388	110175
2-13/16"	1-1/4"-8 LH	RFQ*	102717
3-1/2"	2"-4.5 TPI-LH	RFQ*	137118
3-1/4"	2"-8 LH	121560	RFQ*
3-1/4"	1-5/8"-6 LH	102413	102692
4-1/4"	2.250 x 4.5” LH	120868	RFQ*
Jaco			
1-1/4"	5/8"-11 LH	RFQ*	RFQ*
Kawaguchi			
50mm	M30 x 3.0mm LH	RFQ*	RFQ*
70mm	M40 x 4.0mm LH	102509	RFQ*
80mm	TR42 x 4.0mm LH	RFQ*	126949
Klockner			
80mm	M48 x 4.0mm LH	110550	RFQ*
Krauss-Maffei			
45mm	M24 x 3.0mm LH	RFQ*	124682
Lombard			
1-5/8"	3/4"-10 LH	111155	RFQ*
3-1/2"	1-5/8"-8 LH	RFQ*	120151
McNeil			
1-3/8"	5/8"-18 LH	RFQ*	120149
MIR			
100mm	1-3/4"-5 LH	RFQ*	114280

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Ball Check Screw Tips

Make of Press Screw Tip OD	Screw Tip Thread	IMS Item # With Welded in Pin	IMS Item # With Replaceable Seat
Mitsubishi			
70mm	M39 x 4.0mm LH	RFQ*	120127
Natco			
2-¼"	1"-8 LH	102401	102765
70mm	1-⅛"-12 LH	102450	RFQ*
70mm	1-⅛"-6 LH	102540	RFQ*
90mm	1-½"-12 LH	102406	RFQ*
90mm	1-½"-6 LH	130692	102649
105mm	1-¾"-6 LH	102523	102626
120mm	2"-6 LH	RFQ*	102715
New Britain			
2-½"	1-¼"-8 LH	RFQ*	127041
3-½"	1-¾"-8 LH	RFQ*	126200
30mm	TR18 x 2.5mm LH	RFQ*	102760
45mm	TR27 x 3.0mm LH	102516	RFQ*
55mm	TR35 x 3.0mm LH	102443	102683
Newbury			
1"	½"-13 LH	102485	102616
1-¼"	⅝"-11 LH	RFQ*	102754
1-⅜"	⅝"-11 LH	102387	102656
1-½"	¾"-10 LH	102461	RFQ*
1-¾"	⅞"-9 LH	102437	102704
2"	1"-8 LH	102412	102680
2-¼"	1"-8 LH	RFQ*	144210
Niigata			
76mm	M42 x 3.0mm LH	110208	RFQ*
Nissei			
71mm	TR44 x 3.0mm LH	110266	142056
80mm	TR48 x 3.0mm LH	RFQ*	125537
90mm	TR55 x 3.0mm LH	110264	RFQ*
Reed			
2”	1"-8 LH	102514	102632
2-⅛"	1"-8 LH	RFQ*	102611
2-¼"	1"-8 LH	102448	RFQ*
2-½"	1-¼"-8 LH	102424	102714
2-¾"	1-½"-8 Acme LH	102399	102722

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Ball Check Screw Tips

Make of Press Screw Tip OD	Screw Tip Thread	IMS Item # With Welded in Pin	IMS Item # With Replaceable Seat
Reed			
3”	1-3/8"-8 LH	102521	102672
3-3/4"	1-7/8"-8 LH	RFQ*	102625
3-5/16"	1-3/4"-5 LH	102496	102648
4-1/8"	2-1/4"-8 LH	121133	RFQ*
4-1/4"	2"-8 LH	102405	RFQ*
Stokes			
1-1/4"	1/2"-20 LH	102441	RFQ*
1-1/4"	1/2"-13 LH	121096	113912
1-7/8"	3/4"-16 LH	RFQ*	110405
2"	1"-8 LH	111103	RFQ*
2"	1"-12 LH	102435	RFQ*
2-1/2"	1-1/8"-12 LH	102459	102664
2-1/2"	1-1/4"-10 LH	102416	RFQ*
2-3/4"	1-1/4"-12 LH	102410	102642
3"	1-3/8"-12 LH	102506	RFQ*
3"	1-5/8"-6 LH	102490	RFQ*
3-1/2"	1-5/8"-12 LH	102386	RFQ*
Stubbe			
45mm	M24 x 3.0mm LH	102526	RFQ*
Toshiba			
25mm	M12 x 1.5mm LH	114153	RFQ*
40mm	M22 x 2.0mm LH	124107	RFQ*
95mm	M45 x 4.0mm LH	RFQ*	127231
100mm	M50 x 4.0mm LH	RFQ*	RFQ*
105mm	M50 x 4.0mm LH	126788	RFQ*
115mm	M60 x 4.0mm LH	126625	RFQ*
Trubor			
31mm	5/8"-11 LH	110753	RFQ*
Uniloy - Milacron			
45mm	M24 x 3.0mm LH	102526	RFQ*
45mm	M18 x 1.5mm LH	124339	RFQ*

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Ball Check Screw Tips

Make of Press Screw Tip OD	Screw Tip Thread	IMS Item # With Welded in Pin	IMS Item # With Replaceable Seat
Van Dorn			
1-3/8"	1"-3/8"-8 LH	RFQ*	138205
25mm	1/2"-13 LH	114309	RFQ*
30mm	5/8"-11 LH	102397	102646
35mm	3/4"-10 LH	102414	102694
40mm	3/4"-10 LH	102488	102670
45mm	TR20 x 2.0 LH	RFQ*	143067
50mm	1"-8 LH	102422	102624
57mm	1-1/4"-7 LH	102389	102662
65mm	1-3/8"-6 LH	102471	102763
69mm	1-3/8"-6 LH	102533	102739
80mm	1-3/8"-6 LH	102512	102720
90mm	1-3/4"-8 LH	102447	102712
105mm	1-3/4"-8 LH	102464	102687
115mm	2"-8 LH	111192	106406

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Check Out These Other Useful IMS Products!

Heat Resistant Gloves

Durable Work Gloves For Higher Temperature Jobs!

Use them for quick transfer of hot Nozzles, Screws, Screw Tips, Molds, Water Lines, Heater Bands, etc.

- Reinforced sewn knuckle straps
- Up to 450° F (intermittent)
- Band topped cuff
- One size fits all

24 oz
Hot Mill Gloves

Item No. 136369

- Reinforced sewn knuckle straps
- Up to 300° F (intermittent)
- Band topped cuff
- One size fits all

30 oz
Hot Mill Gloves

Item No. 136370

For More Gloves and Pricing see Page 446-449

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Screw Tip Wear Issues

Cracked Ring: Excessive barrel wear in the metering area. Unmelted plastic in the valve can cause a situation where the ring will not seat against the rear seat. This is usually due to a poor start up or shut down.

Broken Stud: This is usually due to a poor start up or shut down procedures. Failure to make sure barrel is up to operating temperature at start up or failure to properly purge barrel and screw at shut down.

Slow Recovery: Excessive back pressure is the most common cause. However, if there is excessive wear between the front seat and ring it can impede the movement of plasticized material and screw recovery can be drastically affected.

Failure To Hold Cushion: Excessive wear on the seating areas can allow material to pass back over the valve or ball check.

Poor Quality Consistency: Excessive wear on the seating areas can allow material to pass back over the valve or ball check.

D-2 Tool Steel

Heat treated to Rc 58-60, D-2 is a relatively inexpensive, high carbon-high chromium steel with proven, uniform wear resistance surpassing most other steels.

H-13 Nitrided

Tool steel with good strength that is thru-hardened and ground dimensionally then nitrided for 72 hours. A tough material good for general applications.

CPM9V

Highly wear resistant tool steel with a high percentage of vanadium carbide. Excellent for abrasive applications.

CPM420V

Ideal for highly corrosive applications. 420V also has significant wear resistant characteristics.

NOTE: If your screw is turning during injection, it's a good indication that your non return valve is leaking.

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Free Flow Screw Tip Assemblies

Over 150 Sizes In Stock

H13 Tool Steel — STANDARD
(CPM9V, D-2, M-4 and Nitrite available)

Extra-Deep Flutes
- Minimize frictional heat
- Allow free flow of plastic

Standard OEM Sliding Ring
- Highly polished surface to maximize flow
- Precision ground to reduce wear on barrel

Optional BRODY-Ring® Seal*
- Prevents blow-back
- Ensures positive shot control
- Extends quality production runs even on worn barrels

OR

Rear Seat
- Increases plasticizing capacity
- Speeds up shot recovery
- Permits low nose-end temperatures

*BRODY-ring® seals can safely be used if up to .025" combined screw tip and barrel wear. If worn above this amount, your barrel should be relined ---- Call IMS for quote.

Optional PVD And CVD Surface Treatments Help Extend Tip Life — Inquire

Tech Tips

Hand tighten screw tips. Use a wrench, only if needed, to remove the tips.

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Free Flow Screw Tip Assemblies

BRODY-Ring® OPTIONAL — See Pages 555-557

Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material	
			H13	CPM9V
Arburg				
15mm	M8x1.25 RH	40°	170753	160913
15mm	M8x1.25 RH	60°	170754	160912
18mm	M10x1.5 RH	20°	170751	147858
18mm	M10x1.5 RH	70°	160915	162974
18mm	M10x1.5 RH	90°	170752	160914
20mm	M10x1.5 RH	60°	170360	132379
22mm	M12x1.75 RH	30°	147821	147820
22mm	M12x1.75 RH	60°	100905	119050
25mm	M12x1.75 RH	30°	167779	167780
25mm	M12x1.75 RH	70°	168360	144113
25mm	M12x1.75 RH	120°	167781	132342
30mm	M14x1.5 RH	40°	160911	150349
30mm	M14x1.5 RH	80°	150348	136275
30mm	M14x1.5 RH	120°	160909	160910
35mm	M18x1.5 RH	40°	147867	144101
35mm	M18x1.5 RH	120°	100857	144100
40mm	M18x1.5 RH	40°	145598	167775
40mm	M18x1.5 RH	90°	145597	167774
45mm	M22x1.5 RH	60°	123993	167776
45mm	M22x1.5 RH	90°	150388	167777
45mm	M27x3.0 RH	90°	170462	170889
Autojector				
¾"	7/16"-14 LH	40°	160074	160075
1-¼"	⅝" - 11 LH	52°	124696	123472
1-½"	¾"-10 LH	40°	126019	167782
1-¾"	⅞" -9 LH	50°	150433	132450
1-¾"	¾"-10 LH	49°	164669	164670
Battenfeld				
22mm	M12x1.75 LH	90°	149442	151057
25mm	M12x1.75 LH	90°	170882	171574
30mm	M14x1.5 LH	90°	160079	160080
35mm	M16x1.5 LH	90°	160908	133706
40mm	M20x2.0 LH	90°	132367	131629
45mm	M24x2.0 LH	90°	167679	148539
50mm	M24x2.0 LH	90°	158272	160081
55mm	M24x2.0 LH	90°	132942	131657
60mm	M24x2.0 LH	90°	160082	132162
65mm	M24x2.0 LH	90°	160084	123905
70mm	M30x3.5 LH	90°	167681	122780
75mm	M30x3.5 LH	90°	172357	172358
85mm	M35x2.0 LH	90°	160072	160073

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Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material H13	IMS Item # Style / Material CPM9V
Boy				
14mm	M8x1.25 LH	90°	150342	150341
22mm	M10x1.5 LH	90°	140489	167766
24mm	M12x1.75 LH	45°	133444	121753
28mm	M12x1.75 LH	60°	144859	147839
28mm	M12x1.75 LH	90°	148519	148520
32mm	M14x2.0 LH	90°	168391	168392
32mm	M14x2.0 LH	60°	162797	162798
38mm	M16x2.0 LH	90°	150344	150343
38mm	M16x2.0 LH	90°	144753	143022
42mm	M16x2.0 LH	90°	144207	144206
42mm	M16x2.0 LH	90°	144209	144208
48mm	M18x2.5 LH	90°	170755	148575
Cincinnati				
18mm	M9x1.5 LH	60°	160002	160004
18mm	M10x1.5 LH	90°	160003	160005
22mm	M12x1.75 LH	60°	168317	148590
22mm	M12x1.75 LH	90°	170790	148591
22mm	M10x1.5 LH	60°	148586	170788
26mm	M12x1.75 LH	60°	170789	168174
26mm	M14x2.0 LH	60°	147154	147152
26mm	M16x2.0 LH	90°	147153	147151
28mm	M12x1.75 LH	60°	148605	148606
28mm	M16x2.0 LH	60°	148604	162796
28mm	M16x2.0 LH	90°	123548	150491
32mm	M18x2.5 LH	60°	147887	132330
32mm	M18x2.5 LH	90°	147129	145670
32mm	M18x2.5 LH	60°	162809	162811
32mm	M18x2.5 LH	90°	162810	162812
35mm	M18x2.5 LH	60°	148527	148526
36mm	M20x2.5 LH	60°	150316	132319
36mm	M20x2.5 LH	90°	150315	150314
36mm	M20x2.5 LH	60°	133243	170787
40mm	M20x2.5 LH	60°	142153	137553
40mm	M20x2.5 LH	90°	133420	123954
40mm	M20x2.5 LH	60°	162775	162774
42mm	M22x2.5 LH	60°	160010	170786
44mm	M24x3.0 LH	60°	148554	148555
44mm	M24x3.0 LH	90°	137623	142145

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Cincinnati	(continued)			
45mm	M22x2.5 LH	60°	144703	137686
48mm	M24x3.0 LH	60°	167613	RFQ*
50mm	M24x3.0 LH	60°	138535	145553
52mm	M30x3.5 LH	90°	164626	167759
52mm	M30x3.5 LH	60°	164625	167760
55mm	M27x3.0 LH	60°	147791	147792
56mm	M30x3.5 LH	90°	145549	RFQ*
56mm	M30x3.5 LH	60°	RFQ*	RFQ*
56mm	M30x3.5 LH	90°	145549	147853
56mm	M30x3.5 LH	60°	167608	145552
60mm	M27x3.0 LH	60°	160018	167609
64mm	M36x4.0 LH	90°	160055	160056
64mm	M36x4.0 LH	60°	160057	160058
65mm	M30x3.5 LH	60°	132654	160976
70mm	M36x4.0 LH	60°	162913	162915
70mm	M36x4.0 LH	22°	161045	161046
80mm	M42x4.5 LH	60°	137819	144151
90mm	M48x5.0 LH	60°	143426	164623
100mm	M52x5.0 LH	60°	134367	137428
110mm	M56x5.5 LH	60°	150340	132936
125mm	M64x6.0 LH	60°	132313	160076
140mm	M72x6.0 LH	60°	147883	137895
200mm	M100x6.0 LH	60°	147130	147131
1-5/16"	5/8"-11 LH	90°	168440	168441
1-5/16"	5/8"-11 LH	120°	170196	168439
1-5/8"	3/4"-10 LH	120°	132986	132164
1-5/8"	3/4"-10 LH	90°	150351	150350
2"	1"-8 LH	90°	160923	160925
2-1/4"	1"-8 LH	90°	170783	132165
2-1/2"	1-1/4"-7 LH	90°	140388	162929
2-1/2"	1-1/4"-12 LH	120°	160006	170782
2-3/4"	1-1/4"-12 LH	90°	162832	131626
2-3/4"	1-1/4"-12 LH	120°	162833	162834
3-1/4"	1-1/2"-6 LH	120°	170780	132321
3-1/4"	1-1/2"-6 LH	90°	148538	131963
3-1/4"	1-1/2"-12 LH	120°	136130	170779
3-1/2"	1-1/2"-6 LH	90°	145612	132166
4-1/2"	2"-6 LH	90°	133438	133439
5-1/4"	2-1/4"-6	90°	167360	170778

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Demag				
18mm	M10x1.5 RH	60°	170750	148572
22mm	M10x1.5 RH	30°	160045	160044
25mm	M10x1.5 RH	22°	142324	142322
25mm	M10x1.5 RH	60°	142325	142323
30mm	M12x1.75 LH	60°	145641	145642
35mm	M14x2.0 LH	60°	164679	134162
40mm	M16x2.0 LH	60°	162763	134068
45mm	TR20x3.0 LH	60°	138125	140303
50mm	TR22x3.0 LH	60°	150372	150373
60mm	TR27x3.0 LH	60°	147200	144156
70mm	TR30x3.0 LH	60°	140540	137794
80mm	TR35x3.0 LH	60°	140260	145643
95mm	TR40x3.0 LH	60°	150374	150375
110mm	TR50x3.0 LH	60°	132154	148576
Dong Shin Promax				
80mm	M40x3.0 LH	30°	166950	170749
Egan				
1-¼"	½"-13 LH	30°	164700	164701
1-½"	⅝"-11 LH	30°	167592	167593
2"	⅞"-9 LH	30°	167594	167595
2-½"	1-⅛"-7 LH	30°	165841	164702
3-½"	1-¾"-6 LH	30°	147137	147136
Enaiviv				
32mm	M16x2.0 RH	30°	170343	170345
50mm	M24x3.0 RH	30°	169143	170342

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Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material	
			H13	CPM9V
Engel				
18mm	M10x1.5 LH	60°	150317	162975
22mm	M12x1.75 RH	60°	150512	138877
25mm	M12x1.75 RH	60°	167610	132235
30mm	M12x1.75 RH	60°	144146	136413
35mm	M16x2.0 RH	60°	147785	147786
35mm	M12x1.75 RH	60°	147787	137179
40mm	M16x2.0 LH	60°	136011	147789
45mm	M20x2.5 RH	60°	150676	144147
50mm	M24x3.0 RH	60°	147150	150313
55mm	M24x3.0 RH	60°	145593	136133
60mm	M30x3.5 RH	60°	136429	131617
70mm	M36x4.0 RH	60°	160008	160009
80mm	M36x4.0 RH	60°	136200	131625
90mm	M42x4.5 RH	60°	135009	132681
105mm	M42x4.5 RH	60°	145685	145684
120mm	M54x2.0 RH	60°	165591	167748
135mm	M64x2.0 RH	60°	167623	167624
150mm	M64x2.0 RH	60°	145458	145459
150mm	M64x2.0 RH	60°	170893	170894
160mm	M74x2.0 RH	60°	167625	167626
Farrel				
3.6”	1-⅝"-8 LH	45°	145444	145445
4-¾"	2-¼"-8 LH	45°	161748	167747
Goldstar				
28mm	M16x1.5	40°	168437	168438
40mm	M22x2.0	34°	147180	147179
50mm	M28x2.0	30°	135011	167677
55mm	M28x2.1	30°	167683	167680
60mm	M28x2.3	30°	167684	167682
65mm	M28x2.5	30°	167685	167686
75mm	M40x2.0	30°	167687	167688
80mm	M42x3.0	30°	167689	167690
85mm	M42x3.0	30°	170817	170818
90mm	M50x3.0	30°	167692	167693
100mm	M52x3.0	30°	167694	167695
105mm	M55x3.0	30°	158234	167696
115mm	M62x3.0	40°	167697	167698

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Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material H13	IMS Item # Style / Material CPM9V
Haitian				
28mm	M12x1.75 LH	30°	168389	168390
32mm	M16x2.0 LH	30°	167703	167704
36mm	M16x2.0 LH	30°	167705	167706
40mm	M20x2.5 LH	30°	166276	167707
45mm	M20x2.5 LH	30°	167047	167708
50mm	M24x3.0 LH	30°	167709	167710
55mm	M24x3.0 LH	30°	167711	167712
60mm	M27x3.0 LH	60°	167713	167714
65mm	M30x3.5 LH	60°	167715	167716
70mm	M36x3.5 LH	60°	167717	167718
75mm	M36x3.5 LH	60°	167719	167720
75mm	M36x4.0 LH	60°	173708	RFQ
80mm	M38x4.0 LH	60°	167721	167722
85mm	M39x4.0 LH	60°	167738	167739
90mm	M48x4.0 LH	60°	164703	167723
100mm	M55x4.0 LH	60°	167724	167725
110mm	M60x4.0 LH	60°	167726	167727
HPM				
1-¾"	¾"-10 LH	60°	147145	147146
1-¾"	¾"-16 LH	60°	170745	169289
1-¾"	¾"-16 LH	42°	160849	160850
2"	⅞"-9 LH	60°	131977	160849
2-¼"	1"-8 LH	60°	160115	160116
2-½"	1-⅛"-7 LH	60°	138591	160850
2-⅝"	1-¼"-8 LH	60°	162890	170746
3"	1-⅝"-6 LH	60°	150335	151066
3-¼"	1-¾"-6 LH	60°	160614	164682
3-¼"	1-⅝"-6 LH	60°	170747	170748
3-½"	1-¾"-6 LH	60°	160047	160049
4"	2"-6 LH	60°	148560	131438
4-½"	2-¼"-6 LH	60°	147840	147841
6"	3"-6 LH	60°	160013	167664
55mm	M27x2.0 LH	50°	137636	167663
60mm	M30x2.0 LH	60°	167662	137496
70mm	M36x2.0 LH	22°	148611	148609
70mm	M36x4.0 LH	50°	150318	140376

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Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material	
			H13	CPM9V
Husky				
42mm	M20x2.5 LH	60°	137022	167657
50mm	M20x2.0 LH	60°	160899	167658
50mm	M24x3.0 LH	60°	160900	167659
60mm	M30x3.5 LH	60°	132080	167660
60mm	M30x2.0 LH	60°	164622	170744
70mm	M36x4.0 LH	60°	145619	145620
80mm	M42x4.5 LH	60°	164641	144397
100mm	M52x5.0 LH	50°	167651	167652
100mm	M60x5.5 LH	60°	167653	167654
135mm	M68x6.0 LH	50°	167655	167656
140mm	M72x6.0 LH	60°	167665	144157
Impco				
2"	7/8"-14 LH	40°	161546	170743
2-1/2"	1-1/2"-8 LH	40°	140237	170740
4-1/4"	2-1/4"-4.5 LH	40°	170741	170742
Jaco				
1-1/4"	5/8"-11 LH	50°	137822	136417
JSW				
28mm	M16x2.0 LH	30°	147189	137605
28mm	M12x1.5 LH	30°	162790	162791
35mm	TR20x3.0 LH	18°	162970	167761
40mm	TR22x3.0 LH	22°	160189	138217
45mm	M24x3.0	20°	168248	168249
45mm	TR24x3.0	20°	147190	167762
45mm	TR27x3.0	20°	162904	144193
45mm	M22x2.5	60°	170209	170210
45mm	TR24x3.0	90°	170361	170362
46mm	TR24x3.0	17°	147192	147193
53mm	TR28x3.0	16°	162940	170737
58mm	TR36x3.0	18°	134131	167740
60mm	TR35x3.0	23°	170209	170210
66mm	TR38x3.0	14°	162868	162869
72mm	TR40x3.0	16°	167763	162917
76mm	TR40x3.0	16°	170738	170739
84mm	TR47x3.0	18°	147195	145671
84mm	TR42x3.0	18°	170735	170736
92mm	TR48x3.0	20°	164695	164696
100mm	TR52x3.0	30°	168352	168353
110mm	TR55x3.0	30°	168354	168355
130mm	TR65x3.0	30°	168358	168359

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			H13	CPM9V
Kawaguchi				
30mm	TR15x2.0 LH	40°	148592	167764
30mm	M16x1.5 LH	40°	144227	145412
34mm	M18x2.0 LH	40°	162938	162939
35mm	M20x2.0 LH	23°	144116	162941
36mm	M20x2.0 LH	40°	168343	168344
36mm	TR20x2.0 LH	40°	167736	167737
40mm	M20x2.0 LH	40°	135795	132815
40mm	¾"-10 LH	40°	164593	170733
40mm	M22x2.0 LH	40°	164594	164595
42mm	TR24x3.0 LH	40°	164596	170734
45mm	TR24x3.0 LH	40°	137107	167730
45mm	TR25x3.0 LH	40°	164655	167731
50mm	TR30x3.0 LH	40°	167732	136280
50mm	TR24x3.0 LH	40°	150345	167733
55mm	TR30x3.0 LH	40°	168362	168363
60mm	TR34x4.0 LH	40°	119222	167734
63mm	TR34x4.0 LH	40°	145689	145690
70mm	TR38x4.0 LH	40°	145682	167729
72mm	TR40x4.0 LH	40°	137842	145407
85mm	TR46x5.0 LH	40°	132437	145408
90mm	TR46x5.0 LH	40°	145691	145692
100mm	TR52x5.0 LH	40°	145693	145694
115mm	TR58x6.0 LH	40°	145695	168247
Kaiming				
55mm	M30x2.0 LH	30°	170203	170204
Klockner-Windsor				
90mm	M52x3.0 LH	90°	167675	167676
115mm	M68x4.0 LH	90°	147132	147133
KHM				
65mm	M33x3.0 LH	40°	161525	170731
70mm	M35x3.0 LH	60°	163959	170732

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Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material H13	IMS Item # Style / Material CPM9V
Krauss-Maffei				
30mm	M16x2.0 LH	60°	160902	160903
35mm	M18x2.5 LH	23°	159991	170728
35mm	M18x2.5 LH	60°	159992	148540
40mm	M20x2.5 LH	60°	123530	133390
50mm	M27x3.0 LH	60°	150370	142243
60mm	M33x3.5 LH	60°	149037	160122
70mm	M36x4.0 LH	60°	162060	160926
80mm	M42x4.5 LH	60°	158286	160927
90mm	M48x5.0 LH	60°	164642	164643
95mm	M48x5.0 LH	60°	170308	170309
100mm	M56x5.5 LH	60°	167750	167749
105mm	TR55x3.0 LH	60°	148542	148543
Meiki				
50mm	M24x2.0 LH	26°	150977	170388
55mm	M30x2.0 LH	30°	169309	168310
60mm	M30x2.0 LH	26°	170729	170730
Mitsubishi				
28mm	M12x1.75 LH	15°	148598	148600
28mm	M16x2.0 LH	15°	148599	148601
36mm	M22x2.5 LH	22°	150337	150338
45mm	M27x3.0 LH	26°	150463	150464
50mm	M27x3.0 LH	26°	135708	167649
57mm	M33x3.5 LH	20°	148568	148603
62mm	M36x4.0 LH	26°	148522	150450
70mm	M39x4.0 LH	26°	148657	144219
80mm	M45x4.5 LH	26°	162806	144221
90mm	M48x5.0 LH	30°	148678	162808
105mm	M56x5.5 LH	30°	164668	167674
120mm	M60x5.5 LH	30°	162758	162759
135mm	M64x6.0 LH	30°	162760	162761

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Negri Bossi				
38mm	M16x1.5 LH	90°	164665	164666
40mm	M18x1.5 LH	90°	150693	167591
45mm	M22x2.0 LH	75°	167643	167644
52mm	M22x2.0 LH	40°	167587	167588
70mm	M26x2.0 LH	90°	167621	167622
80mm	M36x2.0 LH	60°	167589	167590
110mm	M48x2.0 LH	60°	170340	170341
135mm	M60x3.0 LH	60°	167585	167586
New Britain				
1⅜"	9/16"-18 LH	60°	160886	160887
2”	1"-8 LH	60°	160848	147187
36mm	TR20x3.0 LH	20°	167666	167667
Newbury				
1"	½"-13 LH	45°	147142	133308
1"	½"-13 LH	90°	147143	134331
1"	½"-13 LH	1-¼"	160031	160032
1¼"	⅝"-11 LH	60°	167783	RFQ*
1¼"	⅝"-11 LH	1-½"	143726	RFQ*
1⅜"	⅝"-11 LH	120°	144701	136276
1⅜"	⅝"-11 LH	60°	144149	136401
1½"	¾"-10 LH	30°	147868	147870
1½"	¾"-10 LH	60°	147869	147871
1¾"	⅞"-9 LH	60°	162756	RFQ*
1¾"	⅞"-9 LH	1½"	148516	162874
2¼"	1"-8 LH	60°	124735	167645
Niigata				
35mm	M18x2.5 LH	70°	160017	142327
40mm	M20x2.5 LH	70°	160040	137893
45mm	M24x3.0 LH	70°	145258	132171
52mm	M27x3.0 LH	70°	147860	143012
60mm	M30x3.5 LH	70°	164647	167647
68mm	M36x3.0 LH	70°	162802	169054
76mm	M42x3.0 LH	70°	140544	167671

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continued on next page

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Free Flow Screw Tip Assemblies

BRODY-Ring® OPTIONAL — See Pages 555-557

Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material	
			H13	CPM9V
Nissei				
14mm	M7x.75 LH	30°	170391	148635
16mm	M9x1.0 LH	20°	170390	132232
19mm	M10x1.5 LH	30°	170389	150346
22mm	TR12x2.0 LH	60°	133784	147831
26mm	TR14x2.0 LH	60°	147140	147141
26mm	M12x1.75 LH	60°	164628	164629
28mm	TR14x2.0 LH	40°	148634	136181
30mm	TR16x2.0 LH	60°	167603	132187
32mm	TR16x2.0 LH	40°	164712	164713
32mm	TR18x2.0 LH	40°	136410	138355
36mm	TR20x2.0 LH	40°	133149	132785
36mm	M18x2.5 LH	40°	170428	170207
40mm	TR24x3.0 LH	40°	150347	134294
45mm	M24x3.0 LH	40°	171844	171395
45mm	TR26x3.0 LH	40°	133751	133207
50mm	TR28x3.0 LH	40°	140526	136428
56mm	TR32x3.0 LH	40°	144850	138123
58mm	TR36x3.0 LH	40°	160113	160114
63mm	TR36x3.0 LH	40°	144205	144204
71mm	TR44x3.0 LH	40°	142053	158282
72mm	TR44x3.0 LH	40°	144109	167641
75mm	TR44x3.0 LH	40°	149115	167642
80mm	TR48x3.0 LH	40°	134584	150387
84mm	TR52x3.0 LH	40°	143219	170387
90mm	TR55x3.0 LH	40°	145591	162906
100mm	TR65x3.0 LH	40°	132325	150284
112mm	TR65x3.0 LH	40°	150278	148613
120mm	TR75x4.0 LH	40°	160077	160078
125mm	TR75x4.0 LH	40°	131863	167646

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Free Flow Screw Tip Assemblies

BRODY-Ring® OPTIONAL — See Pages 555-557

Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material	
			H13	CPM9V
Reed				
1-¾"	¾"-10 LH	45°	123544	170756
2"	1"-8 LH	45°	170776	170777
2"	1"-8 LH	60°	170757	140169
2"	1"-8 LH	120°	170758	160853
2-½"	1¼"-8 LH	45°	170759	170760
2-½"	1¼"-8 LH	60°	167598	167599
2-½"	1¼"-8 LH	120°	170761	170762
3"	1-⅜"-12 LH	45°	170763	135031
3"	1-⅜"-12 LH	60°	132188	170764
3"	1-⅜"-12 LH	120°	170765	170766
3-⅜"	1-⅝"-8 LH	45°	160895	170767
3-⅜"	1-⅝"-8 LH	60°	160894	170768
3-⅜"	1-⅝"-8 LH	120°	170769	170770
3-¾"	1-⅞"-8 LH	45°	170771	170772
3-¾"	1-⅞"-8 LH	60°	160562	170773
3-¾"	1-⅞"-8 LH	120°	170774	170775
Sandretto				
30mm	M12x1.75 LH	40°	163169	162794
35mm	M14x2.0 LH	40°	162795	143031
40mm	M18x2.5 LH	30°	160921	170382
40mm	M16x2.0 LH	40°	160922	170383
45mm	M20x2.5 LH	40°	162773	170384
55mm	M27x3.0 LH	40°	150585	170385
65mm	M30x3.5 LH	40°	129603	170386
80mm	M36x4.0 LH	40°	171590	170883
Shen Zhou				
60mm	M30x2.0 LH	30°	170380	170381
Shinwa-Seiki				
35mm	M18x2.5 LH	36°	170363	170364
35mm	M18x2.5 LH	60°	170365	160890
40mm	M20x2.5 LH	36°	170366	150669
50mm	M27x3.0 LH	50°	142237	160891
60mm	M36x3.0 LH	50°	142242	160892
70mm	M40x3.0 LH	36°	170311	170312
70mm	M40x3.0 LH	60°	170313	170314
70mm	M42x4.5 LH	36°	170315	170316
90mm	TR45x3.0 LH	60°	170317	170318

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Free Flow Screw Tip Assemblies

BRODY-Ring® OPTIONAL — See Pages 555-557

Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material H13	IMS Item # Style / Material CPM9V
Stokes				
1-⅝"	¾"-10 LH	90°	170367	170368
2-½"	1-⅛"-12 LH	90°	170369	145582
3-½"	1-⅝"-12 LH	60°	164707	164709
Sumitomo				
16mm	M8x1.0 LH	70°	147156	165023
18mm	M9x1.0 LH	60°	145607	145606
20mm	M10x1.25 LH	60°	168328	168329
22mm	M10x1.25 LH	60°	167639	136416
25mm	M18x2.0 LH	60°	168308	168309
28mm	M12x1.5 LH	60°	168330	168331
32mm	M16x1.5 LH	60°	131881	165027
36mm	M16x1.5 LH	60°	125404	165092
36mm	M18x2.0 LH	60°	145587	160854
40mm	M20x2.0 LH	60°	148551	148552
45mm	M20x2.0 LH	60°	138127	160855
50mm	M24x2.0 LH	60°	145588	144388
56mm	M24x2.0 LH	60°	164605	164606
63mm	M33x3.0 LH	60°	145589	145633
71mm	M33x3.0 LH	60°	145590	162804
80mm	M40x3.0 LH	60°	147863	147862
90mm	M52x4.0 LH	60°	145635	145634
Toshiba				
18mm	M8x1.0 LH	30°	145410	137468
22mm	M10x1.25 LH	60°	170350	170351
25mm	M12x1.5 LH	30°	150366	150367
25mm	M12x1.5 LH	50°	145584	145578
30mm	M12x1.5 LH	60°	150368	150369
28mm	M15x1.5 LH	60°	160065	160067
28mm	M15x1.5 LH	30°	160068	160069
32mm	M18x2.0 LH	25°	160011	132374
36mm	M22x2.0 LH	30°	170352	170353
36mm	M22x2.0 LH	60°	144114	145686
40mm	M22x2.0 LH	60°	144213	144212
40mm	M22x2.0 LH	23°	144215	144214
45mm	M26x1.5 LH	60°	148514	123390
50mm	M28x2.0 LH	60°	162800	162801
50mm	M28x2.0 LH	60°	123545	145545

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Free Flow Screw Tip Assemblies

BRODY-Ring® OPTIONAL — See Pages 555-557

Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material H13	IMS Item # Style / Material CPM9V
Toshiba				
55mm	M28x2.0 LH	60°	124275	134132
60mm	M28x2.0 LH	23°	160124	160125
60mm	M28x2.0 LH	60°	137779	160108
70mm	M36x3.0 LH	23°	147819	160107
70mm	M36x3.0 LH	60°	145672	170371
70mm	M36x3.0 LH	60°	160106	143327
80mm	M42x3.0 LH	23°	150431	150432
80mm	M42x3.0 LH	60°	136427	129178
90mm	M45x4.0 LH	23°	164639	164640
90mm	M45x4.0 LH	60°	160059	160061
95mm	M45x4.0 LH	60°	167606	167607
100mm	M50x4.0 LH	23°	164687	167672
100mm	M50x4.0 LH	60°	164689	167673
105mm	M50x4.0 LH	60°	160050	160052
120mm	M60x4.0 LH	60°	167627	167628
125mm	M64x6.0 LH	60°	167629	167630
Toyo				
24mm	M12x1.5 LH	30°	160104	150332
24mm	M12x1.5 LH	45°	160105	150331
28mm	M16x2.0 LH	30°	160095	160096
28mm	M16x2.0 LH	45°	160097	160098
32mm	M18x2.5 LH	30°	147844	147843
32mm	M18x2.5 LH	45°	160100	160102
36mm	M18x2.5 LH	30°	167635	167636
36mm	M18x2.5 LH	45°	167637	167638
40mm	M22x2.5 LH	30°	144154	138527
40mm	M22x2.5 LH	45°	164671	164672
46mm	M24x3.0 LH	30°	147880	138011
46mm	M24x3.0 LH	45°	167631	167632
50mm	M27x3.0 LH	30°	134113	162830
50mm	M27x3.0 LH	45°	162831	147134
55mm	M27x3.0 LH	30°	138881	147155
55mm	M27x3.0 LH	45°	167633	167634
60mm	M30x3.0 LH	30°	148614	137451
68mm	M33x3.5 LH	30°	137061	160103
75mm	M36x4.0 LH	30°	167741	167742
75mm	M36x4.0 LH	45°	163201	167743
83mm	M39x4.0 LH	30°	160099	160101

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BRODY-Ring® OPTIONAL — See Pages 555-557

Make of Press Screw Tip OD	Screw Tip Thread	Nose Angle	IMS Item # Style / Material H13	IMS Item # Style / Material CPM9V
Trubor				
25mm	½"-13 LH	30°	148795	162667
31mm	⅝"-11 LH	30°	134356	126583
35mm	⅝"-11 LH	30°	134350	170373
38mm	¾"-10 LH	30°	170374	170375
41mm	¾"-10 LH	30°	170376	170377
Trueblood				
1”	½"-13 LH	60°	150687	170378
1-¼"	⅝"-11 LH	90°	170379	149113
1-½"	⅝"-11 LH	90°	167808	167597
2"	⅞"-9 LH	90°	167809	167596
UBE				
100mm	M42x4.5 LH	31°	167751	167752
100mm	M56x5.0 LH	31°	167753	167754
100mm	M48x5.0 LH	60°	167755	167756
112mm	M48x5.0 LH	31°	150692	170372
120mm	M60x4.0 LH	31°	167757	167758
Van Dorn				
30mm	⅝"-11 LH	30°	150371	134585
25mm	¾"-10 LH	45°	143621	131965
38mm	¾"-10 LH	30°	158257	145599
40mm	¾"-10 LH	30°	132941	140287
50mm	1"-8 LH	30°	144104	132159
57mm	1-¼"-7 LH	30°	138259	137853
65mm	1-⅜"-6 LH	30°	136680	131611
69mm	1-⅜"-6 LH	30°	160851	160852
75mm	1-⅜"-6 LH	30°	150377	150378
80mm	1-⅜"-6 LH	30°	135729	145622
90mm	1-¾"-8 LH	30°	143620	145455
105mm	1-¾"-8 LH	30°	147899	134152
115mm	2"-8 LH	45°	144867	160123
135MM	2-½"-8 LH	40°	150379	150380
Yudak				
32mm	⅝"-11 LH	34°	170663	170339
Weltec				
60mm	M27x3.0 LH	60°	137266	137138

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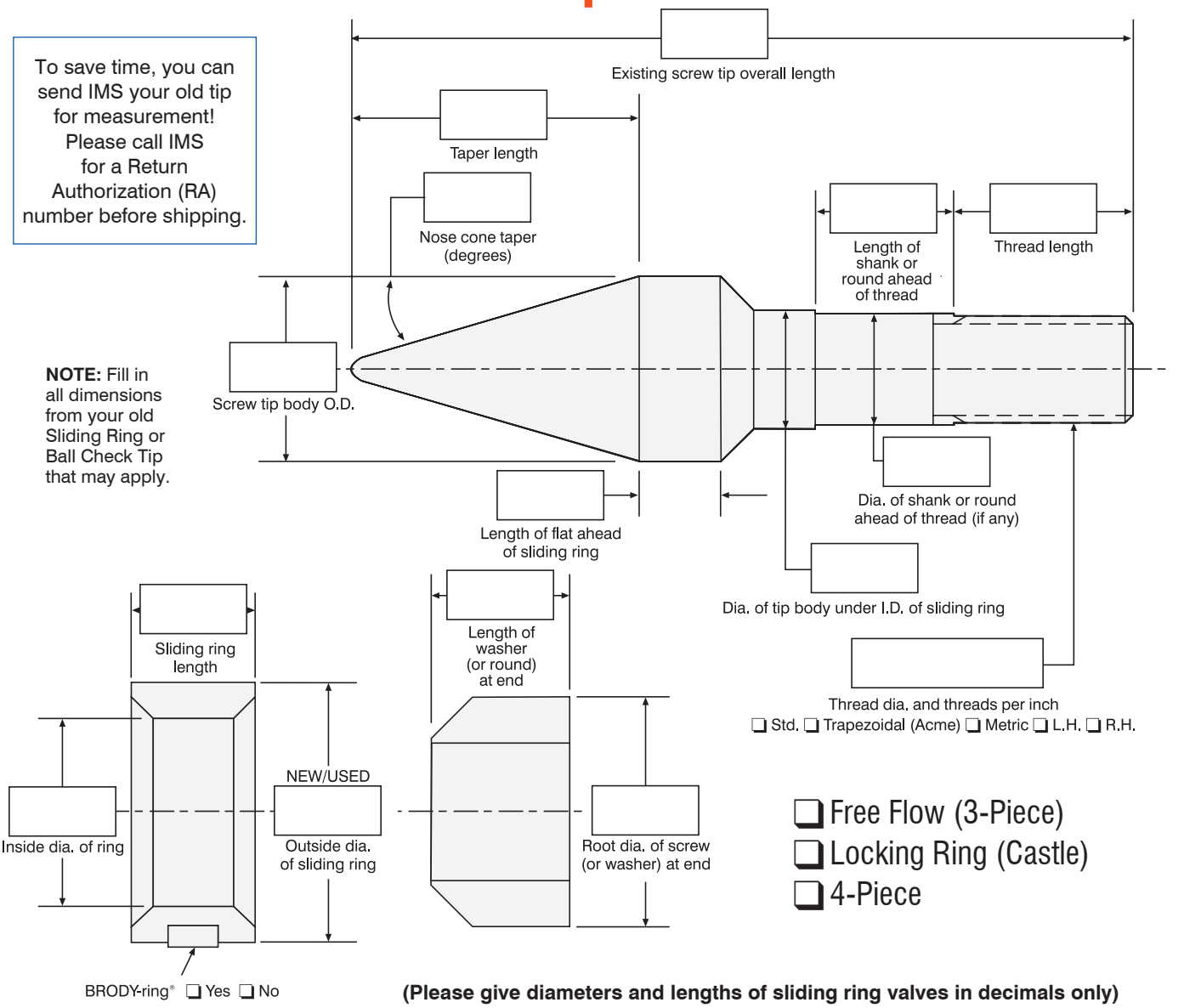
REQUEST FOR QUOTE: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

Made-to-Order Screw Tip Form

To save time, you can send IMS your old tip for measurement! Please call IMS for a Return Authorization (RA) number before shipping.



NOTE: Fill in all dimensions from your old Sliding Ring or Ball Check Tip that may apply.

❑ Free Flow (3-Piece)
❑ Locking Ring (Castle)
❑ 4-Piece

(Please give diameters and lengths of sliding ring valves in decimals only)

Specify:

1. Press Make _____
   Model _____
   Serial Number _____
   Year _____
2. Material to be Molded _____
3. Operating Temperature _____
4. Inside Diameter of Barrel in Ring Travel Zone:
   NEW _____
   USED _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Many Ready To Ship Same Day! Our shop works with:

- H-13
- D-2
- S-7
- CPM9V
- 920 Stainless
- CPM-M4
- CPM10V

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"Our tech's #1 priority is to get you up and running"

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- Ferromatic
- Goldstar
- Haitian
- HPM
- Hunter
- Husky
- Impco
- JSW
- Kawaguchi
- Klockner
- Kraus-Maffei
- Lombard
- Mitsubishi
- Natco
- Negri-Bossi
- Netstal
- New Britain
- Newbury
- Niigata
- Nissei
- Pyramid
- Reed
- Sandretto
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- Stokes
- Sumitomo
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... and MORE!

Check Out These Other Useful IMS Products

Multimeters

Pages 97-99

True RMS Multimeter with Infrared Thermometer

Two Useful Instruments In One Compact Case At One Great Price!

Item #132602

Includes: Meter, Test Leads, Type K Temperature Probe,
Protective Holster, 9V Battery and Three Year Limited Warranty

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IMS Screw Tip BRODY-Ring®

Postpone Barrel Repairs ---- Improve Press Performance

- Shorter screw travel for faster cycles.
- End all O.D. blow-back.
- Positive injection pressure.
- Consistent shot control.
- Color changes made quicker.
- Retrofit MOST tips.
- Give new press performance on any injection machine — even with a worn barrel.

Mold With A Cushion!

Extend Barrel Life 2 to 3X!

BRODY-Ring® on a 50 mm Van Dorn Ball Check Screw Tip

Stop Screw Tip Blow-By With A BRODY-Ring®!

The introduction of the BRODY-Ring® was a major breakthrough in improving Reciprocating-Screw Press efficiency. Try a tip with a BRODY-Ring®. It will make your old press perform better than new. If your barrel is worn, the results are even more positive because you can postpone a barrel relining job until your job is completed and you can afford the downtime.

The IMS BRODY-Ring® molds with a cushion, allowing you to mold better parts. This ensures perfect fills every time. It maximizes part strength and lets you hold critical part dimensions more closely because you exert the same pressure on every shot. Helps minimize part strains.

The BRODY-Ring® prevents blow-by around the sliding ring or ball check tip. It speeds color changes because there is no space between the ring and the tip where material can hang up, burn and contaminate.

Positive shut-off of the BRODY-Ring® stops the jetting back of plastic around the O.D. of the sliding ring or tip body. This reduces frictional heat created by the plastic as it leaks back around the tip while you are trying to fill the part.

BRODY-Rings® can allow you to cut cycle time too. You do not have to OVER-STROKE (or over-retract) your screw to compensate for all the plastic that leaks back past ordinary tips of whatever design. By allowing you to shorten your screw stroke, you save cycle time. So mold with a cushion and make better parts faster!

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Made in the U.S.A

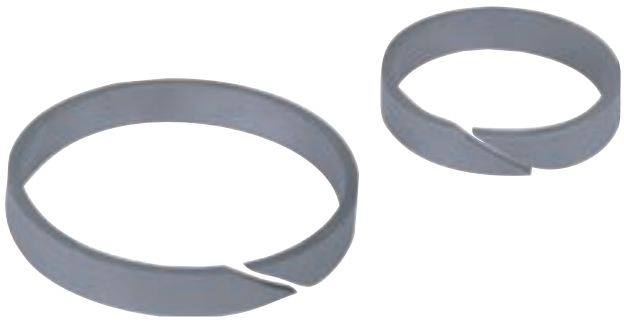
IMS BRODY-Ring® Seals

Improve machine performance — Extend barrel life

BRODY-ring® Pricing Guide (Screw Tips NOT Included): Specify actual screw tip O.D. and machine make

Metric	
Nominal Screw Tip O.D. (Up to and including)	**Item #**
15mm	136177
18mm	117933
20mm	164569
22mm	124150
24mm	124151
25mm	101603
26mm	110655
28mm	107972
30mm	101590
31mm	105612
32mm	105684
34mm	124315
35mm	101573
36mm	101608
37mm	143077
38mm	105263
40mm	101595
41mm	124736
42mm	105362
44mm	128171
45mm	101583
46mm	115425
48mm	127764
50mm	101569
52mm	123323
55mm	101605
56mm	114045
57mm	101599
58mm	101593
60mm	101615
62mm	133962
63mm	110462
65mm	101612
66mm	135727
68mm	143064
69mm	101622
70mm	101620
71mm	110465
72mm	101617
75mm	103820
76mm	120972
80mm	101613
83mm	114663
84mm	120498
85mm	105257
90mm	101621
95mm	128149
99mm	140235
100mm	101619
105mm	101618
110mm	129815
112mm	129285
115mm	101616
120mm	101614
125mm	123328
135mm	137021
140mm	141690
150mm	145456
155mm	133629
160mm	120525
170mm	128339

Standard	
Nominal Screw Tip O.D. (Up to and including)	**Item #**
1"	101571
1¼"	101606
1 5/16"	101600
1⅜"	101594
1½"	101588
1⅝"	101582
1¾"	101577
2"	101567
2.1"	101598
2⅛"	101592
2¼"	101587
2⅜"	105249
2½"	101576
2.7"	101611
2¾"	101604
2.8"	101597
2 13/16"	106513
3"	101591
3¼"	101585
3 5/16"	101579
3½"	101575
3¾"	101610
4"	101602
4⅛"	107463
4¼"	104131
4½"	101589
4¾"	132458
5¼"	101584
5½"	108269
6"	101570
6½"	143059



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Instructions for IMS BRODY-Ring®

Grooving & Installation Instructions

(See drawing for proper groove depth)

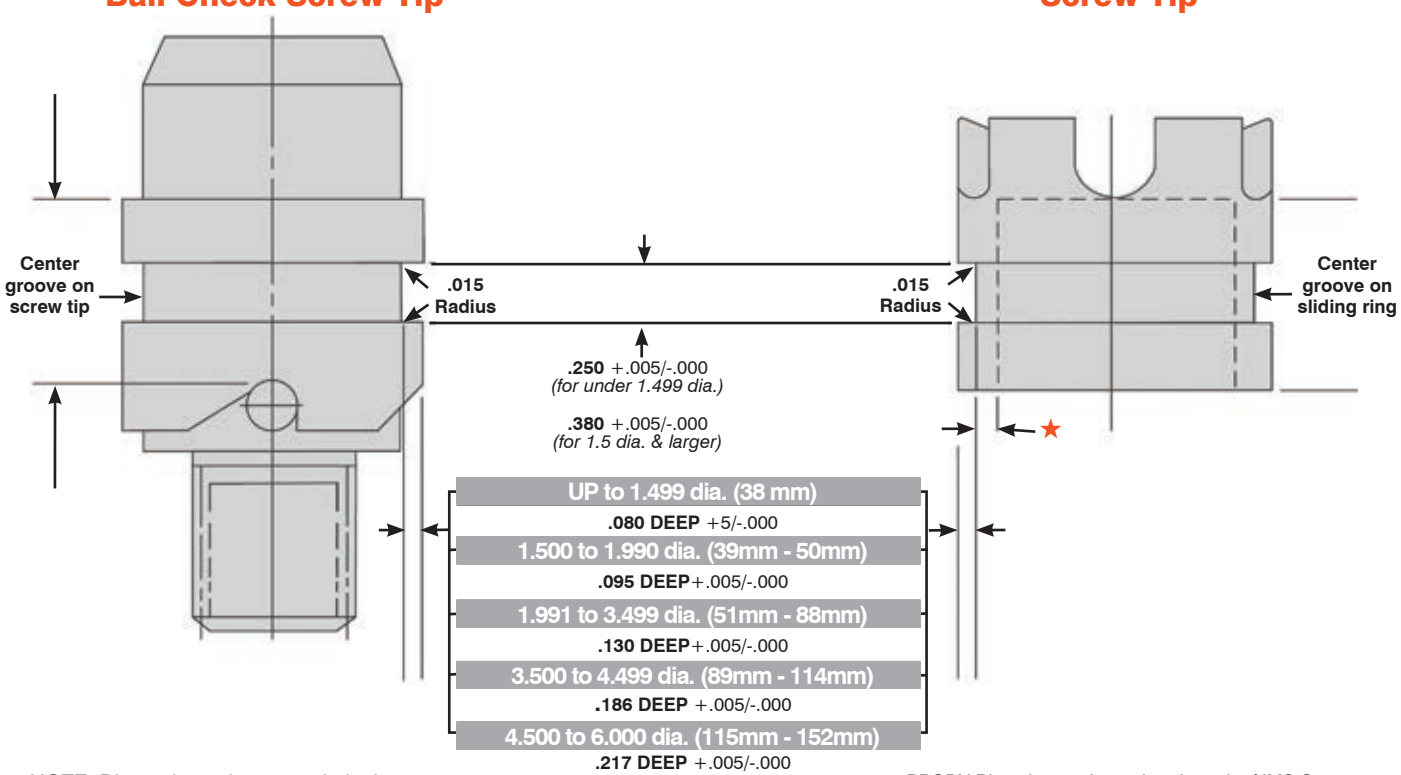
1. Machine your sliding ring or tip body in lathe, or grind (if above 48 Rockwell C).
2. Be sure to protect all polished surfaces and threads.
3. Recommended lathe speed: 80 surface feet per minute.
4. Use groove cutting tool.
5. If groove is cut into a case-hardened surface, screw tip or check ring should be heat treated through to 46-48 Rockwell C prior to installation of BRODY-Ring®.
6. If groove is cut into a nitrided surface, screw tip or check ring should be renitrided prior to installation of BRODY-Ring®.
7. Slowly and carefully slide BRODY-Ring® over tip body or sliding ring until it snaps into groove.
8. To install in barrel, use hose clamp or piston ring compressor to compress BRODY-Ring®.

Special Notes

1. BRODY-Rings® take up a temporary maximum of .025" total wear between screw tip and barrel.
2. BRODY-Rings® are only a temporary solution to worn barrel problems and should only be used until complete barrel resleeving (also available from IMS) is possible.
3. If any questions, please call an IMS Customer Service Representative.
4. Wall thickness under groove must be equal to groove depth for adequate check ring strength. ★

Typical IMS Or Other Make Ball Check Screw Tip

Typical Sliding Ring Screw Tip



NOTE: Dimensions shown are in inches.

BRODY-Ring® is a registered trademark of IMS Company.

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Ball Check Spanner Wrench

Designed for Safer, Easier Screw Tip Removal

Adjustable Pin Spanner Wrenches from IMS are just what you need for safe, easy installation and removal of ball check type screw tips. These quality wrenches adjust automatically to the diameter of the tip. They fit snugly and securely, and will not harm tips if used as intended. A long, heavy duty handle provides good leverage and strength. The IMS line of Spanner Wrenches will fit any screw tip diameter from ¾" to 6¼". See chart below for specific diameter ranges.

Item #	Capacity Range for Diameters	Pin Height x Diameter	Length Overall (fully open)	Weight
Ball Check Spanner Wrench Without Coated Handle				
130560	¾" to 2"	3/16" × 3/16"	6⅜"	0.27 lbs.
130561	1¼" to 3"	3/16" × 3/16"	8⅛"	0.53 lbs.
130562	2" to 4¾"	¼" × ¼"	11⅜"	1.07 lbs.
130563	4½" to 6¼"	¼" × ⅜"	12⅛"	1.20 lbs.

Screw Carrying/Handling Tool

For Carrying, Removing and Installing Feed Screws

The Superior Screw Handling Device!

- High Strength Aluminum welded Aluminum – Long Lasting, Durable
- Light weight – Won't dramatically increase weight of already cumbersome screw
- Includes comfortable rubber hand grips – provides user comfort while transporting screws
- Adjustable Screw Positioning Pins with Aluminum Handles – No tools required to adjust tool. Quick adjustments = less time wasted
- Brass Screw Positioning Pins – won't scratch new screws, easy to replace if damaged or worn
- Fits most screws for most presses. Adjustable from 1 9/16" to 3½" Diameter Screws

Item #164751

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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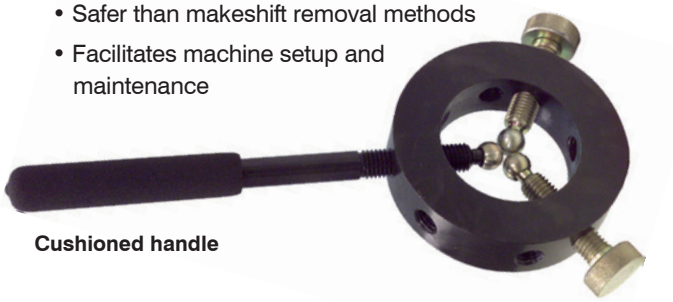
IMS Fluted Screw Tip Wrench

Fully Adjustable — 3, 4 or 5 Flute

Made in the U.S.A

The IMS Fluted Screw Tip Wrench is the ideal tool for removing fluted screw tips. It avoids costly damage caused by other removal methods. The wrench is compatible with hundreds of screw tip sizes. It adjusts up to a 3" screw tip body diameter. And you can use it for screw tips with 3, 4 and 5 flutes.

- Specifically designed for removing fluted screw tips
- Avoids damage to fluted screw tips
- Requires virtually no adjustment
- Safer than makeshift removal methods
- Facilitates machine setup and maintenance



Cushioned handle

Purchasers also order:

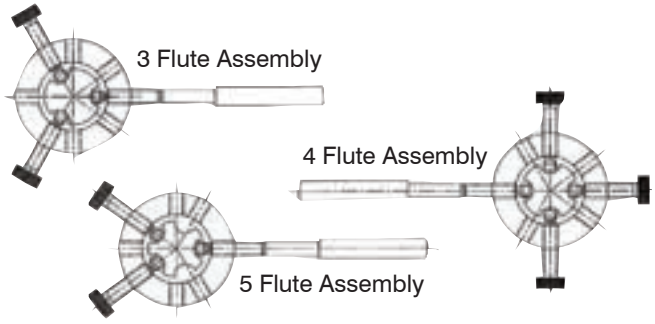
- High Heat Thread Lube, page 521

Specifications and Prices

4140 tool steel handle	Fits 3, 4 and 5 flute screw tips
Black oxide finish	Fits screw tip body diameter up to 3"
1750 ft. lbs. max. torque rating	

Item #	Description
123894	Fluted Screw Tip Wrench

— Compatible with Multiple Screw Tip Styles —



Easy Change Pin Design

Tech Tips

Hand tighten screw tips. Use a wrench, only if needed, to remove the tips.
Always use anti-seize on the threads when installing.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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IMS OEM Replacement Screws

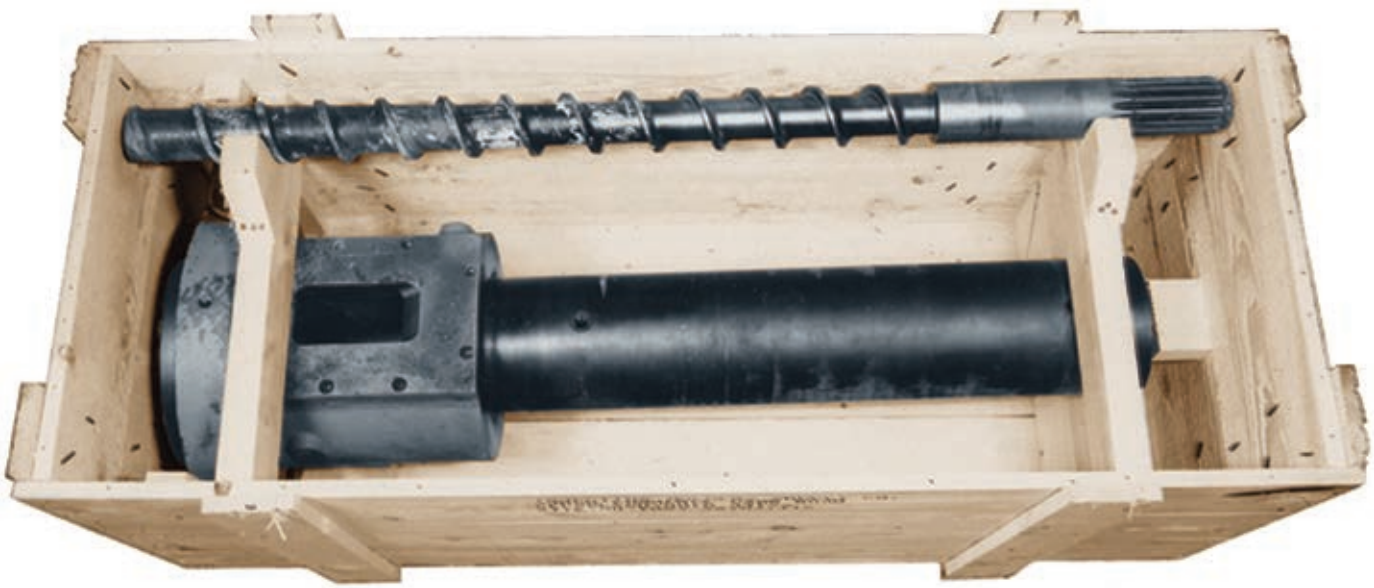
Stocked In Many Popular Sizes

OEM Replacement Screws promote smooth material flow without material degradation. Screws with chrome-plated and nitrided surface treatments are also available. Contact the IMS Sales Team at **sales@imscompany.com** for more information.

Purchasers also order:

- Purgex, pages 586-587

Ask about Screw & Barrel Package Deals



Contact the IMS Components Team at sales@imscompany.com

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

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-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
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0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
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60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
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To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Screw Material Guidelines

Base Screw Materials				Acceptability For Resin Wear Conditions				
				Abrasive			Corrosive (7)	
Material Designation	Treatment(1)	Rc (2)	Fh (3)	Normal (4)	Moderate (5)	Severe (6)	Moderate	Severe
Alloy Steels								
4140	Flame-hardened	48-55	no	Acceptable	Poor	N/A	N/A	N/A
4140	Chrome-plated	60-65	yes	Good	Acceptable	N/A	Good	N/A
Nitralloy 135-M	Nitrided	63-70	yes	Good	Acceptable	N/A	Poor	N/A
Tool Steels								
CPM 9V	Heat-treated	54-56	no	Excellent	Excellent	Good	Acceptable	N/A
CPMM4	Heat-treated	62-64	no	Excellent	Good	Acceptable	Poor	N/A
CPM 420	Heat-treated	54-56	no	Acceptable	Poor	N/A	Good	Poor
Special Alloys								
Monel K-500	Age hardened	37-39	opt'l	Acceptable	N/A	N/A	Excellent	Good
Nickel 718	Age hardened	43-45	opt'l	Acceptable	N/A	N/A	Excellent	Good
Encapsulations	Carbide coatings	70 +	no	Excellent	Excellent	Good	Good	Poor

CPM - Crucible Materials Corporation N/A - Not Acceptable

(1) Includes chrome-plating to .003"-.005" and gas or ion nitriding for 24+ hour cycle.
(2) Rockwell C hardness.
(3) Flight hardsurfacing required.
(4) Thermoplastics with no reinforcements.
(5) Thermoplastics with up to 30% reinforcement.
(6) Thermoplastics with more than 30% reinforcement.
(7) Moderate includes cellulosics, acetals and others containing corrosive additives.

Material Options

Feed screws are manufactured from conventional tool steels such as 4140, D-2 or H-13. Particle Metallurgy processing such as CPM9V, S90V, CPMM4 is also used.

Nitralloy 135M
Excellent low-cost, prehardened steel machined and Nitrided for 72 hours. For wear-resistant or general purpose materials. Low-cost alternative when excessive wear is not a primary consideration.

D-2 Tool Steel
A high carbon/high chrome (12%) tool steel with good wear resistance, but low on torque strength.

H-13 Tool Steel
A good high strength pre-hardened tool steel which is machined, thru-hardened, and ground dimensionally, then nitride hardened for 72 hours for better wear resistance. H-13 is tough and can handle pressure and torque.

CPM9V Tool Steel
Highly wear resistant tool steel with a high percentage of vanadium carbide developed for high wear (abrasive) applications. It resists wear from abrasive fillers in resin.

CPM10V Tool Steel
Excellent wear-resistant tool steel. Contains 10% vanadium. Ideal for highly abrasive plastics.

CPM420V Tool Steel
Stainless tool steel best suited for corrosion resistant applications.

CPMM4 Tool Steel
Crucible's CPM®-M4 is a high vanadium, special purpose, high speed steel exhibiting better wear resistance and toughness than D2 or CPM®-9V. CPM®-M4 has a hardness rating of 64.0.

M-4
M4 has higher resistance to heat than 9V The heat tolerance for CPM 9V is only 800 and the heat tolerance for M4 is 1200˚F

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Hard Facing On Screw Flights

4140
A tool steel with good strength when surface treated or hard faced.

STELLITE #6
4140 based. Recommended for resins with a low percentage of filled materials. 37-42 RC hardness.

STELLITE #12
Save as above with 40-47 RC hardness.

COLMONOY 56
Nickel based. More wear resistant than Stellite. Recommended for glass-filled or resins. 50 to 55 RC hardness.
More wear resistant than Stellite Recommended for glass-filled resins. 50-55RC.

Nitriding

Increases the hardness and life of tool steel screws such as 135M and 4140. Very cost effective.

A 4140 alloy steel screw can be nitrided satisfactorily, however, a nitriding steel (such as Nitralloy 135M) has aluminum added to give a better response in nitriding hardness, both as to consistency and depth.

Gas Nitriding is used to create a surface hardness on the screw. The hard layer of steel will vary in depth from .007" to .015" depending upon the length of the nitriding cycle. The hard layer (usually well above 60 RC) is achieved by heating the steel in an atmosphere of nitrogen (ammonia gas) at temperatures of 950 to 1050˚F. The nitrogen atoms are diffused into the surface of the steel, combining with nitride-forming elements, such as chromium, aluminum, molybdenum, vanadium, tungsten and titanium, to produce a very hard surface, particularly for the first .002" to .005" depth. Nitrided screws have a very good wear resistance until the surface hardness is worn away. After the surface is worn .007", wear accelerates and the screw may quickly be worn to a condition that is beyond repair.

Chrome Plating

Offers hardness and low friction with corrosion protection. Double and triple chrome plating often used for corrosive applications.

Although most processors are familiar with chrome-plating, there is an important specification to be considered in purchasing a chrome-plated screw or having a repaired screw chrome-plated. The critical specification is the depth of the plating.

Most of the screws that are not manufactured from solid tool steels or special alloys have a flight hard-surfacing material welded to form the outside diameter of the screw flights.

The hard-surfacing materials are predominantly cobalt-based or nickel-based. The most common cobalt-based materials include the Stellites (6 and 12) which exhibit uniform wear and are satisfactory in non-corrosive environments.

Carbide Coating

Carbide coating - Guaranteed to double the life of a CPM9V screw.

Particle Metallurgy Tool Steels

Examples of tool steels made by the PM process that are used for screws include CPM9V, CPMM4, and CPMS90V, all from Crucible Materials Corporation. However, there are other manufacturers of PM steels that offer comparable characteristics to the CPM products.

Nickel Alloys

Processing fluoropolymers must be done with nickel alloy screws or screws that are totally encapsulated with a relatively iron-free material. Monel K-500 and Inconel 718 are both nickel alloys that can be hardened into the low 40's RC. Both resist corrosion quite well and, although very expensive, provide an acceptable solution to the extreme corrosiveness of PVC.

Total Encapsulation

There are several methods used to totally encapsulate a screw with wear and/or corrosion resistant material. The methods include detonation guns, HVOF systems and various spray weld processes. A wide selection of materials can be used ranging from the types of materials used for flight hard-surfacing to customized products containing very hard wear resistant carbides.

NOTE: Screw and Barrel wear over time, will reduce screw recovery, increase scrap rates and increase energy consumption. While molders may recognize the costs of wear, they usually accept it as a necessary part of their business. Using a nozzle tip blank such as IMS's 136499 or 136486, try to inject slowly forward at reduced pressure to quantify the ability of the press to hold cushion. You can quickly spot a problem before it becomes serious.

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Feed Screws

Make of Press Screw OD	OAL	IMS Item Nos. (Materials) 4140 w/Colmonoy #56	Nitralloy 135M	CPM9V	D-2	4140 w/ Stellite #12
Arburg						
15mm	29.25"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
18mm	23.00"	RFQ*	RFQ*	119171	RFQ*	RFQ*
20mm	28.8"	RFQ*	RFQ*	132378	RFQ*	RFQ*
22mm	17-1/8"	RFQ*	111676	RFQ*	RFQ*	RFQ*
25mm	28-1/4"	RFQ*	121160	RFQ*	RFQ*	RFQ*
25mm	34"	RFQ*	122213	RFQ*	RFQ*	RFQ*
25mm	22.7"	RFQ*	144098	132341	137631	RFQ*
30mm	20.17"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
30mm	22.687"	RFQ*	RFQ*	RFQ*	127277	RFQ*
30mm	38.51"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
35mm	27.562"	RFQ*	145585	144099	127777	RFQ*
35mm	27.562"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
Autojector						
3/4"	21.649"	RFQ*	RFQ*	121642	RFQ*	RFQ*
1"	25.44"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
1-1/2"	28.62"	RFQ*	124165	145463	RFQ*	RFQ*
1-1/2"	32-5/8"	RFQ*	125816	RFQ*	RFQ*	RFQ*
1-1/4"	23.922"	132069	124695	RFQ*	RFQ*	RFQ*
1-1/4"	22.68"	RFQ*	RFQ*	144138	RFQ*	RFQ*
Battenfeld						
35mm	45.7"	145065	RFQ*	RFQ*	RFQ*	RFQ*
35mm	47.0"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
45mm	35"	RFQ*	136257	RFQ*	RFQ*	RFQ*
45mm	52.3"	144186	RFQ*	RFQ*	RFQ*	RFQ*
50mm	61-13/16"	125402	RFQ*	RFQ*	RFQ*	RFQ*
Boy						
22mm	25.60"	RFQ*	RFQ*	RFQ*	137886	RFQ*
24mm	25.63"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
32mm	31.50"	RFQ*	RFQ*	127577	RFQ*	RFQ*
38mm	38.898"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
Cincinnati						
1"	30-1/4"	RFQ*	122108	RFQ*	RFQ*	RFQ*
2"	43"	124866	RFQ*	RFQ*	RFQ*	RFQ*
2-3/4"	69.69"	RFQ*	RFQ*	RFQ*	RFQ*	137142

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Feed Screws

Make of Press Screw OD	OAL	IMS Item Nos. (Materials) 4140 w/Colmonoy #56	Nitralloy 135M	CPM9V	D-2	4140 w/ Stellite #12
Cincinnati						
16mm	20-5/16"	RFQ*	120492	RFQ*	RFQ*	RFQ*
18mm	27-1/8"	RFQ*	120494	RFQ*	RFQ*	RFQ*
28mm	33.687"	RFQ*	RFQ*	122046	RFQ*	RFQ*
32mm	37.32"	RFQ*	RFQ*	133550	RFQ*	RFQ*
40mm	43.063"	RFQ*	RFQ*	137555	RFQ*	RFQ*
45mm	52.63"	142411	RFQ*	RFQ*	RFQ*	RFQ*
50mm	52.68"	RFQ*	144170	RFQ*	RFQ*	RFQ*
50mm	59.13"	RFQ*	RFQ*	RFQ*	RFQ*	144171
65mm	66.375"	132653	128372	RFQ*	RFQ*	RFQ*
80mm	81.18"	RFQ*	137820	RFQ*	RFQ*	RFQ*
90mm	80.18"	RFQ*	RFQ*	RFQ*	RFQ*	145600
90mm	92.63"	RFQ*	RFQ*	RFQ*	RFQ*	145602
90mm	102.05"	RFQ*	RFQ*	RFQ*	RFQ*	145603
Demag						
22mm	30-1/4"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
35mm	40.55"	RFQ*	RFQ*	RFQ*	RFQ*	125641
60mm	65.91"	RFQ*	145507	145509	RFQ*	RFQ*
70mm	78.3"	148594	164609	RFQ*	RFQ*	RFQ*
Engel						
18mm	24.4"	RFQ*	RFQ*	142282	RFQ*	144142
25mm	27.56"	RFQ*	RFQ*	120658	RFQ*	RFQ*
25mm	34"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
30mm	31.81"	RFQ*	118821	RFQ*	132170	RFQ*
30mm	36.61"	RFQ*	RFQ*	122315	RFQ*	RFQ*
30mm	23.8"	RFQ*	RFQ*	RFQ*	RFQ*	119247
30mm	24.3"	RFQ*	RFQ*	RFQ*	RFQ*	121891
45mm	44.5"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
Fu Chen						
42mm	37.45"	RFQ*	RFQ*	132355	RFQ*	RFQ*
Goldstar						
85mm	107.8"	144194	RFQ*	RFQ*	RFQ*	RFQ*

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Feed Screws

Make of Press Screw OD	OAL	IMS Item Nos. (Materials) 4140 w/Colmonoy #56	Nitralloy 135M	CPM9V	D-2	4140 w/ Stellite #12
HPM						
1"		132275	RFQ*	RFQ*	RFQ*	RFQ*
1-½"		RFQ*	134877	RFQ*	RFQ*	RFQ*
2"	65.25"	RFQ*	125349	RFQ*	RFQ*	RFQ*
Husky						
70mm	74.41"	145618	145617	RFQ*	RFQ*	RFQ*
Impco						
2-½"	77.25"	132799	RFQ*	RFQ*	RFQ*	RFQ*
Jaco						
1-¼"	29.0"	RFQ*	RFQ*	136349	RFQ*	RFQ*
JSW						
28mm	29"	RFQ*	130672	RFQ*	RFQ*	RFQ*
35mm	37-½"	RFQ*	130671	RFQ*	RFQ*	RFQ*
40mm	42.625"	RFQ*	RFQ*	138218	RFQ*	RFQ*
46mm	54.21"	RFQ*	144187	RFQ*	RFQ*	144188
46mm	47.4"	RFQ*	144189	RFQ*	RFQ*	144190
58mm	54.53"	RFQ*	RFQ*	173718	RFQ*	RFQ*
Kawaguchi						
30mm	31.01"	RFQ*	144225	RFQ*	RFQ*	144226
36mm	36.6"	RFQ*	129622	RFQ*	RFQ*	RFQ*
50mm	53.312"	RFQ*	127304	RFQ*	RFQ*	RFQ*
Killion						
1-¼"	35.62"	RFQ*	142346	RFQ*	RFQ*	RFQ*
Lester						
2"	51-¼"	RFQ*	130892	RFQ*	RFQ*	RFQ*
2-½"	65"	RFQ*	129060	RFQ*	RFQ*	RFQ*
Lombard						
1-½"	44"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
Mitsubishi						
55mm	57.62"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*

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Feed Screws

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Natco						
1"	18.50"	107967	RFQ*	RFQ*	RFQ*	RFQ*
70mm	64.44"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
NBY						
1"	18.5"	RFQ*	RFQ*	107967	RFQ*	RFQ*
Negri Bossi						
45mm	41"	RFQ*	RFQ*	RFQ*	130599	RFQ*
Nestal						
25mm		RFQ*	137321	RFQ*	RFQ*	RFQ*
New Britain						
1-5/8"	40.125"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
36mm		RFQ*	142190	RFQ*	RFQ*	RFQ*
55mm	33-5/16"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
65mm		RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
Newbury						
1"	18.5"	RFQ*	124350	126826	RFQ*	RFQ*
1"	24.31"	RFQ*	138202	132438	RFQ*	RFQ*
1"	27.25"	160037	160036	160038	RFQ*	RFQ*
1-1/2"	28.625"	RFQ*	RFQ*	RFQ*	RFQ*	131955
1-1/4"	22.81"	RFQ*	119437	132510	RFQ*	137413
1-3/4"	42.47"	RFQ*	RFQ*	120221	RFQ*	RFQ*
1-3/4"		RFQ*	RFQ*	137027	RFQ*	RFQ*
1-3/8"	27.32"	RFQ*	RFQ*	143042	RFQ*	RFQ*
1-3/8"	33.125"	RFQ*	RFQ*	136404	144702	RFQ*
2"	31.75"	RFQ*	RFQ*	145645	RFQ*	RFQ*
2"	52.5"	RFQ*	RFQ*	145646	RFQ*	RFQ*
2-1/4"	41.75"	RFQ*	RFQ*	145647	RFQ*	RFQ*
Niigata						
18mm	28.62"	RFQ*	RFQ*	145465	145464	RFQ*
35mm	32.25"	RFQ*	133621	RFQ*	RFQ*	RFQ*
35mm	25.75"	RFQ*	RFQ*	RFQ*	136676	RFQ*

*RFQ=Request for Quote

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Feed Screws

Make of Press Screw OD	OAL	IMS Item Nos. (Materials) 4140 w/Colmonoy #56	Nitralloy 135M	CPM9V	D-2	4140 w/ Stellite #12
Nissei						
16mm	18.75”	RFQ*	RFQ*	132231	RFQ*	RFQ*
19mm	18.6”	145467	145466	145468	RFQ*	RFQ*
22mm	18.41”	RFQ*	RFQ*	RFQ*	132369	RFQ*
22mm	22.44”	RFQ*	RFQ*	RFQ*	145648	RFQ*
26mm	24.32”	RFQ*	145649	RFQ*	RFQ*	RFQ*
26mm	26.4”	RFQ*	145650	RFQ*	RFQ*	RFQ*
28mm	31.3”	RFQ*	RFQ*	126906	RFQ*	RFQ*
30mm	24.39”	145470	145469	145471	RFQ*	RFQ*
32mm	31.1”	RFQ*	145651	RFQ*	RFQ*	RFQ*
32mm	35.06”	RFQ*	RFQ*	138503	RFQ*	RFQ*
36mm	30.81”	RFQ*	145652	RFQ*	RFQ*	RFQ*
36mm	34.87”	132887	RFQ*	135691	131960	RFQ*
36mm	39.05”	144211	RFQ*	132784	133148	RFQ*
40mm	34.4”	RFQ*	145653	RFQ*	RFQ*	RFQ*
40mm	38.8”	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
40mm	44.09”	148585	145654	RFQ*	RFQ*	RFQ*
45mm	38.5”	RFQ*	145472	145474	RFQ*	145473
45mm	38.5”	RFQ*	138880/PVC	RFQ*	RFQ*	RFQ*
45mm	49.8”	RFQ*	145655	RFQ*	RFQ*	RFQ*
50mm	49.56”	145479	145475	145477	RFQ*	RFQ*
50mm	53.6”	RFQ*	145656	RFQ*	RFQ*	RFQ*
56mm	49.25”	RFQ*	145478	145480	RFQ*	RFQ*
56mm	53.375”	RFQ*	RFQ*	138290	RFQ*	RFQ*
56mm	60.2”	145482	145481	145483	RFQ*	RFQ*
63mm	53.35”	145485	145484	145486	RFQ*	RFQ*
63mm	59.88”	RFQ*	145657	RFQ*	RFQ*	RFQ*
63mm	68.1”	RFQ*	145658	RFQ*	RFQ*	RFQ*
71mm	59.5”	RFQ*	RFQ*	RFQ*	RFQ*	142138
71mm	67.75”	145488	145487	145489	RFQ*	RFQ*
72mm	62.75"	RFQ*	145625	RFQ*	RFQ*	145626
75mm	72.95”	142338	RFQ*	RFQ*	RFQ*	RFQ*
Reed						
1”		RFQ*	125584	RFQ*	RFQ*	RFQ*
2”	44.25”	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
2”	29.5”	RFQ*	142228	RFQ*	RFQ*	RFQ*
2-3/4”	48.312”	RFQ*	129530	RFQ*	RFQ*	RFQ*

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Feed Screws

Make of Press Screw OD	OAL	IMS Item Nos. (Materials) 4140 w/Colmonoy #56	Nitralloy 135M	CPM9V	D-2	4140 w/ Stellite #12
Sandretto						
45mm	46.875"	RFQ*	124149	RFQ*	RFQ*	RFQ*
50mm	75.5"	RFQ*	144191	RFQ*	RFQ*	RFQ*
55mm	68.375"	RFQ*	138813	RFQ*	RFQ*	RFQ*
Sumitomo						
25mm	28.14"	145491	145490	145492	RFQ*	RFQ*
32mm	38.56"	145501	131879	RFQ*	RFQ*	RFQ*
56mm	65.04"	145504	145503	145505	RFQ*	RFQ*
Toshiba						
28mm	31.37"	RFQ*	RFQ*	131374	RFQ*	RFQ*
32mm	34.34"	RFQ*	RFQ*	132351	RFQ*	RFQ*
32mm	37.75"	RFQ*	RFQ*	122748	RFQ*	RFQ*
36mm	40.75"	144105	RFQ*	RFQ*	130869	RFQ*
40mm	43.81"	RFQ*	133739	RFQ*	RFQ*	RFQ*
55mm	61.6"	168251	124079	168250	RFQ*	RFQ*
60mm	75.25"	RFQ*	RFQ*	133443	RFQ*	RFQ*
Toyo						
40mm	40.46"	RFQ*	RFQ*	RFQ*	RFQ*	RFQ*
68mm	68.375"	124197	RFQ*	RFQ*	RFQ*	RFQ*
UBE						
30mm	24.48"	RFQ*	132663	RFQ*	RFQ*	RFQ*
Van Dorn						
30mm	31.48"	RFQ*	RFQ*	124101	RFQ*	RFQ*
30mm	33"	RFQ*	RFQ*	RFQ*	131434	RFQ*
35mm	35.34"	145510	140520	131964	RFQ*	RFQ*
38mm	36.81"	145518	145517	145519	RFQ*	RFQ*
40mm	38.18"	RFQ*	142176	140612	119183	RFQ*
50mm	50"	136208	121178	137561	127325	RFQ*
57mm	54.33"	127699	131864	125533	RFQ*	RFQ*
65mm	59.7"	124224	137260	137259	RFQ*	RFQ*
69mm	68.19"	145512	145511	145513	RFQ*	RFQ*
80mm	75.6"	122466	131696	120644	RFQ*	RFQ*
90mm	85.62"	145515	145514	145516	RFQ*	RFQ*

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
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66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.
-17.8	**0**	32.0
-17.2	**1**	33.8
-16.7	**2**	35.6
-16.1	**3**	37.4
-15.6	**4**	39.2
-15.0	**5**	41.0
-14.4	**6**	42.8
-13.9	**7**	44.6
-13.3	**8**	46.4
-12.8	**9**	48.2
-12.2	**10**	50.0
-11.7	**11**	51.8
-11.1	**12**	53.6
-10.6	**13**	55.4
-10.0	**14**	57.2
- 9.44	**15**	59.0
- 8.89	**16**	60.8
- 8.33	**17**	62.6
- 7.78	**18**	64.4
- 7.22	**19**	66.2
- 6.67	**20**	68.0
- 6.11	**21**	69.8
- 5.56	**22**	71.6
- 5.00	**23**	73.4
- 4.44	**24**	75.2
- 3.89	**25**	77.0
- 3.33	**26**	78.8
- 2.78	**27**	80.6
- 2.22	**28**	82.4
- 1.67	**29**	84.2
- 1.11	**30**	86.0
- 0.56	**31**	87.8
0	**32**	89.6
0.56	**33**	91.4
1.11	**34**	93.2
1.67	**35**	95.0
2.22	**36**	96.8
2.78	**37**	98.6
3.33	**38**	100.4
3.89	**39**	102.2
4.44	**40**	104.0
5.00	**41**	105.8
5.56	**42**	107.6
6.11	**43**	109.4
6.67	**44**	111.2
7.22	**45**	113.0
7.78	**46**	114.8
8.33	**47**	116.6
8.89	**48**	118.4
9.44	**49**	120.2
10.0	**50**	122.0
10.6	**51**	123.8
11.1	**52**	125.6
11.7	**53**	127.4
12.2	**54**	129.2
12.8	**55**	131.0
13.3	**56**	132.8
13.9	**57**	134.6
14.4	**58**	136.4
15.0	**59**	138.2
15.6	**60**	140.0
16.1	**61**	141.8
16.7	**62**	143.6
17.2	**63**	145.4
17.8	**64**	147.2
18.3	**65**	149.0
18.9	**66**	150.8
19.4	**67**	152.6
20.0	**68**	154.4
20.6	**69**	156.2
21.1	**70**	158.0
21.7	**71**	159.8
22.2	**72**	161.6
22.8	**73**	163.4
23.3	**74**	165.2
23.9	**75**	167.0
24.4	**76**	168.8
25.0	**77**	170.6
25.6	**78**	172.4
26.1	**79**	174.2
26.7	**80**	176.0
27.2	**81**	177.8
27.8	**82**	179.6
28.3	**83**	181.4
28.9	**84**	183.2
29.4	**85**	185.0
30.0	**86**	186.8
30.6	**87**	188.6
31.1	**88**	190.4
31.7	**89**	192.2
32.2	**90**	194.0
32.8	**91**	195.8
33.3	**92**	197.6
33.9	**93**	199.4
34.4	**94**	201.2
35.0	**95**	203.0
35.6	**96**	204.8
36.1	**97**	206.6
36.7	**98**	208.4
37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.
38	**100**	212
43	**110**	230
49	**120**	248
54	**130**	266
60	**140**	284
66	**150**	302
71	**160**	320
77	**170**	338
82	**180**	356
88	**190**	374
93	**200**	392
99	**210**	410
100	**212**	413.6
104	**220**	428
110	**230**	446
116	**240**	464
121	**250**	482
127	**260**	500
132	**270**	518
138	**280**	536
143	**290**	554
149	**300**	572
154	**310**	590
160	**320**	608
166	**330**	626
171	**340**	644
177	**350**	662
182	**360**	680
188	**370**	698
193	**380**	716
199	**390**	734
204	**400**	752
210	**410**	770
216	**420**	788
221	**430**	806
227	**440**	824
232	**450**	842
238	**460**	860
243	**470**	878
249	**480**	896
254	**490**	914
260	**500**	932
266	**510**	950
271	**520**	968
277	**530**	986
282	**540**	1004
288	**550**	1022
293	**560**	1040
299	**570**	1058
304	**580**	1076
310	**590**	1094
316	**600**	1112
321	**610**	1130
327	**620**	1148
332	**630**	1166
338	**640**	1184
343	**650**	1202
349	**660**	1220
354	**670**	1238
360	**680**	1256
366	**690**	1274
371	**700**	1292
377	**710**	1310
382	**720**	1328
388	**730**	1346
393	**740**	1364
399	**750**	1382
404	**760**	1400
410	**770**	1418
416	**780**	1436
421	**790**	1454
427	**800**	1472
432	**810**	1490
438	**820**	1508
443	**830**	1526
449	**840**	1544
454	**850**	1562
460	**860**	1580
466	**870**	1598
471	**880**	1616
477	**890**	1634
482	**900**	1652
488	**910**	1670
493	**920**	1688
499	**930**	1706
504	**940**	1724
510	**950**	1742
516	**960**	1760
521	**970**	1778
527	**980**	1796
532	**990**	1814
538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
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221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

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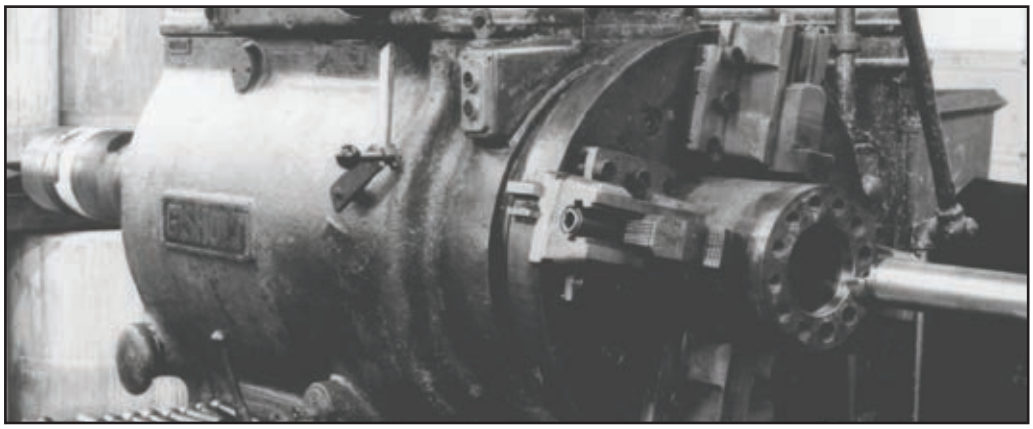
IMS OEM Replacement Barrels

YES — IMS was first to offer Sleeved Barrels! We have repaired thousands of barrels over a 50+ year period!

Prompt Service still counts!



1. D-2 Steel

In the 1950's, IMS developed standard, wear resistant D-2 liners for longer barrel life. D-2 is hardened throughout to combine hardness and toughness. When nitrided, it gives outstanding performance, even on glass-filled plastics.

2. CPM-10V CRUCIBLE® Tool Steel for heavily filled materials

CPM-10V is an abrasion-resistant steel from CRUCIBLE® Specialty Metals Division. Produced by a patented process, it incorporates high amounts of carbon, chromium, and vanadium to give a toughness not found in other tool steels. So far, it's the smart molders first choice for barrel liners used to melt glass-filled and other abrasive-filled plastics.

3. Bimetallic

IMS offers bimetallic liners from the supplier of your choice, such as Bimex, Xaloy and Wexco. If you have a preference based on your experience, ask IMS for a quotation on a bimetallic liner using the specific grade or trade name you prefer.

Order Instructions

Always phone an IMS Technical Specialist BEFORE you ship your barrels to IMS. You will be given a Return Authorization (RA) Number to ensure that your barrel is scheduled with minimum delay.

Ship worn or damaged barrel to:
IMS Company, 10373 Stafford Road, Chagrin Falls, Ohio 44023
Ship as Class 85 Machine Parts.
You save money when crate is reusable!

FREE Inspection when Repair is Authorized
Every barrel repair requires careful study so that a correct price can be quoted to you in advance. If repair, salvage or replacement is authorized by you, there is no extra charge for our inspection. If you decide NOT to repair or replace the barrel, it is necessary to bill you for out-of-pocket costs incurred in handling and inspecting it to determine its salvageability. Yes, IMS makes new barrels! Repairs include replacement of cracked or broken front end, refacing and reworking end cap or supplying a new one of the standard or new spiral design.

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Essential Barrel Information

Tool Steel-Lined Barrels

Premature and uneven cylinder wear is expensive in terms of both replacement costs and lost process efficiency. IMS barrels are lined with your needs in mind. For low abrasion applications, we keep your costs down by using D-2 tool steel.

Barrel Liner Material Guidelines

D-2 Tool Steel
Heat treated to RC 58-60, D-2 is a relatively inexpensive, high carbon-high chromium steel with proven, uniform wear resistance surpassing most other steels.

Nitrided Barrels
Nitrided barrels are lined with Nitralloy 135M. Gas nitriding is available on barrels.

Nitrided barrels are not recommended for use with abrasive or corrosive resins due to their inability to resist wear over an extended period of time.

CPM Family

CPM tool steels are premier products of Crucible Specialty Metals Division. The process of producing CPM tools involves gas atomization of pre-alloyed molten steel to form powder that is then isostatically compressed into 100% dense compacts. CPM steels have no alloy segregation and exhibit extremely uniform carbide distribution. The CPM process produces very homogeneous, high quality steel characterized by superior dimensional stability, grindability, and toughness compared to steels produced by conventional processes.

CPM9V
With a lower carbon and vanadium to improve toughness and heat check resistance, CPM9V performs well in problem applications where high carbon, high chromium tool steels, such as CPM10V or the high speed steels, lack sufficient toughness or heat check resistance, or where lower alloy tool steels and hot work tool steels lack sufficient wear resistance.

CPM10V
CPM10V has its vanadium content optimized to provide superior wear resistance while maintaining toughness and fabrication characteristics comparable to D2 and M2. Its exceptional wear resistance and good toughness make it an excellent candidate to replace carbide and other highly wear resistant materials in cold work tooling applications, particularly where tool oughness is a problem or where cost effectiveness can be demonstrated. Due to it's 10% vanadium content, this steel is one of the most abrasion resistant materials available.

CPM15V
CPM15V is intended for applications requiring exceptional wear resistance. It has more vanadium carbides in its composite than CPM10V and provides more wear resistance and longer tool life. CPM15V also offers an alternative to solid carbide where carbide fails by fracture or where intricate tool design makes carbide difficult or risky to fabricate. Due to it's 15% vanadium content CPM15V will outwear CPM10V.

CPMS90V
A stainless steel with a high volume of vanadium carbides for exceptionally good wear resistance. Due to its high vanadium content for wear resistance and it's sufficient chromium content, to provide good corrosion resistance, the wear and corrosion resistance of S90V make it an excellent candidate where increased wear is a primary concern. It can be heat treated to a lower hardness for use as a screw material or to a higher hardness (RC 58-60) for barrel lining.

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Nitrided Barrels

Nitrided barrels may be made from 4140 but a nitriding steel, such as Nitralloy 135M enables a better nitrided interior surface to be achieved. Two nitriding methods are available: gas nitriding and ion nitriding.

Gas Nitriding
Gas Nitriding is used to create a surface hardness on the screw. The hard layer of steel will vary in depth from .007" to .015" depending upon the length of the nitriding cycle. The hard layer (usually well above 60 Rc) is achieved by heating the steel in an atmosphere of nitrogen (ammonia gas) at temperatures of 950˚F to 1050˚F. The nitrogen atoms are diffused into the surface of the steel, combining with nitride-forming elements, such as chromium, aluminum, molybdenum, vanadium, tungsten and titanium, to produce a very hard surface, particularly for the first .002" to .005" depth. Nitrided screws have a very good wear resistance until the surface hardness is worn away. After the surface is worn .007", wear accelerates and the screw may quickly be worn to a condition that is beyond repair.

Ion Nitriding
Ion nitriding is similar to gas nitriding, using an electrical potential to ionize low pressure nitrogen gas. The ions produced are accelerated to the surface of the steel, heating it to a temperature for diffusion to take place (i.e., the uniting of the atomic nitrogen with the nitride-bearing elements in the steel). Because the temperatures are lower and pressures more controllable, a more uniform surface hardness depth may be achieved. The ionization occurs in a plasma discharge process which creates a glow, hence, this type of nitriding is also referred to as the 'plasma method' or 'glow discharge' nitriding.

Nitrided barrels are not recommended for use with abrasive or corrosive resins because of their inability to resist wear over an extended time period.

Bimetallic Barrels

Cast bimetallic barrels are manufactured by metallurgically bonding the lining alloy to the inner surface of a pre-machined, seamless steel tube, forging or bar stock. The bonding is achieved by heating the barrel (and the lining alloy) to the point where the alloy is melted. The barrel is then spun and cooled, centrifugally casting the alloy on the inner surface of the barrel. The casting is typically .040" - .080" in depth.

The linings range from standard abrasion-resistant, to corrosion-resistant, to premium. Each provides different degrees of wear resistance.

IMS manufactures bimetallic barrels in-house using top of the line cast bimetallic barrel blanks. We carry in inventory most common sizes of these barrel blanks in order to meet our customer's needs.

Standard Bimetallic
Standard wear-resistant liner. Nickel-Boron alloy with good abrasion resistance and low friction co-efficient.

Carbide Bimetallic
Super wear-resistant tungsten carbide liner. For highly abrasive applications. Some corrosion resistance.

Premium Bimetallic
Corrosion resistant liner. Cobalt-nickel based with high chromium content. Provides excellent wear resistance in highly corrosive conditions.

continued on next page

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Relined Barrels

IMS offers full-length relining of barrels up to eight (8) inches in diameter and 180" inches in length, using premium tool steels and special alloys, depending upon the customer's need.

Upon receipt of your barrel, our engineers will do a thorough inspection of your barrel. We will then contact you with a quote for repair, either by phone or fax. At that time you will have the option of proceeding with the work (upon IMS's receipt of your purchase order approval), having IMS return the barrel to you or having us dispose of it.

AN IMS ALTERNATIVE: R215 Carbide bound liner: We start with a solid piece of 4100 series tool steel with a bored ID. CO56 powder is then placed in the 4100 series barrel, heated up and spun. This makes the CO56 melt and stick to the inside of the barrel, similar to a sleeve. It is then bored to manufacturer specs and polished. This barrel can be later bored out and resleeved w/carbide or tool steel if necessary.

Bonding is achieved by heating the barrel (and the lining alloy) to the point where the alloy is melted. The barrel is then spun and cooled, centrifugally casting the alloy on the inner surface of the barrel. The resulting lining is about 1/16" (.0625") thick throughout the barrel. Due to the temperatures reached in the spin-casting process, the 4100 series backing material is annealed. In larger barrels, a pressure sleeve made from heat treated or forged alloy steel is placed over the nozzle end of the barrel by shrink fitting.

Barrel Lining Material	Acceptability For Resin Wear Conditions				
	Abrasive			Corrosive	
	Normal (4)	Moderate (5)	Severe (6)	Moderate	Severe
NITRIDE: (Gas or Ion)					
4140 or equivalent	Acceptable	Poor	N/A	Poor	N/A
Nitralloy 135 M or equivalent	Acceptable	Poor	N/A	Poor	N/A
BIMETALLIC:					
Standard	Good	Acceptable	Poor	Poor	N/A
Corrosion Resistant	Good	Acceptable	Poor	Excellent	Good
Premium	Excellent	Excellent	Good	Excellent	Excellent
TOOL STEELS:					
D-2	Good	Acceptable	Poor	Acceptable	N/A
CPM10V	Excellent	Excellent	Good	Acceptable	N/A
CPM15V	Excellent	Excellent	Excellent	Acceptable	N/A
CPMS90V	Good	Acceptable	Poor	Good	Poor
SPECIAL ALLOYS:					
Nickel 718 (Inconel or Pyromet)	Acceptable	N/A	N/A	Excellent	Excellent
Monel K-500	Acceptable	N/A	N/A	Excellent	Excellent
Hastelloy C-276	Acceptable	N/A	N/A	Excellent	Excellent
C-2 Tungsten Carbide	Excellent	Excellent	Excellent	Excellent	Good

CPM - Crucible Materials Corporation N/A - Not Acceptable

(1) All Thermoplastics without reinforcement or abrasive fillers.
(2) Thermoplastics with abrasive reinforcement or fillers up to 30%.
(3) Thermoplastics with 30% or more reinforcements or abrasive fillers and thermosets.
(4) Cellulosics, Ionomers, Acetals and others containing corrosive additives.
(5) Fluoropolymers.

Measuring Barrel Wear

- Clean the barrel ID, while hot, with a soft wire or brass brush, preferably wrapped with copper gauze. Allow to cool to room temperature.
- Set dial bore gage to nominal bore diameter of the barrel. Record your findings, taking a reading along the ID of the barrel every 2 - 3 inches. Examine condition of barrel ID, looking for any "washed out" areas, cracks and gouges. Inspect feed throat area and end cap.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
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-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
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71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
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93	**200**	392	343	**650**	1202
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127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
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143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
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243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
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266	**510**	950	521	**970**	1778
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Please refer to imscompany.com for current pricing

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IMS OEM Replacement Front End Caps

Prompt Delivery on Made-To-Order End Caps

- IMS can replace, and in some cases repair, any barrel end cap.
- Traditional end caps have evenly spaced bolt holes. Some press end caps have non-concentric bolt patterns. Another common style in use consists of a nozzle that threads directly into the barrel. IMS can replace all of these styles, and more. Just provide information, or a sample, and IMS will replace it, or repair it.
- IMS will inspect it, and quote what items can be fixed, and what they will cost. If an end cap cannot be repaired, IMS will quote a new replacement.
- IMS can build end caps from any material: H13, Nitralloy, 4140 steel, D2. You name it, we will build it from that material.
- Various surface treatments are also available: chrome plating, PVD (Titanium Nitride), conventional nitriding, and many others.

Compare Our Quality, Price And Delivery!

Order Instructions

Call for a Return Authorization Number

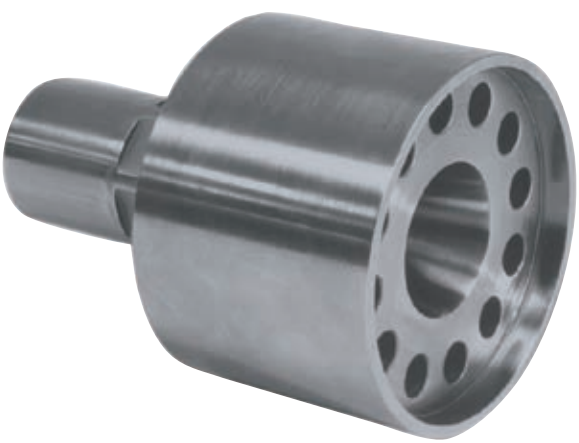
Always phone an IMS Technical Specialist before you ship your end cap to IMS. You will be given a Return Authorization (RA) Number to ensure that your end cap is scheduled with minimum delay.

Ship worn or damaged end cap to:
IMS Company, 10373 Stafford Road, Chagrin Falls, Ohio 44023
Ship as Class 85 Machine Parts.

You save money when crate is reusable!
— Free Inspection when Repair is Authorized —

Every end cap repair requires careful study so that a correct price can be quoted to you in advance. If repair, salvage or replacement is authorized by you, there is no extra charge for our inspection. If you decide NOT to repair or replace the end cap, it is necessary to bill you for out-of-pocket costs incurred in handling and inspecting it to determine its salvageability.

End Cap Repairs Are No Problem For Ims



Expert Service!

IMS Company

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

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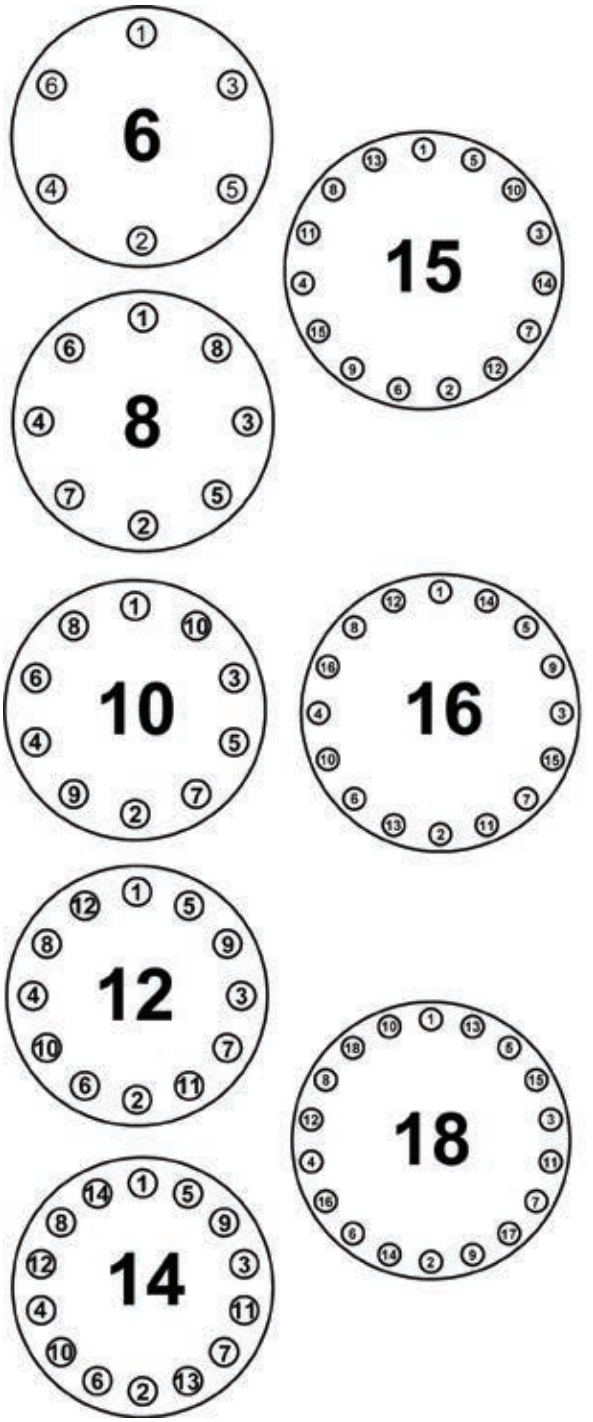

End Cap Assembly Instructions

STEP 1: Lubricate bolt threads in area of engagement. Also, lubricate face of bolt using a nickel based anti-seize compound (Item #130787 — see page 653).

STEP 2: Install all bolts finger tight.

STEP 3: Number bolts so that torquing requirements can be met.

STEP 4: Apply torque in 20% (1/5) increments of required torque, loading all bolts at each increment before proceeding to the next sequence.

STEP 5: Repeat final torque sequence when the barrel is at operating temperature.

End Cap Bolt Specs

Bore Diameter	Torque Ft. LBS.
30mm	22
36mm	27
38mm	30
40mm	24
50mm	64
57mm	83
65mm	98
69mm	145
75mm	150
80mm	195
90mm	301
105mm	512
115mm	886
135mm	1110
155mm	1750

Tech Tips

It is highly important to tighten all end cap and nozzle sealing surfaces properly. All mating surface must come together evenly and squarely to ensure a proper seal.

When thread on end caps are used and a torque wrench is not available, it is important to use extreme care when tightening bolts. Over tightening can cause damage to the sealing surfaces.

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-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
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- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.
-17.8	**0**	32.0
-17.2	**1**	33.8
-16.7	**2**	35.6
-16.1	**3**	37.4
-15.6	**4**	39.2
-15.0	**5**	41.0
-14.4	**6**	42.8
-13.9	**7**	44.6
-13.3	**8**	46.4
-12.8	**9**	48.2
-12.2	**10**	50.0
-11.7	**11**	51.8
-11.1	**12**	53.6
-10.6	**13**	55.4
-10.0	**14**	57.2
- 9.44	**15**	59.0
- 8.89	**16**	60.8
- 8.33	**17**	62.6
- 7.78	**18**	64.4
- 7.22	**19**	66.2
- 6.67	**20**	68.0
- 6.11	**21**	69.8
- 5.56	**22**	71.6
- 5.00	**23**	73.4
- 4.44	**24**	75.2
- 3.89	**25**	77.0
- 3.33	**26**	78.8
- 2.78	**27**	80.6
- 2.22	**28**	82.4
- 1.67	**29**	84.2
- 1.11	**30**	86.0
- 0.56	**31**	87.8
0	**32**	89.6
0.56	**33**	91.4
1.11	**34**	93.2
1.67	**35**	95.0
2.22	**36**	96.8
2.78	**37**	98.6
3.33	**38**	100.4
3.89	**39**	102.2
4.44	**40**	104.0
5.00	**41**	105.8
5.56	**42**	107.6
6.11	**43**	109.4
6.67	**44**	111.2
7.22	**45**	113.0
7.78	**46**	114.8
8.33	**47**	116.6
8.89	**48**	118.4
9.44	**49**	120.2
10.0	**50**	122.0
10.6	**51**	123.8
11.1	**52**	125.6
11.7	**53**	127.4
12.2	**54**	129.2
12.8	**55**	131.0
13.3	**56**	132.8
13.9	**57**	134.6
14.4	**58**	136.4
15.0	**59**	138.2
15.6	**60**	140.0
16.1	**61**	141.8
16.7	**62**	143.6
17.2	**63**	145.4
17.8	**64**	147.2
18.3	**65**	149.0
18.9	**66**	150.8
19.4	**67**	152.6
20.0	**68**	154.4
20.6	**69**	156.2
21.1	**70**	158.0
21.7	**71**	159.8
22.2	**72**	161.6
22.8	**73**	163.4
23.3	**74**	165.2
23.9	**75**	167.0
24.4	**76**	168.8
25.0	**77**	170.6
25.6	**78**	172.4
26.1	**79**	174.2
26.7	**80**	176.0
27.2	**81**	177.8
27.8	**82**	179.6
28.3	**83**	181.4
28.9	**84**	183.2
29.4	**85**	185.0
30.0	**86**	186.8
30.6	**87**	188.6
31.1	**88**	190.4
31.7	**89**	192.2
32.2	**90**	194.0
32.8	**91**	195.8
33.3	**92**	197.6
33.9	**93**	199.4
34.4	**94**	201.2
35.0	**95**	203.0
35.6	**96**	204.8
36.1	**97**	206.6
36.7	**98**	208.4
37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.
38	**100**	212
43	**110**	230
49	**120**	248
54	**130**	266
60	**140**	284
66	**150**	302
71	**160**	320
77	**170**	338
82	**180**	356
88	**190**	374
93	**200**	392
99	**210**	410
100	**212**	413.6
104	**220**	428
110	**230**	446
116	**240**	464
121	**250**	482
127	**260**	500
132	**270**	518
138	**280**	536
143	**290**	554
149	**300**	572
154	**310**	590
160	**320**	608
166	**330**	626
171	**340**	644
177	**350**	662
182	**360**	680
188	**370**	698
193	**380**	716
199	**390**	734
204	**400**	752
210	**410**	770
216	**420**	788
221	**430**	806
227	**440**	824
232	**450**	842
238	**460**	860
243	**470**	878
249	**480**	896
254	**490**	914
260	**500**	932
266	**510**	950
271	**520**	968
277	**530**	986
282	**540**	1004
288	**550**	1022
293	**560**	1040
299	**570**	1058
304	**580**	1076
310	**590**	1094
316	**600**	1112
321	**610**	1130
327	**620**	1148
332	**630**	1166
338	**640**	1184
343	**650**	1202
349	**660**	1220
354	**670**	1238
360	**680**	1256
366	**690**	1274
371	**700**	1292
377	**710**	1310
382	**720**	1328
388	**730**	1346
393	**740**	1364
399	**750**	1382
404	**760**	1400
410	**770**	1418
416	**780**	1436
421	**790**	1454
427	**800**	1472
432	**810**	1490
438	**820**	1508
443	**830**	1526
449	**840**	1544
454	**850**	1562
460	**860**	1580
466	**870**	1598
471	**880**	1616
477	**890**	1634
482	**900**	1652
488	**910**	1670
493	**920**	1688
499	**930**	1706
504	**940**	1724
510	**950**	1742
516	**960**	1760
521	**970**	1778
527	**980**	1796
532	**990**	1814
538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Purgex Purging Compounds

Minimize Purge Time - Maximize Production Time

- Effectively cleans and removes residual contamination from barrels, screws, check valves, extrusion dies, cold or hot runner systems, melt pumps and accumulators
- Fast, efficient color, resin and tooling changeovers
- Eliminates black specks and streaking
- Reduces scrap – you will manufacture more good parts to sell!

Continued on next page

Select your process, resin and temperature to find your Purgex Grade

Products	Purgex 456 Plus	Purgex 457 Plus	Purgex 459 Plus	Purgex 461
Process				
Injection Molding	•	•	•	
Injection Blow Molding	•	•	•	
Extrusion: Blow Molding	•	•	•	
Extrusion: Profile	•	•	•	
Extrusion: Coumpounding		•	•	
Extrusion: Sheet	•	•	•	•
Blown Film				•
Primary Application	General Purpose	General Purpose and Filled Resins	Automotive Interiors and General Purpose	Blown Film
Works best on Resins:	PP-Copolymer, PP-Homopolymer, PVC-Flexible, LDPE, HDPE	ABS, HDPE, PVC-Rigid, PU, PP-Copolymer, PP-Homopolymer, PMMA	PP-Copolymer, PC/ABS,TPOs, TPEs	LDPE, LLDPE
Also Useful For:	TPEs, TPOs, PVC-Rigid, Startup, Shutdown, many other resins processed in this temperature range	Nylon, PC/ABS, Startup, Shutdown, PE, PVC-Flexible, TPOs, LDPE, TPEs, PBT, many other resins processed in this temperature range	ABS, Nylon, Startup, Shutdown, HDPE, PP-Homopolymer, PVC-Rigid, PVC-Flexible, many other resins processed in this temperature range	
Amount Needed				
Amount	1 to 1.5 times barrel capacity, depending on condition of machine/tool and colorant/additive loading			Use 15 lbs of Purgex™ 461 per 100 lbs of throughput Note: After use on a regular basis, the amount used to purge can often be reduced by 25 to 50%
Temperature Range				
Fahrenheit / Celsius	380°F - 550°F / 193°C to 288°C			250°F - 450°F / 120°C -232°C
Recommended For:				
Hot Runners	•	•	•	
Cold Runners	•	•	•	
Mixing Nozzles	•	•	•	
Extrusion: Dies	•	•	•	•
Check Valves	•	•	•	
Melt Pumps	•	•	•	•
Accumulators		•	•	
100lb Item # & Price	122704: $385.51	127906: $390.35	169540: $403.25	168663: $503.26
1000lb Item # & Price	131191: $3,516.34	131876: $3,564.73	169836: $3,709.90	169837: $4,548.66

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Purgex Purging Compounds

Minimize Purge Time - Maximize Production Time

Continued from previous page

- Thorough cleaning of melt pumps and is safely processed though dies as small as .030" (0.75mm)
- Active components in most Purgex grades neutralize acid gases generated by PVC or polystyrene carriers
- With regular use, Purgex forms a temporary barrier which protects steel surfaces from oxidation, extending the cleaning process

Scoop not included -See page 591

Products	Purgex 602 Plus	Purgex 742	Purgex 3056 Plus	Purgex 3057 Plus
Process				
Injection Molding	•	•	•	•
Injection Blow Molding				
Extrusion: Blow Molding				
Extrusion: Profile				
Extrusion: Coumpounding			•	•
Extrusion: Sheet			•	•
Blown Film				
Primary Application	Clear Resins	Automotive Interiors Polypropylene Copolymers	Engineering Resins and General Purpose	Engineering Resins and Glass Filled
Works best on Resins:	PC, PS, SAN	PP-Copolymer, TPOs, PE	Nylon, PBT, POM	Nylon, PBT, POM, PET, PPO, PPA
Also Useful For:		PP-Homopolymer, HDPE, LDPE	PVC-Flexible, PVC-Rigid, Startup, Shutdown, PET, PPO, PPA, many other resins processed in this temperature range	PVC-Flexible, PVC-Rigid, Startup, Shutdown, many other resins processed in this temperature range
Amount Needed				
Amount	1 to 1.5 times barrel capacity, depending on condition of machine/ tool and colorant/ additive loading	1 barrel capacity, depending on condition of machine/tool and colorant/additive loading	1 to 1.5 times barrel capacity, depending on condition of machine/tool and colorant/additive loading	
Temperature Range				
Fahrenheit / Celsius	360°F to 550°F / 183°C to 288°C	375°F - 475°F / 191° C to 246° C	380°F - 600°F / 193°C - 316°C	
Recommended For:				
Hot Runners	•	•	•	•
Cold Runners	•	•	•	•
Mixing Nozzles	•	•	•	•
Extrusion: Dies			•	•
Check Valves	•	•	•	•
Melt Pumps			•	•
Accumulators				
100lb Item # & Price	161951: $661.33	169838: $409.70	122705: $409.70	129493: $424.22
1000lb Item # & Price	131009: $6,290.70	167122: $3,613.12	131877: $3,790.55	132085: $3,919.59

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Please refer to imscompany.com for current pricing

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Purge Hopper

Simplifies the Loading of Purging Compounds

- **Lightweight**
- **Portable**
- **Durable**
- **Easy to install**
- **Inexpensive**

Looking for a better way to feed purger into your machines?

IMS Temporary Purge Hoppers are just what you need. Use them on any machine with a 1.5” diameter or larger feed opening. Powerful magnets hold the hopper in place. They’re lightweight yet durable and very inexpensive.

IMS Purge Hoppers also work well on 55 gallon drums for applications such as waste oil.

Three Neodenium magnets helps hold hopper in place

Specifications	
Capacity:	12 lbs. polyethylene
Construction:	High density polyethylene
Color:	White
Weight:	10.88 oz.

Item #	Description
127716	Purge Hopper

Plastic Resin Scoops

#132787

#132788

#146497

Item	Size	Style	Color
132787	32 oz	Flat Bottom	White
132788	82 oz	Flat Bottom	White
146497	128 oz	Flat Bottom	White

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Made in the U.S.A

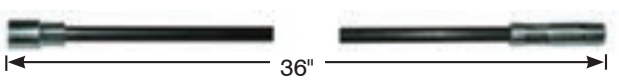
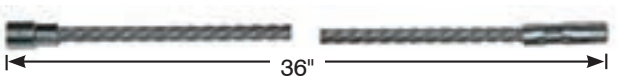
Heavy Duty Barrel Cleaning Brushes

For Easy, Thorough Cleaning of Internal Barrel Surfaces

- High-carbon steel bristles
- Double stem, double spiral design

Specifications and Prices

Bristle Diameter: 0.012"
Brush Length: 4½"
Overall Length: 7½"

Item #	Brush Diameter	NPT	Item #	Brush Diameter	NPT
Standard					
101012	¾"	¼"	100941	3"	¼"
100981	1"	¼"	101117	3¼"	¼"
100949	1¼"	¼"	101086	3½"	¼"
101127	1½"	¼"	101057	3¾"	¼"
101094	1¾"	¼"	101028	4"	¼"
101063	2"	¼"	100996	4½"	¼"
101034	2¼"	¼"	100963	5¼"	¼"
101003	2½"	¼"	101142	6"	¼"
100972	2¾"	¼"	112376	all 17 Standard Brushes	
Metric					
119802	14mm	5/16"-18	100944	40mm	¼"
140255	15mm	5/16"-18	101031	45mm	¼"
119796	16mm	5/16"-18	101000	50mm	¼"
101076	18mm	¼"	100969	55mm	¼"
140256	20mm	¼"	100937	57mm	¼"
101017	22mm	¼"	101113	60mm	¼"
100986	24mm	¼"	101083	65mm	¼"
100954	25mm	¼"	101025	69mm	¼"
101122	27mm	¼"	100992	70mm	¼"
101132	28mm	¼"	100961	80mm	¼"
101099	30mm	¼"	101139	90mm	¼"
101067	32mm	¼"	101105	105mm	¼"
101040	35mm	¼"	101074	115mm	¼"
101008	36mm	¼"	101046	135mm	¼"
100976	38mm	¼"			
Drill Extension Rods (for all except 119802, 140255, 119796)					
101035	3' fiberglass		101004	3' twisted steel	
					
For 119802, 140255, 119796					
101128	Extension (5/16"-18 thread 24" length)		101064	T-handle only	
101095	Extension (5/16"-18 thread 36" length)				

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Silicone Grease

Ideal nozzle and screw tip thread lubricant

Apply Where Copper Or Graphite-Based Compounds Cannot Be Used

It's Clear & Clean Won't Carbonize

It's also an effective mold release for epoxy, polystyrene, PVC and polyester resins when spot lubrication is necessary

Other Features

- Inert to metals, plastics and most organic materials
- Insoluble in water, methyl or ethyl alcohol, glycerol or mineral oil
- Moisture resistant
- Good chemical stability

Specifications

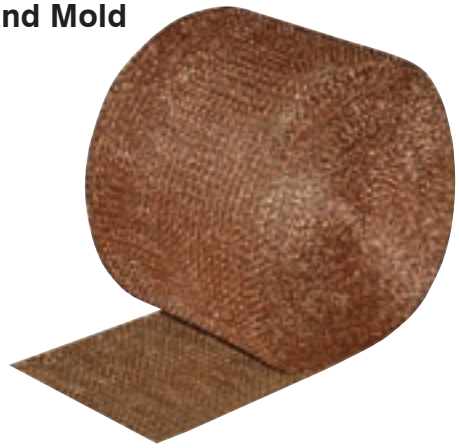
- Temperature Range: -40° to +400° F
- FDA rated 21CFR 178.3570 and 175.300
- Color: White to Translucent
- Non-Melting
- Low Volatility
- High Dielectric Strength

Item #	Description
172095	Silicone Grease (4.5 oz. tube)

Copper Gauze

For Safe Cleaning of Screw, Barrel and Mold

- Reversible – medium grade mesh on the outside – turn gauze inside out for heavier cleaning coarse mesh
- Safe, soft copper will not mar surfaces
- Knitted mesh keeps flat wire on edge for scraping
- Tough, interlocking loops will not pull apart
- Pure Copper - will not rust or contaminate
- Non-flammable - will not burn, smoke or spark



Specifications and Prices

Outside Cleaning Grit: Medium
Inside Cleaning Grit: Coarse
Width: 5"
Ribbon Dimensions: 0.003" x .0.015"

Item #	Description
123300	Copper Gauze (100' roll)
122990	Copper Gauze (400' roll)

Also See IMS High Heat - Copper Flake Thread Lube • Page 521

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GREEN Products

IMS Heat Transfer and Anti-Seize Compounds

SAFEKOTE 60™

An affordable, high heat compound for continuous use up to 600°F

- Eliminates trouble- causing air pockets
- Distributes heat more uniformly
- Reduces scale and oxidation
- Helps prevent seizing and galling

Specifications

Melting point of Copper:	1981° F
***Max. Continuous Service Temp. for Carrier Medium:**	600°F – For Cartridge Heaters and Threads (not exposed to air)

Also an excellent anti-seize compound for use on end cap bolts, and nozzle and screw tip threads.

Item # Description

130787	12-oz. jar SAFEKOTE 60™ complete with brush top

INFRA-KOTE

Both excellent heat transfer compounds for use with cartridge heaters and heater bands.

Improve surface contact between heaters and equipment, extending heater life, providing better response times and reducing energy costs.

Limited use heat transfer compound formulated for continuous use up to 350°F

- Prolongs heater life
- Cuts energy costs
- Ensures consistent heat transfer
- Facilitates heater removal

Specifications

Melting point of Copper:	1981° F
Melting point of Aluminum:	1220° F
Melting point of Graphite:	in air, 750°F to 1100°F in a reduced oxygen environment, 6700°F
Max. Continuous Service Point:	350°F
Grease Media Decomposition:	550°F

Item # Description

103781	16-oz. jar Infra-Kote with brush top

Available ONLY from IMS!

SAFEKOTE 60™ is a trademark of IMS Company

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Components & Supplies

Mold & Die Maintenance

Mold Bushings
Pages 594 – 596

Mold Pins
Pages 597 – 603

Mold Supplies
Pages 604 – 605

Compression Springs
Pages 606 – 614

Most items IN STOCK for Same Day Shipment

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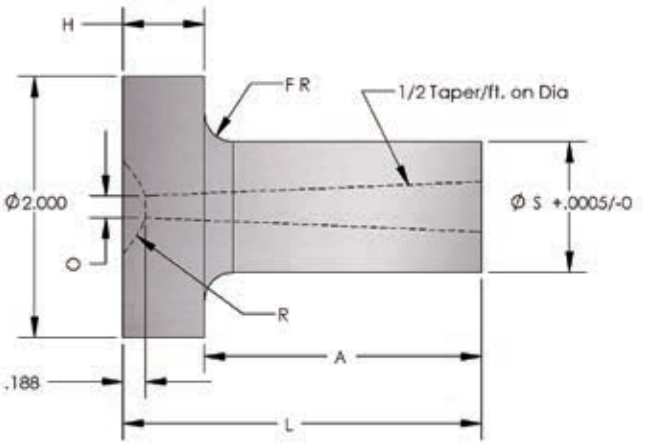
Made in the U.S.A

Sprue Bushings - AB Series



S (Shank)	H (Head)	F	O	A	L	Catalog Number R=½	Catalog Number R=¾
0.75	0.875	0.125	5/32	29/32	1 25/32	155022	155040
				1 13/32	2 9/32	155023	155041
				1 29/32	2 25/32	155024	155042
				2 13/32	3 9/32	155025	155043
				2 29/32	3 25/32	155026	155044
				3 13/32	4 9/32	155027	155045
			7/32	29/32	1 25/32	155028	155046
				1 13/32	2 9/32	155029	155047
				1 29/32	2 25/32	155030	155048
				2 13/32	3 9/32	155031	155049
				2 29/32	3 25/32	155032	155050
				3 13/32	4 9/32	155033	155051
			9/32	29/32	1 25/32	155034	155052
				1 13/32	2 9/32	155035	155053
				1 29/32	2 25/32	155036	155054
				2 13/32	3 9/32	155037	155055
				2 29/32	3 25/32	155038	155056
				3 13/32	4 9/32	155039	155057

S (Shank)	H (Head)	F	O	A	L	Catalog Number R=½	Catalog Number R=¾
1	0.875	0.25	9/32	29/32	1 25/32	155094	155112
				1 13/32	2 9/32	155095	155113
				1 29/32	2 25/32	155096	155114
				2 13/32	3 9/32	155097	155115
				2 29/32	3 25/32	155098	155116
				3 13/32	4 9/32	155099	155117
				3 29/32	4 25/32	155100	155118
				4 29/32	5 25/32	155101	155119
				5 29/32	6 25/32	155102	155120
			11/32	29/32	1 25/32	155103	155121
				1 13/32	2 9/32	155104	155122
				1 29/32	2 25/32	155105	155123
				2 13/32	3 9/32	155106	155124
				2 29/32	3 25/32	155107	155125
				3 13/32	4 9/32	155108	155126
				3 29/32	4 25/32	155109	155127
				4 29/32	5 25/32	155110	155128
				5 29/32	6 25/32	155111	155129

S (Shank)	H (Head)	F	O	A	L	Catalog Number R=½	Catalog Number R=¾
1	0.875	0.25	5/32	29/32	1 25/32	155058	155076
				1 13/32	2 9/32	155059	155077
				1 29/32	2 25/32	155060	155078
				2 13/32	3 9/32	155061	155079
				2 29/32	3 25/32	155062	155080
				3 13/32	4 9/32	155063	155081
				3 29/32	4 25/32	155064	155082
				4 29/32	5 25/32	155065	155083
				5 29/32	6 25/32	155066	155084
			7/32	29/32	1 25/32	155067	155085
				1 13/32	2 9/32	155068	155086
				1 29/32	2 25/32	155069	155087
				2 13/32	3 9/32	155070	155088
				2 29/32	3 25/32	155071	155089
				3 13/32	4 9/32	155072	155090
				3 29/32	4 25/32	155073	155091
				4 29/32	5 25/32	155074	155092
				5 29/32	6 25/32	155075	155093

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-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
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3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
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54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Nitrided Ejector Pins

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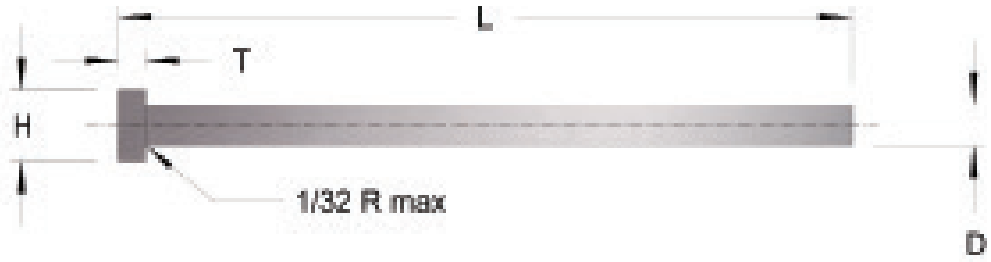

Tolerances	
Pin Diameter (D)	+.0000 -.0004
Head Diameter (H)	+.000 -.010
Head Thickness (T)	+.000 -.002
Length (L)	+.062 -.000

D	H	T	Length (L)										
			6	10		14		18		25	36	39	45
			std dia	std dia	.005 oversize	std dia	.005 oversize	std dia	.005 oversize	std dia			
3/64	5/32	1/8	152854										
1/16	3/16	1/8	152855	157633	157635	160221							
5/64	13/64	1/8	152856	157634	157636								
3/32	7/32	1/8	152857	152858									
7/64	15/64	1/8	152859	152860	157638								
1/8	1/4	1/8	152732	152733	152734	152735	152736	152880		152879			
9/64	1/4	1/8		152737		152738							
5/32	9/32	5/32	152744	152745	152746	152747	152748	152749		152881	152885		
11/64	11/32	3/16		152750		152751							
3/16	3/8	3/16	152752	152739	152753	152754	152755	152756		152741		152865	
13/64	3/8	3/16		152757		152758							
7/32	13/32	3/16		152760	152761	152762				152763			
15/64	13/32	3/16				152765				152882			
1/4	7/16	3/16	152766	152742	152767	152768	152769	152770	152771	152772	152874	152866	
17/64	7/16	1/4		152773		152774				152775			
9/32	7/16	1/4	152776		152778	152779		152780		152781			
19/64	1/2	1/4				152783							
5/16	1/2	1/4	152784	152785	152786	152787	152788	152728	152789	152790	152875	152867	
21/64	9/16	1/4		152791		152792				152793			
11/32	9/16	1/4	152794		152796	152797				152798			
23/64	5/8	1/4		152799		152800							
3/8	5/8	1/4	152801	152743	152802	152803	152804	152729	152805	152806	152864	152868	152890
13/32	11/16	1/4	152807		152809	152810		152811		152812			
7/16	11/16	1/4	152813		152815	152816	152817	152818		152819	152876	152869	
15/32	3/4	1/4			152826	152878		152827		152828			
1/2	3/4	1/4	152829	152830	152831	152832	152833	152820		152821	152863	152870	152889
9/16	13/16	1/4	152822	152823		152824		152834		152835			
5/8	7/8	1/4	152836	152837		152838		152730		152731	152877	152871	
11/16	15/16	1/4		152839		152883		152840		152841			
3/4	1	1/4	152842	152740		152843		152844		152845	152862	152872	152891
7/8	1 1/8	1/4		152846		152884		152847		152848			
1	1 1/4	1/4	152849	152850		152851		152852		152853	152861	152873	

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Nitrided Ejector Pins - Shoulder

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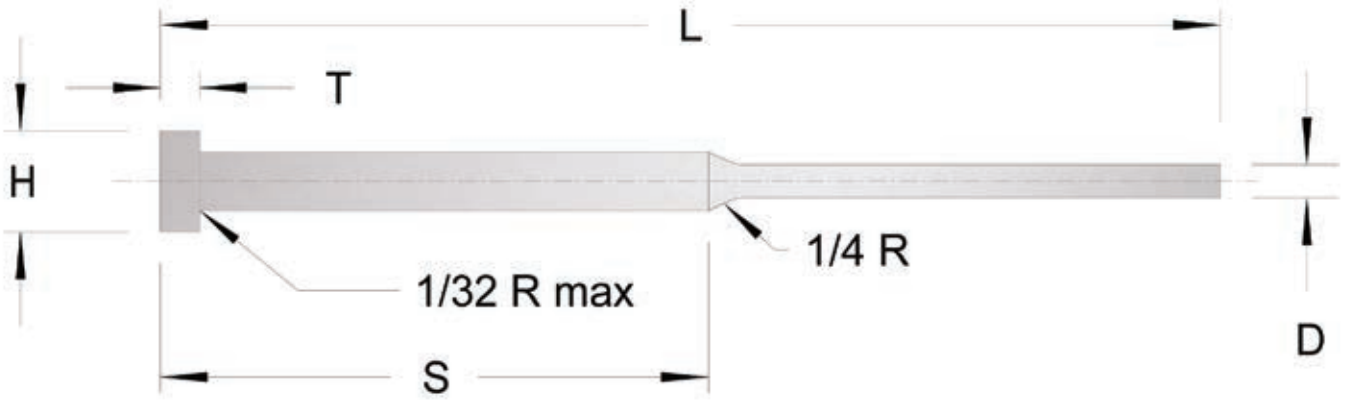

Tolerances	
Pin Diameter (D)	+.000 -.001
Shoulder Diameter (1/8)	+.000 -.003
Head Diameter (H)	+.000 -.003
Head Thickness (T)	+.000 -.002
Length (L)	+.062 -.000

D	H	T	S	L=6	L=10		L=14
Pin dia	Head Dia	Head Thick	Shoulder Length	D std	D std	D .005 oversize	D std
3/64	1/4	1/8	1/2	152892	152893	152894	
			2	152895	152896	152897	152898
1/16	1/4	1/8	1/2	152899	152900	152901	
			2	152902	152903	152904	152905
5/64	1/4	1/8	1/2	152906	152907	152908	
			2	152909	152910	152911	152912
3/32	1/4	1/8	1/2	152913	152914	152915	
			2	152916	152917	152918	152919
7/64	1/4	1/8	1/2	152920	152921	152922	
			2	152923	152924	152925	152926

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Through Hardened Ejector Pins

Materials: 1.2344 (H-13)
Hardness: Core: 50-52 Rc; Surface: 65-70 Rc

D	H	T	Available Lengths					
+0/-.0003	+0/-.010	+0/-.002	4	6	8	10	12	14
1/32	1/8	1/8	153328	153329				
3/64	5/32	1/8	153330	153331				
1/16	3/16	1/8	153332	153333	153334	153335		
5/64	13/64	1/8	153336	153337	153338	153339		
3/32	7/32	1/8	153340	153341	153342	153343		
7/64	15/64	1/8	153344	153345	153346	153347		
1/8	1/4	1/8	153348	153349	153350	153351	153352	153353
9/64	1/4	1/8	153354	153355		153356		153357
5/32	9/32	5/32	153358	153359	153360	153361	153362	153363
11/64	11/32	3/16	153364	153365		153366		153367
3/16	3/8	3/16	153368	153369	153370	153371	153372	153373
13/64	3/8	3/16	153374	153375		153376		153377
7/32	13/32	3/16	153378	153379	153380	153381	153382	153383
15/64	13/32	3/16	153384	153385		153386		153387
1/4	7/16	3/16	153388	153389	153390	153391	153392	153393
17/64	7/16	1/4	153394	153395		153396		153397
9/32	7/16	1/4	153398	153399	153400	153401		153402
19/64	1/2	1/4	153403	153404		153405		153406
5/16	1/2	1/4	153407	153408	153409	153410	153411	153412
21/64	9/16	1/4	153413	153414		153415		153416
11/32	9/16	1/4	153417	153418		153419		153420
23/64	5/8	1/4	153421	153422		153423		153424
3/8	5/8	1/4	153425	153426	153427	153428	153429	153430
25/64	37/64	1/4	153431	153432		153433		153434
13/32	11/16	1/4	153435	153436		153437		153438
27/64	11/16	1/4	153439	153440		153441		153442
7/16	11/16	1/4	153443	153444		153445		153446
29/64	45/64	1/4	153447	153448		153449		153450
15/32	3/4	1/4	153451	153452		153453		153454
31/64	3/4	1/4	153455	153456		153457		
1/2	3/4	1/4	153458	153459	153460	153461	153462	153463
17/32	25/32	1/4	153464	153465		153466	153467	153468
9/16	13/16	1/4	153469	153470	153471	153472	153473	153474
5/8	7/8	1/4	153475	153476	153477	153478	153479	153480
11/16	15/16	1/4	153481	153482	153483	153484	153485	153486
3/4	1	1/4	153487	153488	153489	153490	153491	153492
7/8	1 1/8	1/4	153493	153494	153495	153496	153497	153498
1	1 1/4	1/4	153499	153500	153501	153502	153503	153504

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Nitrided Ejector Pins - Metric (DIN 1530A)

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Materials: 1.2344 (H-13)

Hardness: Core: 40 - 44 Rc; Surface: 68-72 Rc

D g6	H +0/-.02	T +0/-.05	Available Lengths										
			100	125	160	200	250	315	400	500	630	800	1000
1.5	3	1.5	153505	153506	153507	153508	153509	153510					
2	4	2	153514	153515	153516	153517	153518	153519	153520				
2.2			153521	153522	153523	153524	153525	153526	153527				
2.5	5		153530	153531	153532	153533	153534	153535					
2.7			153536	153537	153538	153539		153540	153541				
3	6	3	153544	153545	153546	153547	153548	153549	153550	153551	153552	153553	
3.2			153556	153557	153558	153559	153560	153561	153562	153563	153564	153565	
3.5	7		153568	153569	153570	153571	153572	153573	153574				
3.7			153575	153576	153577	153578	153579	153580	153581	153582	153583		
4	8		153586	153587	153588	153589	153590	153591	153592	153593	153594	153595	
4.2			153597	153598	153599	153600	153601	153602	153603	153604	153605	153606	
4.5			153609	153610	153611	153612	153613	153614	153615		153616		
5	10		153619	153620	153621	153622	153623	153624	153625	153626	153627	153628	
5.2			153630	153631	153632	153633	153634	153635	153636	153637	153638	153639	
5.5			153643	153644	153645	153646	153647	153648	153649	153650			
6	12	5	153655	153656	153657	153658	153659	153660	153661	153662	153663	153664	153665
6.2			153667	153668	153669	153670	153671	153672	153673	153674	153675	153676	
6.5			153677	153678	153679	153680	153681	153682	153683	153684			
7			153688	153689	153690	153691	153692	153693	153694	153695	153696	153697	153698
8	14		153703	153704	153705	153706	153707	153708	153709	153710	153711	153712	153713
8.2			153718	153719	153720	153721	153722	153723	153724	153725	153726	153727	153728
8.5			153731	153732	153733	153734	153735	153736	153737	153738	153739		
9			153740	153741	153742	153743	153744	153745	153746	153747	153748	153891	
10	16		153751	153752	153753	153754	153755	153756	153757	153758	153759	153760	153761
10.2			153765	153766	153767	153768	153769	153770	153771	153772	153773	153774	
10.5			153775	153776	153777	153778	153779	153780	153781	153782	153783		
11			153784	153785	153786	153787	153788	153789	153790	153791	153792		
12	20	7	153793	153794	153795	153796	153797	153798	153799	153800	153801	153802	153803
12.2			153806	153807	153808	153809	153810	153811	153812	153813	153814	153815	153816
12.5			153817	153818	153819	153820	153821	153822	153823	153824	153825	153826	
14	22		153827	153828	153829	153830	153831	153832	153833	153834	153835	153836	153837
16			153841	153842	153843	153844	153845	153846	153847	153848	153849	153850	153851
18	24				153856	153857	153858	153859	153860	153861	153862	153863	153864
20	26	8			153865	153866	153867	153868	153869	153870	153871	153872	153873
25	32	10				153875	153876	153877	153878	153879	153880	153881	153882
32	40					153883	153884	153885	153886	153887	153888	153889	153890

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Through Hardened Ejector Pins - Metric (DIN 1530AH)

Hardness: 58-62 Rc

D g6	H +0/-.02	T +0/-.05	Available Lengths							
			100	125	160	200	250	315	400	500
1	2.5	1.2	154476	154477	154478	154479				
1.1			154480	154481	154482					
1.2			154483	154484	154485	154486				
1.3	3	1.5			154487					
1.4			154488	154489	154490					
1.5			154475	154492	154493		154495	154496		
1.6			154497	154498	154499					
1.7			154501							
1.8			154502	154503	154504					
1.9			154505		154506					
2	4	2	154510	154511	154512	154513	154514	154515		
2.1			154516	154517	154518					
2.2			154519	154520	154521	154522	154523			
2.3			154524	154525	154526	154527				
2.4			154528	154529	154530					
2.5	5		154531	154532	154533	154534	154535	154536	154537	
2.6			154538	154539	154540	154541				
2.7			154542	154543	154544	154545	154546	154547		
2.8			154548	154549	154550					
2.9			154551	154552	154553					
3	6	3	154557	154558	154559	154560	154561	154562	154563	154564
3.1			154565	154566	154567					
3.2			154568	154569	154570	154571	154572	154573		
3.3			154574	154575	154576					
3.4			154577	154578	154579					
3.5	7		154580	154581	154582	154583	154584	154585	154586	
3.6			154587	154588	154589					
3.7			154590	154591	154592	154593	154594	154595		
3.8			154596	154597	154598	154599				
3.9			154600	154601	154602					
4	8		154606	154607	154608	154609	154610	154611	154612	154613
4.1			154614	154615	154616					
4.2			154618	154619	154620	154621	154622	154623	154624	
4.3			154625	154626	154627					
4.4			154628	154629	154630	154631				
4.5			154632	154633	154634	154635	154636	154637	154638	

continued on next page

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Through Hardened Ejector Pins - Metric (DIN 1530AH)

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continued from last page

D g6	H +0/-.02	T +0/-.05	Available Lengths									
			100	125	160	200	250	315	400	500	630	800
4.6	8	3	154639	154640	154641	154642						
4.7			154643	154644	154645	154646	154647					
4.8			154648	154649	154650							
4.9			154651	154652	154653							
5	10		154657	154658	154659	154660	154661	154662	154663	154664		
5.1			154665	154666	154667							
5.2			154668	154669	154670	154671	154672	154673	154674			
5.3			154675	154676	154677		154678					
5.4			154679	154680	154681							
5.5			154682	154683	154684	154685	154686	154687	154688	154689		
5.6			154690	154691	154692	154693						
5.7			154694	154695	154696							
5.8			154697	154698	154699							
5.9			154700	154701	154702							
6	12	5	154706	154707	154708	154709	154710	154711	154712	154713	154714	
6.1			154715	154716	154717							
6.2			154718	154719	154720	154721	154722	154723	154724	154725		
6.3			154726	154727	154728							
6.4			154729	154730	154731							
6.5			154732	154733	154734	154735	154736	154737				
6.6			154738	154739	154740							
6.7			154741	154742	154743							
6.9			154747	154748	154749							
7			154750	154751	154752	154753	154754	154755	154756			
7.2			154757	154758	154759	154760						
7.5			154761	154762	154763	154764						
8	14		154767	154768	154769	154770	154771	154772	154773	154774	154775	
8.2			154777	154778	154779	154780	154781	154782	154783			
8.5			154784	154785	154786	154787	154788	154789				
9			154790	154791	154792	154793	154794	154795				
9.5			154796	154797	154798	154799						
10	16		154801	154802	154803	154804	154805	154806	154807	154808	154809	154810
10.2			154811	154812	154813	154814	154815	154816	154817			
10.5			154818	154819	154820	154821	154822	154823	154824			
11			154825	154826	154827	154828	154829	154830	154831			
12	18	7	154833	154834	154835	154836	154837	154838	154839	154840	154841	154842
12.2			154843	154844	154845	154846	154847	154848				
12.5			154849	154850	154851	154852	154853	154854				
13.5	22					154855						
14			154856	154857	154858	154859	154860	154861	154862	154863		
16			154864	154865	154866	154867	154868	154869	154870	154871	154872	
18			154873	154874	154875	154876	154877	154878	154879	154880		
20	26	8			154881	154882	154883	154884	154885	154886	154887	154888

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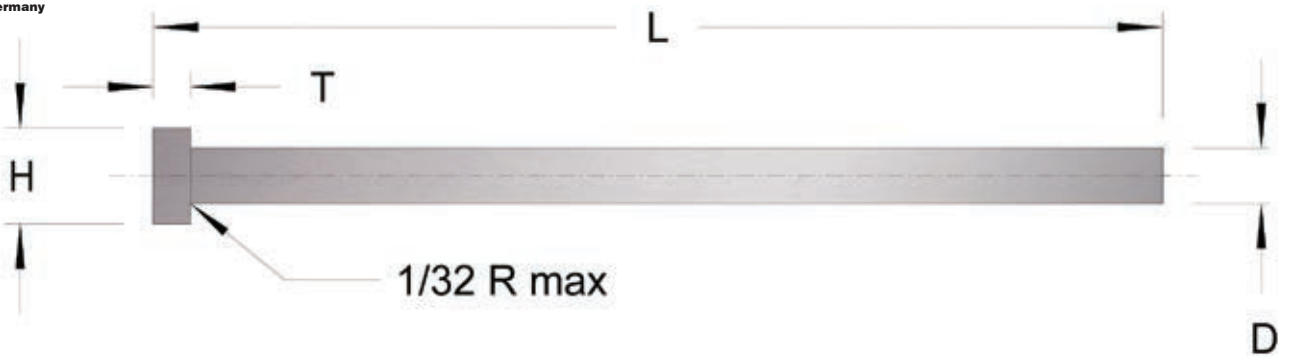
Core Pins

Precision Made in Germany



Tolerances	
Pin Diameter (D)	+.001 -.000
Head Diameter (H)	+.000 -.010
Head Thickness (T)	+.000 -.002
Length (L)	+.030 -.000

Standard Hardness Rc 30 - 35					
D Pin Dia	H Head Dia	T Head Thick	Catalog Number		
			L = 3	L = 6	L = 10
3/32	1/4	1/8	153182	153183	153184
7/64	1/4	1/8	153185	153186	153187
1/8	1/4	1/8	153188	153189	153190
9/64	1/4	1/8	153191	153192	153193
5/32	9/32	5/32	153194	153195	153196
11/64	11/32	3/16	153197	153198	153199
3/16	3/8	3/16	153200	153201	153202
13/64	3/8	3/16	153203	153204	153205
7/32	13/32	3/16	153206	153207	153208
1/4	7/16	3/16	153209	153210	153211
9/32	7/16	1/4	153212	153213	153214
5/16	1/2	1/4	153215	153216	153217
11/32	9/16	1/4	153218	153219	153220
3/8	5/8	1/4	153221	153222	153223
13/32	11/16	1/4	153224	153225	153226
7/16	11/16	1/4	153227	153228	153229
15/32	3/4	1/4	153230	153231	153232
1/2	3/4	1/4	153233	153234	153235
9/16	13/16	1/4		153236	153237
5/8	7/8	1/4		153238	153239
3/4	1	1/4		153240	153241

High Hardness Rc 50 - 55					
D Pin Dia	H Head Dia	T Head Thick	Catalog Number		
			L = 3	L = 6	L = 10
3/32	1/4	1/8	153242	153243	153244
7/64	1/4	1/8		153246	153247
1/8	1/4	1/8	153248	153249	153250
9/64	1/4	1/8		153252	153253
5/32	9/32	5/32		153255	153256
11/64	11/32	3/16		153258	153259
3/16	3/8	3/16	153260	153261	153262
13/64	3/8	3/16		153264	153265
7/32	13/32	3/16		153267	153268
1/4	7/16	3/16	153269	153270	153271
9/32	7/16	1/4		153273	153274
5/16	1/2	1/4		153276	153277
11/32	9/16	1/4		153279	153280
3/8	5/8	1/4	153281	153282	153283
13/32	11/16	1/4		153285	153286
7/16	11/16	1/4		153288	153289
15/32	3/4	1/4		153291	153292
1/2	3/4	1/4	153293	153294	153295
9/16	13/16	1/4		153296	153297
5/8	7/8	1/4		153298	153299
3/4	1	1/4		153300	153301

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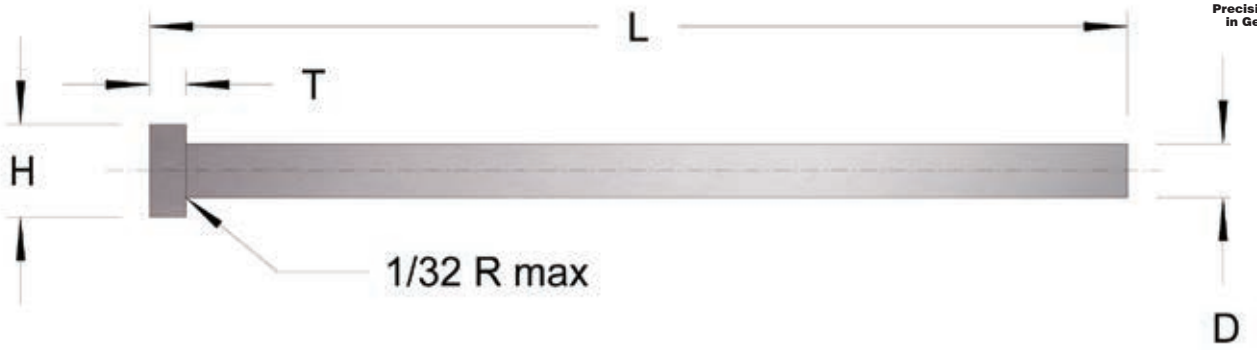
Return Pins

Precision Made in Germany



Nitrided to Rc 65-80 and polished to a surface finish of 4-5 micron.

L	1/2	5/8	3/4
3 9/16	153302		
4 1/16	153303	153309	
4 9/16	153304	153310	
4 15/16			153318
5 1/16	153305	153311	
5 7/16			153319
5 9/16	153306	153312	
5 15/16			153320
6 1/16	153307	153313	
6 7/16			153321
6 9/16	153308	153314	
6 15/16			153322
7 1/16		153315	
7 7/16			153323
7 9/16		153316	
7 15/16			153324
8 1/16		153317	
8 7/16			153325
8 15/16			153326
9 7/16			153327
D	.500	.625	.750
H	.750	.875	1.00
T	.250	.250	.250

Tolerances	
Pin Diameter (D)	+.000 -.001
Head Diameter (H)	+.000 -.010
Head Thickness (T)	+.000 -.002
Length (L)	+.013 -.008

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Check out these other Useful Products from IMS!

Heavy Duty Mold Lifting Slings

Avoid Damage to Molds, Barrels and Feed Screws From Chains and Cables

Rugged, Sewn, Woven Nylon Web, Double Ply construction

Vertical Lift Capacity

1" Wide Sling: up to 3,200 lbs
2" Wide Sling: up to 6,400 lbs
3" Wide Sling: up to 8,800 lbs
4" Wide Sling: up to 11,500 lbs

See Page 30 For More Information

Made in the U.S.A

Chain Slings

For More Versatile Help With Heavy Duty Lifting Applications

- **Made of Grade 100 Alloy Steel -** for maximum abrasion and corrosion resistance
- **Meets ASME B30.9 OSHA & NACM Standards**
- Grade 100 has 25% greater work load limit than grade 80
- User can experience more work load limit with a smaller diameter chain based on the application
- Grade 100 reduces overall wear on the links and extends the life of the chain

See Page 29 For More Information

IMS Select

Mold Handling Latch (G.A.I.M. T.O.I.™)

(Pronounced Game Toy) by G.A.I.M. Engineering

GREEN Products

Keeps Mold Halves Together For Safe Handling

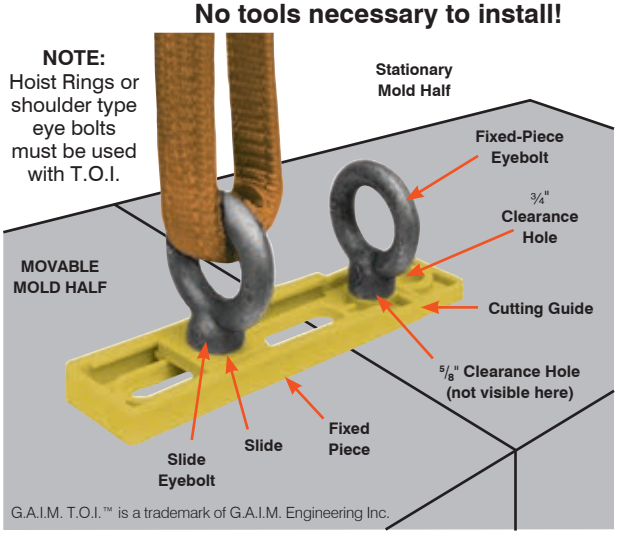
- Avoid costly damage to your molds during installation, removal, transporting or storage
- Cost much less than conventional, custom strapping systems
- Can be moved from one mold to another

Made of 100% Recycled Reinforced Nylon

See Page 31 For More Information

No tools necessary to install!

NOTE: Hoist Rings or shoulder type eye bolts must be used with T.O.I.



G.A.I.M. T.O.I.™ is a trademark of G.A.I.M. Engineering Inc.

Check out these other Useful Products from IMS!

Original Formula® Mold Grease

Long Lasting Lubricant with PTFE — Good to 500°F

Made in the U.S.A

Forms an adherent, but slippery film. Won't wipe off through tight bushings.

- Superior strength and load bearing ability
- Superior lubricity -40° F to +500° F
- Waterproof
- Anticorrosive
- Non-melting
- Non-silicone
- NSF listed

NSF Nonfood Compounds H2

The Original and Still the Best!™

See Page 146 For More Information

IMS Paintable Ejector Pin Lube L T

Made for use on knock-out pins in forward position

IMS Paintable Ejector Pin Lube LT is a clean, paintable, load-bearing lubricant designed for spraying on close-fitting knockout pins. The lubricant produces minimal part marking, won't bleed out and can be used in a -65°F to +350°F temperature range.

No Chlorinated Solvents

IMS White Lithium Lubricant Spray

Ideal for injection molds and most other industrial applications

- Sprays Like a Fluid – to Penetrate Into Tight Passages
- Thickens Into Grease – to Lubricate
- Medium-bodied Grease
- Moisture Proof, and Resists Most Chemicals and Acids

Replaces #127364

See Page 145 For More Information

Brass Mold Surface Cleaning Brushes

Designed to operate at high speeds, these brass brushes effectively clean large mold surfaces, producing polished results.

See Page 85 For More Information

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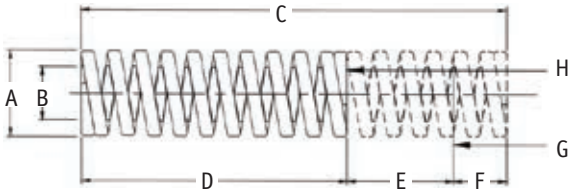
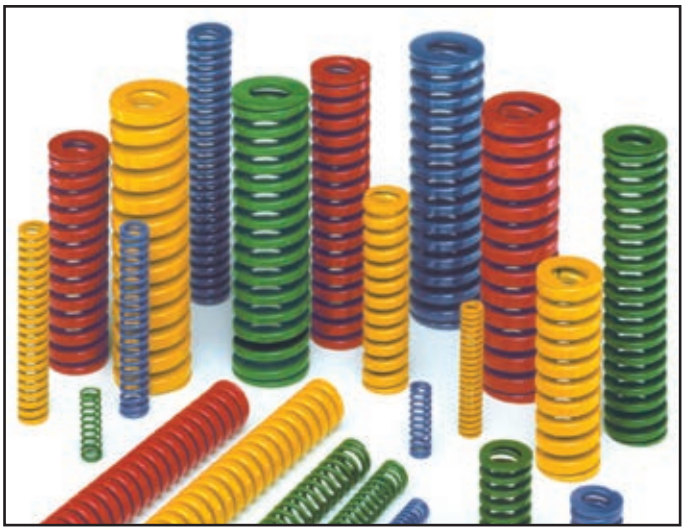
Die/Compression Springs



A = Hole diameter (in)
B = Rod diameter (in)
C = Free length (in)
D = Compression length (in)
E = Operating travel (in)
F = Initial compression (in)
G = Pre-load (lbs)
H = Load required to deflect E+F (lbs)



Tech Tips

Initial compression > 20% operating travel

Initial compression + operating travel < Maximum operating deflection

Catalog Number	Outside Diameter	Inside Diameter	Length	Load (lbs)	Deflect (in.)	Wire Construction
GREEN - Medium Load						
162096	3/8"	3/16"	1"	14	0.54	Round
162097			1¼"	13.6	0.68	Round
162098			1½	13.3	0.82	Round
162099			1¾"	13.2	0.97	Round
162100			2"	13.2	1.11	Round
162101			2½"	13	1.4	Round
162102			3"	12.6	1.66	Round
162103			12"	11.9	6.62	Round
162104	1/2"	9/32"	1"	27	0.53	Round
162105			1¼"	26	0.67	Round
162106			1½"	25.9	0.83	Round
162107			1¾"	25	0.96	Round
162108			2"	24.1	1.09	Round
162109			2½"	23.9	1.38	Round
162110			3"	23.9	1.67	Round
162111			3½"	23.5	1.96	Round
162112			12"	22.5	6.7	Round
162113	5/8"	11/32"	1"	54	53	Round
162114			1¼"	51.4	0.67	Round
162115			1½"	48.8	0.81	Round
162116			1¾"	46.9	0.94	Round
162117			2"	46.9	1.09	Round
162118			2½"	46.7	1.38	Round
162119			3"	45.1	1.65	Round
162120			3½"	44.8	1.94	Round
162121			4"	44.8	2.23	Round
162122			12"	42.9	6.75	Round
162123	3/4"	3/8"	1"	162	0.51	Rectangular
162124			1¼"	158	0.65	Rectangular
162125			1½"	150	0.78	Rectangular
162126			1¾"	150	0.92	Rectangular

continued on next page

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Die/Compression Springs (continued)

Catalog Number	Outside Diameter	Inside Diameter	Length	Load (lbs)	Deflect (in.)	Wire Construction
162127	¾"	⅜"	2"	150	1.06	Rectangular
162128			2½"	147	1.33	Rectangular
162129			3"	147	1.62	Rectangular
162130			3½"	144	1.87	Rectangular
162131			4"	144	2.16	Rectangular
162132			4½"	143	2.42	Rectangular
162133			5"	143	2.69	Rectangular
162134			5½"	143	2.9	Rectangular
162135			6"	143	3.26	Rectangular
162136			12"	140	6.48	Rectangular
162137	1"	½"	1"	311	0.51	Rectangular
162138			1¼"	299	0.65	Rectangular
162139			1½"	292	0.79	Rectangular
162140			1¾"	281	0.92	Rectangular
162141			2"	280	1.06	Rectangular
162142			2½"	270	1.32	Rectangular
162143			3"	265	1.59	Rectangular
162144			3½"	261	1.85	Rectangular
162145			4"	255	2.11	Rectangular
162146			4½"	254	2.37	Rectangular
162147			5"	254	2.65	Rectangular
162148			5½"	255	2.93	Rectangular
162149			6"	255	3.21	Rectangular
162150			7"	255	3.67	Rectangular
162151			8"	255	4.33	Rectangular
162152			12"	255	6.5	Rectangular
162153	1¼"	⅝"	1½"	433	0.75	Rectangular
162154			1¾"	415	0.87	Rectangular
162155			2"	411	1.01	Rectangular
162156			2½"	400	1.26	Rectangular
162157			3"	400	1.53	Rectangular
162158			3½"	400	1.8	Rectangular
162159			4"	397	2.07	Rectangular
162160			4½"	397	2.35	Rectangular
162161			5"	390	2.6	Rectangular
162162			5½"	386	2.86	Rectangular
162163			6"	383	3.11	Rectangular
162164			7"	377	3.63	Rectangular
162165			8"	375	4.14	Rectangular
162166			10"	369	5.15	Rectangular
162167			12"	366	6.18	Rectangular
162168	1½"	¾"	2"	609	1.01	Rectangular
162169			2½"	582	1.27	Rectangular
162170			3"	575	1.53	Rectangular
162171			3½"	572	1	Rectangular
162172			4"	565	2.07	Rectangular
162173			4½"	561	2.33	Rectangular
162174			5"	559	2.59	Rectangular
162175			5½"	559	2.88	Rectangular
162176			6"	549	3.12	Rectangular

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Die/Compression Springs (continued)

Catalog Number	Outside Diameter	Inside Diameter	Length	Load (lbs)	Deflect (in.)	Wire Construction
162177	1½"	¾"	7"	546	3.64	Rectangular
162178			8"	528	4.06	Rectangular
162179			10"	524	5.09	Rectangular
162180			12"	516	6.1	Rectangular
162181	2"	1"	2½"	1148	1.28	Rectangular
162182			3"	1098	1.53	Rectangular
162183			3½"	1076	1.8	Rectangular
162184			4"	1062	2.07	Rectangular
162185			4½"	1044	2.33	Rectangular
162186			5"	1029	2.58	Rectangular
162187			5½"	1029	2.86	Rectangular
162188			6"	1017	3.12	Rectangular
162189			7"	1007	3.65	Rectangular
162190			8"	984	4.15	Rectangular
162191			10"	978	5.2	Rectangular
162192			12"	960	6.23	Rectangular
162193	2½"	1½"	3"	1640	1.49	Rectangular
162194			3½"	1575	1.75	Rectangular
162195			4"	1528	2	Rectangular
162196			4½"	1490	2.25	Rectangular
162197			5"	1456	2.51	Rectangular
162198			6"	1440	3.02	Rectangular
162199			7"	1412	3.52	Rectangular
162200			8"	1390	4.03	Rectangular
162201			10"	1345	5.02	Rectangular
162202			12"	1330	6.02	Rectangular
			BLUE - Medium-High Load			
162203	⅜"	3/16"	1"	30.8	0.43	Round
162204			1¼"	30	0.54	Round
162205			1½"	29.3	0.65	Round
162206			1¾"	28.8	0.76	Round
162207			2"	28.4	0.87	Round
162208			2½"	28.3	1.1	Round
162209			3"	28	1.33	Round
162210			12"	27.6	5.42	Round
162211	½"	9/32"	1"	55.9	0.43	Round
162212			1¼"	54.9	0.55	Round
162213			1½"	54.6	0.67	Round
162214			1¾"	53.2	0.79	Round
162215			2"	53	0.91	Round
162216			2½"	52	1.15	Round
162217			3"	50.8	1.37	Round
162218			3½"	51.3	1.62	Round
162219			12"	50.5	5.72	Round
162220	⅝"	11/32"	1"	81	0.42	Round
162221			1¼"	75.8	0.53	Round
162222			1½"	74.8	0.65	Round
162223			1¾"	72.4	0.76	Round
162224			2"	70.7	0.87	Round
162225			2½"	69	1.1	Round

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Die/Compression Springs (continued)

Catalog Number	Outside Diameter	Inside Diameter	Length	Load (lbs)	Deflect (in.)	Wire Construction
162226	5/8"	11/32"	3"	68.1	1.33	Round
162227			3½"	67.9	1.56	Round
162228			4"	67.7	1.79	Round
162229			12"	66	5.5	Round
162230	¾"	⅜"	1"	227	0.44	Rectangular
162231			1¼"	212	0.55	Rectangular
162232			1½"	206	0.66	Rectangular
162233			1¾"	197	0.76	Rectangular
162234			2"	194	0.87	Rectangular
162235			2½"	189	1.09	Rectangular
162236			3"	186	1.31	Rectangular
162237			3½"	186	1.54	Rectangular
162238			4"	186	1.75	Rectangular
162239			4½"	184	1.98	Rectangular
162240			5"	184	2.21	Rectangular
162241			5½"	183	2.43	Rectangular
162242			6"	183	2.65	Rectangular
162243			12"	183	5.35	Rectangular
162244	1"	½"	1"	409	0.43	Rectangular
162245			1¼"	385	0.54	Rectangular
162246			1½"	367	0.65	Rectangular
162247			1¾"	366	0.77	Rectangular
162248			2"	366	0.89	Rectangular
162249			2½"	350	1.11	Rectangular
162250			3"	346	1.34	Rectangular
162251			3½"	336	1.55	Rectangular
162252			4"	333	1.77	Rectangular
162253			4½"	332	2	Rectangular
162254			5"	332	2.25	Rectangular
162255			5½"	332	2.48	Rectangular
162256			6"	322	2.7	Rectangular
162257			7"	330	3.14	Rectangular
162258			8"	326	3.58	Rectangular
162259			12"	320	5.35	Rectangular
162260	1¼"	⅝"	1½"	606	0.65	Rectangular
162261			1¾"	584	0.75	Rectangular
162262			2"	569	0.86	Rectangular
162263			2½"	531	1.06	Rectangular
162264			3"	514	1.27	Rectangular
162265			3½"	510	1.49	Rectangular
162266			4"	510	1.71	Rectangular
162267			4½"	510	1.94	Rectangular
162268			5"	510	2.18	Rectangular
162269			5½"	510	2.39	Rectangular
162270			6"	506	2.61	Rectangular
162271			7"	506	3.05	Rectangular
162272			8"	501	3.48	Rectangular
162273			10"	498	4.36	Rectangular
162274			12"	498	5.25	Rectangular

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Die/Compression Springs (continued)

Catalog Number	Outside Diameter	Inside Diameter	Length	Load (lbs)	Deflect (in.)	Wire Construction
162275	1½"	¾"	2"	809	0.83	Rectangular
162276			2½"	765	1.04	Rectangular
162277			3"	757	1.26	Rectangular
162278			3½"	736	1.47	Rectangular
162279			4"	733	1.69	Rectangular
162280			4½"	720	1.89	Rectangular
162281			5"	720	2.12	Rectangular
162282			5½"	720	2.33	Rectangular
162283			6"	714	2.55	Rectangular
162284			7"	709	2.99	Rectangular
162285			8"	707	3.42	Rectangular
162286			10"	707	4.33	Rectangular
162287			12"	703	5.17	Rectangular
162288	2"	1"	2½"	1272	1.05	Rectangular
162289			3"	1197	1.25	Rectangular
162290			3½"	1180	1.46	Rectangular
162291			4"	1180	1.7	Rectangular
162292			4½"	1180	1.93	Rectangular
162293			5"	1160	2.13	Rectangular
162294			5½"	1155	2.36	Rectangular
162295			6"	1160	2.59	Rectangular
162296			7"	1155	3.05	Rectangular
162297			8"	1140	3.47	Rectangular
162298			9"	1140	3.93	Rectangular
162299			10"	1140	4.39	Rectangular
162300			12"	1135	5.27	Rectangular
162301	2½"	1½"	3"	2240	1.29	Rectangular
161834			3½"	2160	1.52	Rectangular
162302			4"	2104	1.74	Rectangular
162303			4½"	2103	1.98	Rectangular
162304			5"	2080	2.22	Rectangular
162305			6"	2024	2.67	Rectangular
162306			7"	1987	3.12	Rectangular
162307			8"	1960	3.57	Rectangular
162308			9"	1960	4.06	Rectangular
162309			10"	1960	4.56	Rectangular
162310			12"	1960	5.4	Rectangular
		RED - Heavy Duty Load				
162311	⅜"	3/16"	1"	43	0.35	Round
162312			1¼"	43	0.46	Round
162313			1½"	42	0.55	Round
162314			1¾"	42	0.66	Round
162315			2"	42	0.75	Round
162316			2½"	42	0.97	Round
162317			3"	42	1.15	Round
162318			12"	41	4.74	Round
162319	½"	9/32"	1"	78	0.34	Round
162320			1¼"	76	0.44	Round
162321			1½"	74	0.53	Round
162322			1¾"	73	0.63	Round

continued on next page

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Die/Compression Springs (continued)

Catalog Number	Outside Diameter	Inside Diameter	Length	Load (lbs)	Deflect (in.)	Wire Construction
161981	½"	9/32"	2"	73	0.75	Round
162323			2½"	73	0.95	Round
162080			3"	73	1.15	Round
162324			3½"	73	1.33	Round
162325			12"	72	4.73	Round
162326	5/8"	11/32"	1"	170	0.34	Round
162327			1¼"	160	0.43	Round
162328			1½"	160	0.54	Round
162329			1¾"	151	0.63	Round
162330			2"	151	0.74	Round
162331			2½"	151	0.94	Round
162332			3"	151	1.15	Round
162333			3½"	151	1.37	Round
162334			4"	151	1.57	Round
162335			12"	150	4.83	Round
162336	¾"	3/8"	1"	436	0.33	Rectangular
162337			1¼"	418	0.42	Rectangular
162338			1½"	404	0.51	Rectangular
162339			1¾"	383	0.59	Rectangular
162340			2"	375	0.67	Rectangular
162341			2½"	377	0.86	Rectangular
162342			3"	373	1.03	Rectangular
162343			3½"	371	1.21	Rectangular
162344			4"	371	1.39	Rectangular
162345			4½"	371	1.58	Rectangular
162346			5"	371	1.75	Rectangular
162347			5½"	371	1.92	Rectangular
162348			6"	371	2.11	Rectangular
162349			12"	360	4.18	Rectangular
162350	1"	½"	1¼"	663	0.42	Rectangular
162351			1½"	639	0.51	Rectangular
162352			1¾"	642	0.61	Rectangular
162353			2"	638	0.71	Rectangular
162354			2½"	618	0.89	Rectangular
162355			3"	618	1.08	Rectangular
162356			3½"	618	1.28	Rectangular
162357			4"	618	1.47	Rectangular
162358			4½"	618	1.66	Rectangular
162359			5"	618	1.86	Rectangular
162360			5½"	618	2.06	Rectangular
162361			6"	618	2.24	Rectangular
162362			7"	618	2.62	Rectangular
162363			8"	618	3.02	Rectangular
162364			12"	618	4.6	Rectangular
162365	1¼"	5/8"	1½"	1052	0.49	Rectangular
162366			1¾"	1026	0.58	Rectangular
162367			2"	1007	0.67	Rectangular
162368			2½"	1004	0.86	Rectangular
162369			3"	985	1.04	Rectangular

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Die/Compression Springs (continued)

Catalog Number	Outside Diameter	Inside Diameter	Length	Load (lbs)	Deflect (in.)	Wire Construction
162370	1¼"	⅝"	3½"	973	1.23	Rectangular
162371			4"	974	1.41	Rectangular
162372			4½"	960	1.59	Rectangular
162373			5"	985	1.8	Rectangular
162374			5½"	965	1.97	Rectangular
162375			6"	965	2.15	Rectangular
162376			7"	960	2.52	Rectangular
162377			8"	947	2.87	Rectangular
162378			10"	960	3.65	Rectangular
162379			12"	951	4.36	Rectangular
162380	1½"	3/4”	2"	1388	0.69	Rectangular
162381			2½"	1350	0.88	Rectangular
162382			3"	1340	1.07	Rectangular
162383			3½"	1340	1.27	Rectangular
162384			4"	1333	1.47	Rectangular
162385			4½"	1340	1.69	Rectangular
162386			5"	1337	1.87	Rectangular
162387			5½"	1335	2.08	Rectangular
162388			6"	1347	2.28	Rectangular
162389			7"	1343	2.67	Rectangular
162390			8"	1347	3.07	Rectangular
162391			10"	1332	3.85	Rectangular
162392			12"	1339	4.65	Rectangular
162393	2"	1"	2½"	2080	0.86	Rectangular
162394			3"	2007	1.04	Rectangular
162395			3½"	1960	1.22	Rectangular
162396			4"	1960	1.43	Rectangular
162397			4½"	1960	1.63	Rectangular
162398			5"	1935	1.79	Rectangular
162399			5½"	1910	1.97	Rectangular
162400			6"	1910	2.15	Rectangular
162401			7"	1910	2.55	Rectangular
162402			8"	1910	2.91	Rectangular
162403			10"	1875	3.62	Rectangular
162404			12"	1875	4.45	Rectangular
YELLOW - Extra Heavy Duty Load						
162405	⅜"	3/16"	1"	62	0.33	Round
162406			1¼"	60	0.41	Round
162407			1½"	60	0.52	Round
162408			1¾"	60	0.6	Round
162409			2"	60	0.68	Round
162410			2½"	60	0.86	Round
162411			3"	60	1.05	Round
162412			12"	59	4.2	Round
162413	½"	9/32"	1"	119	0.35	Round
162414			1¼"	110	0.43	Round
162415			1½"	110	0.52	Round
162416			1¾"	110	0.61	Round
161982			2"	110	0.72	Round
162417			2½"	110	0.9	Round

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Die/Compression Springs (continued)

Catalog Number	Outside Diameter	Inside Diameter	Length	Load (lbs)	Deflect (in.)	Wire Construction
162081	½"	9/32"	3"	110	1.12	Round
162418			3½"	110	1.31	Round
162419			12"	108	4.47	Round
162420	5/8"	11/32"	1"	256	0.35	Round
162421			1¼"	230	0.43	Round
162422			1½"	221	0.51	Round
162423			1¾"	220	0.6	Round
162424			2"	220	0.71	Round
162425			2½"	218	0.88	Round
162426			3"	216	1.06	Round
162427			3½"	215	1.26	Round
162428			4"	215	1.45	Round
162429			12"	214	4.43	Round
162430	¾"	⅜"	1"	551	0.3	Rectangular
162431			1¼"	535	0.39	Rectangular
162432			1½"	535	0.48	Rectangular
162433			1¾"	529	0.57	Rectangular
162434			2"	527	0.66	Rectangular
162435			2½"	525	0.84	Rectangular
162436			3"	522	1.02	Rectangular
162437			3½"	516	1.19	Rectangular
162438			4"	508	1.36	Rectangular
162439			4½"	508	1.52	Rectangular
162440			5"	505	1.71	Rectangular
162441			5½"	505	1.87	Rectangular
162442			6"	505	2.04	Rectangular
162443			12"	505	4.16	Rectangular
162444	1"	½"	1¼"	799	0.4	Rectangular
162445			1½"	768	0.48	Rectangular
162446			1¾"	749	0.57	Rectangular
162447			2"	733	0.65	Rectangular
162448			2½"	735	0.84	Rectangular
162449			3"	720	1.01	Rectangular
162450			3½"	720	1.18	Rectangular
162451			4"	715	1.35	Rectangular
162452			4½"	715	1.55	Rectangular
162453			5"	715	1.72	Rectangular
162454			5½"	715	1.91	Rectangular
162455			6"	715	2.11	Rectangular
162456			7"	715	2.48	Rectangular
162457			8"	715	2.48	Rectangular
162458			12"	715	4.31	Rectangular
162459	1¼"	⅝"	1½"	1231	0.44	Rectangular
162460			1¾"	1225	0.53	Rectangular
162461			2"	1222	0.62	Rectangular
162462			2½"	1220	0.8	Rectangular
162463			3"	1200	0.97	Rectangular
162464			3½"	1195	1.15	Rectangular
162465			4"	1160	1.3	Rectangular

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Die/Compression Springs (continued)

Catalog Number	Outside Diameter	Inside Diameter	Length	Load (lbs)	Deflect (in.)	Wire Construction
162466	1¼"	⅝"	4½"	1160	1.46	Rectangular
162467			5"	1160	1.64	Rectangular
162468			5½"	1160	1.85	Rectangular
162469			6"	1160	2	Rectangular
162470			7"	1160	2.33	Rectangular
162471			8"	1160	2.69	Rectangular
162472			10"	1160	3.42	Rectangular
162473			12"	1160	4.14	Rectangular
162474	1½"	¾"	2"	1964	62	Rectangular
162476			3"	1834	0.95	Rectangular
162477			3½"	1802	1.12	Rectangular
162478			4"	1813	1.3	Rectangular
162479			4½"	1796	1.47	Rectangular
162480			5"	1779	1.64	Rectangular
162481			5½"	1774	1.81	Rectangular
162482			6"	1754	1.97	Rectangular
162483			7"	1733	2.31	Rectangular
162484			8"	1730	2.65	Rectangular
162485			10"	1730	3.35	Rectangular
162486			12"	1730	4.06	Rectangular
162487	2"	1"	2½"	3140	76	Rectangular
162488			3"	3013	0.92	Rectangular
162489			3½"	2929	1.08	Rectangular
162490			4"	2872	1.24	Rectangular
162491			4½"	2828	1.41	Rectangular
162492			5"	2794	1.57	Rectangular
162493			5½"	2790	1.75	Rectangular
162494			6"	2745	1.89	Rectangular
162495			7"	2712	2.21	Rectangular
162496			8"	2686	2.53	Rectangular
162497			10"	2653	3.18	Rectangular

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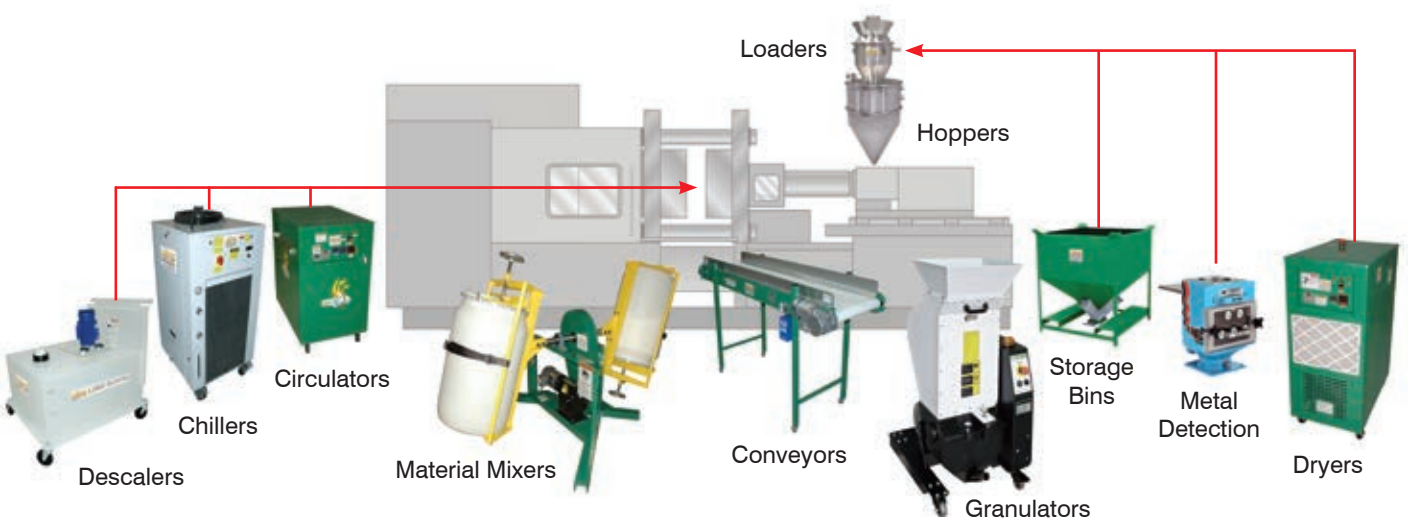

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Most items IN STOCK for Same Day Shipment

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Process Trouble-Shooting Guidelines				
Problem	CRYSTALLINE MATERIALS		AMORPHOUS MATERIALS	
	Lower/Reduce	Raise/Increase	Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

Converting Fractional Inches To Decimals And Millimeters

Fraction	Decimal	MM
1/64"	.015625”	0.3969
1/32"	.03125”	0.7938
3/64"	.046875”	1.1906
1/16"	.0625”	1.5875
5/64"	.078125”	2.3812
3/32"	.09375”	2.3812
7/64"	.109375”	2.7781
1/8"	125”	3.175
9/64"	.140625”	3.5719
5/32"	.15625”	3.9688
11/64"	.171875”	4.3656
3/16"	.1875”	4.7625
13/64"	.203125”	5.1594
7/32"	.21875”	5.5562
15/64"	.234375”	5.9531
1/4"	.25”	6.35
17/64"	.265625”	6.7469
9/32"	.28125”	7.1438
19/64"	.296875”	7.5401
5/16"	.3125”	7.9375
21/64"	.328125”	8.3344
11/32"	.34375”	8.7312
23/64"	.359375”	9.1281
3/8"	.375”	9.525
25/64"	.390625”	9.9219
13/32"	.40625”	10.3188
27/64"	.421875”	10.7156
7/16"	.4375”	11.1125
29/64"	.453125”	11.5094
15/32"	.46875”	11.9063
31/64"	.484375”	12.3031
1/2"	.5”	12.7

Fraction	Decimal	MM
33/64"	.515625”	13.0969
17/32"	.53125”	13.4938
35/64"	.546875”	13.8906
9/16"	.5625”	14.2875
37/64"	.578125”	14.6844
19/32"	.59375”	15.0812
39/64"	.609375”	15.4781
5/8"	.625”	15.875
41/64"	.640625”	16.2719
21/32"	.65625”	16.6688
43/64"	.671875”	17.0656
11/16"	.6875”	17.4625
45/64"	.703125”	17.8594
23/32"	.71875”	18.2563
47/64"	.734375”	18.6531
3/4"	.75”	19.05
49/64"	.765625”	19.4469
25/32"	.78125”	19.8438
51/64"	.796875”	20.2406
13/16"	.8125”	20.6375
53/64"	.828125”	21.0344
27/32"	.84375”	21.4312
55/64"	.859375”	21.8281
7/8"	.875”	22.225
57/64"	.890625”	22.6219
29/32"	.90625”	23.0188
59/64"	.921875”	23.4156
15/16"	.9375”	23.8125
61/64"	.953125”	24.2094
31/32"	.96875”	24.6062
63/64"	.984375”	25.0031
1"	1.0”	25.4

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IMS Select Portable Resin Bins

Ideal for the Storage and Transfer of Material

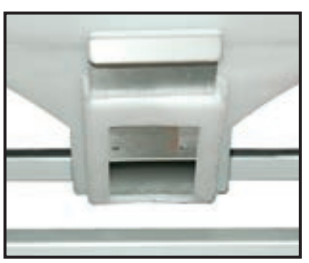
High density food grade polyethylene
- Increases durability and life of the bin, easy to clean

Plastic infused with anti-static additive
- Permits compatibility with most plastic resins

Translucent sides
- Easily allows visibility of material levels

Standard Features:
- Heavy duty welded steel frame, painted
- Pocket folder for data sheet
- Side vacuum tube port accepts wands up to 4" in diameter (except 75lb bin which is 2¼" dia.)
- Stainless steel slide gate for quick material evacuation
- Removable lid
- Light weight
- Fork lift capable

Stainless Steel Slide Gate



Portable!
Equipped with four heavy duty, non-marking casters

Stackable up to 3 High!*

*800 and 1200lb bins do not stack

Probe *not included*

75lb
#137951
includes Tube Sock

Pocket folder standard on all bins

158lb
#122649
includes Tube Cap

368lb
#122650
includes Tube Cap

800lb
#132633
includes Tube Cap

1,200lb
#129902
includes Tube Cap

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Portable Resin Bins (continued)

Specifications and Prices					
	75lb #137951	158lb #122649	368lb #122650	800lb #132633	1,200lb #129902
Capacity†:	2.3 cu. ft.	4½ cu. ft.	10½ cu. ft.	22.7 cu. ft.	34.2 cu. ft.
Dimensions:	18.8"w x 18.8"d x 30.1"h	23"w x 23"d x 37.6"h	31"w x 31"d x 42.8"h	37.5"w x 37.5"d x 52.4"h	43.5"w x 43.5"d x 56.7"h
Casters:	four, 4" locking swivel casters			two, 5" rigid/two, 5" locking swivel casters	
Ship Weight:	75 lbs.	90 lbs.	120 lbs.	250 lbs.	290 lbs.
Unit Price:	**$369.94**	**$512.15**	**$683.02**	**$1,229.32**	**$1,346.19**

Spare Parts		
147967	Caster, 4" Diameter, Flange Mount, Locking Swivel and Wheel for 137951, 122649, 122650	**$33.70**
128074	Caster, 4" Diameter, Stud Mount, Non-Locking Swivel, Locking Wheel for 137951, 122649, 122650	**37.50**
142811	Caster, 5" Diameter, Flange Mount, Locking Swivel and Wheel for 132633, 129902	**56.45**
142810	Caster, 5" Diameter, Flange Mount, Locking Fixed Wheel for 132633, 129902	**74.15**
142807	Lid for 137951 (75lb)	**Inquire**
142808	Lid for 122649 (158lb)	**42.90**
138237	Lid for 122650 (368lb)	**Inquire**
142809	Lid for 132633 (800lb)	**Inquire**
142083	Lid for 129902 (1,200lb)	**Inquire**

Optional Accessories		
150554	1.5" Diameter Tube Sock (seals out contaminants between vacuum tube) for bin 137951	**$22.05**
150555	2" Diameter Tube Sock for bin 137951	**22.05**
138215	1.5" Diameter Tube Sock for bins 122649, 122650, 132633 and 129902	**22.05**
138756	2" Diameter Tube Sock for bins 122649, 122650, 132633 and 129902	**22.05**
133871	Tube Cap 4" OD for Vacuum Tube	**3.25**
147578	Vacuum Tube, Plastic/Lexan for use with bin 137591	**Inquire**
138120	Vacuum Tube, Plastic/Lexan for use with bins 122649 and 122650	**Inquire**
147579	Vacuum Tube, Plastic/Lexan for use with bins 132633 and 129902	**Inquire**

†Capacity based on styrene Optional lid holders, push bars and handles available — Inquire

Other Optional Accessories

Stainless Steel and Aluminum Pick-Up Wands

Stainless Steel

Aluminum

Economical Aluminum

4 Types: Standard Wand, Standard Wand with Bag Protector, Adjustable Wand and Adjustable Wand with Bag Protector

From **1" to 4"** O.D. and **36" to 48"** L Starting at just **$61.39**

See page 668 for many more sizes and styles

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Resin Bin Loader Stand

Standard Features:

- Welded steel frame construction
- Telescoping loader mount - adjustable height
- Toe locking, swivel casters

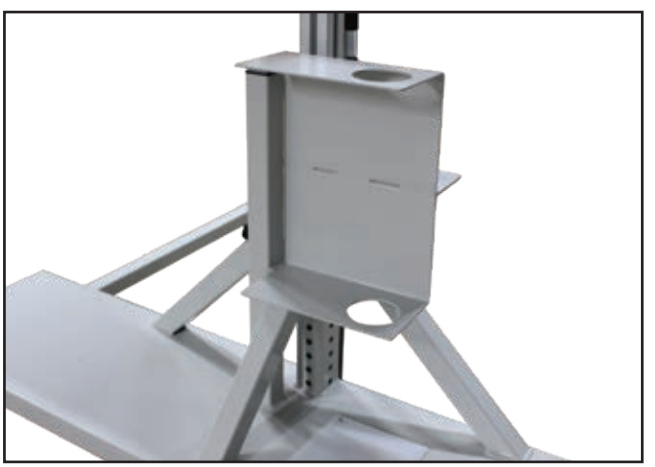
  - Loader Not Included

Complete with Ratchet-Type Safety Stop

Starting Price:

$1,795.00

Custom Order - Call For Information



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Converting Fractional Inches To Decimals And Millimeters

Fraction	Decimal	MM
1/64"	.015625”	0.3969
1/32"	.03125”	0.7938
3/64"	.046875”	1.1906
1/16"	.0625”	1.5875
5/64"	.078125”	2.3812
3/32"	.09375”	2.3812
7/64"	.109375”	2.7781
1/8"	125”	3.175
9/64"	.140625”	3.5719
5/32"	.15625”	3.9688
11/64"	.171875”	4.3656
3/16"	.1875”	4.7625
13/64"	.203125”	5.1594
7/32"	.21875”	5.5562
15/64"	.234375”	5.9531
1/4"	.25”	6.35
17/64"	.265625”	6.7469
9/32"	.28125”	7.1438
19/64"	.296875”	7.5401
5/16"	.3125”	7.9375
21/64"	.328125”	8.3344
11/32"	.34375”	8.7312
23/64"	.359375”	9.1281
3/8"	.375”	9.525
25/64"	.390625”	9.9219
13/32"	.40625”	10.3188
27/64"	.421875”	10.7156
7/16"	.4375”	11.1125
29/64"	.453125”	11.5094
15/32"	.46875”	11.9063
31/64"	.484375”	12.3031
1/2"	.5”	12.7

Fraction	Decimal	MM
33/64"	.515625”	13.0969
17/32"	.53125”	13.4938
35/64"	.546875”	13.8906
9/16"	.5625”	14.2875
37/64"	.578125”	14.6844
19/32"	.59375”	15.0812
39/64"	.609375”	15.4781
5/8"	.625”	15.875
41/64"	.640625”	16.2719
21/32"	.65625”	16.6688
43/64"	.671875”	17.0656
11/16"	.6875”	17.4625
45/64"	.703125”	17.8594
23/32"	.71875”	18.2563
47/64"	.734375”	18.6531
3/4"	.75”	19.05
49/64"	.765625”	19.4469
25/32"	.78125”	19.8438
51/64"	.796875”	20.2406
13/16"	.8125”	20.6375
53/64"	.828125”	21.0344
27/32"	.84375”	21.4312
55/64"	.859375”	21.8281
7/8"	.875”	22.225
57/64"	.890625”	22.6219
29/32"	.90625”	23.0188
59/64"	.921875”	23.4156
15/16"	.9375”	23.8125
61/64"	.953125”	24.2094
31/32"	.96875”	24.6062
63/64"	.984375”	25.0031
1"	1.0”	25.4

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Made in the U.S.A

Heavy Duty Mobile Storage Hoppers

For Intermediate Storage Between Bulk Bins and Your Machine

Provide Optimum Efficiency—Flexibility—Portability

Stackable! 3 high for a continuous flow of material

Save Time & Space

Also available in Stainless Steel

Other Bulk Densities Available - Call to Inquire

- **Construction:**
  - 14 gauge carbon steel hopper
  - 7 gauge carbon steel legs
  - 10 gauge carbon steel fork lift pockets
- **Hopper Capacity:**
  - Cubic Feet **20-60**
  - Pounds **700-2,100**
  - (based on material with a density of 35 lbs per cu.ft.)
  - (2,700 lb weight limit)

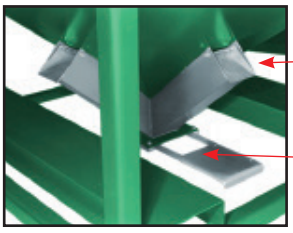


Photo shows two of four, 4" square entry ports for vacuum material removal. Contamination lids are provided for each port. Also shown is the adjustable slide gate shutoff for controlling hopper discharge.

Four way vacuum ports with contamination lids

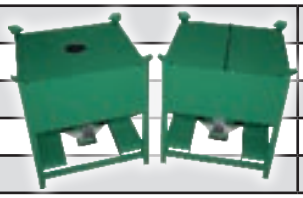
Large 4" locking slide gate with plastic guides ensure smooth operation.

*Note: 60° Hoppers feature a larger 6" slide gate for hard to flow material

Capacity		Dimensions				Discharge Style	Max Weight 45lbs per cu. ft.	Item #	Unit Price	Item #	Unit Price
Lbs	Cu. Ft.	L	W	H*(45˚)	H*(60˚)			45° Hopper Slope		60° Hopper Slope	
700	20	44"	44"	36"	43"	4 Ports & Slide Gate	900	**143855**	**$1,491.00**	**143856**	**$1,782.00**
700	20	44"	44"	30"	43"	Slide Gate Only†	900	**143860**	**1,376.00**	**143861**	**1,677.00**
1,050	30	44"	44"	46"	53"	4 Ports & Slide Gate	1350	**107934**	**1,589.00**	**129380**	**1,801.00**
1,050	30	44"	44"	40"	53"	Slide Gate Only†	1350	**143862**	**1,494.00**	**143863**	**1,787.00**
1,400	40	44"	44"	56"	63"	4 Ports & Slide Gate	1800	**137680**	**1,665.00**	**138754**	**1,869.00**
1,400	40	44"	44"	50"	63"	Slide Gate Only†	1800	**143864**	**1,626.00**	**143865**	**1,852.00**
1,750	50	44"	44"	66"	73"	4 Ports & Slide Gate	2250	**136279**	**1,859.00**	**143857**	**1,992.00**
1,750	50	44"	44"	60"	73"	Slide Gate Only†	2250	**142141**	**1,750.00**	**143866**	**1,917.00**
2,100	60	44"	44"	76"	83"	4 Ports & Slide Gate	2700	**143858**	**2,211.00**	**143859**	**2,240.00**
2,100	60	44"	44"	70"	83"	Slide Gate Only†	2700	**143867**	**1,980.00**	**143868**	**1,749.00**

*Add 3.5" for stacking pads for overall height †Does not include vacuum ports

Hopper Covers	#107918	One Piece with 8" Center Opening	**$364.00**
	#107904	Two Piece, Opens at Center with Piano Hinges	**227.00**
	#143851	Solid Lid	**220.00**
Caster Package	#133639	(2) 4" Swivel, (2) 4" Locking Casters (adds 1 7/16" to overall height)	**477.00**
Push Bar:	#143853	Used with Caster Package	**185.00**



Additional options available on page 625 — See Discharge Frames and Loading Platforms on page 634

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Please refer to imscompany.com for current pricing

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IMS Heavy Duty Mobile Storage Hoppers Quote Form

Specify:

1. **Quantity:** _____

2. **Capacity:** ❑ 700 lbs / 20 cu ft ❑ 1,050 lbs / 30 cu ft ❑ 1,400 lbs / 40 cu ft
❑ 1,750 lbs / 50 cu ft ❑ 2,100 lbs / 60 cu ft

3. **Slope Angle:** ❑ 45° ❑ 60°

4. **Vacuum Ports (4)** ❑ Yes ❑ No

5. **Covers** (No Cover STD):	Item #	Unit Price
❑ Hopper Cover – one piece	143851	**$193.00**
❑ Hopper Cover – one piece with 8" dia. hole	107918	**320.00**
❑ Hopper Cover – two piece, hinged	107904	**199.00**

6. **Slide Gates** (4" STD on 45˚ Hoppers):		
❑ 6" (STD on 60˚ Hoppers)	143871	**Inquire**
❑ 8"	143872	**Inquire**
❑ 10"	143873	**Inquire**

NOTE: Hoppers with slide gates larger than 4" can't have vacuum ports

7. **Distribution Box for vacuum removal:**

1 Hole	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**Inquire**
2 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**Inquire**
3 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**Inquire**

8. **Distribution Box Probe (required for Distribution Box):**
❑ 1.5" ❑ 2" ❑ 2.5" ❑ 3" ❑ 4" **Inquire**
NOTE: One probe required per distribution box hole

9. **Caster Package:** ❑ 133639 **RFQ**

10. **Paints/Coatings:**		
❑ Paint inside of hopper	143878	**$278.00**
❑ Epoxy coat inside of hopper (clear)	143877	**278.00**
❑ Paint outside (custom color)	143870	**298.00**

11. **Misc.**		
❑ 4-way fork-lift pockets (2-way STANDARD)	142836	**Inquire**
❑ Pallet Jack Option	143854	**Inquire**
❑ Push Bar (for when casters are installed)	143853	**$179.00**
❑ 52" high Discharge Stand	107859	**2,623.00**
❑ Loading Platform	107889	**Inquire**
❑ Grate Magnet	143852	**551.00**
❑ View Window	142837	**Inquire**
❑ Vibrator Mounting Pads	143876	**451.00**
❑ Removable Bag Break Grate	158358	**595.00**
❑ Lexan Card Holder	158382	**62.00**

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Made in the U.S.A

Heavy Duty Surge Bins

For Dry Bulk Material Storage

- 45° hopper slope for free flowing material or 60° hopper slope for material prone to bridging
- Bolt down foot pads - securely anchors bins to shop floor
- Hoppers and frames are constructed of 14-gauge carbon steel
- 1¼" half couplings with plugs standard - Allows addition of high & low level indicators
- Provides quick accessible in-plant storage of blended or virgin material

Common Specifications

- **Lid Door:** 12" x 14"; hinged
- **Lifting Lugs:** Four per bin
- **Windows:** One high / One low
- **Discharge:** 12" square

Also available in Stainless Steel

Capacity		Hopper Slope	Dimensions			Item #	Unit Price
Lbs	Cu. Ft.		L	W	H		
1008	29	45°	54"	54"	55.50"	144001	**$3,227.00**
1008	29	60°	54"	54"	64.25"	144002	**3,232.00**
1624	46	45°	54"	54"	68.50"	142709	**3,905.00**
1624	46	60°	54"	54"	77.25"	144003	**3,966.00**
2408	69	45°	60"	60"	77.50"	144004	**4,987.00**
2408	69	60°	60"	60"	87.75"	144005	**5,004.00**
3192	91	45°	60"	60"	91.50"	144006	**5,872.00**
3192	91	60°	60"	60"	101.75"	144007	**5,777.00**
4060	116	45°	60"	60"	106.50"	144008	**6,780.00**
4060	116	60°	60"	60"	116.75"	144009	**6,868.00**
4816	138	45°	72"	72"	97.50"	144010	**8,391.00**
4816	138	60°	72"	72"	110.75"	144011	**8,539.00**
5328	161	45°	72"	72"	107.50"	144012	**9,318.00**
5328	161	60°	72"	72"	120.75"	144013	**9,512.00**
6384	182	45°	72"	72"	116.50"	144014	**9,931.00**
6384	182	60°	72"	72"	129.75"	144015	**10,160.00**
7196	206	45°	72"	72"	126.50"	144016	**10,857.00**
7196	206	60°	72"	72"	139.75"	144017	**11,132.00**
8008	229	45°	72"	72"	136.50"	144018	**12,311.00**
8008	229	60°	72"	72"	149.75"	144019	**12,371.00**
9604	274	45°	84"	84"	129"	144020	**13,856.00**
9604	274	60°	84"	84"	145"	144021	**14,020.00**
11200	320	45°	84"	84"	143.25"	144022	**15,122.00**
11200	320	60°	84"	84"	159.25"	144023	**15,156.00**
12796	336	45°	84"	84"	157.75"	144024	**17,075.00**
12796	336	60°	84"	84"	173.50"	144025	**17,173.00**
14392	411	45°	84"	84"	172"	144026	**23,046.00**
14392	411	60°	84"	84"	188"	144027	**23,489.00**
16016	458	45°	84"	84"	186.50"	144028	**24,748.00**
16016	458	60°	84"	84"	202.25"	144029	**25,095.00**

***based on material with a density of 35 lbs per cu.ft. Specify custom dimensions for loader cut out and mounting holes (see next page)**

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Please refer to imscompany.com for current pricing

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IMS Heavy Duty Surge Bins Quote/Ordering Form

Specify:

1. **Quantity:** _____

2. **Capacity:**

❑ 1,008 lbs / 29 cu ft	❑ 4,060 lbs / 116 cu ft	❑ 7,196 lbs / 206 cu ft	❑ 12,796 lbs / 366 cu ft
❑ 1,624 lbs / 46 cu ft	❑ 4,816 lbs / 138 cu ft	❑ 8,008 lbs / 229 cu ft	❑ 14,392 lbs / 411 cu ft
❑ 2,408 lbs / 69 cu ft	❑ 5,328 lbs / 161 cu ft	❑ 9,604 lbs / 274 cu ft	❑ 16,016 lbs / 458 cu ft
❑ 3,192 lbs / 91 cu ft	❑ 6,384 lbs / 182 cu ft	❑ 11,200 lbs / 320 cu ft	

3. **Slope Angle:** ❑ 45° ❑ 60°

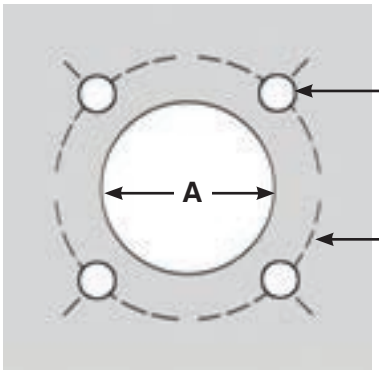
5. **Covers** (One piece with 12" x 14" lid door STANDARD):		**Loader Cut Out for Cover**
❑ Hopper Cover (Split ⅓, ⅔ design)	143879	**$552.00**
6. **Slide Gates:**		
❑ Manual	143881	**412.00**
❑ Gate & Drain (for 45° bins)	143882	**633.00**
❑ Gate & Drain (for 60° bins)	143883	**633.00**
❑ Gate & Drain (for 45° bins-butterfly)	143884	**746.00**
❑ Gate & Drain (for 60° bins-butterfly)	143885	**746.00**

7. **Distribution Box for vacuum removal:**

1 Hole	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**Inquire**
2 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**Inquire**
4 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**Inquire**
9 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**Inquire**
13 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**Inquire**

8. **Distribution Box Probe (required for Distribution Box):**
❑ 1.5" ❑ 2" ❑ 2.5" ❑ 3" ❑ 4" — **Inquire**
NOTE: One probe required per distribution box hole

9. **Indicator Panel** (Number of Bins):
❑ 1 ❑ 2 ❑ 3 ❑ 4. — **Inquire**



(**A**) Loader Cut Out Dia:

(**B**) Mounting Hole Dia:

(**C**) Number of Mounting Holes:

(**D**) Mounting Hole Pattern: _____

10. **Paints/Coatings:**		
❑ Clear epoxy coat inside of hopper (up to 72" x 72")	143891	**$647.00**
❑ Clear epoxy coat inside of hopper (84" x 84" or more)	143892	**$869.00**
❑ Paint outside (custom color)	143870	**293.00**
11. **Misc.**		
❑ 60" Flange to Floor Clearance (20" STD)	143888	**$743.00**
❑ 80" Flange to Floor Clearance (20" STD)	143889	**967.00**
❑ Grating inside bin (replaces cover)	143893	**1,008.00**
❑ Hatchway Door Air Filter	143886	**118.00**
❑ Additional View Windows (2 standard)	142837	**Inquire**
❑ Low Level Indicator (paddle blade style)	147688	**434.00**
❑ High Level Indicator (paddle blade style)	147689	**434.00**
❑ Level Indicator Flange (extra)	158380	**Inquire**

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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IMS Air Operated Floor Level Gaylord Tilters

Ensure a Steady, Uninterrupted Flow of Material to Your Loader

Safe & Reliable Performance

- Easy floor-level loading with pallet jack
- Tilt Actuator: Heavy Duty, Multi-Ply Rubber Air Bag
- Rugged, 7 gauge steel construction
- Virtually maintenance-free
- Easy access to all components
- No assembly needed, just connect your air supply

Standard† Ratchet-Type Safety

Stops tilter from crashing down if air pressure is lost.

Standard Only on IMS Tilters

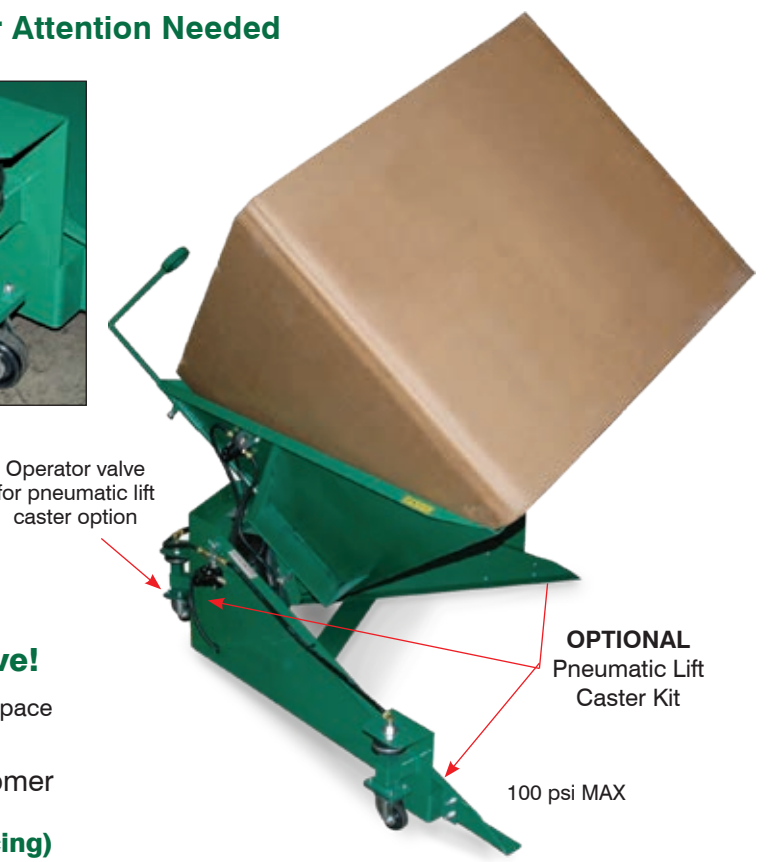
†Not included with #133309

Completely Automatic – No Operator Attention Needed

Optional Pneumatic Lift Caster Kit

- Allows for easy mobility throughout your facility for multiple jobs
- Raises/lowers empty tilter* with simple operational hand valve
- For mobility, air source can be disconnected after tilter is lifted

*Not intended to move full Gaylords



Easy to load and now easy to move!

"Provides flexibility — We don't lose valuable floor space when it is not in use."

– Valued Customer

(See next page for specifications and pricing)

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Please refer to imscompany.com for current pricing

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Air Operated Floor Level Gaylord Tilters

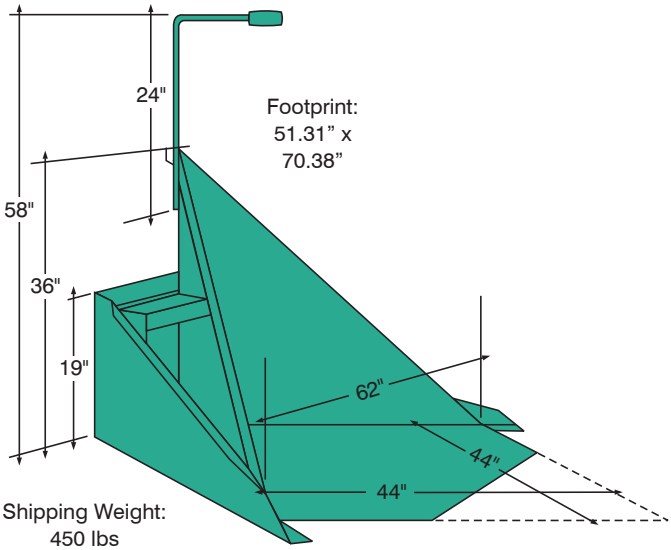
Made in the U.S.A

How They Work

Self-Balancing, Air Bag Design

Pre-adjusted air pressure: begins to tip the device only when the gaylord empties to about 900 lbs. The tilt angle automatically increases gradually until the gaylord is empty.

Accepts Most Gaylords



Shipping Weight:
450 lbs

Now 5 Models To Suit Your Needs And Budget!

Complete with Ratchet-Type Safety Stop

Item #115952

$3,177.00

#116291	Same as #115952 plus Air Vibrator (Recommended for acrylic & other hard-to-move materials)	**$3,983.00**
#116288	Same as #115952 plus Timer-Controlled Electric Vibrator (Recommended for acrylic & other hard-to-move materials)	**4,683.00**
#148081	Same as #115952 plus Pneumatic Lift Caster Kit (see previous page)	**4,594.00**
#133309	Same as #115952 without Ratchet-Type Safety Stop	**2,536.00**
#142851	Same as #133309 includes Pneumatic Vibrator	**3,343.00**

Specifications

- Air Pressure: 40 - 100 psi (tilter regulator locked at 43 psi)
- Pneumatic Control Unit: Includes UP/STOP/DOWN Switch, Pressure Regulator and Gauge
- Optional Vibrator: 120/60/1, 1.4 Amp
- Crated Size: 60"W x 72"L x 44"H

Bucket extension for extra large Gaylord available — Call to Inquire

See Gaylord Covers on Page 645

Retrofit Kits

#116246	For adding Ratchet-Type Safety Stop to IMS floor-level tipsters
#148243	For adding Pneumatic Lift Caster Kit to IMS floor-level tipsters
#129716	For adding Air Vibrator Assembly to IMS floor-level tipsters
#105989	For adding Electric Vibrator Assembly w/ Timer to floor-level tipsters

Spare Parts

#113001	Air Bag / Bladder
#132185	Wand Holder
#130790	Air Vibrator Assembly
#124995	Control Valve
#115879	Air Pressure Regulator
#125179	Timer

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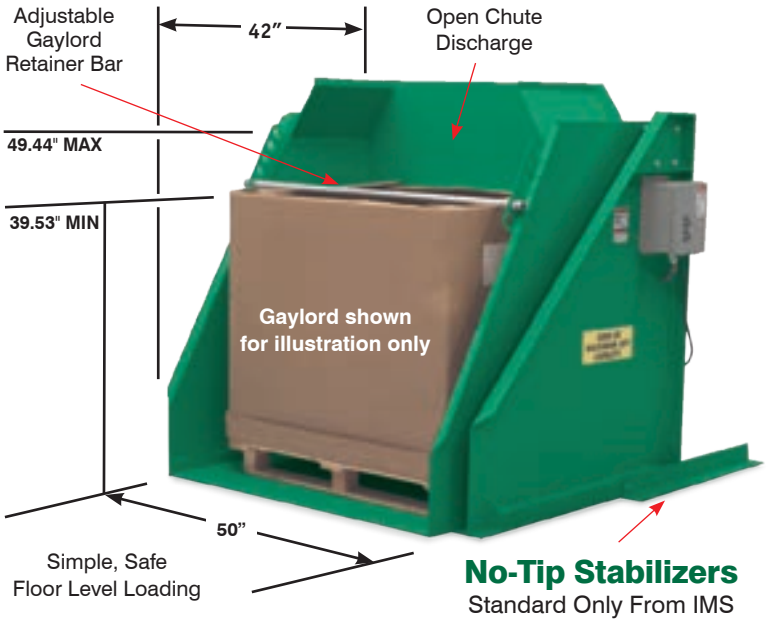
Made in the U.S.A

Hydraulic Gaylord/Box Dumper

Simplifies and Speeds the Transfer of Material From Gaylord to Mixers or Other Containers

- Top quality, certified components, plus heavy duty materials and construction
- Ensure long service life
- Stabilizers prevent tipping, even when dumper is not anchored to floor
- Increase safety and versatility

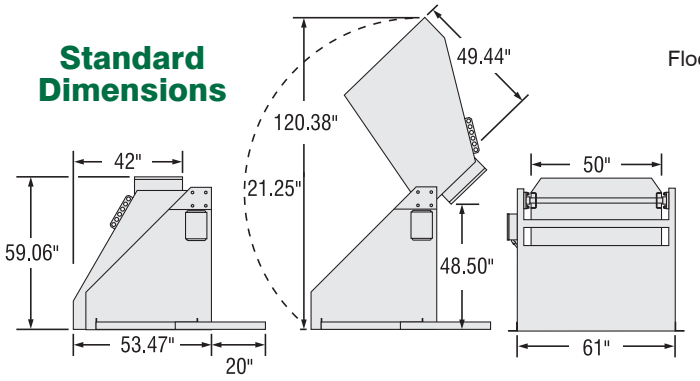


No-Tip Stabilizers
Standard Only From IMS

Specifications

- **Voltage:** 115/60/1 (standard), 230/60/3, 460/60/3
- **Amps:** 17.2 at 115V, 4.6 at 230V, 2.3 at 460V
- **Hydraulic Pump:** 1.5 hp, 1725 rpm, TEFC
- **Dump Cycle:** 40 seconds to rise, 35 seconds to lower
- **Crated Weight:** 2,750 lbs **Crated Size:** 7' l x 6' w x 6' h

Standard Dimensions



Item #117995 (115/60/1)
Item #148775 (230/60/1)
Item #133294 (230/60/3)
Item #134007 (460/60/3)

$10,995.00

Options

Other capacities, dump heights, dump speeds, dump chutes, voltages and higher cycle units available to order — **Inquire**

Spare Part		
Item #136642	1½ hp motor (115/60/1)	**Inquire**
Optional Accessory		
Item #136278	24" Riser (Dump Height: 72")	**Inquire**

Low cost risers can increase dump height from 48" up to 140"
NOTE: Dumpers on risers MUST be anchored bolted to the floor

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Please refer to imscompany.com for current pricing

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High Speed Hurricane™ Mixers

Keeps All The Pellets Moving All The Time!

Made in the U.S.A

Fast: Unique, Hurricane blending action cuts mixing time.

Portable: Mixers can be transported to material storage area, filled, operated, then delivered to any area of your plant by forklift.

Versatile: Entire mixer can be raised on a forklift for manual unloading or stacked on a support frame or hopper.

Consistent: Non-slip, direct drive, and automatic timer ensure complete color mixing every time.

Easy to Clean: Lift-Off Top and Removable Auger Assembly allow quick color/material changes.

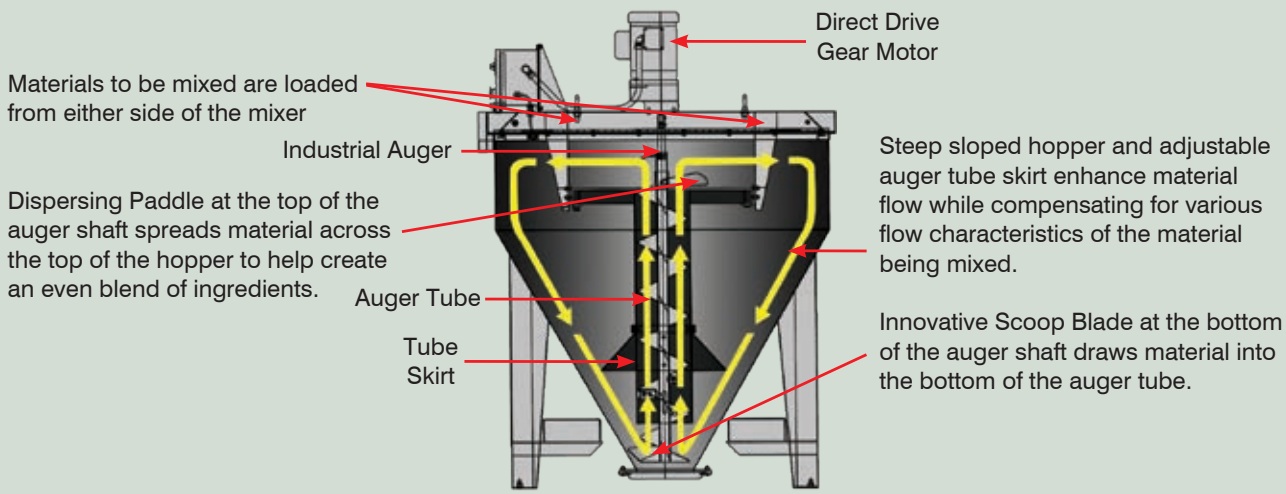
Every shop needs both a Drum Tumbler and a Hurricane Mixer

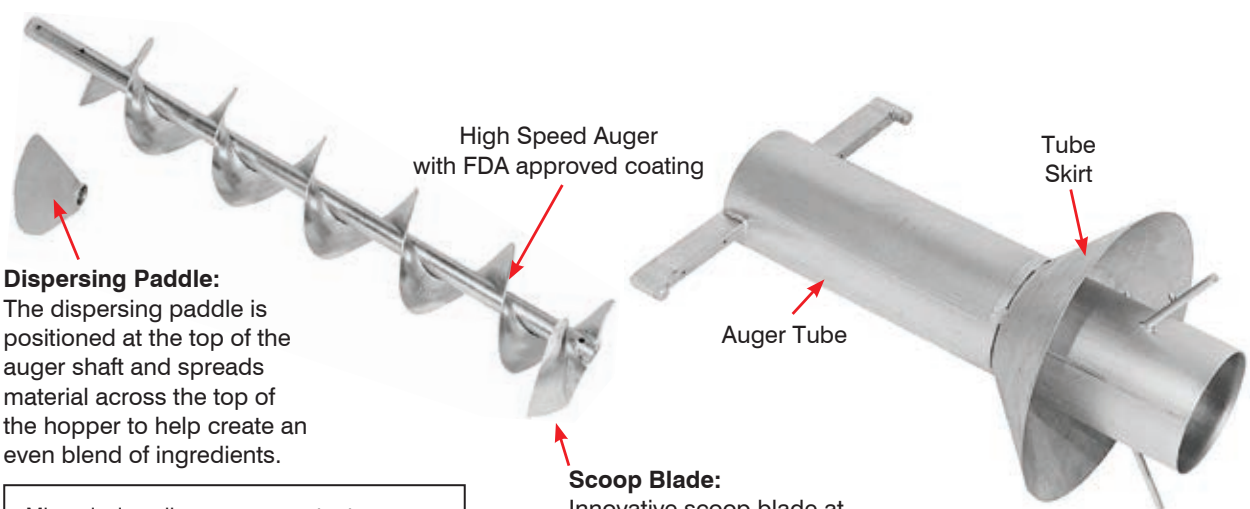
The Hurricane works faster for larger batches. It is ideal for mixing virgin with regrind and for coloring with concentrates. Cleanup is needed at color change, so use the Hurricane when you would not be changing color often. Not advised for dry-color use.

Drum Tumbler accept 1 or 2 drums at a time. It is good for dry-color mixing. Color and material changeover is a matter of changing drums.

Hurricane needs no cage. Easily moved by forklift, it offers a great deal of flexibility.

Now Available In 6 Sizes!





Dispersing Paddle:
The dispersing paddle is positioned at the top of the auger shaft and spreads material across the top of the hopper to help create an even blend of ingredients.

Mixer design allows one operator to remove entire auger assembly and completely clean the mixer in just minutes at material changes.

Scoop Blade:
Innovative scoop blade at the bottom of the auger shaft draws material into the bottom of the auger tube.

Hurricane™ is a trademark of IMS Company

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Made in the U.S.A

High Speed Hurricane™ Mixers

Fast, Safe & Consistent Pellet, Color & Additive Blending

Automatic Timer enables operator to do other jobs while materials mix

Direct Drive Gear Motor cuts energy costs

Lift-Off Top and Removable Auger Assembly allow quick cleanout for color material changes

Also available in Stainless Steel

Piano-hinged, center mounted covers allow loading from either side

Interlock Safety Switch turns unit off when covers are opened (not shown)

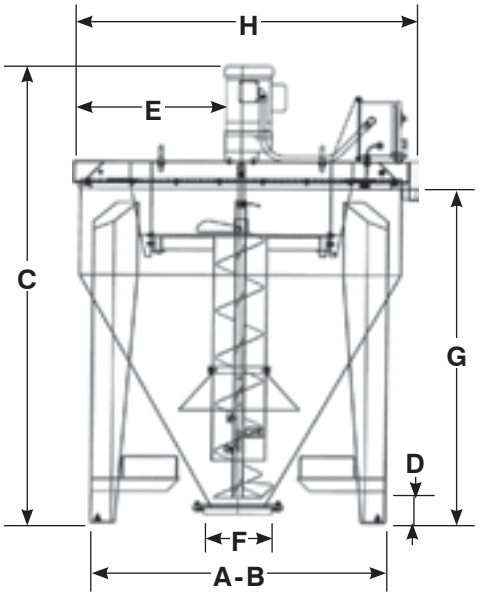
Sturdy, 14 gauge steel with built-in, 2-way entry pocket for fork-lift

60° hopper slope aids mixing action and ensures complete material clean-out

Large, positive-lock, slide gate allows quick and complete emptying of the mixer and prevents spillage while mixer is in transit

Dimensions

	A	B	C	D	E	F	G	H
148502	23"	23"	53¼"	N/A	12"	4"	41"	28"
107927	44"	44"	63"	7⅜"	16"	8"	43½"	53"
107896	44"	44"	71"	7⅜"	16"	8"	51½"	53"
143628	44"	44"	78"	7⅜"	16"	8"	58½"	53"
143626	44"	44"	90"	7⅜"	16"	8"	70½"	53"
143627	52"	52"	103"	12¼"	22"	10"	87"	65"



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Great for small jobs and tight spaces!

(Item #148502) Model HM250

(Item #107927) Model HM500

(Item #107896) Model HM850

Made in the U.S.A

Hurricane Mixers employ a high-speed blending action that minimizes mixing time. An internal auger raises the pellets within a tube from the bottom to the top, where a high-speed rotating blade efficiently scatters them to the sides.

Use these mixers for blending virgin pellets with regrind and for coloring with concentrates (not advised for dry color mixing).

The rugged design withstands constant, everyday use. Additionally, you'll find it easy to clean and maintain.

Hurricane Mixers are built in six sizes. Call for stock sizes. Larger sizes may be special ordered.

- Unique blending action cuts color mixing time, improving productivity
- Nonslip, direct drive and automatic timer result in complete and consistent color blending with every mix
- Lift-off top and removable auger assembly permit dismantling and cleaning within minutes without tools
- Two-way entry pockets for forklift permits easy transport of the mixer
- Large, positive seal, 8" diameter slide gate allows you to quickly empty the mixer to prepare for the next batch
- Interlock safety switch stops mixing action whenever the lid is raised, improving operator safety
- 14-gauge carbon steel construction extends equipment life and decreases repair costs
- No safety cage required.

Specifications and Prices

Item No.:	**148502** (Model HM250)	**107927** (Model HM500)	**107896** (Model HM850)
Volume/Capacity:	5 cu. ft., 175 lbs.*	11.1 cu. ft., 380 lbs.*	19.3 cu. ft., 670 lbs.*
Auger:	4" dia., 310 rpm	8" dia., 226 rpm	8" dia., 226 rpm
Motor:	⅓ HP	1½ HP	1½ HP
Amperage:	3 amp (115/60/1)	15.2 amp (115/60/1)	15.2 amp (115/60/1)
Power Cord Length:	6'	6'	6'
Shipping Size:	26" W x 26" L x 60" H	44" W x 44" L x 63" H	44" W x 44" L x 71" H
Weight:	200 lbs.	495 lbs.	565 lbs.
Shipping Weight:	300 lbs.	550 lbs.	650 lbs.
Unit Price:	**$8,792.00**	**$8,792.00**	**$9,945.00**

Item No.:	**143628** (Model HM1000)	**143626** (Model HM1500)	**143627** (Model HM3000)
Volume/Capacity:	26.6 cu. ft., 931 lbs.*	39 cu. ft., 1,360 lbs.*	80 cu. ft., 2,800 lbs.*
Auger:	8" dia., 226 rpm	8" dia., 226 rpm	8" dia., 226 rpm
Motor:	1½ HP	1½ HP	2 HP
Amperage:	15.2 amp (115/60/1)	15.2 amp (115/60/1)	15.2 amp (460/60/3)
Power Cord Length:	6'	6'	6'
Shipping Size:	44" W x 44" L x 78" H	44" W x 44" L x 90" H	103" W x 52" L x 52" H
Weight:	555 lbs.	605 lbs.	785 lbs.
Shipping Weight:	675 lbs.	725 lbs.	850 lbs.
Unit Price:	**$11,085.00**	**$12,237.00**	**$18,169.00**

*Based on material with a density of 35 lbs. per cu. ft.

Stainless Steel Construction Also Available — Inquire

Replacement Parts

Motor, Reducer and Wear Blocks Available — Inquire

See next page for Mixer Discharge Frame and Loading Platform

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Discharge Frame And Loading Platform

For Use with Heavy Duty Storage Hoppers and Hurricane Mixers*

Improve Operator Safety and Convenience

Discharge Frame

Fits all 44” square Mixers and Mobile Storage Hoppers

For Drum & Gaylord Loading

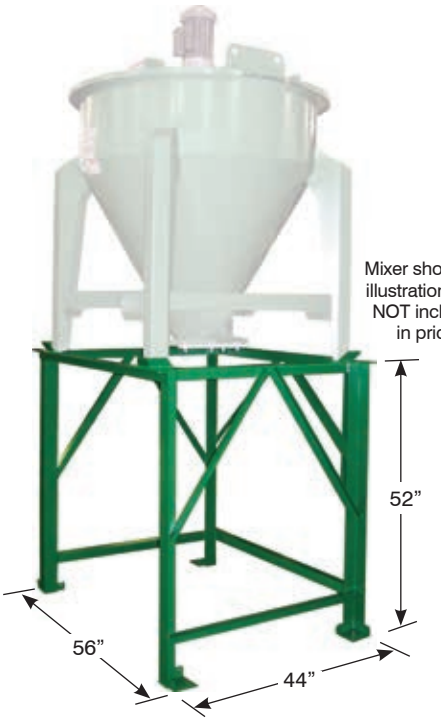

Photo above shows a #107927 Mixer atop a 52” high Discharge Frame. When the mixing cycle has been completed, the operator needs only to open the mixer slide gate and allow the contents of the mixer to flow neatly into the gaylord below. The entire load is then easily transported to wherever it is needed via forklift.

Item #	Description	Unit Price
107859	Discharge Frame for Mixers and Mobile Storage Hoppers	**$2,133.00**

*Not for use with mixer #148502

Loading Platform

For discharge frame
Enables operator to load, inspect & clean mixer without having to lower it to the floor

Mixer and Discharge Frame shown for illustration only, NOT included in price.

Item #	Description	Unit Price
107889	Loading Platform for Discharge Frame	**Inquire**

Hurricane™ is a trademark of IMS Company

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Material Mixing Drum Tumblers

Easily Blend Material While Saving Time, Labor and Money

Made in the U.S.A

IMS' Proven Performance

Optimum Mixing

- Exclusive 18 RPM and Drum Angle - provides the fastest, most complete mixing possible in the industry

Durable

- Solid steel frame - for longevity
- High torque drive belt - virtually adjustment free
- Built with components you can trust - Dayton motor and Winsmith reducer

Available as convertible tumbler with Leg Extension Kit –
allows easy conversion from single to double tumbler

Model TBD15

2 Year Warranty

Attention
External Controls Required

Optional: Tumbler Control Panel
Enables Safe and Easy Installation

- Motor starter with overload protection
- Provides open contact for safety cage tie in
- Fully enclosed panel
- Start/Stop switch
- Jog switch
- See page 638

Tech Tips

IMS Drum Tumblers have retained their usefulness in the mixing world because material can be stored in drums indefinitely, thereby eliminating the need to clean the mixing vessel.

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Made in the U.S.A

1½ HP Single Drum Tumbler

Corner Design For Optimal Shop Floor Layout

Corner wall design
- Conserves floor space
- Cuts guarding costs

Smooth action, high torque belt drive -
- Provides low maintenance
- Virtually adjustment free
- Absorbs start-up torques and stopping impacts
- Reduces wear and tear on expensive drive components

Low-wear high ratio gear reducer
- Transmits ample torque which permits a 1.5 hp motor to handle a startup load with less wear on components

Ample access to all components -
Enables simple maintenance

Drum tumbler must have enclosure for operator safety
— Contact IMS for enclosure options

Attention
External Controls Required
Optional: Tumbler Control Panel

Enables Safe and Easy Installation, See page 638

NOTE: Mounting anchor bolts included.
Plastic drum (shown) sold separately. See page 638

2 Year Warranty

Uses two walls to cut tumbler guarding cost. Requires only one protective barrier, 192" long.

Model TBD15 Corner

Easily Converts from Single to Double Tumbler

- Dayton motor and Winsmith reducer
- Heat treated main shaft
- 2" wide nylon quick release safety drum belt
- Drawing included for protective enclosure
- Drive belt requires no lubrication

Belt guard removed for illustration only.

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Specifications and Prices

Load Limit: 280 lbs. (including drum)
Motor: 1½ HP (TEFC) 1750 rpm, 208/240/480/60/3
Amperage: 5.1 (208v), 4.8 (240v), 2.4 (480v)

Tumbling Speed: 18 rpm
Drive Belt: Heavy torque drive
Operating Space: See illustration

Separate Ship Weights
Tumbler: 730 lbs
30 gal Holder: 186 lbs
55 gal Holder: 216 lbs

Drum Sizes and Holders	30 Gallon Holder	55 Gallon Holder
Maximum / Minimum Drum Height	34" Max / 30" Min	37" Max / 33" Min
Maximum / Minimum Drum Diameter	22" Max / 20" Min	25" Max / 21½" Min

Item #	Description	Unit Price
149886	1½ HP Belt Drive Corner Tumbler only (no holder) and three anchor bolts	$9,040.00
149887	Tumbler with one 30 gallon drum holder (#107873) and three anchor bolts	10,210.00
149888	Tumbler with one 55 gallon drum holder (#107857) and three anchor bolts	10,590.00
149892	Leg Extension Kit — Converts #149886 Single Tumbler to Double Tumbler	350.00
149893	Retrofit Kit — Converts older model IMS Single Tumbler to Double Tumbler	700.00

Ask about drums in steel, stainless steel and plastic.

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IMS Select 1½ HP Double Drum Tumbler

Industry Recommended For Quick and Constant Material Mixing

Made in the U.S.A

Smooth action, high torque belt drive
- Provides low maintenance
- Virtually adjustment free
- Absorbs start-up torques and stopping impacts
- Reduces wear and tear on tumbler parts

Low-wear high ratio gear reducer
- Transmits ample torque which permits a 1.5 hp motor to handle a startup load with less wear on expensive drive components

Ample access to all components - Enables simple maintenance

Drum tumbler must have enclosure for operator safety — Contact IMS for enclosure options

2 Year Warranty

Model TBD15 Double

Easily Converts from Single to Double Tumbler

Attention

External Controls Required

Optional: Tumbler Control Panel

Enables Safe and Easy Installation, See page 638

NOTE: Mounting anchor bolts included.
Plastic drum (shown) sold separately. See page 638

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

- Dayton motor and Winsmith reducer
- Heat treated main shaft
- 2" wide nylon quick release safety drum belt
- Drawing included for protective enclosure
- Drive belt requires no lubrication

Belt guard removed for illustration only.

Specifications and Prices

Load Limit: 280 lbs. per holder (including drum)

Motor: 1½ HP (TEFC) 1750 rpm, 208/240/480/60/3

Amperage: 5.1 (208v), 4.8 (240v), 2.4 (480v)

Tumbling Speed: 18 rpm

Drive Belt: Heavy torque drive

Operating Space: 110" x 59" (with drums)

— Separate Ship Weights —

Tumbler: 730 lbs
(2) 30 gal Holder: 186 lbs ea.
(2) 55 gal Holder: 216 lbs ea.
Leg Kit: 45 lbs

Drum Sizes and Holders	30 Gallon Holder	55 Gallon Holder
Maximum / Minimum Drum Height	34" Max / 30" Min	37" Max / 33" Min
Maximum / Minimum Drum Diameter	22" Max / 20" Min	25" Max / 21½" Min

Item #	Description	Unit Price
149889	1½ HP Belt Drive Double Tumbler only (no holders) and four anchor bolts	$9,350.00
149890	Tumbler with two 30 gallon drum holders (#107873) and four anchor bolts	12,125.00
149891	Tumbler with two 55 gallon drum holders (#107857) and four anchor bolts	12,888.00
Spare Parts		
122100	Reducing Gear Box (60:1, 1½ & 2 HP Tumblers)	$2,364.03
163800	Motor (1½ HP, 208/230/460/60/3)	471.44
107901	Pillow Block Bearing	155.60
135703	Anchor Bolt Assembly for concrete floors	8.00

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Drum Tumbler Control Panel

Permits Safe, Remote Operation

Use this IMS Drum Tumbler Control Panel to operate tumblers from a safe distance. The Control Panel can be easily wired by an electrician and contains all essential controls (less the door switch).

OSHA compliant

Cage door interlock - increases operator safety

Tumbler run timer - easily adjust mixing duration up to 60 minutes

110v signal-light receptacle with separate Off/On switch - provides visual notification of completed mixing with user provided light

Run/Jog - allows operator to correctly position drum holders for loading and unloading

- Transformer-isolated 120 VAC control circuits in panel
- Box is NEMA 12, resistant to moisture, oil and dust
- Sealed NEMA 12, receptacle for auxiliary warning light

Specifications	
Depth:	9¼"
Width:	12½"
Height:	15⅜"
Boxed Weight:	22 lbs.

Made Expressly For Tumbler Users!

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Heavy duty industrial electrical components - provides years of trouble free service

Item #	Description	Unit Price
146621	Drum Tumbler Control Panel (240/60/3) for 1½ HP tumblers	Inquire
146622	Drum Tumbler Control Panel (480/60/3) for 1½ HP tumblers	
109879	Drum Tumbler Control Panel (240/60/3) 1.3 Amps for ¼ HP tumbler	
109885	Drum Tumbler Control Panel (480/60/3) .65 Amps for ¼ HP tumbler	

Ask about custom control panels (allow 2-4 weeks for delivery)

IMPORTANT: When ordering custom control panels, specify motor operating voltage (230 or 460), frequency, number of phases and horsepower so that proper load current meter and coils will be supplied.

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IMS Heavy Duty Drum Holders

Safe to Use and Simple to Load

For use with **IMS** Drum Tumblers

- OSHA yellow finish
- 2” wide nylon, quick-release safety belt
- Welded steel construction

Style 1
Hub
#107955

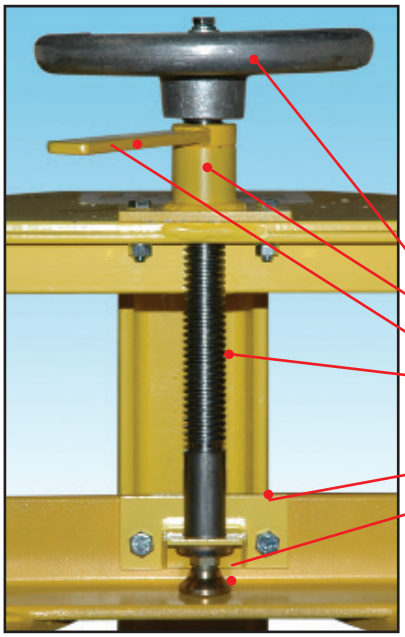
Style 2
Hub
#107887

Only From IMS

Style 2
Drum Holder
#107857

Purchasers also order:

- Drums for mixing and storage, pages 641, 644
- Drum Cart, page 648



#163948 Hardware Kit

Item #	Description
107873	Style 1: fits 30 gal. Drums
107857	Style 2: fits 55 gal. Drums
Spare Parts	
109141	Complete Handwheel Assembly for Style 1 and 2 Drum Holders with 12” screws (includes: #107853, #107916, #107909, #108777 and #108776)
107853	8” diameter handwheel
107916	1”-6 acme threaded nut with bracket
107909	1”-6 acme lock nut and handle
108776	1”-6 acme 12” screw with swivel base for Style 2
109420	1”-6 acme 20” screw with leveling pad #109386 used with 30 gallon conversion drum kit #109419
108777	Sleeve assembly for 12” and 20” screws
109386	Complete leveling pad assembly
109420	1”-6 acme 20” screw with swivel base for Style 1
109419	Conversion Kit - Complete Handwheel Assembly with 20”screw for Style 2 drum holder. Converts 55 gallon drum holder to accommodate and securely fit 30 gallon drums (includes: #107853, #107916, #107909, #108777 and #109420)
107955	Style 1 Hub for 30 gal. drum
107887	Style 2 Hub for 55 gal. drum
165412	Hardware Kit for Style 1 Hub #107873 (2 bolt pattern)
163948	Hardware Kit for Style 2 Hub #107887 (4 bolt pattern)
107874	2” wide nylon quick release safety belt
107871	V-bracket with left and right cleat for Style 1
107855	V-bracket with left and right cleat for Style 2
107938	Left-hand aluminum cleat
107917	Right-hand aluminum cleat

WARNING: Cancer and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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IMS Mini-Tumblers

Ideal for Small Batch, Test Runs and Laboratory Work

Corner-over-corner design - efficiently blends dry or liquid materials

Blending of ordinary pails - reduces spills and prevents messy cleanups

Adjustable cross bar - screw down top bar with locking handle ensures quick changeovers

- Rotate one or two (1 gal to 5 gal) cans at the same time
- Accepts steel or plastic containers
- Painted steel frame and cabinet
- Completely enclosed chain drives for safety
- Ample access to all components

Item #167535
Mini-Tumbler with Timer

Item #161485
Mini-Tumbler without Timer

External Controls Required
See page 638

NOTE: IMS Mini-Tumblers rotate pails, cans or buckets at a constant 23 RPM in one direction. They do NOT shake or oscillate.

Specifications and Prices

Can Sizes: 4.5” to 16.5” height, 12” diameter
Max Capacity: 100 lbs per can
Tumbling Speed: 23 rpm
Ship Dimensions: 42”L x 42”W x 34”H
Horsepower: 1/4
Weight: 205 lbs

Item #	Motor	Timer	Unit Price
167535	115V, 1 phase, 60 Hz	1-60 Minutes	**$2,800.00**
161485	208-230/460V, 3 phase, 60 Hz	None	**RFQ**

Optional Accessory

Guard Enclosure

(Guard Enclosure shown installed with Chain Drive Tumbler)

OSHA Compliant - keep workers safe and avoid fines
Retrofittable - use with your existing units

170852 (for #167535): **$2,435.00**
#67481 (for #161485): **2,025.00**

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Plastic Material Drums

High Quality Alternative to Heavy Steel Drums

- Lightweight and durable HDPE (High Density Polyethylene)
- Impact- and stress-cracking resistant
- Translucent Lid Features: (1) ¾" NPS Threaded Opening, (1) 2" NPS Threaded Opening, Plugs with Urethane Gasket
- Blue Drums have solid lids, no openings
- Lever Lock Ring: Galvanized Steel with Powder Coated Paint
- DOT approved

See Drum Covers on Page 642

30 and 55 gallon Translucent Drums

Specifications and Prices			
Type	**30 gal. Translucent**	**55 gal. Translucent**	**55 gal. Blue Drum**
Outside Diameter	18.75”	22.75”	22.9”
Outside Height	30”	36”	36.8”
Shipping Weight	15 lbs.	26 lbs.	20 lbs.

Item #	Description
175177	30 gal. translucent drum, lid w/ gasket, clamp ring, DOT rated
175178	55 gal. translucent drum, lid w/ gasket, clamp ring, DOT rated

See Also IMS Exclusive Drum Tumblers - Page 636 - 637

Plastic Drum Liners

- Help protect regrind/virgin material from moisture and contaminants during manufacturing and storage
- Help keep contents from leaking out of container
- Can also be used to protect finished products and large parts
  - Liners are shipped in neat, easy to store rolls
  - Fewer liners per roll make them Easier to Handle

FDA Approved

Made of translucent LDPE

Item #	Fits Drum Size	Size W x H	Thickness	Liners Per Roll
137339	30 gal.	34” x 51”	2 mil.	250
137340	55 gal.	38” x 63”	2 mil.	200
137341	55 gal.	38” x 63”	4 mil.	100

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Drum Covers

Keep Your Molding Material Clean — Contaminant-Free

Seal Out:

- Dirt and dust
- Metal Objects
- Trash

Works for Positive or Negative Applications

Replace cumbersome, Loose-fitting covers now!

2" dia. (±1/2") Elasticized Center Port helps hold loader probe in place

See-through vinyl windows let you check material level and probe position

Tie-Downs standard to accommodate positive-pressure applications
PATENTED

Lightweight, stretchable construction makes covers easy to install

Fits all 22" dia. (± 1") drums

Item #	Description
109468	Drum Cover — 1 port
127050	Drum Cover — 2 ports, 180° apart

Custom drum covers available — INQUIRE

Economical Drum Covers

Elastic Band expands to fit all standard size 55 gallon drums — holds cover in place

- Protects in-plant or bulk packaged products from outside elements
- Ideal for food, chemical and pharmaceutical applications
- Made of clear, 4-mil LDPE film

Item #	Description
137747	Drum Cover, 55 gallon, 4 Mil., Clear

IMS Company

www.imscompany.com phone order toll-free (USA & Canada) **1.800.537.5375**

fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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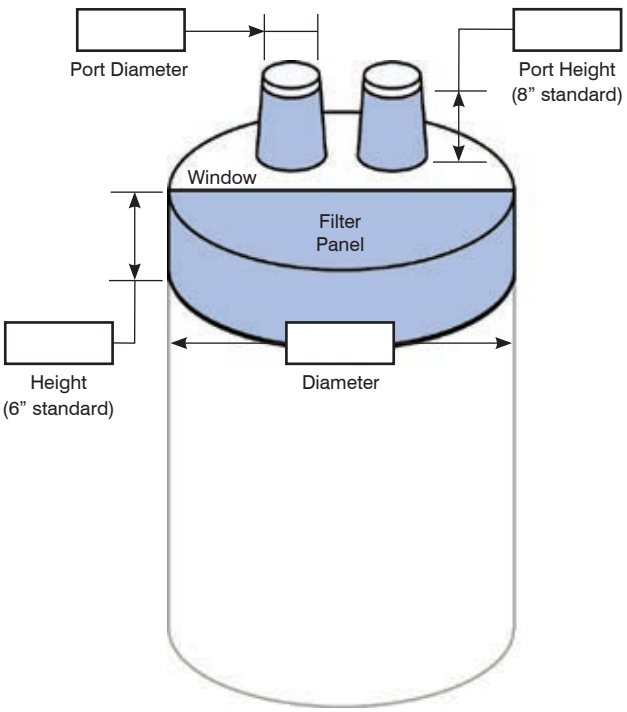
Custom Drum Cover Form

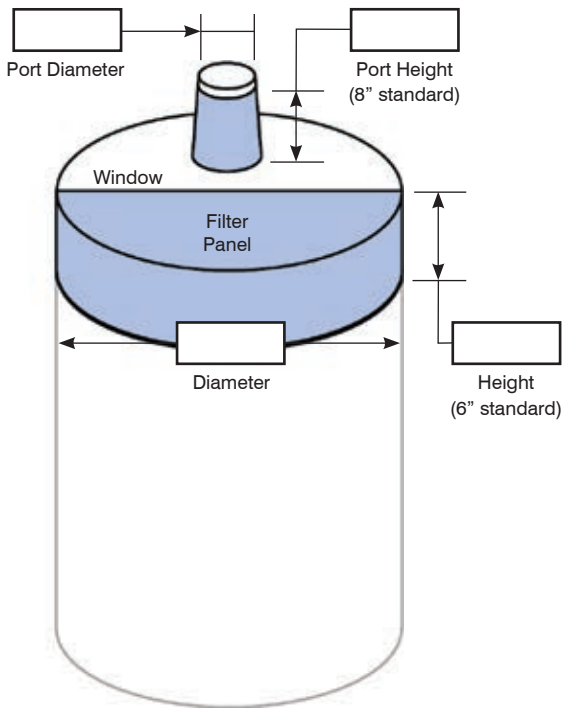
Fill In The Appropriate Dimension Blanks

DP Style
(Featuring Two Ports)



DP Style Quantity: ___

DN Style
(Featuring One Port)



DN Style Quantity: ___

Specify:

1. Color ❑ **Blue** **or** ❑ **Brown**

Please enclose a drawing if more custom items are needed.

If you would like your logo silk screened in lieu of the IMS Logo please provide art file (JPEG, EPS or TIFF) —
Minimum Order Quantity: 25
Price: $150 for 1 color / Additional $25 for PMS color matching / Additional $6 per location for 2 color print
Lead Time required — Call for details
Contact the IMS Supplies Team at sales@imscompany.com for details.

Date:_____ Quantity:_____ Phone: (_____) _____ Fax: (_____) _____

Name:_____ Title:_____

Company Name: _____ Email: _____

Address:_____

City: _____ State: _____ Zip:_____

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IMS Select Stainless Steel Drums

For Medical and Food-Grade Applications

- Can be sanitized for medical and food grade applications
- Perfect for use with abrasive materials
- 16 gauge, type-304 stainless steel with 2B finish and seamless chime
- Easy to clean

Perfect for Abrasive Materials & Food and Medical Applications

Specifications and Prices		
Type	**30 gal. Stainless Steel**	**55 gal. Stainless Steel**
Contents (no outage*)	33.06 gal.	59.2 gal.
Outside Diameter	20”	24”
Outside Height	31”	32½”
Tare Weight	49 lbs.	61 lbs.

Item #	Description
122141	16 gal. painted 20 gauge steel drum complete with lid and gasket (not shown)
105574	30 gal. stainless steel drum complete with lid, gasket and clamp ring
105569	55 gal. stainless steel drum complete with lid, gasket and clamp ring
Spare Parts	
105606	Clamp ring (carbon steel) for 55 gal. stainless steel drum

* Outage is DOT headspace (ex. 55 nominal gallons will hold 60.5 gallons)

Plastic Gaylord Liners

Help protect regrind/virgin material from moisture and contaminants during manufacturing and storage

Help keep contents from leaking out of container

Can also be used to protect finished products and large parts

- Liners are shipped in neat, easy to store rolls
- Fewer liners per roll make them easier to handle

FDA Approved

Item #	Size W*x L x D	Thickness	Liners Per Roll
137336	44” x 38” x 80”	2 mil.	75
137337	52” x 48” x 72”	2 mil.	60
137338	52” x 48” x 96”	2 mil.	60

*Total width tolerance ±3”

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

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Gaylord Covers

Seals Material in and Keeps Dirt Out

Keep Molding Material Clean and Contaminant-Free

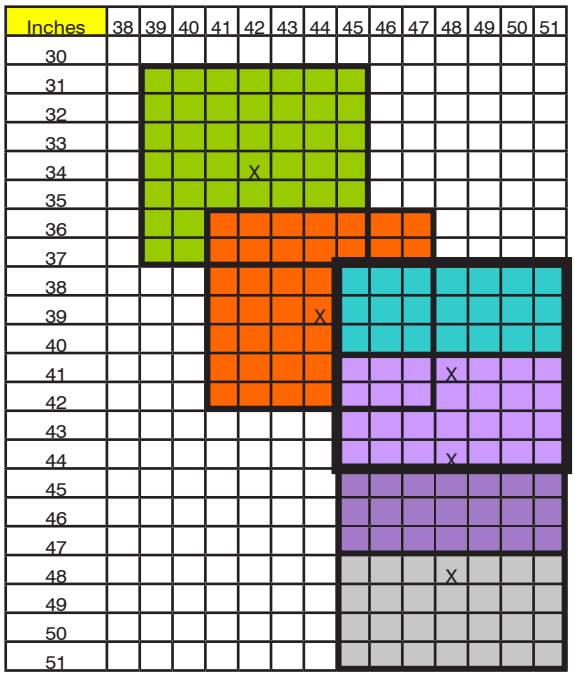
- Replace cumbersome loose-fitting covers now!
- Seal out: dirt/dust, metal objects, trash
- Help reduce parts rejects and press downtime

- Lightweight, stretchable construction makes covers easy to install
- Cloth Filter Panel allows make-up air in, keeps dirt out
- Vinyl Window for visual level check
- Port(s) – for entry of loader probe or blower discharge ducting/hose
  - 2 Port Gaylord Covers and all Drum Covers – accept 2" to 2¾" dia. probes via elastic band
  - 1 Port Gaylord Covers – accept 4" to 8" dia. ducting/ hose via adjustable drawstring
- Handy Zippers let you seal off unused ports

Elastic Band on 10" skirt
(All Models have an elastic band with belt and buckle)

Gaylord Cover Size Chart

GAYLORD COVERS Negative Pressure (for removing material) - 2 Ports Complete with Belt and Buckle to securely hold the cover in place			
Item #	**Size Standard**	**Min.**	**Max**
109462	34" x 42"	31" x 39"	37" x 45"
144062	39" x 44"	36" x 41"	42" x 47"
144064	41" x 48"	38" x 45"	44" x 51"
144066	44" x 48"	41" x 45"	47" x 51"
144068	48" x 48"	45" x 45"	51" x 51"
Positive Pressure (for adding material) - 1 Port Complete with Belt and Buckle to securely hold the cover in place			
Item #	**Size Standard**	**Min.**	**Max**
144061	34" x 42"	31" x 39"	37" x 45"
144063	39" x 44"	36" x 41"	42" x 47"
144065	41" x 48"	38" x 45"	44" x 51"
144067	44" x 48"	41" x 45"	47" x 51"
144069	48" x 48"	45" x 45"	51" x 51"
Drum Cover 1 Port Complete with Special Tie Cord			
Item #	**Size Standard**		
109468	22" dia		
Drum Cover 2 Ports Complete with Special Tie Cord			
Item #	**Size Standard**		
127050	22" dia		



Carton Clips

Many molding shop uses:

Hold box flaps down

- Allow closer box to personnel placement – eliminate leaning and reaching
- Help prevent conveyed boxes from snagging each other/ tipping

Great for holding gaylord liners in place

#137148

Removable and Reusable!

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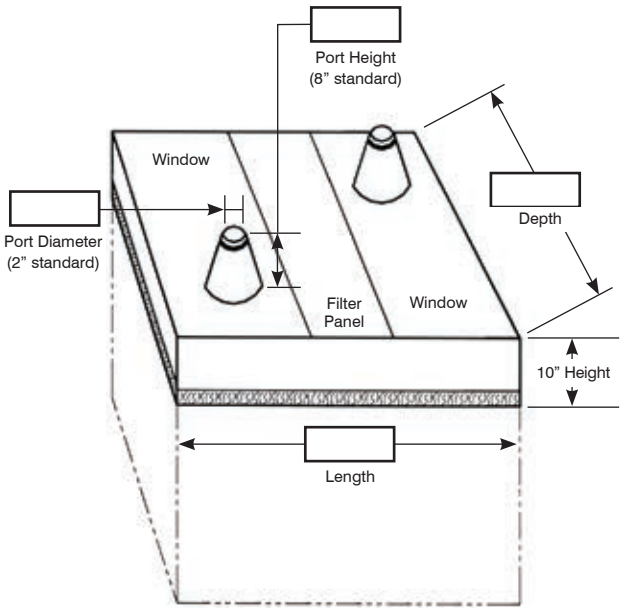
Custom Gaylord Cover Form

Fill In The Appropriate Dimension Blanks

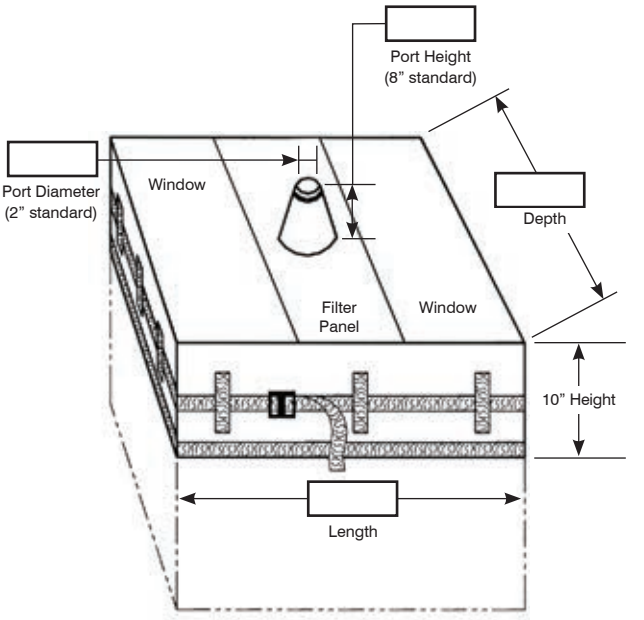
Negative Pressure - GN

(Used for Withdrawal)



Positive Pressure - GP

(Used for Filling)



GN Style Quantity: _____

GP Style Quantity: _____

Specify:

1. How many ports? _____
2. Location of Ports: _____
3. Are you o Filling or o Withdrawing Material?

If Filling:

1. Blower Size: _____
2. Blower Air Output: _____
3. Other Filling Type: _____

Please enclose a drawing if more custom items are needed.

If you would like your logo silk screened in lieu of the IMS Logo please provide art file (JPEG, EPS or TIFF) —

Minimum Order Quantity: 25
Price: $150 for 1 color / Additional $25 for PMS color matching / Additional $6 per location for 2 color print
Lead Time required — Call for details
Contact the IMS Supplies Team at **sales@imscompany.com** for details.

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

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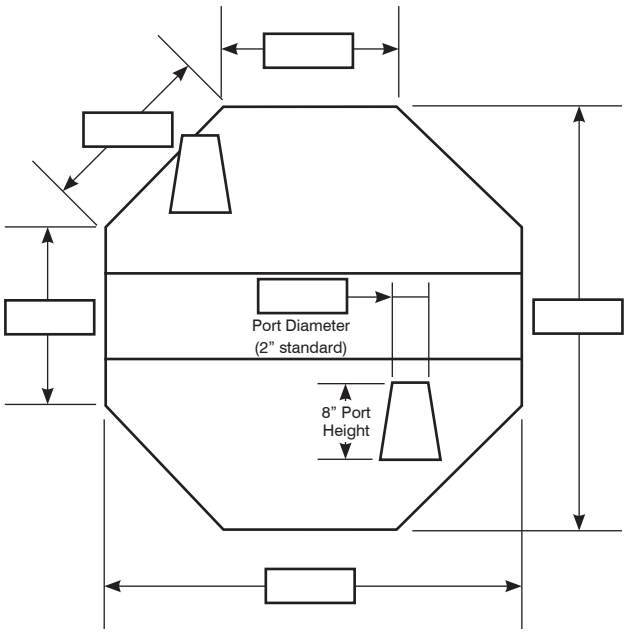
Custom Octagon Gaylord Cover Form

Fill In The Appropriate Dimension Blanks

Negative Pressure

(Used for Withdrawal)

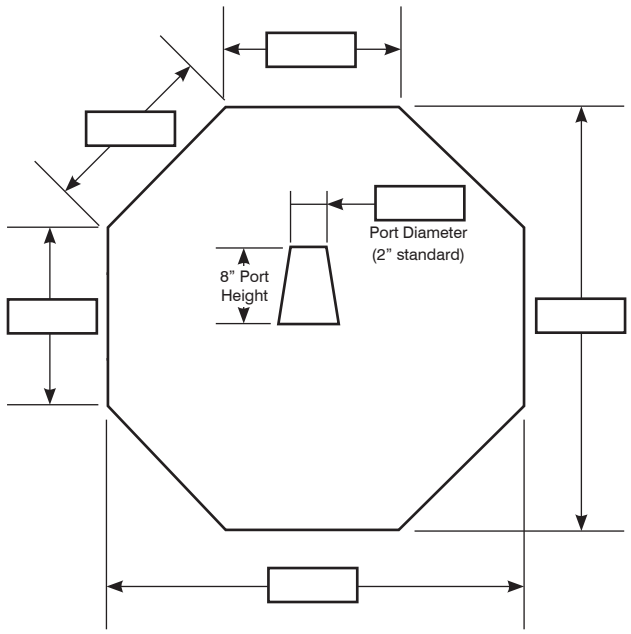


Quantity: _____

Features: two access ports 2" in diameter and 8" tall (standard height). Breathable filter panel and two vinyl windows for quick visual level checks. The skirt is 10" long and has an elastic band to hold the cover in place.

Positive Pressure

(Used for Filling)



Quantity: _____

Features: one center port 8" tall (standard height). Breathable filter panel and two vinyl windows for quick visual level checks. The skirt is 10" long and has an elastic band and belt with buckle to hold the cover securely in place.

Ports can be located elsewhere if needed — please mark the appropriate drawing above if you prefer this option

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Grab-R-Arm™ Drum Cart

- Safe! Adjustable Grab-R-Arm™ Holds Barrel Securely In Place
- Transport Barrels with Speed & Convenience
- Reduce Accidents

Sturdy, All Welded Construction

Handles up to 350 lbs.

Only from IMS

Easy Loading — Safer To Use

Item No. 105597

Lo-Profile Drum Caddy

- Quick
- Durable
- Easy to Use

Handles up to 1,000 lbs.

Item No. 163725

Drum Dollie

- Strong and Durable easily transports up to 55 gallon drums
- Welded Steel Frame with 3⅛" cross straps with powder coat finish
- Heavy-Duty zinc-plated casters with non-marking 3" x 1¼" polyolefin treads

Item No. 146498

Specifications

Dollie		Casters	
Capacity:	900 lbs.	**Material:**	Polyolefin
Drum Size:	Up to 55 gal.	**Size:**	3" x 1¼"
I.D.:	23¾"		
Weight:	28 lbs.		

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tech support toll-free (USA & Canada) 1.866.467.9001
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Please refer to imscompany.com for current pricing

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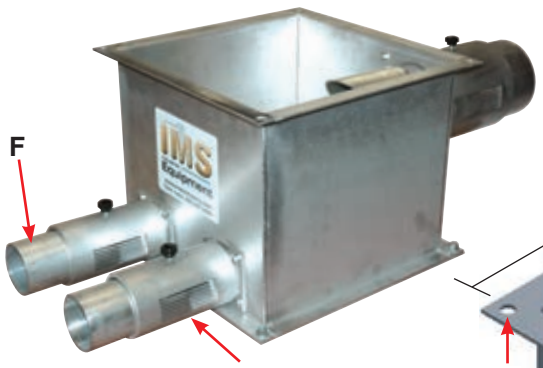
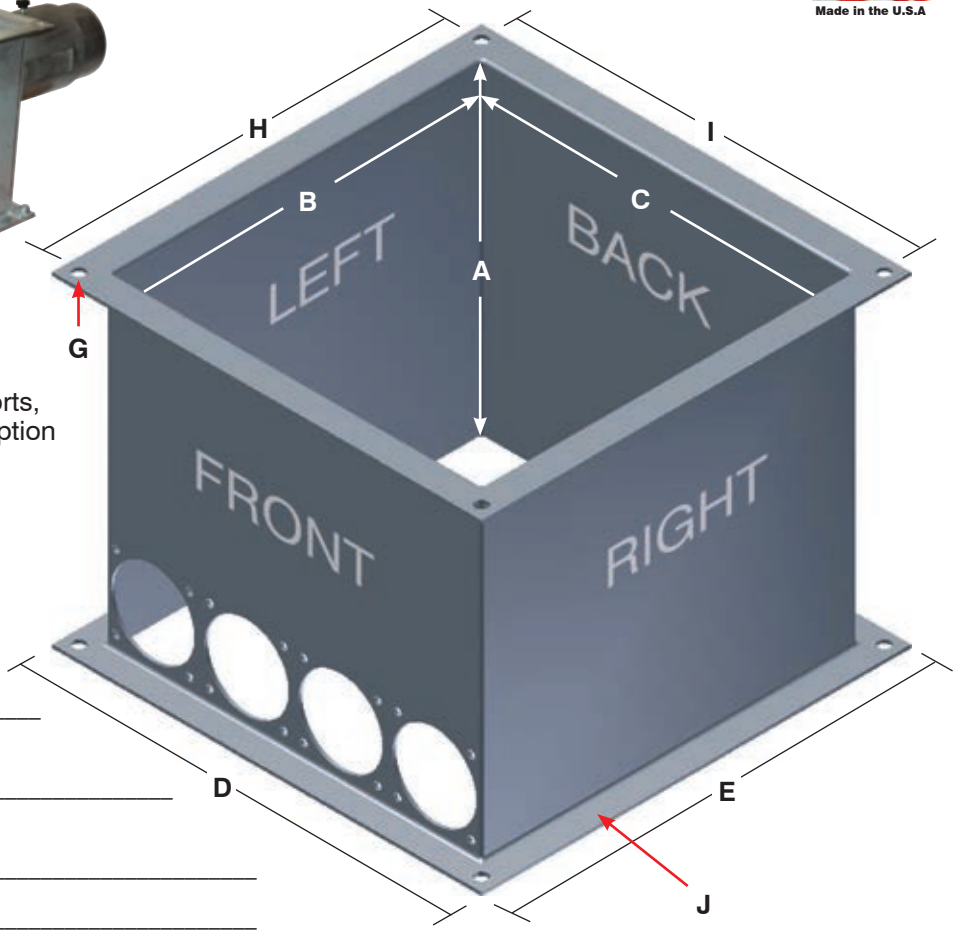
REQUEST FOR QUOTE: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

Custom Takeoff Box Quote/Ordering Form

Made in the U.S.A



Example shown with 2 front ports,
1 rear port and air adjustment option



Specify:

1. Material: ❑ Aluminum (standard)
   ❑ Other: _____
2. (A) Height: _____
3. (B) Inside Depth: _____
4. (C) Inside Width : _____
5. Flange Size - (D): _____ x (E): _____
6. (F) Number of Ports: _____

(F) Port #1 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No
(F) Port #2 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No
(F) Port #3 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No
(F) Port #4 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No
(F) Port #5 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No
(F) Port #6 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No

7. (G) Hole Diameter: _____ Hole Center to Hole Center (H): _____ x (I) : _____
8. (J) Bottom Cleanout: ❑ Hinged or ❑ Bolted

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

email: sales@imscompany.com fax: 1 888 288 6900

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Material Loaders

ELECTRIC HOPPER LOADERS

Stainless Steel Body

IMS Series Stainless Steel Material Loaders

- Stainless steel construction on all material contact surfaces
- Adjustable no-load alarm horn and strobe light
- Conveying Capacity: Up to 440 lbs/hr
- 1.4HP vacuum motor
- Self-cleaning

See Pages 654-655

Shini Self-Contained Hopper Loader

- Stainless steel construction on all material contact surfaces
- Conveying Capacity: Up to 880 lbs/hr
- Self-cleaning
- Microprocessor based controller with 3' cord
- Proportional valve

See Pages 656-657

Aluminum Body

IMS Mini Loader Series

- 4 styles available – Standard, Self Cleaning, Proportional, and Powder
- Conveying Capacity: 250 lbs/hr to 1000 lbs/hr
- Heavy gauge aluminum construction, stainless steel optional
- Microprocessor based controller

See Pages 658-659

1250VP

1250PLVPA

PL1250

IMS Whisper Loader Series

- 4 styles available – Standard, Self Cleaning, Proportional, and Powder
- Conveying Capacity: 950 lbs/hr to 2500 lbs/hr
- Heavy gauge aluminum construction, stainless steel optional
- Microprocessor based controller

See Pages 660-663

1500VPA

JIT Design

IMS Series and Shini Self-Contained JIT Hopper Loaders

- Stainless steel construction on all material contact surfaces
- Sight glass standard
- Self-cleaning
- Material shortage alarm

See Page 654 and 656

1500PLVPA

PL1500

1750VPA

2000VPA

IMS Company

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Material Loaders

COMPRESSED AIR VENTURI LOADERS

JIT Venturi Style with Controller

IMS Compressed Air Loader

- Stainless steel construction on all material contact surfaces
- Compressed air design reduces ambient sound over vacuum style motors
- Automated, self-contained design conveys material to machine when needed
- Conveying Capacity: Up to **500 lbs/hr**

See Page 666

Shini Compressed Air Venturi Hopper Loader

- Stainless steel construction on all material contact surfaces
- Compressed air design reduces ambient sound over vacuum style motors
- Automated, self-contained design conveys material to machine when needed
- Conveying Capacity: Up to **400 lbs/hr**

See Page 667

NEW Shini Single Station/Vacuum Hopper Loader Systems

- Floor Level Blower & Controller
- Separate Stainless Steel Receiver
- Microprocessor Controller

See Pages 669-670

Also Available

IMS Series and Shini Add-On Proportional Valves

- Conveniently converts loaders to dual inlet proportioning loaders
- Complete with everything you need
- Interfaces with loaders control panel

See Page 655 and 657

Spare Parts for All Loaders

- Wide offering of itemized spare parts for convenient ordering and maintenance

See Pages 654, 655

NEW Shini Multi Station Hopper Loader Systems

- Floor Level Blower & Controller
- 2 or 4 Hopper Loading System
- Separate Stainless Steel Receiver
- Microprocessor Controller

See Pages 671

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Material Loaders

Quick Reference Price Chart

Electric Hopper Loaders						
Item #	**Model**	**Throughput**	**Construction**	**Inlet**	**Page**	**Unit Price**
IMS Series Hopper Mount Style Loaders						
137121	200	450 lbs/hr	Stainless Steel	1½"	655	**$1,005.00**
133758	400	650 lbs/hr				**1,140.00**
137122	800	900 lbs/hr				**1,425.00**
IMS Series Just-In-Time Throat Mount Style Loaders						
133656	200JT	450 lbs/hr	Stainless Steel	1½"	655	**$1,510.00**
137123	300JT	650 lbs/hr				**1,645.00**
Shini Hopper Mount Style Loaders						
162525	SAL-1U	66 lbs/hr	Stainless Steel	1½"	657	**1,020.00**
149112	SAL-6U	660 lbs/hr				**1,265.00**
149533	SAL-12U	900 lbs/hr				**1,645.00**
Shini Just-In-Time Throat Mount Style Loader						
149026	SAL-3U-E	450 lbs/hr	Stainless Steel	1½"	657	**1,625.00**
1250 Series Mini Loaders						
174750	1250B (Standard)	600 lbs/hr	Aluminum	1¼"	659	**Inquire**
115403	1250VPA (Self-Cleaning)	600 lbs/hr				**Inquire**
115407	1250PLVPA (Proportional)	950 lbs/hr				**Inquire**
118317	PL1250 (Powder)	400 lbs/hr				**Inquire**
1500 Series WHISPER® Loaders						
115402	1500A (Standard)	1600 lbs/hr	Aluminum	1½"	661	**Inquire**
115401	1500VPA (Self-Cleaning)	1600 lbs/hr				**Inquire**
115405	1500PLVPA (Proportional)	1600 lbs/hr				**Inquire**
118331	PL1500 (Powder)	950 lbs/hr				**Inquire**
1750 Series WHISPER® Loaders						
132424	1750VPA (Self-Cleaning)	2000 lbs/hr	Aluminum	1¾"	663	**Inquire**
2000 Series WHISPER® Loaders						
170658	2000VPA-6M (Self-Cleaning)	2500 lbs/hr	Aluminum	2"	663	**Inquire**

Compressed Air Venturi Loaders						
Item #	**Model**	**Throughput**	**Construction**	**Inlet**	**Page**	**Unit Price**
IMS Series CAL Compressed Air Loaders						
175076	CAL 1	125 lbs/hr	Stainless Steel	1¼"	666	**$1,495.00**
175077	CAL 2	125 lbs/hr				**1,495.00**
Shini Compressed Air Venturi Hopper Loaders						
149534	VL-120I (110V)	400 lbs/hr	Stainless Steel	1¼"	667	**1,425.00**

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Please refer to imscompany.com for current pricing

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IMS Series Stainless Steel Loaders

Single Phase Hopper Loaders

Now With "No-Load" Material Alarm

#137121
Model 200

#133758
Model 400

#137122
Model 800

#133656
Model 200JT

#137123
Model 300JT

5 Sizes and 2 Styles to Choose From!

Hopper Mount Style

Efficiently keeps your machine hopper full

Totally Self-Contained

Just-in-Time Throat Mount Style

Sight glass design for on demand loading

#142842
Model 150

Maximize versatility with an

IMS Series Add-on Proportional Valve

- Conveniently converts all IMS Series Loaders to dual inlet proportioning loaders
- Complete with everything you need
- Interfaces with loaders control panel

IMS Company

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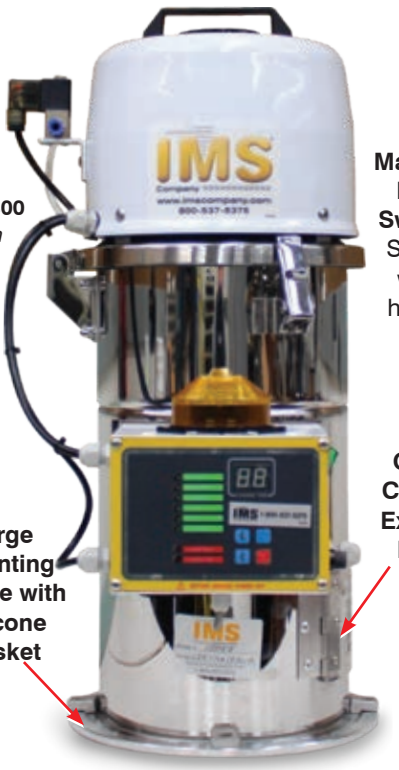
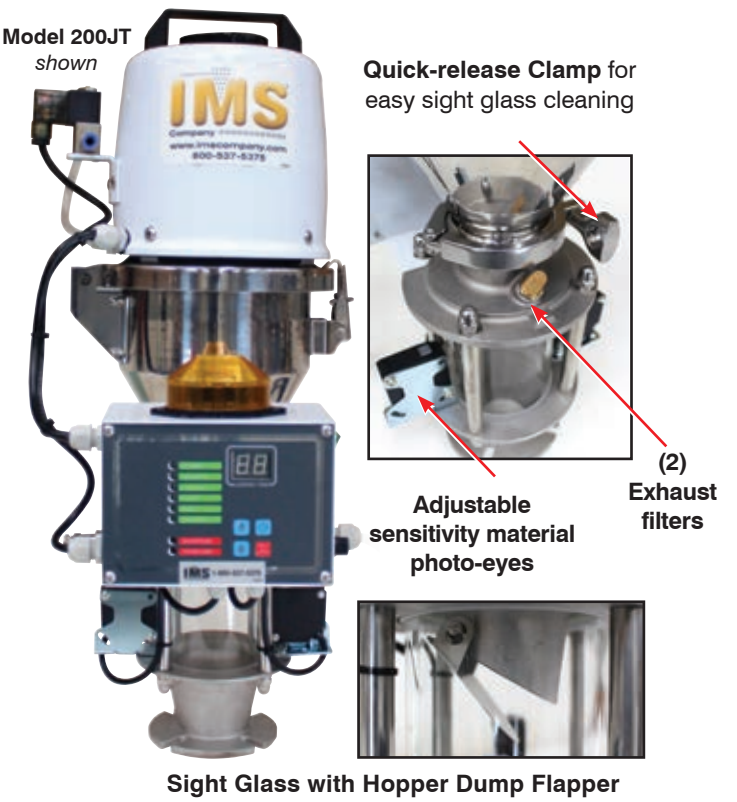
IMS Series Stainless Steel Material Loaders

Easy to Operate With Great Features, Reliable Performance and IMS Quality

Hopper Mount



Just-In-Time / Throat Mount



Sight Glass with Hopper Dump Flapper

Features

Hinged Flip-top Lid

Hinged flip-top lid with quick-release clamps for easy filter changes

Alarm Strobe Light

Provides visual and audio alarm if loader doesn't sense material

Motor Screen

Safety screen in lid prevents resin pellets from destroying motor should filter damage occur

Corrosion free stainless steel construction - Increases longevity of common wear parts

No-load alarm horn and strobe light - Avoids down-time

1½" replaceable inlet - Saves time and money

Powerful 1.4HP vacuum motor (replaceable brushes) - Handles demands (long lasting)

Self-cleaning filter with built-in solenoid valve - Keeps filter from clogging

Powder coated steel, sound-deadened motor hood and low noise motor - Minimizes ambient sound into facility

Heavy duty metal control panel - For industrial use

State of the art microprocessor - Easy to read and simple to operate

Interfaces with add-on proportional valve (sold separately) - Doesn't need an additional control panel to operate

IMS Company

www.imscompany.com phone order toll-free (USA & Canada) **1.800.537.5375**

fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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IMS Series Stainless Steel Material Loaders

Includes:

- Stainless steel pick-up wand, 10' of 1½" grounded loader hose and hose clamps
- 15' grounded power cord and plug*
- Quick release clamps
- Replaceable vacuum 1½" OD inlet
- Cloth filter with reinforced stainless steel support screen

*Avoid using extension cords. If you must, do not exceed 20'

Specifications

Required Voltage: 120/60/1
Full Load Amps: Dedicated 20-amp line
Air Required: 70 PSI regulated and filtered

- Replaceable Inlets
- Large View Window
- Stainless Steel
- High Performance Cylinders
- Includes: Probe, Hose and Hose Clamps

IMS Series Add-on Proportional Valve

Item #142842
Model 150

Specifications and Prices

Item #	Description	Throughput	Hopper Capacity	Dimensions	Weight	Unit Price
IMS Series Hopper Mount Style Loaders						
137121	Model 200	450 lbs/hr	6.6 lbs	19.6" H x 13.5" D	26.45 lbs	**$1,005.00**
133758	Model 400	650 lbs/hr	13.2 lbs	24.4" H x 13.6" D	28.6 lbs	**1,140.00**
137122	Model 800	900 lbs/hr	26.4 lbs	29.7 H x 13.6" D	33.0 lbs	**1,425.00**
IMS Series Just-In-Time Throat Mount Style Loaders						
133656	Model 200JT	450 lbs/hr	6.6 lbs	24.2" H x 12.2" D	28.6 lbs	**$1,510.00**
137123	Model 300JT	650 lbs/hr	13.2 lbs	28.9" H x 13.6" D	30.8 lbs	**1,645.00**
IMS Add-on Proportioning Valve						
142842	Model 150 Add-on Proportioning Valve - Interfaces with Loader Control Panel Includes: Valve, Pick-Up Wand, Hose and Hose Clamps					**$765.00**

Spare Parts

Item #	Description	Unit Price
143234	Spare Vacuum Motor, 1.4 hp	**$149.50**
143377	Replacement Carbon Motor Brushes (set of 2)	**11.50**
143385	Cloth Motor Filter Only for 200 & 200JT	**24.00**
143237	Cloth Motor Filter Only for 400, 800, & 300JT	**24.00**
160661	Motor Filter Assembly for 200 & 200JT (Includes Gasket, Mesh Screen, & Filter)	**90.00**
160662	Motor Filter Assembly for 400, 800, 300JT (Includes Gasket, Mesh Screen, & Filter)	**90.00**
143393	Replacement Sight Glass for 200JT & 300JT	**170.00**
143396	Replacement Photo-Eye Sensors for 200JT & 300JT	**222.85**
168566	Exhaust Door Filter for 200	**Inquire**
168567	Exhaust Door Filter for 400 and 800	**Inquire**

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SHINI Self-Contained Hopper Loaders

Material loading at a great price

Hopper Mount

Model SAL-6U *shown*

Large Mounting Flange with Silicone Gasket

1 Year Warranty

Just-In-Time / Throat Mount

Model SAL-3U-E *shown*

Quick-release Clamp for easy sight glass cleaning

Adjustable Sensor

Sight Glass with Hopper Dump Flapper

Hinged Flip-top Lid

Hinged flip-top lid with quick-release clamps for easy filter changes

Motor Screen

Safety screen in lid prevents resin pellets from destroying motor should filter damage occur

Corrosion free stainless steel construction - Increases longevity of common wear parts

Material shortage alarm - Avoids down-time

1½" replaceable inlet - Saves time and money

Powerful 1.85HP* vacuum motor (replaceable brushes) - Handles demands (long lasting)
*SAL-1U: 115V / .875 HP

Motor overload protection - Protects motor from voltage spikes

Adjustable automatic pneumatic filter cleaning - Keeps filter from clogging

Sound proof motor cover - Reduces operating noise

Heavy duty mounting flange - Allows easy installation for multiple mounting sizes

Detachable remote control (with 3' cord) - Allows manual operation when machine mounted

IMS Company

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SHINI Self-Contained Hopper Loaders

Includes:

- 10’ grounded loader hose, 1½" ID
- 12’ power cord and plug
- 2 adjustable clamps
- 3’ stainless steel pick-up wand

Specifications

Required Voltage: 115/60/1

Specifications and Prices

IMS Item #	Shini #	Throughput	Hopper Capacity	Level Switch	Dimensions	Weight	Unit Price
Shini Hopper Mount Style Loaders							
162525	SAL-1U	66 lbs/hr	1 lbs	Magnetic Proximity Switch	21" H x 13" D	27 lbs	**1,020.00**
149112	SAL-6U	660 lbs/hr	8.5 lbs	Magnetic Proximity Switch	25⅜" H x 16⅛" D	31 lbs	**1,265.00**
149533	SAL-12U	900 lbs/hr	17 lbs	Magnetic Proximity Switch	29⅜" H x 16⅛" D	29 lbs	**1,645.00**
Shini Just-In-Time Throat Mount Style Loader							
149026	SAL-3U-E	450 lbs/hr	4.25 lbs	Photo Sensor	29⅛" H x 14½"	27 lbs	**1,625.00**

Spare Parts

Item #	Description	Item #	Description
161696	Control Panel (Main Control Box, Board and Keypad)	165322	6" Filter and Gasket for SAL-1U
161700	Control Panel Housing Only	161706	11" Filter and Gasket for SAL-6U and 12U
161697	Main Control Circuit Board Only	161704	9" Filter and Gasket for SAL-3U-E
165728	Handheld Keypad/Pendant with Cord and Plug Assembly	167050	Metal 6" Filter Baffle Ring for SAL-1U
161703	Solenoid Valve	161707	Plastic 11" Filter Baffle Ring for SAL-6U and 12U
161702	Quick Release Hold Down Latch	168234	Metal 11" Filter Baffle Ring for SAL-6U and 12U
161705	Plastic 9" Filter Baffle Ring for SAL-3U-E	168734	Metal 9" Filter Baffle Ring for SAL-3U-E
161695	Proximity Switch for SAL-6U and SAL-12U	163689	Baffle Plate/Dump Flap Assembly for SAL-6U and 12U
161708	Sight Glass Tube for SAL-3U-E	167518	Vacuum Motor with Fan (120V) for SAL-1U
161709	Photo Sensor Assembly for SAL-3U-E	161692	Vacuum Motor with Fan (120V) for SAL-6U, 12U and 3U-E
166288	4 Bolt Gasket/Flange Seal for SAL-1U	167326	Vacuum Motor Brush Kit for SAL-1U (2 Brushes)
166286	Stainless Steel Material Inlet Pipe for SAL-1U	161693	Vacuum Motor Brush Kit for SAL-6U, 12U and 3U-E (2 Brushes)

Shini Proportional Valves

Accurate Blending of Multiple Materials Into Single Inlet Receiver

Easily mounts directly onto loader inlet

Single DIN cable connects to loader

Control Box Power: 115V

Efficient blending of virgin and regrind pellets reduces production costs

Control box models comply with electrical standards (CE, UL, CSA, JIS etc.) and allows compatibility with most OEM loaders

Includes:

- Stainless steel pick-up wand
- 12’ loader hose with 4 adjustable clamps

IMS Item #	Shini #	Flow Capacity	Inlet/ Outlet	Compressed Air Pressure	Dimensions Height	Width	Depth	Weight	Unit Price
148861†	SPV-38U	770 lbs/hr	1.5"	40 PSI	9"	10”	6”	8 lbs	**730.00**
148801†	SPV-50U	1200 lbs/hr	2"						**820.00**
158415*	SPV-38UC	770 lbs/hr	1.5"					10 lbs	**875.00**
158416*	SPV-50UC	1200 lbs/hr	2"						**965.00**

†For Shini Loaders Only *Control Panel included - allows usage with other loaders

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Made in the U.S.A

1250 Series Mini Loaders

1250A & 1250VPA Standard and Self Cleaning Mini Loaders

60-80 psi

Self Cleaning Model - Pulses of air to clean the filter (Includes air filter regulator and mounting bracket)

1250PLVPA Proportional, Self Cleaning Mini Loader

60-80 psi

Proportional Model - For effective blending of two different materials

PL1250 Powder, Mini Loader

40-60 psi

Remotely mounted control panel with 12' control cord

Powder Model - Pleated cartridge filter with automatic air pulses to effectively convey a wide variety of powders without blowing dust into the shop air

Quick release clamps - Easy maintenance of motor and filter

Pre-drilled flange - Quick installation onto hopper lid

Proximity switch - Improves accuracy and reliability of material loading

Microprocessor based controller with push button keypad and digital display inside NEMA-1 rated enclosure - Provides user friendly, simple programming

- Heavy gauge aluminum body
- 120V/60/1 brush type motor with 10' cord, 8 amps
- CSA approved
- Quiet-by-pass air cooled motor
- Built in circuit breaker overload protection
- 1½' control cord length (12' on powder loader)
- 1¼" inlet port

2 Year Warranty

Standard Loader shown

continued on next page

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1250 Series Mini Loaders

Includes:

- Aluminum pick-up wand*
- 10' of 1¼" grounded loader hose*
- 2 adjustable clamps
- 10' grounded power cord and plug

*1250PLVPA includes 2 wands and 20' of hose

Specifications

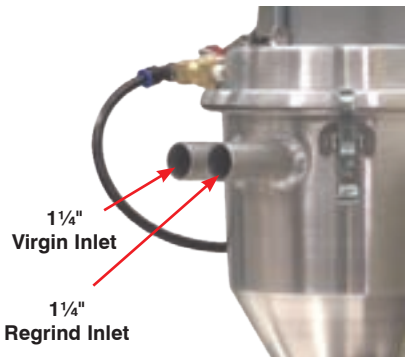
Required Voltage: 120/60/1

Item #	Style	Model	Throughput**	Filter	Dimensions	Weight Unit / Ship	Unit Price
174750	Standard	1250A	600 lbs/hr	105986 Nylon	20.25" H x 11.75" D	14/26 lbs	Inquire
115403	Self-Cleaning	1250VPA	600 lbs/hr	106036 Polyester Felt	20.25" H x 11.75" D	14/26 lbs	
115407	Proportional	1250PLVPA	950 lbs/hr	106036 Polyester Felt	24.50" H x 11.75" D	23/35 lbs	
118317	Powder	PL1250	400 lbs/hr	120065 Pleated Filter	35" H x 11.50" D	26/38 lbs	

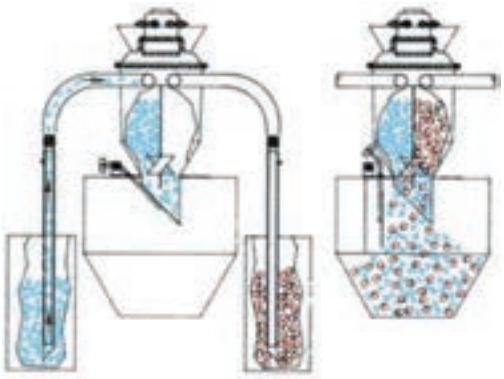
**Test Conditions: 35# cu/ft of round polypropylene pellets (free flowing material/powder) conveyed 10' up and into loader

Stainless Steel Body and/or Brushless Motor Available — Inquire

1250PLVPA Proportional Loader



Interblend is a static internal blender used to prevent layering with a proportioning loader



Replacement Filters

Replacement filters for Self Cleaning Loader		
105986	9" nylon filter	Inquire
106036	9" polyester filter	
106002	9" gasket	

PTFE coated filters available — Inquire

Specially-designed filters capture particles down to 5 microns (powder) .5 micron filter available — inquire

120065 powder loader filter

Inquire

Additional Spare Parts and Accessories

See Page 664 Check before Printing

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1500 Series WHISPER® Loaders

Made in the U.S.A

1500A & 1500VPA Standard and Self Cleaning WHISPER® Loaders

1500A

Self Cleaning Model - Pulses of air to clean the filter (Includes air filter regulator and mounting bracket)

1500PLVPA Proportional, Self Cleaning WHISPER® Loader

Proportional Model - For effective blending of two different materials

PL1500 Powder, WHISPER® Loader

Remotely mounted control panel with 12' control cord

Powder Model - Pleated cartridge filter with automatic air pulses to effectively convey a wide variety of powders without blowing dust into the shop air

Quick release clamps - Easy maintenance of motor and filter

Pre-drilled flange - Quick installation onto hopper lid

Proximity switch - Improves accuracy and reliability of material loading

Microprocessor based controller with push button keypad and digital display inside NEMA-1 rated enclosure - Provides user friendly, simple programming

- Heavy gauge aluminum body
- 120V/60/1 brush type motor with 10' cord, 8 amps
- CSA approved
- Quiet-by-pass air cooled motor with sound deadening
- Built in circuit breaker overload protection
- 12' control cord length
- 1½" inlet port

Standard Loader shown

WHISPER® is a registered trademark of Pneumatic Conveying, Inc.

continued on next page

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1500 Series WHISPER® Loaders

Includes:

- Aluminum pick-up wand*
- 10' of 1½" grounded loader hose*
- 2 adjustable clamps
- 10' grounded power cord and plug

*1500PLVPA includes 2 wands and 20' of hose

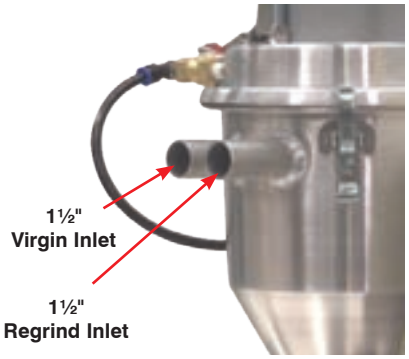
Specifications

Required Voltage: 120/60/1

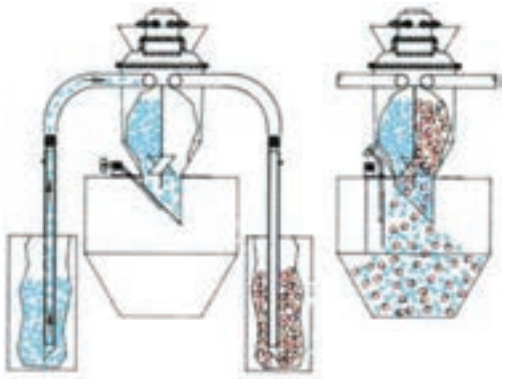
Item #	Style	Model	Throughput**	Filter	Dimensions	Weight Unit / Ship	Unit Price
115402	Standard	1500A	1600 lbs/hr	105977 Nylon	30.875"H x 15"D	24/45 lbs	Inquire
115401	Self-Cleaning	1500VPA	1600 lbs/hr	106026 Polyester Felt	30.875"H x 15"D	24/45 lbs	
115405	Proportional	1500PLVPA	1600 lbs/hr	106026 Polyester Felt	30.875"H x 15"D	27/47 lbs	
118331	Powder	PL1500	950 lbs/hr	105990 Pleated Filter	38"H x 15"D	32/52 lbs	

**Test Conditions: 35# cu/ft of round polypropylene pellets (free flowing material/powder) conveyed 10' up and into loader

1500PLVPA Proportional Loader



Interblend is a static internal blender used to prevent layering with a proportioning loader



Replacement Filters

Replacement filters for Self Cleaning Loader		
105977	14" nylon filter	Inquire
106026	14" polyester filter	
105990	14" gasket	

PTFE coated filters available — Inquire

Specially-designed filters capture particles down to 5 microns (powder) .5 micron filter available — inquire

120065 powder loader filter

(3 required)

Inquire

Additional Spare Parts and Accessories

See Page 665 Check before Printing

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Large Capacity
1750 & 2000 Series WHISPER® Loaders

1750VPA Self Cleaning WHISPER® Loaders

1¾" Inlet

Self Cleaning Model - Pulses of air to clean the filter (Includes air filter regulator and mounting bracket)

2000VPA-6M Self Cleaning WHISPER® Loaders

2" Inlet

IMPROVED Brush Style Motor
- lasts longer / less maintenance

Self Cleaning Model - Pulses of air to clean the filter (Includes air filter regulator and mounting bracket)

Quick release clamps - Easy maintenance of motor and filter

Pre-drilled flange - Quick installation onto hopper lid

Proximity switch - Improves accuracy and reliability of material loading

Microprocessor based controller with push button keypad and digital display inside NEMA-1 rated enclosure
- Provides user friendly, simple programming

- Heavy gauge aluminum body
- 120V/60/1 brush type motor with 10' cord, 8 amps
- CSA approved
- Quiet-by-pass air cooled motor with sound deadening
- Built in circuit breaker overload protection
- 12' control cord length
- 1750VPA: 13/4" inlet port 2000VPA: 2" inlet port

2 Year Warranty

2000VPA shown

continued on next page

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1750 Series WHISPER® Loaders

Includes:

- Aluminum pick-up wand
- 10’ of 1¾" grounded loader hose
- 2 adjustable clamps
- 10’ grounded power cord and plug

Specifications

Required Voltage: 120/60/1

Item #	Style	Model	Throughput**	Filter	Dimensions	Weight Unit / Ship	Unit Price
132424	Self-Cleaning	1750VPA	2000 lbs/hr	106026 Polyester Felt	34"H x 15"D	28 / 48 lbs	**Inquire**

**Test Conditions: 35# cu/ft of round polypropylene pellets (free flowing material/powder) conveyed 10’ up and into loader

2000 Series WHISPER® Loaders

Includes:

- Aluminum pick-up wand
- 10’ of 2” grounded loader hose
- 2 adjustable clamps
- 10’ grounded power cord and plug

Specifications

Required Voltage: 120/60/1

Item #	Style	Model	Throughput*	Filter	Dimensions	Weight Unit / Ship	Unit Price
170658	Self-Cleaning	2000VPA-6M	2500 lbs/hr	106026 Polyester Felt	37.25"H x 15"D	28 / 48 lbs	**Inquire**
Add-on Proportioning Valve							
158416	Model SPV-50UC Add-on Proportioning Valve - See page 659 for details. Includes: Control Box, Valve, Pick-Up Wand, Hose and Hose Clamps						**Inquire**

*Test Conditions: 35# cu/ft of round polypropylene pellets (free flowing material/powder) conveyed 10’ up and into loader

Replacement Filters

Replacement filters for Self Cleaning Loader		
105977	14" nylon filter	**Inquire**
106026	14" polyester filter	
105990	14" gasket	

PTFE coated filters available — Inquire

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IMS 1250 Series Loaders

Mini Loader

Replacement Parts

Item #	Description	Unit Price
105986	9” dia. nylon filter (for 1250A)	Inquire
106036	9” dia. polyester felt filter (for 1250VP and 1250PLVPA)	Inquire
120065	Powder loader filter (for PL1250 — requires 1)	Inquire
106002	9” gasket for all 9” filters	Inquire
106021	Vacuum motor with fan (for 1250A, 1250VP and 1250PLVPA)	Inquire
105987	Brush kit (change brushes every 300 hours)	Inquire
138088	Programing Chip for EZ Module/PLC (for 1250VPA, 1500VPA, 1750VPA and 2000VPA)	Inquire
118589	Toggle switch, on/off (for all 1250 and 1500s)	Inquire
116286	Proximity switch (for all 1250’s and 1500s)	Inquire
106056	Solenoid valve, 4-way (1250VP and 1250PLVPA)	Inquire
114245	Motor housing connector, 6 pin (for PLs and VPs)	Inquire
107656	Motor housing connector, 7 pin (for PLVPAs)	Inquire
116050	Proximity cord (for 1250A and 1500A)	Inquire
106023	1¼" pick-up wand (see page 668 for more selections)	Inquire

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Tech Tips

Be sure and change the motor brushes regularly. Not doing so is the number one cause of motor failure and down time. If you use glass filled material, order a stainless steel unit to prevent plastic contamination from premature aluminum body wear.

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IMS 1500 Series Loaders

WHISPER® Loader

Replacement Parts

Made in the U.S.A

Item #	Description	Unit Price
105977	14” dia. nylon filter (for 1500A)	Inquire
106026	14” dia. polyester felt filter (for 1500VP and 1500PLVPA)	Inquire
120065	Powder loader filter (for PL1500 — requires 3)	Inquire
105990	14” gasket for all 14” filters	Inquire
106008	60 psi filter regulator (for 1500A, 1500VP and 1500PLVPA)	Inquire
106021	Vacuum motor with fan (for 1250A, 1250VP and 1250PLVPA)	Inquire
105987	Brush kit (change brushes every 300 hours)	Inquire
105970	Flapper only (for all 1500's)	Inquire
105978	Lid, latch and sound hood (for 1500VP and 1500PLVPA)	Inquire
106052	Check valve assembly (for 1500PLVPA)	Inquire
119984	Proportional cylinder port plugs (for 1500PLVPA)	Inquire
138088	Programing Chip for EZ Module/PLC (for 1250VPA, 1500VPA, 1750VPA and 2000VPA)	Inquire
119393	Pulse valve assembly (for 1500VP and 1500PLVPA	Inquire
118589	Toggle switch, on/off (for all 1250 and 1500s)	Inquire
116286	Proximity switch (for all 1250’s and 1500s)	Inquire
106056	Solenoid valve, 4-way (1250VP and 1250PLVPA)	Inquire
106031	Motor housing connector, 5 pin (for 1500A)	Inquire
114245	Motor housing connector, 6 pin (for PLs and VPs)	Inquire
107656	Motor housing connector, 7 pin (for PLVPAS)	Inquire
106014	12’ Interconnect cord, 5 pin (for 1500A)	Inquire
109118	12’ Interconnect cord, 6 pin (for 1500A)	Inquire
106714	12’ Interconnect cord, 7 pin (for 1500A)	Inquire
116050	Proximity cord (for 1250a and 1500a)	Inquire
105999	Control box, complete assembly (for 1500A)	Inquire
106033	1½" pick-up wand (see page 668 for more selections)	Inquire

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IMS Series Compressed Air Loaders

Fully Automated, On-Demand Material Conveying

Replaces the DAC Compressed Air Loader

Compressed Air Design - Reduces ambient sound over noisy vacuum motors. Low maintenance, no motor brushes to change.

On-Demand Style - Can operate as a standalone unit for pulling from bags, drums, material bins, gaylords, granulators & material dryers.

Stainless Steel, Versatile Design - Clean operation, prevents contamination, wear resistant

- Up to 125 lbs conveying per hour at 15' vertical distance
- Simple to operate electrical controller (110V standard / 220V optional) limited adjustments
- Quick and easy installation
- Replacable wear plate
- Quick release clamp for ease of cleaning
- Minimal material transfer limits exposure to moisture
- Requires 90psi air pressure to operate
- 1¼" vacuum inlet port

Includes:

- Stainless steel receiving unit w/ sight glass, adjustable proximity switch and pleated filter
- Controller w/ mounting bracket, adjustable air filter regulator and 6' power cord w/ grounded plug
- Mounting flange
- Line-Vac, gaylord/drum wand and take-off box wand
- 10' of 1¼" ID vacuum hose and clamps
- 8' of airline tubing to connect Line-Vac to controller

Item #	Style	Model	Throughput	Shot Capacity	Inlet O.D.	Flange	Unit Price
175076	Press Mounted	CAL-1	125 lbs/hr	10 oz with continuous action	1¼"	6" x 6"	**$1,495.00**
175077	Hopper Mounted	CAL-2				4" x 4"	**1,495.00**

Spare Parts		
175144	Control Box 110V (CAL)	**Inquire**
175145	Control Box 220V (CAL)	**Inquire**
175148	Filter (CAL)	**Inquire**
175149	Proximity Switch / AC Sensor (CAL)	**Inquire**
163070	Sight Glass for DAC-1 and DAC-2*	**$24.60**
125622	Line Vac™ / Eductor*	**176.00**
163625	Wand Only (no eductor) 1¼" O.D.*	**77.44**
159734	Filter (DAC)	**47.00**
147555	Controller with Regulator (DAC)	**643.10**
112094	Proximity Switch / Sensor with cable (DAC)	**153.00**

*Compatible with DAC and CAL Models

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SHINI US Compressed Air Venturi Hopper Loader

Fully Automated, On-Demand Material Conveying

Ideal for use with beside the press dryers or when you need to efficiently transfer small amounts of material on demand.

Stainless steel construction - Provides clean operation

Adjustable level sensor - Signals material status for efficiency

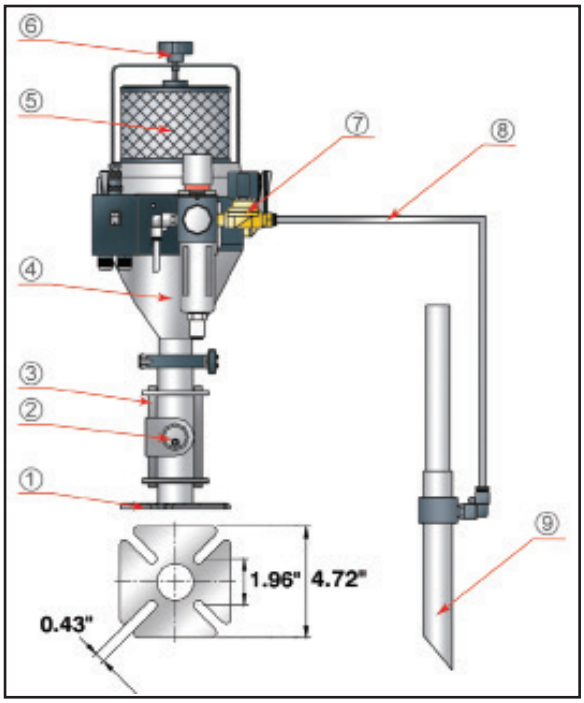
Wide diameter hopper - Allows material to flow without bridging

Filtered exhaust - Keeps shop free of pollutants

Compressed air filter and regulator - Eliminates moisture and maintains steady air pressure

- Quick release clamps for easy cleaning
- Adjustable direction of hopper and base
- Faster material changes
- Mounts directly onto machine throat
- Low maintenance filter assembly
- Compact and light weight

1 Year Warranty



1. Base
2. Proximity sensor
3. Flange connecting rod
4. Hopper
5. Air filter
6. Filter hold-down knob
7. Compressed-air filter, regulator and solenoid valve
8. Air hose
9. Pick-up wand

INCLUDES:
- 12' grounded loader hose, 1¼" ID
- 3' stainless steel pick-up wand

IMS Item # 110V (Shini Model #)	Throughput	Hopper Capacity	Compressed Air Pressure	CFM	Level Switch	Inlet O.D.	Dimensions	Weight	Unit Price
149534 (VL-120I)	400*	0.1 cu ft	70-90 PSI	26	Proximity Sensor	1¼"	21¼" x 9½"	15 lbs	**1,425.00**

*20' maximum conveying distance

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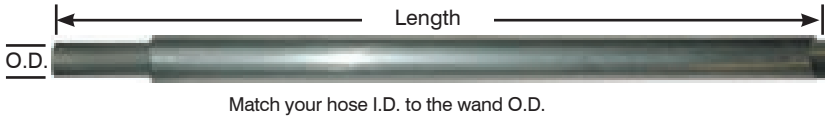
Stainless Steel Pick-Up Wands

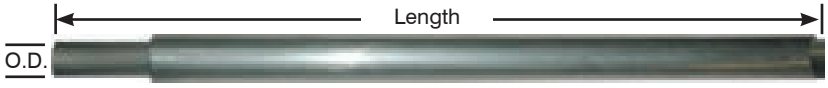


Match your hose I.D. to the wand O.D.

Dual tube design adjusts airflow easily. Simply loosen the thumb screw, slide the inner tube up or down to achieve desired flow and retighten thumb screw

O.D. x Length	Standard Wand	with Bag Protector	Adjustable with Bag Protector*
1" x 36"	136284	136285	136319
1¼" x 36"	136287	136288	136323
1½" x 36"	136290	136291	136327
1¾" x 36"	136294	136295	136331
2" x 42"	136298	136299	136335
2¼" x 42"	136302	136303	N/A
2½" x 42"	136306	136307	136339
3" x 42"	136310	136311	136343

Aluminum Pick-Up Wands



Dual tube design adjusts airflow easily. Simply loosen the thumb screw, slide the inner tube up or down to achieve desired flow and retighten thumb screw

O.D. x Length	Standard Wand	with Bag Protector	Adjustable with Bag Protector*
1" x 36"	136282	136283	136317
1¼" x 36"	106023	136286	136321
1½" x 36"	106033	136289	136325
1¾" x 36"	136292	136293	136329
2" x 42"	136296	136297	136333
2¼" x 42"	136300	136301	N/A
2½" x 42"	136304	136305	136337
3" x 42"	136308	136309	136341

Economical Aluminum & Stainless Steel Pick-Up Wands

Standard Features:

- 48" long body
- Adjustable air flow
- Angle cut on end with bag protector loop

Simply cover or uncover holes to regulate suction

O.D.	Length	Material	Item #	Material	Item #
1¼"	48"	Aluminum	141925	Stainless Steel	165325
1½"			141926		165326
2"			141927		163691
2½"			165324		165327
3"			147838		165328

Custom Probes Made to Order — *Inquire*
Hopper Loader Probe Magnets — See Page 804

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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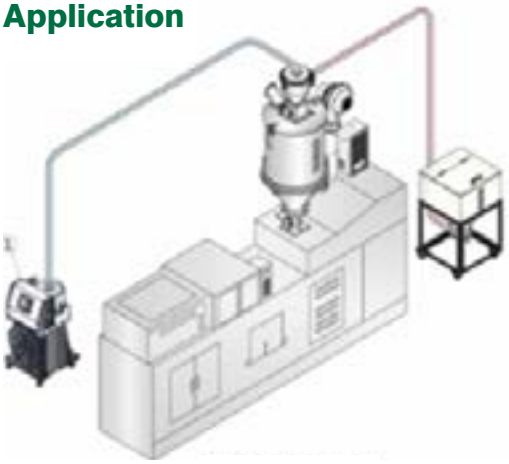
SHINI Single Station Hopper Loader Systems

Heavy Duty Blowers with Separate Single Receiver Body

Application



1 Year Warranty

Features

- Floor Level Blower & Controller
- Separate Stainless Steel Receiver
- Microprocessor Controller
- Audible Material Shortage Alarm
- RS485 Communication Interface
- On board controller compatible with Shini SPV-U Proportional Valve (see page 657)

Single Station Loading System

Item #	Shini Model	Required Vacuum Receiver	Conveying Capacity*	Motor HP	Material Pipe (In)	Vacuum Pipe (In)	Power Supply	Dimensions L	W	H	Weight (lbs.)	Unit Price
173864	SAL-5HP-UG	SHR-24U	2423 lbs./hr	5	2"	2"	460/60/3	19"	23"	54"	163	**3,075.00**
173788	SAL-10HP-UG	SHR-36U	4957 lbs./hr	10	2"	2.5"	460/60/3	23"	27"	72"	352	**7,145.00**

* Test conditions: 40lbs/cu. ft. plastic material conveyed 13' vertical, 16' horizontal

Vacuum Receiver Bodies

Item #	Single Station Hopper Receiver	Hopper Capacity cu. ft.	Material Line Size	Vacuum Line Size	Dimensions L	W	H	Weight (lbs.)	Unit Price
171157	SHR-3U	0.1	1.5"	1.5"	15"	11"	23"	10	**RFQ**
173865	SHR-6U	0.2	1.5"	1.5"	17"	12"	23"	18	**595.00**
173866	SHR-12U	0.4	1.5"	1.5"	24"	13"	27"	20	**720.00**
173896	SHR-24U	0.8	2"	2"	19"	13"	32"	31	**920.00**
173867	SHR-36U	1.3	2"	2.5"	19"	13"	40"	33	**RFQ**

Just In Time Receiver Body also available. Call for details.

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SHINI Single Vacuum Hopper Loader Systems

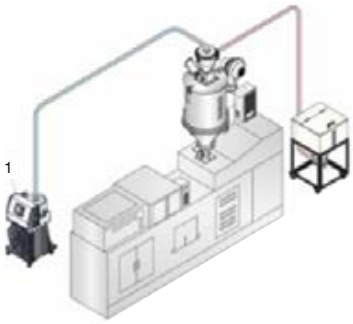
Floor Level Blowers with Separate Receiver Body

Shini USA SAL-G Single Vacuum Hopper Loader Systems are designed to convey material over long distances with a combination floor-level vacuum system & separate receiver body. The receiver body is mounted to the machine/hopper while the main unit's vacuum motor and controls are located on the blower for easy control and maintenance. Each unit comes with microprocessor controls, digital display, air filter, and low material alarm.

Features

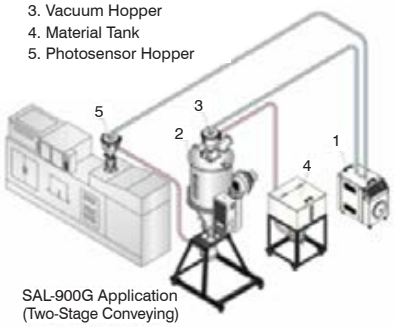
- Floor Level Blower & Controller
- Heavy Duty Casters
- Microprocessor Controller
- Audible Material Shortage Alarm
- RS485 Communication Interface

1 Year Warranty



SAL-800G Application

1. Vacuum Loader
2. "Standard" Hopper Dryers
3. Vacuum Hopper
4. Material Tank
5. Photosensor Hopper



SAL-900G Application
(Two-Stage Conveying)

Single Vacuum Hopper Loader System

Item #	Shini Model	Required Hopper Receiver	Conveying Capacity*	Motor HP	Motor Type	Power Supply	Conveying Pipe Size	Dimensions L	W	H	Weight (lbs.)	Unit Price
173874	SAL-810G	SMH-6L or SVH-6L	749 lbs./hr	1	Induction	230V	1.5"	17"	16"	26"	100	**1,255.00**
173875						460V						**1,255.00**
173877	SAL-820G	SMH-12L or SVH-12L	1410 lbs./hr	2	Induction	230V	1.5"	17"	16"	26"	110	**1,535.00**
173878						460V						**1,535.00**

* Test conditions: 40lbs/cu. ft. plastic material conveyed 13' vertical, 16' horizontal

Standard Hopper Mount (SMH) & Just-in-Time Sight Glass (SVH) Receiver Bodies

Item #	Hopper Receiver	Hopper Capacity cu. ft.	Conveying Pipe Size	Filter	Dimensions L	W	H	Weight (lbs.)	Unit Price
173885	SVH-6L*	0.2	1.5"	Stainless Steel Mesh	12"	10"	23"	13	**675.00**
173886	SMH-6L†	0.2	1.5"	Stainless Steel Mesh	12"	10"	18"	16	**355.00**
173887	SVH-12L*	0.4	1.5"	Stainless Steel Mesh	14"	12"	27"	22	**785.00**
173888	SMH-12L†	0.4	1.5"	Stainless Steel Mesh	14"	12"	21"	16	**495.00**

* Photo Sensor & Reverse Stop Flap
† Mechanical Flap & Micro Switch

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SHINI Multi Station Hopper Loader Systems

Heavy Duty Blowers and Multi-Station Receiver Bodies

Shini SAL-UG-122/124 Multi-Station Loader Systems are designed to convey material to two or four separate stations with a combination floor-level vacuum system & separate receiver bodies. The receiver bodies are mounted to multiple machines/ hoppers while the main unit's vacuum motor and controls are located on the blower for easy control and maintenance. Each unit comes with microprocessor controls, digital display, air filter, and low material alarm.

1 Year Warranty

Features

- Floor Level Blower & Controller
- 2 or 4 Hopper Loading System
- Separate Stainless Steel Receiver
- Microprocessor Controller
- Audible Material Shortage Alarm
- RS485 Communication Interface
- 460 Volt/60/3 Phase

2 Station Mini Central Loading System

Item #	Blower Model	Required Receiver	Conveying Capacity (Lbs./Hr)*	Motor HP	Conveying Pipe OD	Vacuum/ Suction Pipe OD	Dimensions H	W	D	Weight (lbs.)	Unit Price
173403	SAL-5HP-UG122	SHR-12U-S (x2)	2666	5	1.5"	2"	55"	22"	24"	386	**3,845.00**
173890	SAL-10HP-UG122	SHR-36U-S (x2)	4076	10	2"	2.5"	79"	27"	32"	408	**7,975.00**

4 Station Mini Central Loading System

Item #	Blower Model	Required Receiver	Conveying Capacity (Lbs./Hr)*	Motor HP	Conveying Pipe OD	Vacuum/ Suction Pipe OD	Dimensions L	W	H	Weight (lbs.)	Unit Price
171962	SAL-5HP-UG124	SHR-12U-S (x4)	2666	5	1.5"	2"	25"	23"	54"	385	**4,260.00**
173891	SAL-10HP-UG124	SHR-36U-S (x4)	4076	10	2"	2.5"	31"	29"	72"	407	**9,325.00**

Multi-Station Receiver Bodies (Used with 2 or 4 System Blowers Only)

Item #	Shini Model	Hopper Capacity cu. ft.	Conveying Inlet OD	Material Sensor	Dimensions H	W	L	Weight (lbs.)	Unit Price
173893	SHR-3U-S	0.1	1.5"	Prox Sensor	23"	11"	15"	10	**860.00**
173894	SHR-6U-S	0.2	1.5"	Prox Sensor	22"	12"	15"	18	**995.00**
173443	SHR-12U-S	0.4	1.5"	Prox Sensor	19"	13"	24"	20	**1,130.00**
173404	SHR-24U-S	0.8	2"	Prox Sensor	32"	13"	19"	30	**1,315.00**
173892	SHR-36U-S	1.3	2"	Prox Sensor	41"	13"	19"	35	**1,450.00**

* Test conditions: 40lbs/cu. ft. plastic material conveyed 13' vertical, 16' horizontal

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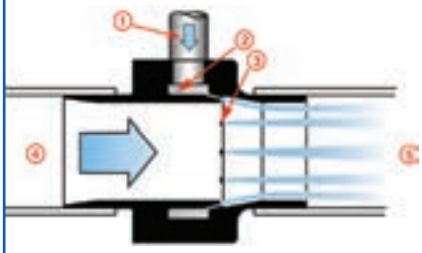
Line Vac™ Air Operated Material Conveyor

A fast, low cost way to convey large volumes of plastic pellets, regrind — even small parts — over long distances

- Standard Duty, Medium Duty and Heavy Duty
- Available in Aluminum, 303 Stainless Steel and Hardened Alloy Steel (316 Stainless Steel available for excellent corrosion resistance)
- Connect with existing Vacuum Hose or NPT Couplings
- Maximum Temperature usage of 275° F/135°C (High heat up to 900°F / 482°C available)
- Multiple Line Vacs™ can be put in a series to cover long distances
- Line Vacs™ can be used with existing material loaders to assist in moving hard to transfer material
- NEW Heavy Duty Line Vacs™ made of Hardened Alloy Steel are specially engineered to convey materials over longer vertical and horizontal distances and the construction helps prevent premature wear



HOW IT WORKS:

Compressed air flows through inlet (1) into an annular plenum chamber (2). It is then injected into the throat through directed nozzles (3). These jets of air create a vacuum at the intake (4) which draws material in and accelerates it through the unit (5) at long vertical or horizontal distances.

Line Vac™

The Line Vac™ is a material loader AND MORE! It is easy to install and use. Regulating the compressed air pressure provides infinite control of the conveying rate. It's compact. It's quiet, and, since there are no moving parts, it is virtually maintenance-free.

Threaded Line Vac™

The Threaded Line Vac attaches easily to plumbing pipe couplers, making it easy to build a complete, powerful conveying system using ordinary pipe and fittings.

Loader Hose, Hose Clamps (sold separately) and Pipe are shown for illustration only.

Best of all, a Line Vac™ costs far less than a typical, single purpose vacuum loader.

Non-Threaded Line Vac

	Item #	NPT	Air Inlet NPT	Material	Temp Rating	Corrosion Resistance	Air Consumption SCFM	Air Consumption SLPM	Vacuum Rating "H2O	Vacuum Rating kPA	Unit Price
Standard Duty	126749	0.75	¼"	Aluminum	275°F (135°C)	FAIR	10.70	303	-72	-18	**$144.00**
	126750	1	¼"				14.70	416	-42	-11	**158.00**
	125622	1.25	¼"				25.90	733	-42	-11	**180.00**
	125555	1.50	⅜"				33	934	-36.8	-9	**218.00**
	125623	2	⅜"				45	1,274	-28.5	-7	**259.00**
	126751	2.50	⅜"				59	1,656	-23.5	-6	**375.00**
	126752	3	½"				69	1,939	14.7	-4	**593.00**
	126753	4	½"				95	2,690	13.6	-3.4	**830.00**
	126754	5	½"				128	3.625	-10.5	-2.6	**1,099.00**

continued on next page

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continued on next page

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	Item #	NPT	Air Inlet NPT	Material	Temp Rating	Corrosion Resistance	Air Consumption SCFM	Air Consumption SLPM	Vacuum Rating "H20	Vacuum Rating kPA	Unit Price
Medium Duty	126736	0.75	¼"	303 Stainless Steel	400°F (204°C)	GOOD	10.70	303	-72	-18	**$416.00**
	126738	1	¼"				14.70	416	-42	-11	**440.00**
	126756	1.25	¼"				25.90	733	-42	-11	**477.00**
	126740	1.50	⅜"				33	934	-36.8	-9	**517.00**
	126741	2	⅜"				45	1,274	-28.5	-7	**550.00**
	126744	2.50	⅜"				59	1,656	-23.5	-6	**988.00**
	126746	3	½"				69	1,939	14.7	-4	**1,795.00**
	126748	4	½"				95	2,690	13.6	-3.4	**2,742.00**
Heavy Duty	168588	0.75	¼"	Hardened Alloy Steel	400°F (204° C)	GOOD	26	736	-144	-36	**$555.00**
	168589	1	¼"				35	991	-105	-26	**620.00**
	168590	1.25	¼"				49	1,388	-83	-21	**686.00**
	168591	1.50	⅜"				55	1,557	-60	-15	**740.00**
	168973	2	⅜"				75	2,124	-42	-10	**810.00**
	168592	2.50	⅜"				90	2,548	-28	-7	**1,227.00**
	168593	3	½"				108	3,058	-20	5	**1,930.00**

Threaded Line Vac

	Item #	NPT	Air Inlet NPT	Material	Temp Rating	Corrosion Resistance	Air Consumption SCFM	Air Consumption SLPM	Vacuum Rating "H20	Vacuum Rating kPA	Unit Price
Standard Duty	133930	0.75	¼"	Aluminum	275°F (135° C)	FAIR	10.70	303	-72	-18	**$184.00**
	133931	1	¼"				14.70	416	-42	-11	**203.00**
	133932	1.25	¼"				25.90	733	-42	-11	**254.00**
	133933	1.50	⅜"				33	934	-36.8	-9	**307.00**
	133934	2	⅜"				45	1,274	-28.5	-7	**366.00**
	168584	2.50	⅜"				59.50	1,656	-23.5	-6	**509.00**
	168585	3	½"				68.50	1,939	14.7	-4	**794.00**
Medium Duty	144335	0.75	¼"	303 Stainless Steel	400°F (204° C)	GOOD	10.70	303	-72	-18	**$530.00**
	144336	1	¼"				14.70	416	-42	-11	**599.00**
	144308	1.25	¼"				25.90	733	-42	-11	**648.00**
	144337	1.50	⅜"				33	934	-36.8	-9	**701.00**
	144338	2	⅜"				45	1,274	-28.5	-7	**764.00**
	168586	2.50	⅜"				59.50	1,656	-23.5	-6	**1,384.00**
	168587	3	½"				68.50	1,939	14.7	-4	**2,037.00**
Heavy Duty	168594	0.75	¼"	Hardened Alloy Steel			26	736	-144	-36	**$692.00**
	168595	1	¼"				35	991	-105	-26	**827.00**
	168596	1.25	¼"				49	1,388	-83	-21	**915.00**
	168597	1.50	⅜"				55	1,557	-60	-15	**991.00**
	168598	2	⅜"				75	2,124	-42	-10	**1,071.00**
	168599	2.50	⅜"				90	2,548	-28	-7	**1,469.00**
	168600	3	½"				108	3,058	-20	5	**2,315.00**

Mounting Brackets

for quick installation

(One required per Line Vac)

Item #	Line Vac Size	Unit Price
126737	¾" and 1"	**$36.00**
126739	1¼" and 1½"	**40.00**
126742	2" and 2½"	**44.00**
126747	3" and 4"	**53.00**
126755	5"	**66.00**

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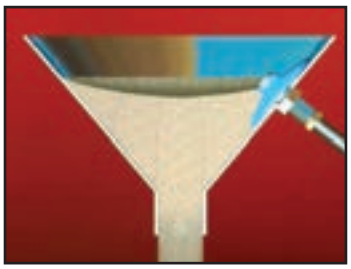
Pneumatic Hopper Agitator (Fluidizer)

The Solution to Hopper Product Bridging

- **Easy to install and use**
- **Easy on the bottom line**
- **Easy to adapt to solve your unique problem**
- **Includes Locking Nut and Steel Washer**

Tough: 350°F (170°C) max temperature
Tough: Silicone and EPDM material
Tough: Steel or stainless steel



Air Consumption 10-20 CFM @20-30 PSI

Aeration loosens up the product allowing it to flow easier. Minimum back pressure puts air energy where it is needed the most — in the hopper or silo.

Directional Air Flow: The fluidizer disk forces air to move along the bin wall freeing up product and assuring good clean-out.

Gentle Vibration keeps the product flowing with-out allowing it to compact or plug.

No Airline Plugging: Patented disk seals tightly against the hopper or silo wall and prevents airline plugging.

Robust Design: The disk will not tear, pick up moisture and is unaffected by temperatures up to 350° F.

Material Compatible: Silicone rubber standard in blue or white (both food grade/FDA approved), or black or white EPDM.

Steel Pneumatic Agitator
Item No. 135221

Stainless Steel, Food Grade Pneumatic Agitator
Item No. 135211

Mini Stainless Steel, Food Grade Pneumatic Agitator 2" O.D. 1/8" Female THD
Item No. 144037

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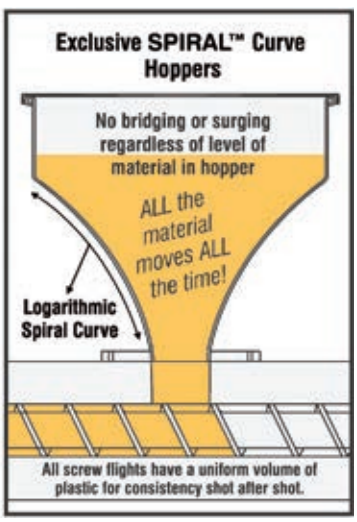
IMS Stainless Steel Feed Hoppers

Choose the Style Best Suited for your Material

Exclusive SPIRAL™-Curve Hopper

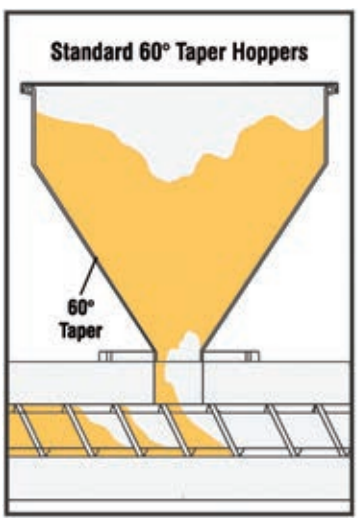
The IMS SPIRAL™-Curve Hopper uses a natural logarithmic curve to feed material at a remarkably consistent rate. No bridging or surging occurs. Whether full or nearly empty, the SPIRAL™-Curve Hopper steadily feeds any type or shape of material, including coarse or mixed material. The screw flights are consistently full. Your process becomes more predictable and repeatable, improving part quality.



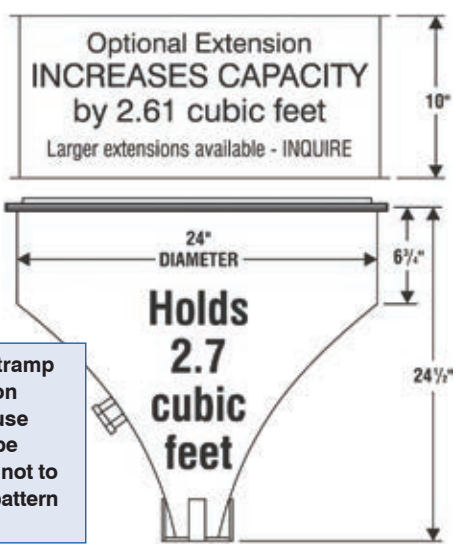
Ideal for coarse or mixed material

Standard 60° Taper Hopper

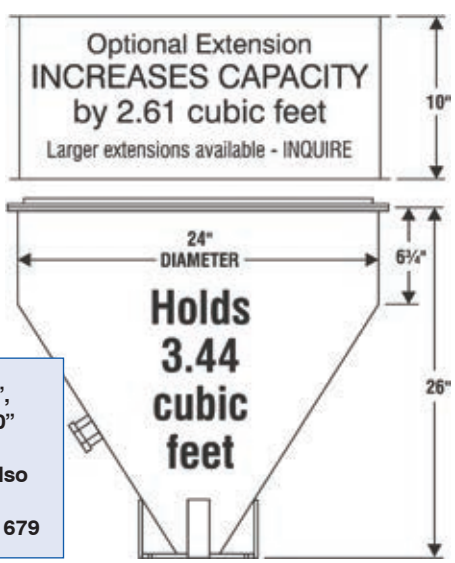
IMS standard 60° Taper Hoppers are designed to replace originally purchased equipment. A variety of sizes and extensions let you buy just the right equipment for your shop at an affordable price. The OEM Replacement Hopper from IMS is well suited for virgin material.



Works best with free flowing virgin material



NOTE: Where tramp metal protection is necessary, use only drawer-type magnets so as not to interrupt flow pattern in hopper.



NOTE: 12", 16" and 20" diameter hoppers also available
See Page 679

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Made in the U.S.A

IMS Select SPIRAL™-Curve Stainless Steel Hoppers

Feed Material at a Remarkably Consistent Rate

A press needs consistent, smooth intake from its hopper to assure quality products. Traditional tapered hoppers can feed material into the screw in surges, resulting in voids and clumps. But the IMS SPIRAL™-Curve Hopper makes smooth intake possible. Recognizing this, some press manufacturers install IMS SPIRAL hoppers as original equipment.

The IMS SPIRAL™-Curve Hopper uses a natural logarithmic curve to feed material at a remarkably consistent rate. No bridging or surging occurs. Whether full or nearly empty, the SPIRAL™-Curve Hopper steadily feeds any type or shape of material, including virgin or mixed material. The screw flights are consistently full. Your process becomes more predictable and repeatable, improving part quality.

- Logarithmic SPIRAL™-Curve design makes the flow of material more efficient, eliminating bridging
- Minimizes part rejects
- Retrofits any existing press
- Heavy duty mounting flange customized to your press
- Stainless steel construction

- Stainless steel lid
- Optional sight glass/drain shows material level
- Optional hopper extensions increase capacity up to nearly 400%

Made in the U.S.A

Conical, 60° Taper Stainless Steel Hoppers

For All Makes and Models of Injection Molding Machines

Excellent for free-flowing virgin material

IMS Standard, 60° Taper Hoppers are specially designed to replace OEM components. Thanks to our variety of sizes and economical, add-on extensions, IMS can provide exceptional quality hoppers at very affordable prices.

- Quality Type-304 spun stainless steel — suitable for food grade applications
- See lids and other accessories on pages 681-683
- Optional sight glass/drain permits viewing level of material
- Optional clamp-on extensions expand capacity (24" Dia. ONLY)

Lids Sold Separately

.65 Cu. Ft. Capacity	1.57 Cu. Ft. Capacity	2.75 Cu. Ft. Capacity	3.44 Cu. Ft. Capacity

SPIRAL™ is a trademark of IMS Company

IMS Company

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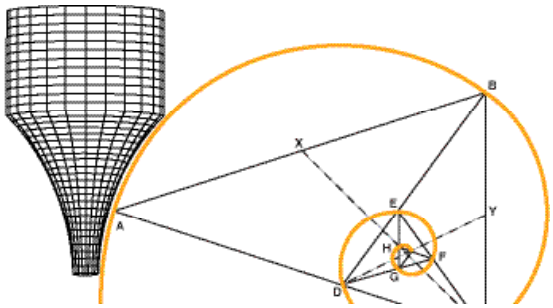
IMS Stainless Steel Feed Hoppers

Spiral™-Curve Hopper With Blank Flange					
Includes: Sight Glass/Drain					
Item #	Capacity	Hopper Diameter	Feed Throat	Flange Size	Unit Price
165862	2.7 Cu. Ft.	24"	3"	8" x 8"	**$2,155.00**

Spiral™-Curve Hopper With No Flange					
Item #	Capacity	Hopper Diameter	Feed Throat	Flange Size	Unit Price
112134	2.7 Cu. Ft.	24"	No Opening	N/A	**$1,452.70**

The SPIRAL™ Hopper
ONLY from IMS



Conical Hoppers With Blank Flanges					
Includes: Sight Glass/Drain					
Item #	Capacity	Hopper Diameter	Feed Throat	Flange Size	Unit Price
145043*	.65 Cu. Ft.	12"	2"	6" x 6"	**$480.00**
143349	1.57 Cu. Ft.	16"	2"		**712.00**
143350	1.57 Cu. Ft.		2½"		**712.00**
143351	1.57 Cu. Ft.		3"		**712.00**
143887	2.75 Cu. Ft.	20"	2½"		**816.00**
143423	3.44 Cu. Ft.	24"	3"	8" x 8"	**920.00**
143424	3.44 Cu. Ft.		4"		**920.00**

* 145043 does NOT include Sight Glass/Drain

See lids and other accessories on pages 679-681

See Custom Ordering Information on Page 683

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Stainless Steel Hoppers & Components

Customize your Hopper with all of the available accessories from IMS. Select from a wide variety of options - Flanges, Slide Gates, Sight Glasses, Lids, Extensions, and Drying packages - so that you have the exact hopper you need for your operation. Some of the options are pre-assembled and ready to ship today, while others are available with a short lead time.

A

Stainless Steel Hopper Cone Only				
	Diameter			
	12"	16"	20"	24"
Conical	120274	120283	120252	120208
Capacity lbs @ 35 lb/ft3	.65 cu/ft 22.75	1.5 cu/ft 54.95	2.75 cu/ft 96.25	3.44 cu/ft 120.4
Height	16"	22"	25½"	26"
Spiral	N/A	N/A	N/A	112134
Capacity lbs @ 35 lb/ft3	N/A	N/A	N/A	2.7 cu/ft 94.5
Height	N/A	N/A	N/A	24½"

Hopper with Custom Flange					
Style	Feed Throat Size	Diameter			
		12"	16"	20"	24"
Conical	Specify*	143353	143354	143355	143356
Spiral™ - Curve	Specify*	N/A	N/A	N/A	143357

*Flange dimensions required - see form on page 681

B

Add a Slide Gate* Up to 8" x 8"			
Diameter			
12"	16"	20"	24"
143111			

Includes 2 Spacers and Gate

*Flange dimensions required - see form on page 681

C

Add A Sight Glass 2" x 4" Clear Poly					Add A Sight Glass & Drain			
Diameter				OR	Diameter			
12"	16"	20"	24"		12"	16"	20"	24"
143338					143352			

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D

Stainless Steel Hopper Lids

Description	Diameter			
	12”	16”	20”	24”
Standard Lid (not clampable)	120284	120280	120251	120207
Hopper Lid: handle, hanging hook, clamping flange	N/A	N/A	N/A	112131
Hopper Lid: hanging hook, clamping flange, plus cut out to mount loader	N/A	N/A	N/A	143110
Hopper Lid: hanging hook, clamping flange (no handle)	N/A	N/A	N/A	113445

E

Extension Kits for 24” Diameter Hoppers (Spiral or Conical)

Description	Height	Item #
Cylinder Only	10”	112127
Extension Kit: Includes 10” stainless steel cylinder, band clamp and silicone gasket		121868
Drying Extension Cylinder Only		113157
Drying Extension Kit: Includes 10” stainless steel cylinder, dispersion cone kit, stainless steel band clamp and silicone gasket		114318
Cylinder Only	20”	125295
Extension Kit: Includes 20” stainless steel cylinder, band clamp and silicone gasket		126124

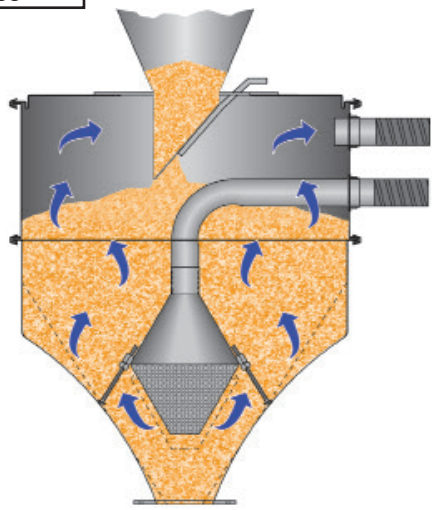
Replacement Parts

Description	Diameter	Item #
Band Clamp	24”	112139
Gasket	24”	112136

F

Hopper with Drying Kit

Style	Description	Item #
Conical	Complete Kit Includes: stainless steel hopper, lid, drying extension, 2 clamp rings, 2 gaskets, dispersion cone, inlet elbow, exhaust pipe and custom flange under 8” x 8”	121872
Spiral		121858



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continued on next page

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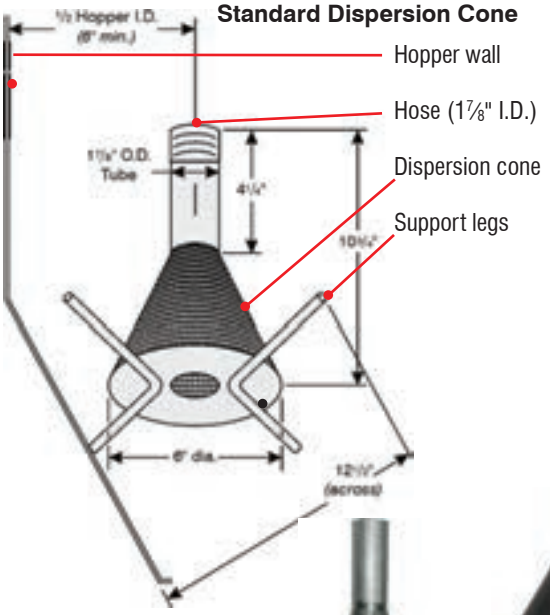
IMS Replacement Hopper Dryer Dispersion Cones

Increase your air flow to more uniformly disperse drying air throughout your hoppers. Available in adjustable and standard models, IMS Dispersion cones feature heavy-duty welded construction for a long service life.

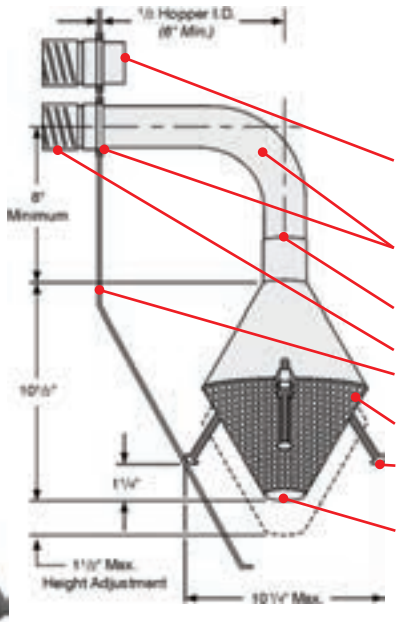
Made in the U.S.A

Standard Dispersion Cone



Steel
#108251

Stainless Steel
#111916



Adjustable Dispersion Cones can be used with all IMS SPIRAL™ -Curve and Conical Drying Hoppers, and all round, tapered hoppers.

- Air exhaust (2" dia.) optional for closed loop drying (requires 2⅝" dia. hole.)
- Elbow and air inlet with O-ring seal (requires 2⅜" dia. hole)
- Extension pipe (not shown)
- Hose (2" I.D.)
- Hopper wall
- Adjustable dispersion cone
- Captive, adjustable support legs (3 places)
- Sealed nose keeps air out of throat to prevent flow restrictions

Item #	Description	Unit Price
108251	Steel Economy Hopper Dryer Dispersion Cone with Non-Adjustable Legs for all square or round material hoppers	**$220.00**
111916	Stainless Steel Premium Hopper Dryer Dispersion Cone with Adjustable Legs for round material hoppers ONLY	**380.00**

Hopper Accessories

IMS provides a complete selection of all hopper connection needs. From pipes and inlets to seals and bolts, IMS can provide all your needs and if you do not see it on the list, IMS can get it for you.

#114317

#109400

#112144

Item #	Description	Diameter	OAL	Elbow Depth	Unit Price
Pipe Extensions / Exhaust Fitting					
114317	Stainless steel extension pipe	2"	14½"	N/A	**$75.50**
109400	Elbow for 18" hopper and air inlet fitting with O-ring seal			6½"	**105.00**
112330	Stainless steel elbow for 18" hopper and air inlet fitting with O-ring seal				**311.50**
112141	Elbow for 24" hopper and air inlet fitting with O-ring seal				**105.00**
Custom elbow sizes available — Inquire					
112144	Stainless steel air exhaust fitting with O-ring seal				**$79.10**

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IMS Stainless Steel Hoppers and Accessories

Hopper: (A) Item # _____

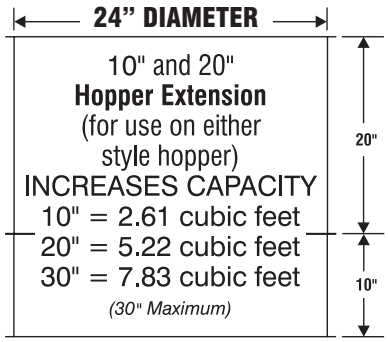
Options: (B) Item # _____

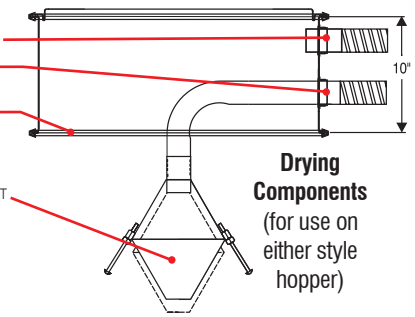
(C) Item # _____

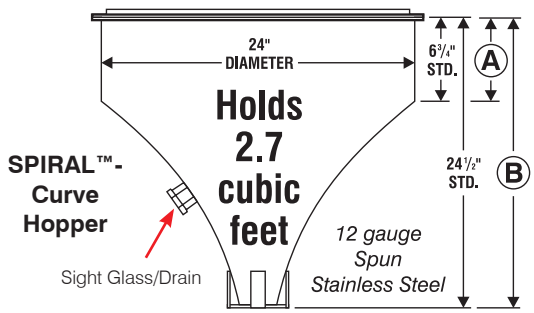
(D) Item # _____

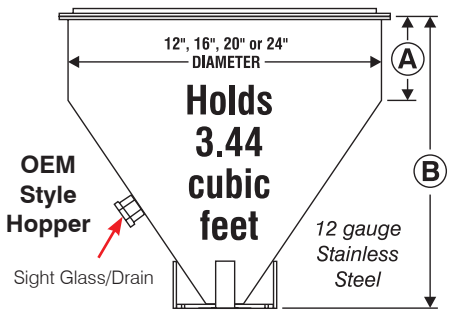
(E) Item # _____

(F) Item # _____



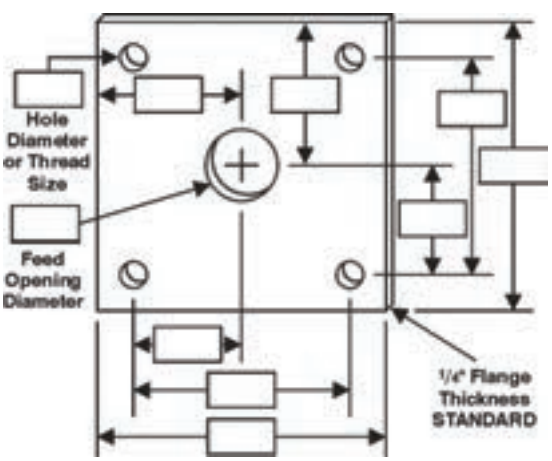






HOPPER DIMENSIONS		
Dia.	A	B
12"	7"	15⅞"
16"	9⅜"	21¾"
20"	10"	25½"
24"	6¾"	26"

Custom Mounting Flange Dimensions (Specify)



If rectangle - specify long or short end for slide gate

Date: _____

P.O.#: _____

Name: _____

Title: _____

Company: _____

Address: _____

City: _____

State: _____

Zip: _____

Phone: (_____) _____

FAX:(_____) _____

E-mail: _____

Machine Make: _____

Tonnage: _____

I understand that this item will be made to my specifications. No changes can be made after receipt of order.
It is a non-returnable item unless defective or IMS error.

Signature: _____

Note: Other flange configurations will be promptly quoted from your sketch or blueprint.

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Made in the U.S.A

IMS Low Material-Level Hopper Alarm

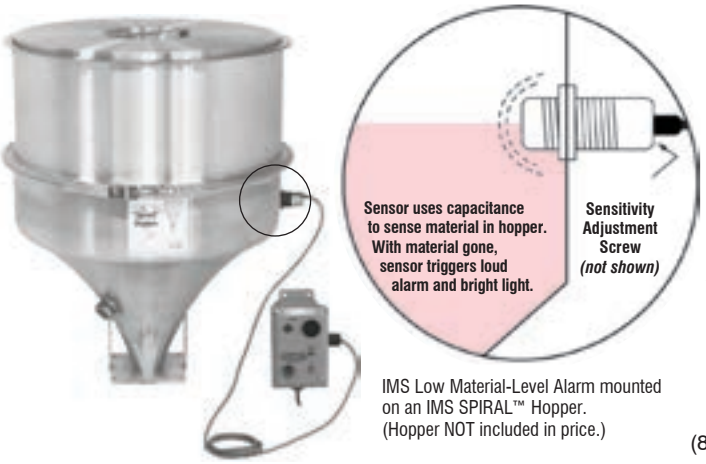
Automatically Senses Low Material Level In Hopper and Sounds Alarm

- Perfect monitor for manually-fed machines
- Great backup for automatic hopper loaders
- Durable construction — For all molding shops
- Reliable — Not affected by static in area

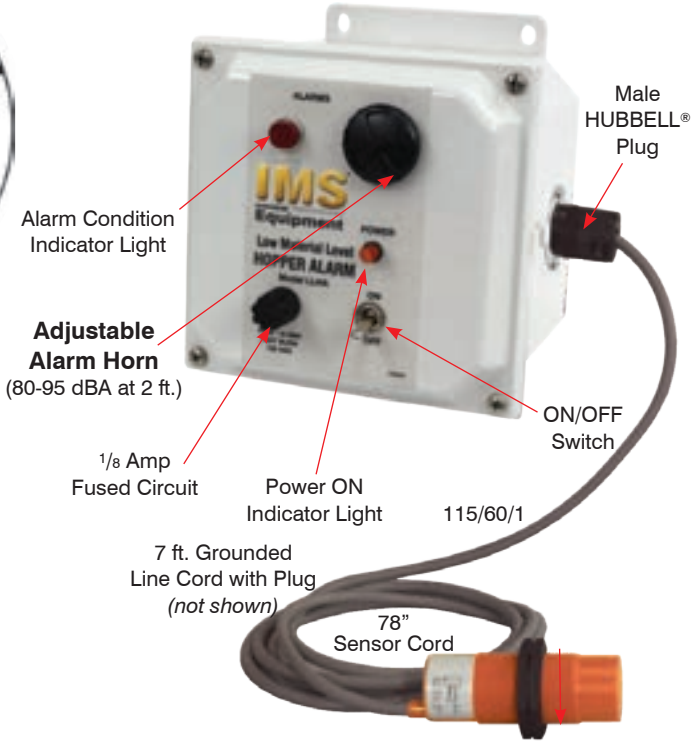
Only From IMS

Helps you Avoid Costly Empty Hopper Shut-Downs!

Typical Installation



IMS Low Material-Level Alarm mounted on an IMS SPIRAL™ Hopper. (Hopper NOT included in price.)



Specifications

Proximity Sensor: ..... Capacitive Type
Maximum Use Temp.: ..... 158° F
(475°F with Insulating Sensor Holder)
Control Box: ..... Rugged Thermoplastic
Dimensions: ..... 4" L x 4" W x 6" H
Weight: ..... 3 lbs, 9 oz.

Optional Insulating Sensor Holder made of high temperature PTFE protects sensor from temperatures up to 475°F
Also seals opening in hopper when sensor is not in place.

Proximity Sensor

Adjustable Sensitivity

Easy To Install
Requires one, 1¼" diameter hole

Completely Sealed — Easy to Clean
Can be removed and replaced in seconds

Low Material Level Alarm

Complete with Sensor, 78" Sensor Cord, Male HUBBELL® Plug, and 7' Grounded Line Cord with Plug.

Item No. 109821

$510.00

#163468	Insulating Sensor Holder	**$115.00 ea.**
#112094	Proximity Sensor with 78" Cord	**153.00 ea.**

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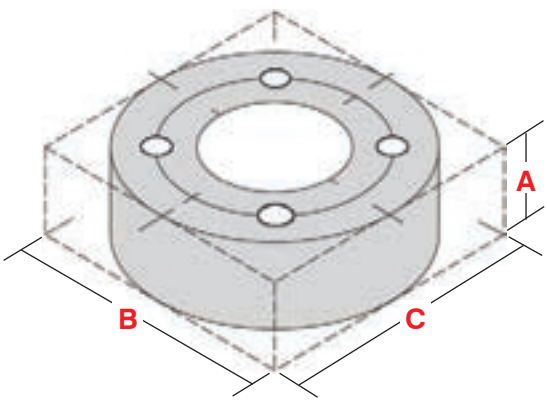
Replacement Hopper Lid/Vacuum Loader Stand Quote/Ordering Form

- Seals hopper from dirt
- Protects loader
- Keeps loaders upright for maintenance on bench or floor
- Custom made, quickly and affordably
- Square or round hoppers
- Aluminum or stainless steel standard

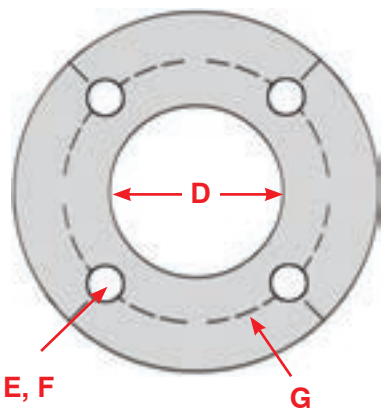
Hopper Dimensions Needed



A: Vertical space required below your loader flange when the dump flap is fully extended, plus 1" clearance.

B: If your hopper is round or square, measure the outside of your hopper at the widest point (width - including the lip), plus 1" clearance.

C: For rectangular hoppers, also measure the outside of the hopper at the longest point (length - including the lip), plus 1" clearance.



Specify:

1. Material: ❑ Painted Steel / Color: _____
   ❑ Aluminum ❑ Stainless Steel
2. (A) Stand Height: _____
3. (B) Diameter/Width: _____
4. (C) Length (Rectangular Only) : _____
5. (D) Loader Cut Out Diameter: _____
6. (E) Mounting Hole Diameter: _____
7. (F) Number of Mounting Holes: _____
8. (G) Diameter of Lid at the Center of Mounting Holes: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Dryers

DESICCANT

Dual Bed

Dri-Air Desiccant Dryers

- Functions independent of ambient conditions
- Dries hygroscopic material to lowest moisture content for processing
- Complete closed loop system allows for dew point temperatures below -40°F
- Requires desiccant beads that adsorb and release moisture without changing size
- True energy efficiency, can save up to 50% energy costs
- Effectively dries all types of plastics in virtually all environments

See Pages 686-695

Honeycomb Wheel

Shini Honeycomb Desiccant Wheel Dryer

- Honeycomb rotor design
- PID temperature controller
- Return air filter mounted inside cabinet

See Page 696

COMPRESSED AIR

Dri-Air Compressed Air Dryer

- Insulated stainless steel hopper
- Machine mounted
- Allows for dew point temperatures as low as -40° F
- Temperature Range: 70°F to 350°F
- Process up to 75 lbs/hr

See Page 701

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Dryers

HOT AIR

Machine Mount

Shini Hot Air Hopper Dryer

- Great price for general purpose applications
- Machine mounted standard (mobile cart available)
- All material contact surfaces made of stainless steel
- Hopper capacity ranges from 25lbs to 1850lbs
- .2 hp to 2 hp blower

See Page 706-707

OVENS

Ovens

- Ideal for small, multi-material batch drying
- Great for non-hygroscopic resins
- Function is dependent on ambient conditions
- Drawer and tray styles available
- Drying Temperature: 325°F – 518°F standard

See Pages 710-715

DRYING HOPPERS

Dri-Air Drying Hoppers

- Insulated stainless steel construction
- Unique diffuser basket allows for drying less than full hoppers
- Standard sizes range from 5 to 2000 lbs

See Page 694

IMS Mobile Drying Hopper

- Floor level hoppers allow for quick and easy changeover
- Stainless steel construction
- Works with non-hygroscopic resins
- For open or closed loop drying
- Requires connection of dryer for complete system

See Pages 708-709

Shini Drying Hoppers

- Stainless steel contact parts
- Elongated sight glass is standard

See Page 705

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DRI-AIR Desiccant Dryers

The Fastest Drying Time in the Industry

Hopper Mount, Dual Bed

Model AHM

By-the-Press, Dual Bed

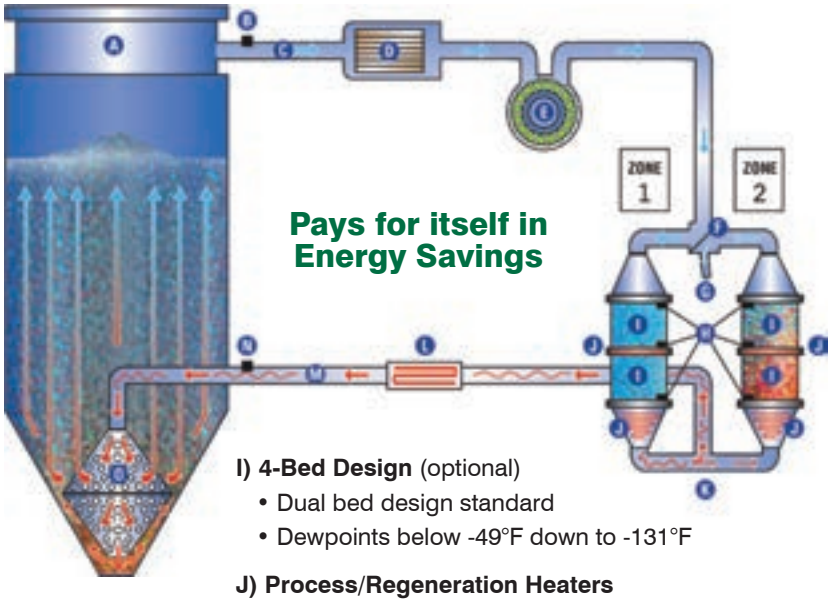
Model ARID-X

Portable, Dual Bed

Model APD

Energy efficient, temperature based desiccant regeneration adapts to ambient and material conditions — 50% more energy efficient than wheel dryers

The Dri-Air System / Airflow Schematic



Pays for itself in Energy Savings

A) Drying Hopper
- Insulated stainless steel
- Laser cut access door eliminates troublesome door gaskets

B) Temp Setback (optional)
- Prevents over-drying

C) Return Line

D) Dryer Filter Element

E) Single Blower Design
- Saves energy for both drying and regeneration air

F) Electric Dryer Valve
- No compressed air required
- High temp, self-adjusting, long-life seals
- 5 year warranty

G) Vent

H) Thermocouple Controlled Regeneration
- On demand, energy efficient regeneration
- No temperature spikes

I) 4-Bed Design (optional)
- Dual bed design standard
- Dewpoints below -49°F down to -131°F

J) Process/Regeneration Heaters

K) Slip Stream of Dry Process Air

L) Process Heater (on 50-CFM models and up)

M) Supply Line

N) Process Thermocouple

O) Air Diffuser Basket

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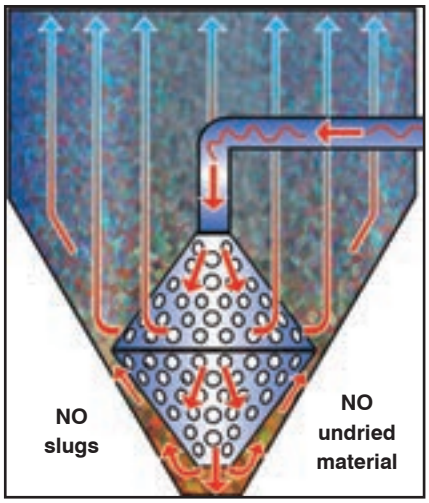
DRI-AIR Features

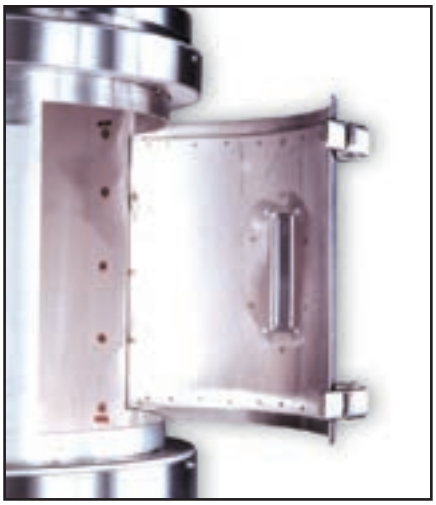
Hopper Features

(see hoppers on page 696)



Unique diffuser basket dries resin down to the slide gate and allows for drying less than full hoppers.

Diffuser basket is constructed of spun stainless steel with a slip coupling for easy removal.



Laser-cut access doors provide a smooth, tight fit and eliminates troublesome gaskets.

DRI-AIR vs. Wheel

- 40-60% more energy efficient than wheel dryers with no moving parts!
- Dewpoints as low as -130°F
- Dryers sized to dry all materials not just Polycarbonate
- Faster drying in any ambient conditions
- Ideal for demanding medical resins and applications
- On demand regeneration provides stable temperatures at the drying hopper

Controller Features

Dri-Touch (Hopper Mount)
7" Color Touch Screen

ADC
Advanced Dryer Control

Energy Comparison @ 50 lbs/hr
Cost Per Year @ 10¢ per kw/hr

$1,587	$3,360
DRI-AIR 1.8 kw	Wheel 4.8 kw

Common Features

- Dew point readout down to -49°F
- Easy setting of process temperature
- Blower rotation and open thermocouple detection
- Set start and stop times daily / Date and time indication
- Monitoring of heater current to check heater and relay conditions
- Automatic learn mode for heater currents at local voltage
- Adjustable high temperature and dew point alarm
- Closed-loop control valve position
- Actual fault indication - no codes to look up / Event log
- Temperature calibration for ISO 9000
- Optional ethernet control
- 5 YEAR WARRANTY

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Made in the U.S.A

DRI-AIR Hopper Mount, Dual Bed Desiccant Dryers

Conserve Valuable Floor Space

AHM Series

Features Below are Standard on AHM-2 through AHM-4
(NOT AHM-1)

Removable Plate for Loader Mount

Optional Hinged Lid for manual filling

Lid Locking Latch

Unique Internal Hopper Design
keeps hot air out of loader

Easy Access Filter

Electric Bed Change Valve
No compressed air required

5 Year Warranty

Temperature Range: 140°F to 300°F ±3°
NOTE: Water After-Cooler required for temps above 250°F. See page 697

Temperatures up to 350°F possible with optional Booster Heater. See page 689

Material View Window Sight Glass

Hinged Laser Cut Access Door
eliminates troublesome gaskets

Easily removable Stainless Steel Diffuser Basket (inside)

Slide Gate Shutoff

Power Disconnect Switch

High Pressure Vortex Blower

Model AHM-3 shown

6" x 6" Mounting Flange Standard

Dri-Air Diffuser Baskets dry resin down to the slide gate which allows drying less than full hoppers
— see page 689 for details

Dryers Include 6" x 6" Cast Aluminum Flange Adapter with 2½" ID Feed Throat and Material Drain Port

Dri-Touch 7" Color Touch Screen

-49°F Dewpoint Monitor, 7 Day Timer, Diagnostic Functions, Alarms, Resin Library, Ethernet Capable and Dri-Link Mobile App

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DRI-AIR Hopper Mount, Dual Bed Desiccant Dryers (continued)

Common Features

- Most energy efficient dryer in the market
- Single blower design for process and regeneration air
- Press / Extruder mounted dryers free up floor space
- Balanced design – reduces stress on feed throat
- Process Rates up to 35 lbs/hr

AHM-1

ELC Control Module

(Standard on AHM-1)

The ELC Control Module has been factory programmed and does not require any additional input by the operator.

The module will automatically monitor and control the dryer's operating parameters by timing the regeneration cycle as well as monitoring and controlling the regeneration heaters and dryer alarms.

AHM-2 through AHM-4

Item #	Item #	Dri-Air Model	Throughput lbs/hr	Hopper Capacity	Controller	Dimensions	Unit Price
110/60/1	**220/60/1**	**Dryers with Basic Temperature Control**					
144541	167972	AHM-1	10 lbs	30 lbs	ELC with High Temperature Alarm	22" x 21" x 28"	**$7,735.00**
230/60/3	**460/60/3**	**Dryers with ADC Advanced Dryer Control**					
170092	170093	AHM-2	25 lbs	60 lbs	ADC Controller	30" x 29" x 42"	**9,325.00**
170094	170095	AHM-3	35 lbs	100 lbs		30" x 29" x 38"	**9,525.00**
170096	170097	AHM-4	35 lbs	150 lbs		30" x 29" x 51"	**9,785.00**
Optional Carts - For Converting All Units to Mobile Dryers							
168205	For All AHM Models	Conversion Kit - Cart, Vacuum Takeoff & Casters (1¼" VTO Box Outlet)				18" x 30" x 30"	**1,850.00**
170098		Conversion Kit - Cart, Vacuum Takeof & Casters (1½" VTO Box Outlet)					**1,850.00**
170099		Conversion Kit - Cart, Vacuum Takeof & Casters (2" VTO Box Outlet)					**1,850.00**

Other Voltages Available - Inquire

Optional Accessories: Water After-Cooler (required for drying temps above 250° F), **Plasticizer Trap and more — See page 695**

4 Bed High Performance AHM Dryers for More Demanding Environments Available - INQUIRE

Mobile Cart

Model AHM Dryer shown on Mobile Cart

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DRI-AIR By-The-Press, Dual Desiccant Bed Dryers

Simplify placement and hook-up to hopper

Also good for use with hopper bank and multi-hopper systems

ADC Advanced Dryer Control:

- -49°F Dewpoint Monitor
- 7 Day Timer
- Diagnostic Functions
- Dewpoint, heater and temperature alarms

Temperature Range: 140°F to 350°F ±3°
NOTE: Water After-Cooler required for temps above 250°F see page 695

With dewpoints down to -49°F, you can be confident these units will dry all materials, regardless of ambient conditions

Thermocouple Plug

Through the door disconnect is standard on all models

Electric Bed Change Valve
–
No compressed air required

5 Year Warranty

Textured-Gloss Powder Coat Exterior Finish

GREEN Products

Energy efficient, temperature based desiccant regeneration adapts to ambient and material conditions
—
50% more energy efficient than wheel dryers

ARID-X Series

Model ARID-X25 shown

IMS Company

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Please refer to imscompany.com for current pricing

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DRI-AIR By-The-Press, Dual Desiccant Bed Dryers

Common Features

- Most energy efficient dryer in the market
- Single blower design for process and regeneration air
- On-demand regeneration; adapts to ambient conditions, materials and process rates
- Space-saving compact design available for process rates up to 200 lbs/hr.

ARID-X10 is the industry's smallest dual desiccant bed dryer - ONLY 21" high!

Ideal for lab, insert and micro-molding applications

ARID-X25 and ARID-X35

ARID-X50 and ARID-X100

ARID-X200

ARID-X10 Includes:

- 6' of insulated process hose and 6' non-insulated return hose

ARID-X25 and Larger Includes:

- Casters, 6' of insulated process hose and 8' of non-insulated return hose and through the door disconnect

Item #	Item #	Dri-Air Model	Throughput lbs/hr	Blower CFM	Max Temp	Supply Hose Dia.	Return Hose Dia.	Dimensions	Unit Price
115/60/1	**230/60/1**								
143403	170861*	ARID-X10	10 lbs	10	300°F	1"	1"	18" x 11" x 21"	**$6,650.00**
230/60/3	**460/60/3**								
143404*	170862*	ARID-X25	25 lbs	25	300°F	1½"	1¾"	24" x 17" x 38"	**$7,300.00**
143405*	170863*	ARID-X35	35 lbs	35	300°F	1½"	1¾"	24" x 17" x 38"	**7,575.00**
143406	170864	ARID-X50	50 lbs	50	350°F	2"	1¾"	32" x 24" x 50"	**9,700.00**
143407	170865	ARID-X100	100 lbs	100	350°F	2"	1¾"	32" x 24" x 50"	**11,510.00**
143408	170866	ARID-X200	200 lbs	200	350°F	3"	3"	36" x 42" x 64"	**15,750.00†**

* Temp up to 350° with optional booster heater

† 230V available for $800 upcharge

Other Voltages Available - Inquire

Optional Accessories: Water After-Cooler (required for drying temps above 250°F)
Plasticizer Trap and more — See page 695

4 Bed High Performance ARID-X Dryers for More Demanding Environments Available - Inquire

For Desiccant see page 697 **For Dryer Hose and Insulation see pages 407-409**

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DRI-AIR Portable, Dual Desiccant Bed Dryers

All In One Design Facilitates Placement, Hook-Up and Hopper Cleaning

With dewpoints down to -49°F,
you can be confident these units will dry all materials, regardless of ambient conditions

ADC Advanced Dryer Control:

- -49° F Dewpoint Monitor
- 7 Day Timer
- Diagnostic Functions
- Dewpoint, heater and temp alarms

Hopper cover includes an internal ring to prevent over filling of material and protect loader flap valves

Stainless steel, insulated Hopper

Laser cut access door eliminates troublesome gaskets and provides a smooth contact surface when closed

Built-in Push Handle

Insulated lower cone on 60 – 1,000 lb capacity hoppers promote faster and more efficient drying

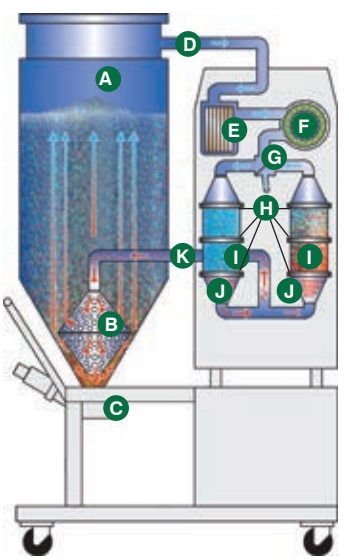
Vacuum Takeoff Port Standard

Temperature Range: 140° F to 350°F ±3°
NOTE: Water After-Cooler required for temps above 250°F see page 695

Textured-Gloss Powder Coat Exterior Finish

Hopper from 60 – 300 lb capacity are seamless – ideal for CD, DVD and medical molding

A Drying Hopper
B Air Diffuser Basket
C Vacuum Takeoff
D Return Line
E Dryer Filter Element
F Vortex Dryer Blower
G Electric Air Valve
H Thermocouples
I Desiccant Beds
J Process/Regeneration Heaters
K Supply Line



Made in the U.S.A

APD Series

Model APD-3 shown

Heavy Duty, Lockable Casters Standard

5 Year Warranty

GREEN Products

Electric Bed Change Valve – No compressed air required

50% more energy efficient than wheel dryers

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DRI-AIR Portable, Dual Desiccant Bed Dryers

Common Features

- Most energy efficient dryer in the market
- Temperature based regeneration; adapts to ambient and material conditions
- Single blower design will save up to 50% in energy costs
- Stainless steel hoppers have laser-cut access doors

Pay for Themselves in Energy Savings

APD-3

APD-10

All Units Include:

- Casters, vacuum takeoff (specify port size) and through the door disconnect

Item # 230/60/3	Item # 460/60/3	Dri-Air Model	Throughput lbs/hr	Hopper Capacity	Blower CFM	Max Temp	Dimensions	Unit Price
144077*	170867*	APD-1	7.5-10 lbs	30 lbs	25	300°F	25" x 39" x 57"	**$10,700.00**
144078*	170868*	APD-2	20 lbs	60 lbs	25	300°F	25" x 39" x 62"	**11,175.00**
144079*	170869*	APD-3	25 lbs	100 lbs	25	300°F	25" x 39" x 60"	**11,725.00**
144080*	170870*	APD-4	35 lbs	150 lbs	35	300°F	25" x 39" x 73"	**12,350.00**
144081	170871	APD-5	50 lbs	150 lbs	50	350°F	30" x 52" x 75"	**14,350.00**
142843	170872	APD-6	50 lbs	200 lbs	50	350°F	30" x 52" x 69"	**14,625.00**
144082	170873	APD-7	75 lbs	300 lbs	75	350°F	30" x 52" x 84"	**16,525.00**
144083	170874	APD-8	90 lbs	300 lbs	100	350°F	30" x 52" x 84"	**17,150.00**
144084	170875	APD-9	110 lbs	400 lbs	100	350°F	50" x 42" x 92"	**19,575.00**
144085†	170876	APD-10	150 lbs	600 lbs	150	350°F	50" x 42" x 112"	**23,650.00†**
144086†	170877	APD-11	200 lbs	600 lbs	200	350°F	50" x 42" x 112"	**24,925.00†**

*Temp up to 350°F with optional booster heater

†APD-10 and APD-11 230V available for $800 upcharge

Other Voltages Available - Inquire

Optional Accessories: Water After-Cooler (required for drying temps above 250°F), **Plasticizer Trap and more — See page 695**

4 Bed High Performance APD Dryers for More Demanding Environments Available - Inquire

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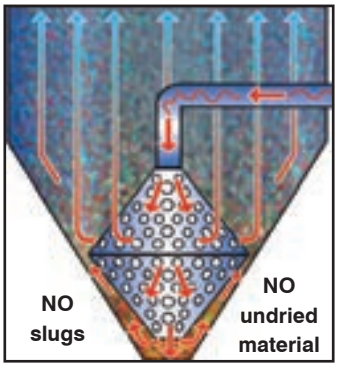
DRI-AIR Stainless Steel Drying Hoppers

Uniform Drying With Easy Accessibility for Cleaning

RH Series



Common Features

- Exclusive basket design assures dried material down to the slide gate
- Full length sight glass is standard on Models RH60 and larger
- Internal ring on hopper cover prevents damage to hopper loaders
- Easy-close slide gate on all sizes
- Insulated side walls eliminate heat loss and conserve energy

Item #	Dri-Air Model	Hopper Capacity	Flange	Feed Hole	Air Port Dia. In	Air Port Dia. Out	Dimensions	Unit Price
144625	RH5	5 lbs*	4 in²	2" dia.	1"	1"	8" dia. x 12" high	**$1,285.00**
175070	RH5	5 lbs*	4 in²	2" dia.	1½"	1¾"	8" dia. x 12" high	**1,285.00**
144626	RH15	15 lbs*	4 in²	2" dia.	1"	1"	10" dia. x 18" high	**1,900.00**
175071	RH15	15 lbs*	4 in²	2" dia.	1½"	1¾"	10" dia. x 18" high	**1,900.00**
144627	RH30	30 lbs*	6 in²	2" dia.	1"	1"	14" dia. x 28" high	**2,300.00**
175072	RH30	30 lbs*	6 in²	2" dia.	1½"	1¾"	14" dia. x 28" high	**2,300.00**
144628	RH60	60 lbs	6 in²	2" dia.	1½"	1¾"	14" dia. x 40" high	**3,000.00**
144629	RH100	100 lbs	6 in²	2" dia.	1½"	1¾"	18" dia. x 37" high	**3,430.00**
144630	RH150	150 lbs	6 in²	2" dia.	1½"	1¾"	18" dia. x 50" high	**3,725.00**
144631	RH200	200 lbs	6 in²	2" dia.	2"	1¾"	23" dia. x 47" high	**4,660.00**
144632	RH300	300 lbs	6 in²	2" dia.	2"	1¾"	23" dia. x 61" high	**5,145.00**
144633	RH400	400 lbs	8 in²	4" dia.	3"	3"	27" dia. x 60" high	**6,799.00**
144634	RH600	600 lbs	8 in²	4" dia.	3"	3"	27" dia. x 80" high	**7,925.00**
RH Hopper Options								
144635	Flip Lid for hopper, allows manual filling – no hopper loader							**$105.00**
144636	Hopper Lid cut out to accept non Dri-Air hopper loader (Specifications Required)							**180.00**
144637	Drawer Magnet for 5 and 15 lb capacity hoppers							**1,260.00**
144638	Drawer Magnet for 30 lb capacity hopper							**1,260.00**

***NOTE: 5, 15 and 30 lb size Hoppers do not have access doors**

Other size RH Hoppers, up to 2,000 lbs., available – Inquire

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DRI-AIR Desiccant Dryer Accessories

Item #	For Dri-Air Model	Description	Unit Price
144617	AHM-1	Water After-Cooler* for drying temperatures above 250°F	$325.00
167971		Plasticizer Trap** — traps volatiles when drying resins / prevents contamination	275.00
144635		Flip Lid for hopper, allows manual filling – no hopper loader	125.00
144618	AHM-2 to 4	Water After-Cooler* for drying temperatures above 250°F	455.00
144619		Plasticizer Trap** — traps volatiles when drying resins / prevents contamination	425.00
170100		Booster Heater for drying at temperatures 301° F to 350°F	750.00
143666		Temperature Set Back Alarm — prevents over drying of material	235.00
144635		Flip Lid for hopper, allows manual filling – no hopper loader	125.00
144706	ARID-X10	Water After-Cooler* for drying temperatures above 250°F	375.00
144710		Plasticizer Trap** — traps volatiles when drying resins / prevents contamination	300.00
144707	ARID-X25 to 35	Water After-Cooler* for drying temperatures above 250°F	495.00
144711		Plasticizer Trap** — traps volatiles when drying resins / prevents contamination	475.00
144708	ARID-X50 to 100	Water After-Cooler* for drying temperatures above 250°F	650.00
144712		Plasticizer Trap** — traps volatiles when drying resins / prevents contamination	525.00
144709	ARID-X200	Water After-Cooler* for drying temperatures above 250°F	1,850.00
144713		Plasticizer Trap** — traps volatiles when drying resins / prevents contamination	925.00
142832	APD-1 to 4	Water After-Cooler* for drying temperatures above 250°F	495.00
142833		Plasticizer Trap** — traps volatiles when drying resins / prevents contamination	475.00
144087	APD-5 to 9	Water After-Cooler* for drying temperatures above 250°F	650.00
144088		Plasticizer Trap** — traps volatiles when drying resins / prevents contamination	525.00
144090	APD-10 to 11	Water After-Cooler* for drying temperatures above 250°F	1,850.00
144091		Plasticizer Trap** — traps volatiles when drying resins / prevents contamination	925.00
144076	ALL APD Models	Low Material Level Light/Sensor on hopper indicates low levels of material	675.00
143666		Temperature Set Back Alarm — prevents over drying of materia	215.00
168159		Adjustable Fill Sensor (for RH60 hoppers and larger only)	540.00
143665		Filter Alarm (Blue)	350.00
143664		System Alarm (Red)	230.00

*Requires user to supply waterline hook up for cooling coil

**Requires Water After-Cooler installed

Ask about...

Desiccant Mini PD Portable Dryers

The Mini PD portable dryer replaces press mounted drying hoppers so material changes can be made off the press/extruder. Dryers can be staged outside the molding area for preparation for the next material run, eliminating downtime on material changeovers.

Hopper Banks

- One dryer connects to multiple hoppers for a centralized drying system.
- Dry different materials at each hopper as each has its own booster heater for temperature control.

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SHINI Honeycomb Desiccant Wheel Dryer

Great Value for Drying Material

Twin condensers with mounted return air filter
- Prevents contamination to the honeycomb
- Regenerative air is quickly and accurately cooled

PID temperature controller - Accurately controls process system for seal temperature and regenerative temperature settings

Return air filter mounted inside cabinet - Prevents contamination to the honeycomb rotor

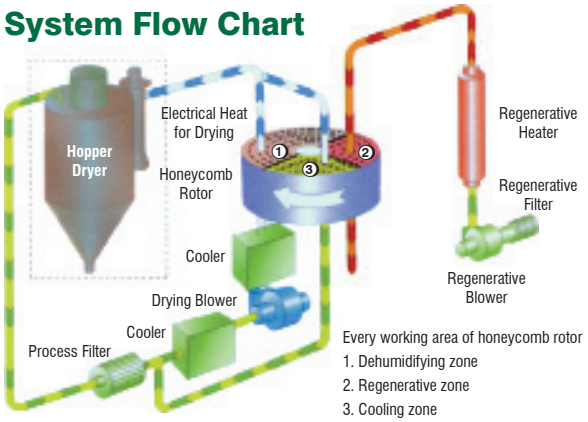
Timing Belt Drive - Eliminates slippage problems of traditional chain driven designs

- Built-in dew point meter
- Drying temp up to 320°F
- Up to 35% operating savings from similar designs
- Works great on hygroscopic resins
- Can supply dehumidified air with a dewpoint of -40°F

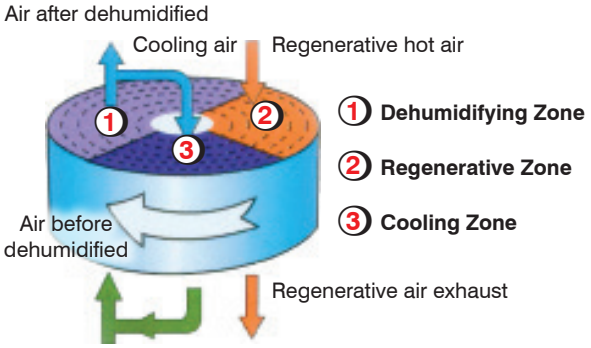
Control Panel

1 YEAR WARRANTY

System Flow Chart



Honeycomb Rotor Working Principle



IMS Item # 230V	IMS Item # 460V	Shini #	*Pounds Per Hour	Process Heater	Regenerative Heater	Process Blower	Regenerative Blower	Dimensions H	Dimensions W	Dimensions D	Weight (LBS)	Unit Price
171259	171260	SD-40H-PHC-D	40	3.0 kW	3.0 kW	0.25 HP	.27 HP	50"	19"	30"	320	**8355.00**
171250	171249	SD-80H-PHC-D	70	6.0 kW	3.0 kW	1.2 HP	.27 HP	54"	21"	32"	374	**9345.00**
171252	171251	SD-120H-PHC-D	90	6.0 kW	3.0 kW	1.2 HP	.27 HP	54"	21"	32"	374	**10860.00**
171254	171253	SD-200H-PHC-D	300	7.2 kW	4.0 kW	2.4 HP	.67 HP	61"	26"	41"	583	**11945.00**
171255	171256	SD-400H-PHC-D	550	18.0 kW	7.2 kW	6.0 HP	1.2 HP	69"	28"	49"	726	**17275.00**
171257	171258	SD-700H-PHC-D	900	24.0 kW	10.0 kW	8.6 HP	2.4 HP	76"	35"	54"	1056	**RFQ**

*Based on polycarbonate material

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Molecular Sieve Desiccant

Highest Quality Desiccant – Ideal for Most Dryers

Made in the U.S.A

Why Buy High-Quality Desiccant?

- Good drying depends on good airflow. Better desiccant provides better airflow by creating less dust to clog your filters. Clean desiccant also helps prevent material contamination.
- The desiccant you buy today is going to dry tons of your material for tens of thousands of cycles. The per-part cost of high quality desiccant is almost too small to compute. The quality and productivity advantage is too great to ignore.

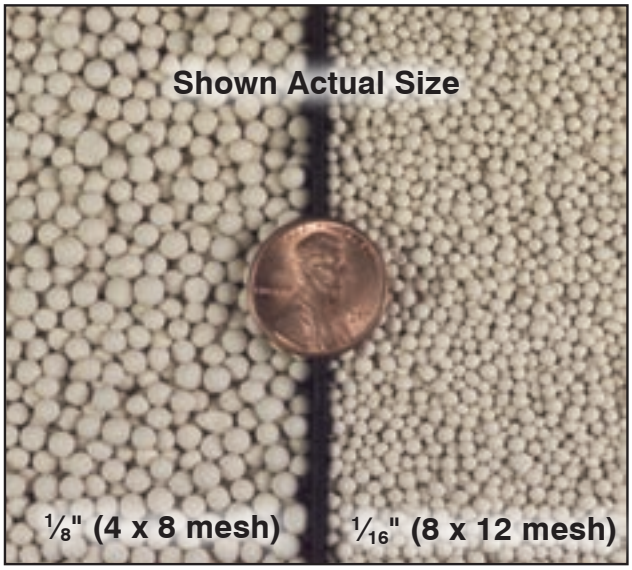
Molding problems, particularly in humid months, often trace back to poor drying caused by stale desiccant. The fact is this: desiccant goes bad. Desiccant captures moisture in its pores, which become blocked with contamination over time. And only fresh desiccant gives your dryers a chance to thoroughly dry your material in hot, humid weather.

Type 4A has smaller pores. It is less subject to contamination but adsorbs slightly less moisture.

Type 13X has larger pores. It adsorbs more moisture but is more subject to contamination. Most dryer manufacturers recommend Type 13X for most applications.

⅛" **Beads (4 x 8)** allow better airflow, but adsorb less moisture.

1/16" **Beads (8 x 12)** adsorb more moisture, but allow less airflow.



Regeneration Temperature:
between 375°F and 600°F

Tech Tips

Desiccants can get contaminated or ruined by off-gases of certain resins. A general rule is to change the desiccant every 18 months.

Item #	Bead Size	Mesh	Container Size
Type 4A			
127918*	⅛"	4 x 8	30 lbs. steel pail
127919*	⅛"	4 x 8	110 lbs. fiber drum
127920*	⅛"	4 x 8	308 lbs. steel drum
127921	1/16"	8 x 12	30 lbs. steel pail
127922	1/16"	8 x 12	110 lbs. fiber drum
127923	1/16"	8 x 12	308 lbs. steel drum
Type 13X			
127924*	⅛"	4 x 8	25 lbs. steel pail
127925*	⅛"	4 x 8	110 lbs. fiber drum
127926*	⅛"	4 x 8	275 lbs. steel drum
127927	1/16"	8 x 12	25 lbs. steel pail
127928	1/16"	8 x 12	110 lbs. fiber drum
127929	1/16"	8 x 12	275 lbs. steel drum

* Ideal for all Dri-Air models

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Portable Dew Point Meter/Monitor

Monitor And Spot Check The Performance Of Your Desiccant Style Drying Equipment

- Establish a repeatable, controlled drying process
- Alerts you to potential problems with desiccant style material dryers
- Verify the accuracy of your material dryers built-in Dew Point Meter (if equipped)
- Built-in Self Test
- Manufactured using NIST*-traceable equipment
- Available with current calibration certificate / Can be recalibrated as needed
- Monitor case is compact, lockable, self-contained and completely portable
- Adjustable alarm set points and changeable temperature display (F to C)

*National Institute of Standards and Technology

Dew Point Range:
-40°F to +30°F
(-40°C to -1.1°C)

How They Work

The meter draws a dried-air sample from the dryer output. The sample's moisture level affects the electrical resistance of the meter's hygrosensor. By reading that resistance, the meter can give the Dew Point Temperature of the sample — the drier the air, the lower the dew point.

*The desiccant tube is used to provide a reliable source of dry air for field testing the monitor's response.

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fax order toll-free (USA & Canada) 1.888.288.6900
phone order toll-free (Mexico) 001.888.304.1307
tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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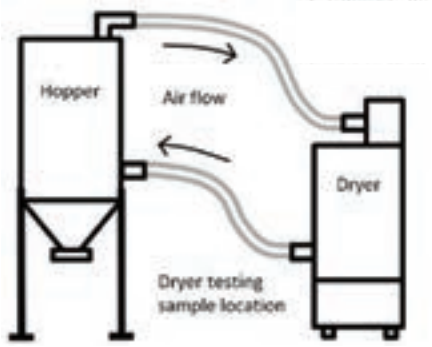
Portable Dew Point Meter/Monitor

Desiccant Dryer Performance Testing

Specifications

The sampling tubing supplied with the monitor can tolerate temperatures up to 275˚F (135˚C). Higher process air temperatures can be cooled to a safe level by sampling through a few feet of ¼" copper tubing.

Sample Air Temperature Limits: Up to 500°F
Dew Point Range: -40° to +30°F (-40° to -1.1°C)
Typical Accuracy: ±3°F (1.7°C)
Alarm Set Point: -10°F (-23˚C)
Sensor Item #: 172054
Analog Output Scaling: -40°F to +70°F (-4˚C to -9˚C)
Power Requirements: 115VAC 50/60HZ / 0.15A max (230VAC optional)
Dimensions: 10.75" x 9.75" x 4.75"
Shipping Weight: 7 lbs.



Model 1072A Portable Dew Point Monitor

Item #171760

Includes: Meter/Monitor in a Durable Case, Desiccant Tube, In-Line Air Filter, Air Sampling Tubing, Manufactured using NIST Traceable Equipment, 6 Foot Grounded Line Cord, and User Manual.

$1,475.60

#172019	Model 1072A Dewpoint Meter with current NIST Calibration Certificate	**Inquire**
	Spare Parts	
#103796	Desiccant Tube, Dew Point Meter/Monitor, Capped Air Tight both ends	**$40.60**
#103808	Inline Air Filter, Dew Point Meter/Monitor	**14.80**
#172054	Standard Hygrosensor for -40˚F to +30˚F Dew Point Readings (Compatible with all 1072 Moldels)	**Inquire**
#172055	High Range Hygrosensor B for -5˚F to +50˚F Dew Point Readings (Compatible with all 1072 Moldels)	**Inquire**
*For higher dew point ranges, inquire with our specialists for a variety of options		

High Temp Range Model 1072B

Dew Point Range:
10°F to 70°F
(-12°C to +21°C)

Also Available for Hot Air or Refrigerant Dryers

(Non Desiccant)

This meter has similar features to the Model 1072A, but monitors higher temperature ranges.

Model 1072B Portable Dew Point Monitor

Item #172020

Includes: Meter/Monitor in a Durable Case, Desiccant Tube, In-Line Air Filter, 6' Air Sampling Tubing, Built-In Audible Alarm, Silence Switch, Manufactured using NIST Traceable Equipment, 6 Foot Grounded Line Cord, and User Manual.

Inquire

#172022	Dew Point Meter/Monitor w/Digital Meter, Model 1072B with NIST Calibration Certificate, -5 to +50˚F 115/50/60/1 Volts	**Inquire**
	Spare Part	
#172055	Hygrosensor for Model 1072B	**Inquire**

Tech Tips

Always do a pre-test or self test the meter to ensure accurate readings before sampling your dryer's dew point and change the filter every 3 months to preserve the sensor.

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Dew Point Chart Recorder

Permanently Records the Dew Point of a Dryer's Output Over a 7 Day Period

(Time-frame adjustable — Inquire)

Model 4027A

Molded Case can be surface or panel mounted.

Door easily opened for access to chart, yet has gasket and sealed glass window to protect internal components.

Analog and digital filters with fixed time-constants smooth input-signal to microprocessor.

Chart and Pen driven by microprocessor-controlled stepper motors.

- Records stability of drying process.
- Isolates drying conditions at time of quality problems and successes.
- Produces document for quality records.

Preset and wired for use with the Model 8072A* Dew Point Meter/Monitor

No Adjustments Necessary

Specifications

Ambient Temperature: 32° F to 131° F (0 to 55° C)

Relative Humidity: 5 to 90% RH at 104° F (40° C)

Mounting Positions (from vertical): Tilted Forward 5°
Tilted Backward 90°
Tilted to Side 20°

Voltage (VRMS): 115 (230 field-selectable)

Frequency: 50/60Hz

Power Consumption: 9 watts maximum

Span Step Response Time: 7 seconds maximum

Reproducibility: 0.1 percent of span

Sampling Rate: Input sampled 2 times every 1.3 seconds

Input Filter: Analog with time constant of 3 seconds and digital with time constant of 1 second

Case: Molded, foamed-Noryl® with gasketed door to meet NEMA 3 enclosure requirements

Pen: Disposable fiber-tip ink cartridge, line length per cartridge more than 100 ft.
One Pen: Purple

Size: 14"H x 14"W x 6"D

Weight: 12 lbs.

Precision crafted by Honeywell, Inc.

Easy To Use

Simply connect to Dew Point Meter and plug in. Single pen recorder draws analog traces on 10" circular chart. Replace paper weekly.

Item #168522

for Model 8072A (#171760)
Includes: Chart Recorder; 15 foot Signal Cord; 6 foot Power Cord with Grounded Plug; 100 sheets of 7-Day Circular Chart Paper and Mounting Bracket.

$2,449.27

#115615	for Model 8072	**$2,620.27**
	Spare Part	
#115608	Circular Chart Paper, 100 sheets	**$135.20**
#115611	Pens, 6 Pack (purple)	**149.00**

***NOTE:** Due to the connector differences, confirm which model Dew Point Meter you have before ordering.

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DRI-AIR Hopper Mounted Compressed Air Dryer

Compact, Easy to Use Dryer

Made in the U.S.A

- **Dry-Pak membrane -** Assures -40°F dewpoint air at the hopper and allows fast drying of hygroscopic resins
- **Press/Extruder mounted dryer -** Frees up critical shop floor space
- **Trouble free design -** No moving parts is ideal for low throughput with minimal maintenance
- **User friendly operation -** Just set the temperature and the machine does the rest
- **Automatic restart -** Dryer settings are restored on power outages less than 30 seconds in duration

- Insulated stainless steel hopper
- Dryer control includes high temp alarm and shutdown
- Process up to 15 lbs/hr
- 70°F to 350°F drying temperature without the need for water cooled after-cooler
- CAHM-60 includes access door and full length site glass

Optional floor stand and compressed air loader for a possible drying solution

Standard ADC Control (shown)

- Alpha numeric display
- -49°F dewpoint monitor
- 7 day timer, alarm history, thermocouple alarms and optional temp set back to prevent over drying

(see page 666 for more information)

IMS Item # 110V	IMS Item # 220V	Dri-Air Model	Process Rate	Capacity	Compressed Air Required	Heater	Dimensions Height	Dimensions Width	Dimensions Depth	Unit Price
161409	161410	CAHM-30	10 lbs/hr	30 lbs	2.5 cfm	1.25 kW	28”	21”	22”	**$8,400.00**
161411	161638	CAHM-60	15 lbs/hr	60 lbs	2.5 cfm	2 kW	42”	29”	30”	**8,850.00**

110 or 220 volt phase 1 electrics, 100 psi clean compressed air required @ 1.5-2.5 scfm

Optional Accessories		
143666	Temperature Set Back Alarm	**$195.00**
168205	Mobile Cart and Vacuum Take-Off Box Accessory	**1,415.00**
170098	Mobile Cart and Vacuum Take-Off Box Accessory	**1,415.00**
170099	Mobile Cart and Vacuum Take-Off Box Accessory	**1,415.00**

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Process Trouble-Shooting Guidelines				
Problem	CRYSTALLINE MATERIALS		AMORPHOUS MATERIALS	
	Lower/Reduce	Raise/Increase	Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

Converting Fractional Inches To Decimals And Millimeters

Fraction	Decimal	MM
1/64"	.015625”	0.3969
1/32"	.03125”	0.7938
3/64"	.046875”	1.1906
1/16"	.0625”	1.5875
5/64"	.078125”	2.3812
3/32"	.09375”	2.3812
7/64"	.109375”	2.7781
1/8"	125”	3.175
9/64"	.140625”	3.5719
5/32"	.15625”	3.9688
11/64"	.171875”	4.3656
3/16"	.1875”	4.7625
13/64"	.203125”	5.1594
7/32"	.21875”	5.5562
15/64"	.234375”	5.9531
1/4"	.25”	6.35
17/64"	.265625”	6.7469
9/32"	.28125”	7.1438
19/64"	.296875”	7.5401
5/16"	.3125”	7.9375
21/64"	.328125”	8.3344
11/32"	.34375”	8.7312
23/64"	.359375”	9.1281
3/8"	.375”	9.525
25/64"	.390625”	9.9219
13/32"	.40625”	10.3188
27/64"	.421875”	10.7156
7/16"	.4375”	11.1125
29/64"	.453125”	11.5094
15/32"	.46875”	11.9063
31/64"	.484375”	12.3031
1/2"	.5”	12.7

Fraction	Decimal	MM
33/64"	.515625”	13.0969
17/32"	.53125”	13.4938
35/64"	.546875”	13.8906
9/16"	.5625”	14.2875
37/64"	.578125”	14.6844
19/32"	.59375”	15.0812
39/64"	.609375”	15.4781
5/8"	.625”	15.875
41/64"	.640625”	16.2719
21/32"	.65625”	16.6688
43/64"	.671875”	17.0656
11/16"	.6875”	17.4625
45/64"	.703125”	17.8594
23/32"	.71875”	18.2563
47/64"	.734375”	18.6531
3/4"	.75”	19.05
49/64"	.765625”	19.4469
25/32"	.78125”	19.8438
51/64"	.796875”	20.2406
13/16"	.8125”	20.6375
53/64"	.828125”	21.0344
27/32"	.84375”	21.4312
55/64"	.859375”	21.8281
7/8"	.875”	22.225
57/64"	.890625”	22.6219
29/32"	.90625”	23.0188
59/64"	.921875”	23.4156
15/16"	.9375”	23.8125
61/64"	.953125”	24.2094
31/32"	.96875”	24.6062
63/64"	.984375”	25.0031
1"	1.0”	25.4

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Replacement Parts

For IMS Hot Air and Refrigerant Type Hopper Dryers

Item #	Description	Unit Price
	Hot Air Model MD100	
108363	Heater Coil and Rack, 460/60/3, 86.53 Ohms (± 5%), 7.5 KW	**$470.00**
108372	Heater Coil and Rack, 230/60/3, 19.87 Ohms (± 5%), 7.5 KW	**Inquire**
112805	Main Temperature Controller	**282.64**
	Hot Air Model HAD751	
108363	Heater Coil and Rack, 460/60/3, 86.53 Ohms (± 5%), 7.5 KW	**$470.00**
112805	Main Temperature Controller	**359.30**
	Refrigerant Model HD75050	
108361	Heater Coil and Rack, 460/60/1, 52.98 Ohms (± 5%), 7.5 KW	**Inquire**
108677	Circuit Breaker, 40 Amp	**Inquire**
112805	Main Temperature Controller	**$359.30**
	Refrigerant Model MD750-50	
108363	Heater Coil and Rack, 460/60/3, 86.53 Ohms (± 5%), 7.5 KW	**$470.00**
108372	Heater Coil and Rack, 230/60/3, 19.87 Ohms (± 5%), 7.5 KW	**Inquire**
112805	Main Temperature Controller (Note: Model MD750-50A uses a West Controller – Inquire)	**359.30**
114177	Condenser Fan Motor (230 volt)	**137.20**
	Refrigerant Model MD750	
112805	Main Temperature Controller	**$359.30**

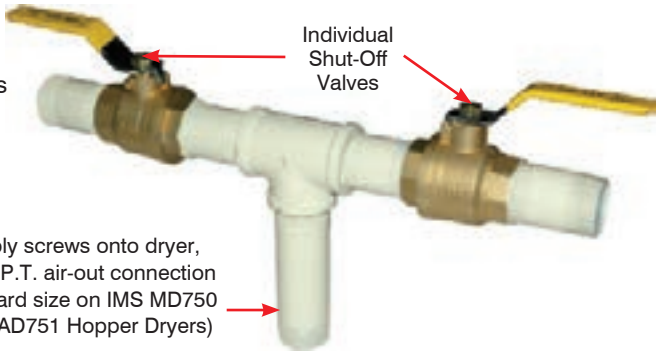
WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

IMS Hopper Dryer Air Manifold

Lets You Serve Two Presses at Once

Use this manifold to connect your dryer to two press hoppers or one press hopper and an IMS Twin Bin Drying Hopper.

- Quick installation, just screw it on
- Easily modified to fit any size application
- T-valves are 1½" N.P.T. for 1⅞" I.D. hose
- Individual shutoff valves
- Fitting for dryer air-out connection



Item #	Description	Unit Price
110503	Hopper Dryer Air Manifold	**Inquire**

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Please refer to imscompany.com for current pricing

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SHINI Drying Hoppers

Great Value For Drying Material

Common Features

- Stainless steel contact parts
- Elongated sight glass is standard on models (except DH-300U)
- Insulated side walls eliminate heat loss and conserve energy

Item #	Shini Model	Hopper Capacity**	Inlet Pipe Diameter	Outlet Pipe Diameter	Weight	Width (In.)	Height (In.)
169872	DH-40U	50 lbs	2”	1.5”	50	15	30
170829	DH-80U	80 lbs	2.5”	2”	80	19	37
170830	DH-120U	150 lbs	2.5”	2”	100	19	48
170831	DH-160U	200 lbs	3”	2.5”	125	22.5	48
170832	DH-230U	285 lbs	3”	2.5”	160	22.5	60
170833	DH-300U	370 lbs	3”	2.5”	180	27	57
170834	DH-450U	550 lbs	3”	2.5”	220	27	73
170835	DH-600U	740 lbs	4”	3”	250	36	72
170836	DH-750U	925 lbs	4”	3”	310	36	83
155759	DH-900U*	1110 lbs	4”	4”	375	41	81.5
170837	DH-1200U*	1500 lbs	4”	4”	550	41	98.5
Optional Floor Stands							
170839	FSU-40	For Model DH-40U					
170840	FSU-80	For Models DH-80U and DH-120U					
170841	FSU-160	For Models DH-160U and DH-230U					
170842	FSU-300	For Models DH-300U and DH-450U					
170843	FSU-600	For Models DH-600U and DH-750U					
Optional Material Suction Box							
161472	SBU-20-38S	Single Tube with 1½" Material Pipe for Models DH-20U – DH-160U					
160451	SBU-160-38S	Single Tube with 1½" Material Pipe for Models DH230U and Up					
170849	SBU-20-50S	Single Tube with 2" Material Pipe for Models DH-20U – DH-160U					
163617	SBU-160-50S	Single Tube with 2" Material Pipe for Models DH-230U and Up					
170850	SBU-20-38D	Double Tube with 1½" Material Pipe for Models DH-20U – DH-160U					
170106	SBU-160-38D	Double Tube with 1½" Material Pipe for Models DH230U and Up					
170851	SBU-20-50D	Double Tube with 2" Material Pipe for Models DH-20U – DH-160U					
170105	SBU-160-50D	Double Tube with 2" Material Pipe for Models DH230U and Up					

*Floor Stand included with DH-900U and DH-1200U

** Based on a material with a bulk density of 35 lbs. per cu. ft.

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SHINI Hot Air Hopper Dryer

Great Value for Drying Material

Stainless steel construction on all contact surfaces - avoids contamination with material

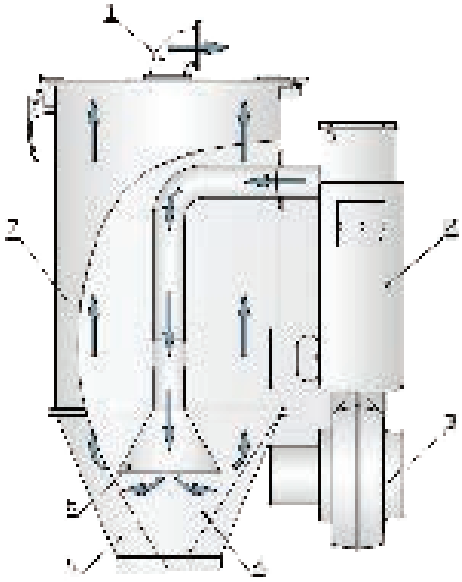
PID microprocessor controller - provides accurate temp control, digital display and auto start/stop functions

Unique hot air inlet design - prevents dust collection

Insulated blower - prolongs blower life expectancy

- Overheat protection to ensure reliable operation
- Removable hopper base from dryer
- 7-day automatic start/stop timer and sight glass

1 Year Warranty



1. Air Exhaust Pipe
2. Control Box
3. Blower
4. Inner Hopper
5. Outer Hopper
6. Hot Air Intake Pipe
7. Hopper

Double Layer Insulated Hopper Design

RS485 Communication Interface

How It Works

In the drying process, hot air with constant temperature is moved by a blower into a two-layer insulated hopper to dry the materials. Moisture will be separated out and taken away by hot air, thus drying material.

Through the screen and shade separator, hot air can be equally dispersed in the material of the hopper (see illustration).

IMS Item # 230V	IMS Item # 460V	Shini #	Hopper Capacity cu ft	Heater (kW)	Blower (hp)	Dimensions H	Dimensions W	Dimensions D	Weight (lbs)	Unit Price
173204	173205	SEHD-12	0.42	2.2	0.1	34"	26"	14"	80	**875.00**
173206	173207	SEHD-25	0.88	3	0.2	40"	29"	16"	90	**980.00**
173208	173209	SEHD-50	1.76	4	0.2	45"	33"	19"	100	**1,085.00**
173210	173211	SEHD-75	2.64	4	0.2	49"	36"	22"	125	**1,460.00**
173212	173213	SEHD-100	3.53	6	0.3	53"	38"	24"	155	**1,750.00**
173214	173215	SEHD-150	5.29	6	0.3	62"	38"	24"	165	**2,085.00**
173216	173217	SEHD-200	7.06	12	0.5	62"	49"	30"	220	**2,945.00**
173218	173219	SEHD-300	10.59	15	0.5	78"	49"	30"	265	**3,495.00**
173220	173221	SEHD-400	14.12	18	1	83"	54"	36"	370	**3,995.00**
173222	173223	SEHD-500	17.65	19.5	1	90"	54"	36"	375	**4,375.00**
173224	173225	SEHD-600	21.18	21	1	100"	54"	37"	530	**4,660.00**
173226	173227	SEHD-800	28.25	24	1	106"	56"	24"	620	**9,325.00**
173228	173229	SEHD-1000	35.31	32	2	118"	56"	24"	670	**9,725.00**

Blower inlet filters, exhaust air filters, hot air regulators, floor stands, material suction box available — Inquire

Please refer to imscompany.com for current pricing

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SHINI Hot Air Hopper Dryer Accessories

Blower Inlet Filters

Filters 80% of dust to dryer
Blower output is adjustable

Item #	Shini Model	For Dryer Models	Air Inlet	Air Outlet	Unit Price
170819	AIF-12	SEHD-12	1.5"	2"	**Inquire**
170147	AIF-25	SEHD-25	1.5"	2"	**Inquire**
170624	AIF-50	SEHD-50/75	2"	3"	**165.00**
167935	AIF-100	SEHD-100/150	2.5"	3"	**180.00**
170820	AIF-200	SEHD-200 - 300	2.5"	4"	**Inquire**
170821	AIF-600	SEHD-400 - 600	2.5"	4"	**345.00**

Exhaust Air Filters

Filters 90% of dust contained in air which is discharging from dryer

Item #	Shini Model	For Dryer Models	Air Inlet	Air Outlet	Unit Price
165656	ADC-1	SEHD-12	1.5"	2”	**125.00**
171195	ADC-2	SEHD-25 - 150	1.5"	2”	**Inquire**
169752	ADC-3	SEHD-200 and up	2"	3”	**Inquire**

Hot Air Recyclers

Keeps factory air clean
Save energy by up to 40%

Item #	Shini Model	For Dryer Models	Air Inlet	Air Outlet	Unit Price
169349	HAR-12	SEHD-12	2"	2"	**Inquire**
170822	HAR-25 EH	SEHD-25	2.5"	2.5"	**340.00**
163883	HAR-50 EH	SEHD-50/75	3"	3"	**380.00**
168710	HAR-100 EH	SEHD-100/150	3"	3"	**Inquire**
168708	HAR-200 EH	SEHD-200 - 300	4"	4"	**Inquire**
173480	HAR-600 EH	SEHD-400 - 600	4"	4"	**Inquire**
173478	HAR-800 EH	SEHD-800 - 1000	4"	4"	**Inquire**

NOTE: Replaces both the ADC and AIF

Floor Stands

Item #	Shini Model	For Dryer Models	Dimensions	Unit Price
163884	FSN-50	SEHD-12 thru 75	27.5" W x 25" L x 24" H	**270.00**
167048	FSN-100	SEHD-100 & 150	31.5" W x 28" L x 24" H	**425.00**
163616	FSN-200	SEHD-200 & 300	47" W x 40" L x 24" H	**840.00**
170823	FSN-400	SEHD-400 & 600	59" W x 47" L x 27" H	**995.00**
170824	FSN-800	SEHD-800 & 1000	51" W x 51" L x 27" H	**1095.00**

Material Suction Box

Item #	Shini Model	For Dryer Models	Tubes	Material Pipe	Unit Price
161472	SBU-20-38S	SEHD-12 - 75	Single	1½"	**Inquire**
160451	SBU-160-38S	SEHD-100 and up		1½"	**Inquire**
170825	SBU-20-50S	SEHD-12 - 75		2"	**240.00**
163617	SBU-160-50S	SEHD-100 and up		2"	**Inquire**
170826	SBU-20-38D	SEHD-12 - 75	Double	1½"	**310.00**
170106	SBU-160-38D	SEHD-100 and up		1½"	**Inquire**
170827	SBU-20-50D	SEHD-12 - 75		2"	**355.00**
170105	SBU-160-50D	SEHD-100 and up		2"	**Inquire**

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Made in the U.S.A

IMS Select Mobile Drying Hoppers

A Better Way To Dry — Minimize Downtime

For Open or Closed-Loop Drying

- **Convenient floor level hoppers -** allow quicker, easier and safer change-overs of materials and colors
- **Unique, logarithmic Spiral™ curve hopper design -** ensures smooth, even material flow for difficult materials
- **Stainless steel hopper and components -** sturdy, rust free construction
- **Portable design -** allows quick and easy cleaning for decreased downtime

2 Year Warranty

2 Hopper Styles Available

- Logarithmic Spiral™ Curve
- OEM - Conical

Standard Conical Model #134006 *shown*

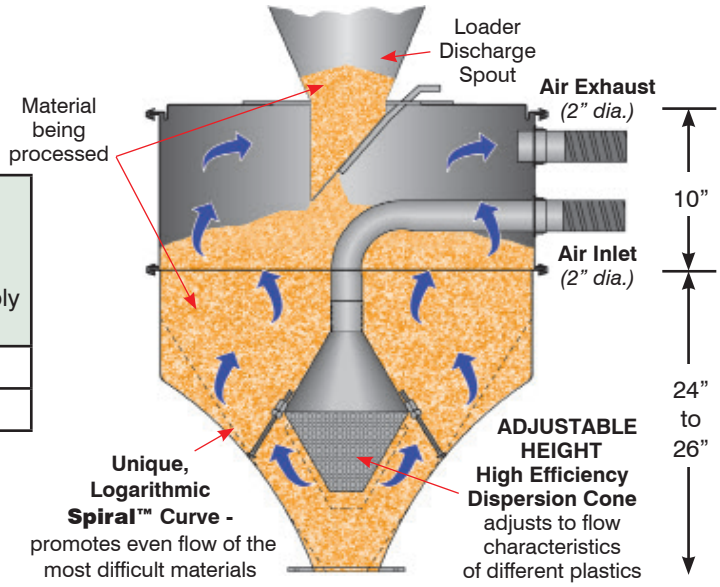
6" x 7½" Slide Gate w/3" dia Feed Hole

Spiral™ Model #113228 *shown*

300 lb. Capacity

(Based on 35 lbs per sq. ft.)

Easily increased with clamp-on extensions



Unit Price

Includes: Cart w/ casters, hopper assembly (**Spiral**™/OEM hopper, hopper extension, stainless steel lid, two high temp silicone gaskets, two clamps, slide gate) and drying assembly (2” inlet elbow, dispersion cone and 2” exhaust)

113228	with **Spiral**™ Curve Hopper	**$4,282.53**
134006	with OEM - Conical Hopper	**$3,750.00**

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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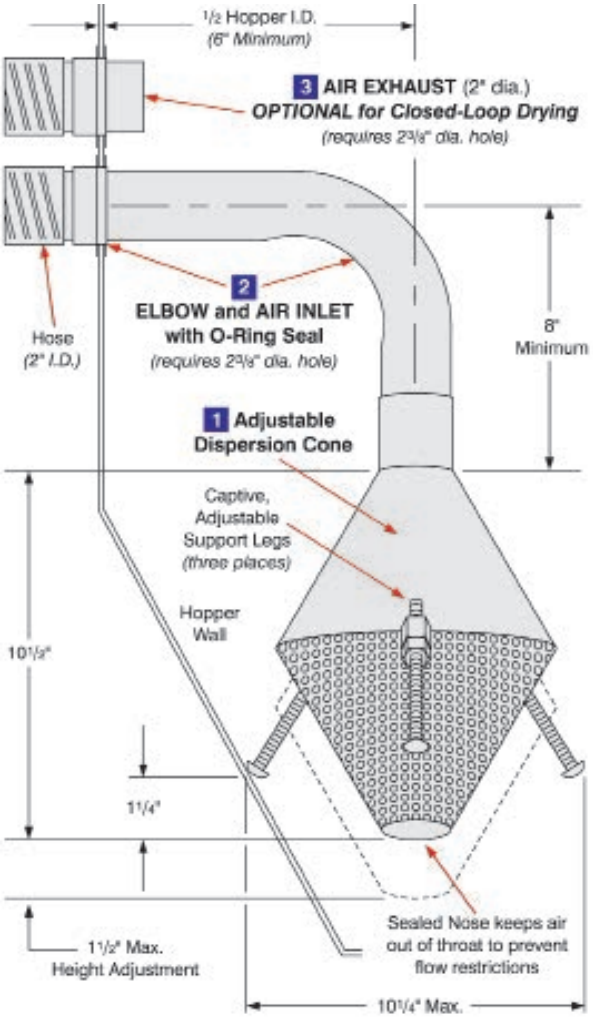
IMS Select Mobile Drying Hoppers

Made in the U.S.A



High-Efficiency Dispersion Cone

for IMS **Spiral**™ and Conical Drying Hoppers
and ALL Round, Tapered Hoppers

- For difficult-to-feed materials
- Rugged, all-welded cone construction
- Adjustable cone-height for variable flow characteristics
- Swaged hose fittings for quick and easy removal when cleaning
- Rigid assembly for maximum performance

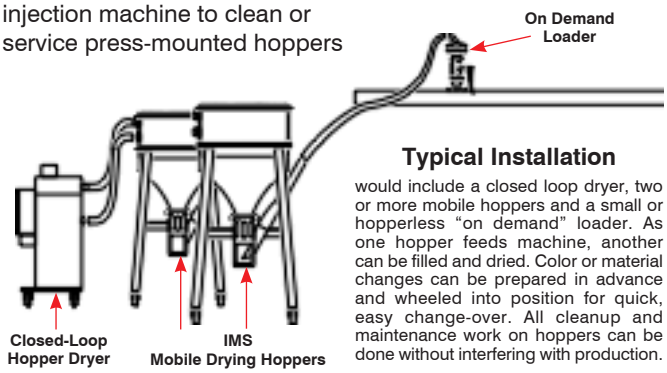
Unit Price

1. Adjustable Dispersion Cone	#111916 (stainless steel)	**204.10 ea.**
2. Elbow for 18" hopper and Air Inlet Fitting with O-Ring Seal	#109400 (carbon steel) #112144 (stainless steel)	**$105.00** **50.00**
(Other elbow sizes available - inquire)		
3. Air Exhaust Fitting with O-Ring Seal	#112144 (stainless steel)	**$50.00**

Use with any "On Demand" loader

(Such as the IMS ME-20 Material Express)

No more climbing atop the injection machine to clean or service press-mounted hoppers



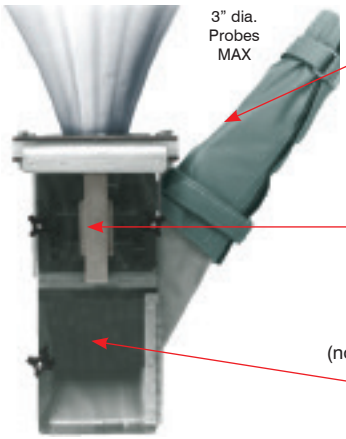
Typical Installation

would include a closed loop dryer, two or more mobile hoppers and a small or hopperless "on demand" loader. As one hopper feeds machine, another can be filled and dried. Color or material changes can be prepared in advance and wheeled into position for quick, easy change-over. All cleanup and maintenance work on hoppers can be done without interfering with production.

For Dryer Hose and Insulation see pages 407-409

Optional Add-On Air Take-Off Components

(Bolts to bottom of slide gate)



Insulated Boot Sleeve Only
#114170
Inquire

Drawer-Type Magnet Only
#105323
RFQ

Housing Only
(no magnet or boot sleeve)
#114165
$289.95

#114318 Hopper Extension Kit

(150 lb add-on capacity)

Includes 10" high extension cylinder, gasket, clamp and dispersion extension pipe

$650.70 ea.

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6 and 9 Tray Convection Bench Ovens

Made in the U.S.A

Need to dry, anneal, or test in small batches? Each tray of the 6 or 9 Tray Bench Oven can hold up to 3.5 lbs. of (styrene) plastic pellets. The 6 Tray Bench Oven heats up to 518° F; the 9 Tray Bench Oven up to 392° F. Hotter temperatures dry the material quickly, increasing productivity. Corrosion resistant trays, shelves and interiors prevent contamination and help ensure a long service life.

- Incoloy sheathed heating elements
- Mercury thermometer
- Graduated knob type thermostat control
- Adjustable shelves
- Mineral-wool insulation
- 6' cord (plug included on 120 volt models)
- Damper controlled induced-air circulation
- Brushed metal

Note: DO NOT use any oven where flammable solvents can be given off, as in paint drying, etc. NEVER leave any oven unattended. Use these ovens for surface drying only; not recommended for hygroscopic plastics. For hygroscopic plastics, see desiccant type dryers.

Door shown open for illustration only

Illustrated: IMS 1.6 kW, 9 tray bench type oven, complete with thermostat control and drying trays

Specifications and Prices

	#108288	**#108287** and **#108276**
Model Number:	DG0106-120	DG0209-120 and DG0209-240
Maximum Temperature:	518°F	392°F
Internal Wall Material:	Galvanized steel	Galvanized steel
Tray Material:	Nickel-plated steel	Nickel-plated steel
Thermostat Control Accuracy:	±21° F	±21° F
Incoloy Heating Elements:	One 800W	Two 800W
Amperage:	6.7 amps (120/60/1)	13.4 amps (120/60/1) 6.7 amps (240/60/1)
Tray Size (Inside):	4½"W x 8½"L x 2½"D	4½"W x 8½"L x 2½"D
Oven Size (Outside):	17"W x 17⅜"L x 24"H	20"W x 14"L x 25"H
(Inside):	13"W x 13"L x 13"H	18"W x 12"L x 16"H
Crated Weight:	75 lbs.	75 lbs.

Item #	Description	Unit Price
108288	6 Tray bench oven (120 volt)	**$2,311.00**
108287	9 Tray bench oven (120 volt)	**2,295.00**
108276	9 Tray bench oven (240 volt)	**2,295.00**

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10 Tray Heavy-Duty Convection Oven

Made in the U.S.A

Designed for the production floor, this heavy-duty oven comes with 10 trays that each hold 31.5 lbs. of (styrene) plastic for drying in small batches. Convection type heating prevents fine material from blowing around. Corrosion resistant trays, shelves and interiors prevent contamination and help ensure a long service life.

- Freestanding for placement anywhere on production floor
- Convection heating design (no fan)
- Chrome-steel sheathed strip heaters
- Maximum temperature: 325°F
- Knob type thermostat control calibrated in degrees
- High temperature safety switch
- Heavy duty, offset door hinges
- 315 lbs. of (styrene) plastic capacity
- Available with optional closed loop ports for desiccant drying.

doors shown open for illustration only

Note: DO NOT use any oven where flammable solvents can be given off, as in paint drying, etc. NEVER leave any oven unattended.

Specifications and Prices

Model Number:	DG0410	Amperage:	18 amps (240/60/1)
Maximum Temperature:	325°F	Tray Size (Inside):	15"W x 24"L x 2½"D
Internal Wall Material:	Type 430 stainless steel	Oven Size (Outside with stand):	48¾"W x 30"L x 44"H
Tray Material:	Nickel plated steel	(Inside):	16"W x 25"L x 20"H
Thermostat Control Accuracy:	±10° F	Crated Weight:	600 lbs.
Sheathed Strip Heaters:	4 kW, chrome steel		
Rockwool Insulation:	2" thick		

Item #	Description	Unit Price
108271	10 Tray Freestanding Oven (240 volts) Complete with sheathed strip heaters and high temperature safety switch	$**17,069.00**

Ask about a closed loop unit with desiccant dryer attachment for hygroscopic plastics

See Desiccant Dryers on pages 688-697

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8 Tray Forced-Air Bench Oven

Made in the U.S.A

Each tray holds up to 16 lbs. of (styrene) plastic for drying small batches. Corrosion resistant trays, shelves and interiors prevent contamination and help ensure a long service life.

- Fan-forced air heats more consistently, improving quality
- Four, removable and adjustable nickel-plated shelves
- Maximum temperature: 350°F
- Fully adjustable thermostat control
- High temperature safety switch
- 6', 3-wire line cord with molded 5-20p plug (120 volt model only)
- Brushed metal
- Capacity: 128 lbs. (styrene)

doors shown open for illustration only

Note: DO NOT use any oven where flammable solvents can be given off, as in paint drying, etc. NEVER leave any oven unattended.

Specifications and Prices

Model Number:	NB350	Amperage:	19 Amps (120/60/1)
Maximum Temperature:	350°F		10 Amps (240/60/1)
Internal Wall Material:	Stainless steel	Tray Size (Inside):	11½"W x 20"L x 2"D
Tray Material:	Nickel plated steel	Oven Size (Outside):	41"W x 30"L x 23"H
Thermostat Control Accuracy:	±10°F	(Inside):	28"W x 24"L x 18"H
Incoloy Heating Elements:	Two 1 kW	Crated Weight:	250 lbs.

Item #	Description	Unit Price
114615	8 Tray bench oven (120 volt)	**$4,851.00**
114623	8 Tray bench oven (240 volt)	**5,205.00**
Optional Accessories		
115170	Individual unit stand (33½" high)	**831.30**
155749	60 minute automatic oven shutoff timer	**Inquire**
108273	12 hour automatic oven shutoff timer	**610.40**
108268	Indicating dial thermometer (50°-550°F)	**165.60**
108286	Replacement set of 8 trays	**1,295.00**

Ask about a closed loop unit with desiccant dryer attachment for hygroscopic plastics

See Desiccant Dryers on pages 688-697

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8 Drawer Forced-Air Bench Oven

Made in the U.S.A

Drawers reduce heat loss and temperature changes compared to tray ovens with doors. Corrosion resistant trays, shelves and interiors prevent contamination and help ensure a long service life.

- Each drawer holds up to 20.5 lbs. (styrene), permitting small batches
- Fan-forced air heats more consistently, improving quality
- Fully adjustable thermostat control
- High temperature safety switch
- 6', 3-wire line cord with molded 5-20p plug (120 volt model only)
- Brushed metal
- Capacity: about 165 lbs. (styrene)

drawers shown open for illustration only

Note: DO NOT use any oven where flammable solvents can be given off, as in paint drying, etc. NEVER leave any oven unattended.

Specifications and Prices

Model Number:	DR350	Amperage:	19 amps (120/60/1)
Maximum Temperature:	350°F		10 amps (240/60/1)
Internal Wall Material:	Stainless steel	Drawer Size (Inside):	11¾"W x 25"L x 2"D
Tray Material:	Type 430 stainless steel		(will accept 3½" high pieces)
Thermostat Control Accuracy:	±10°F	Oven Size:	41"W x 30"L x 23"H
Incoloy Heating Elements:	Two 1 kW	Crated Weight:	285 lbs.

Item #	Description	Unit Price
115827	8 Drawer Thermoplastic Bench Oven (120 volts)	**$4,718.00**
115823	8 Drawer Thermoplastic Bench Oven (240 volts)	**5,072.00**
Optional Accessories		
115170	Individual unit stand (33½" high)	**$566.58**
155749	60 minute automatic oven shutoff timer	**Inquire**
118481	12 hour automatic oven shutoff timer	**Inquire**
108268	Indicating dial thermometer (50°-550°F)	**116.02**

Ask about a closed loop unit with desiccant dryer attachment for hygroscopic plastics

See Desiccant Dryers on pages 688-697

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Custom Drying Oven Quote Form

1. PROCESS (Description): _____

2. MATERIAL HEATED: _____

Size: _____ Weight: _____ Thickest Cross Section: _____

Condition of Pieces: ❑ Wet ❑ Dry ❑ Oily ❑ Other (explain under comments)

3. FLAMMABLE SOLVENTS OR VAPORS INVOLVED IN PROCESS

Type: _____ Amount:___ gallons per batch (or per hour of continuous processing)

4. INERT ATMOSPHERE (if required): ❑ Nitrogen ❑ Argon ❑ Other (explain under comments)

6. TEMPERATURE

Operating Temperature:_____ °F Maximum Temperature:_____ °F

Required Dwell Time at Operating Temperature: ___ (Include time for parts to heat up; assume preheated equipment)
This information must be supplied for continuous processing such as belt and conveyor or rotary hearth.

Required Uniformity within Workspace: _____

6. MATERIAL HANDLING

Batch: ❑ Shelf ❑ Tray ❑ Basket ❑ Fixture ❑ Other (explain under comments)

Quantity of Parts: _____ per Batch or Production Rate

Continuous: ❑ Belt Conveyor ❑ Rotary Hearth ❑ Roller Hearth ❑ Chain Conveyor ❑ Other (explain under comments)

Length Load Zone: _____ Length Unload Zone: _____

Pass Line:_____ Production Rate: _____

Length Cooling Zone: _____ Exit Temperature from Cooling Zone: _____ °F

7. CLEAN ROOM/PHARMACEUTICAL

❑ backwelded seams
❑ door locks/interlock
❑ pressurizing blower
❑ one pass granulation drying
❑ #4 brushed stainless steel exterior
❑ HEPA fresh air inlet
❑ automation depyrogenation cycle
❑ front welded ground seams ½" radius interior corners
❑ door at both ends for pass through
❑ alarms for filters/temperature
❑ motorized intake and exhaust dampers

8. DESIGN

Type of Equipment:: _____ Similar to Standard Model: _____

Work Space Size: _____ Wide x _____ Deep x _____ High

Air Flow: ❑ Horizontal ❑ Combination ❑ Vertical Up ❑ Vertical Down ❑ Other (explain under comments)

Special Features: _____

_____

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Custom Drying Oven Quote Form

9. SPECIFICATIONS APPLICABLE:

Condition of Pieces: ❑ JIC ❑ FM ❑ IRI ❑ MIL Military Specification # _____

10. SERVICES

Electrical Service: _____ Volts ❑ 1 or ❑ 3 Phase ❑ 50 or ❑ 60 Hz

To Be Heated By: ❑ Electric ❑ Natural Gas ❑ Propane ❑ Steam ❑ Other (explain under comments)

11. EQUIPMENT TO BE INCLUDED IN BASE PRICE: _____

_____

12. EQUIPMENT TO BE INCLUDED AS OPTIONS: _____

_____

13. BUILDING DATA

Smallest Opening through which unit must pass:_____ Wide x _____ High
Don't forget doorways, elevators and existing machinery, pipes, or ducts.

Floor space Limitations: _____ Wide x _____ Deep

Headroom Limitations: _____

_____

Floor or Elevator Load Limitations: _____

14. ADDITIONAL COMMENTS OR EXPLANATIONS: _____

_____

_____

_____

_____

_____

Date:_____ Quantity:_____ Phone:(_____)_____ Fax: (_____) _____

Name:_____ Title:_____

Company Name: _____ Email: _____

Address:_____

City: _____ State:_____ Zip:_____

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IMS Hopper Magnet Specifications

Why You Should Specify and Purchase Only IMS Magnets

IMS uses only the best magnetic materials and stainless steel to construct the easiest to clean, most powerful holding and best-reachout hopper magnets in the plastics industry. IMS offers 4 basic designs with different degrees of reachout and holding power, and different levels of cost.

IMS has been your #1 source for positive tramp-metal protection since 1949. We have developed virtually every hopper-magnet breakthrough by constantly searching and trying every magnetic material known to man and assembling them in different configurations to optimize your protection.

	Super	**Lc** (Low Cost)	**Economy**	**Drawer**
Diverters:	N/A	1" wide, 16 ga., 90° bend, 5/8" legs	1 1/8" wide, 14 ga., 90° bend, 3/4" legs	N/A
Space (between diverters):	N/A	1"	7/8"	N/A
Webs:	Rod Supports	11 ga.	14 ga.	N/A
Web Size:	3/8" dia.	3/4" high	1 7/8" high	N/A
Magnetic Tubes:	1" O.D. (.049 wall)	1" O.D. (.049 wall)	1" O.D.	1" O.D.
Magnets:	Rare Earth	Ceramic	Ceramic	Rare Earth
Spacing on Center:	1 1/2" bar to bar	2" bar to bar	2" bar to bar	2" bar to bar
Space Between Tubes:	1/2"	1"	1"	1"
Construction:	Tack to rods	Tack welded 2 places each tube	Punched webs plus track welding	Bolted
Finish:	80-Grit, Glass Bead Blasted	80-Grit, Glass Bead Blasted	Glass Bead Blasted	80-Grit, Glass Bead Blasted
Type of Stainless:	304	304	304	304
Overall Height:	1 3/8"	2 1/8"	2 3/8"	Varies

Caution

Never lay magnets on or near electric motors or electric power sources.
Keep cell phones and electronic devices away from magnets

Tech Tips

NOTE: ALL magnets tend to lose some magnetic power as ambient temperature increases. Inquire for recommendations and performance comparisons if your application calls for temperatures over 400°F.

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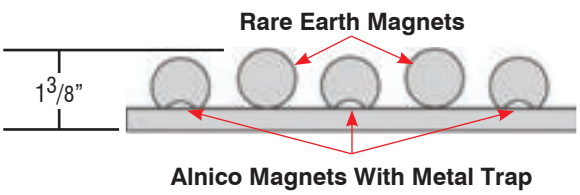
Super Hopper Magnets

Our Exclusive, Top-Of-The-Line Hopper Magnets — Combining Rare Earth and Alnico in One Assembly

- Rare Earth magnet bars provide exceptional holding power
- Alnico magnet bars provide outstanding pull-in power
- Concave bar design traps tramp metal and keeps it from wiping off
- Low profile (diverter-free) design takes up less room in the hopper
- Available for round hoppers only



Alnico Magnets With Metal Trap

Specifications and Prices

Diverters:	N/A	**Spacing on Center:**	1½" bar to bar
Space between Diverters:	N/A	**Space between Tubes:**	½"
Webs:	Rod supports	**Construction:**	Tack to rods
Web size:	⅜" dia.	**Finish:**	80-grit glass bead blasted
Magnetic Tubes:	1" O.D. (.049 wall)	**Type of Stainless:**	304
Magnets:	Rare earth	**Overall Height:**	1⅜"

Item #	Diameter	Unit Price
109954	6”	Inquire
106091	8”	Inquire
108417	10”	Inquire

Other sizes made to order

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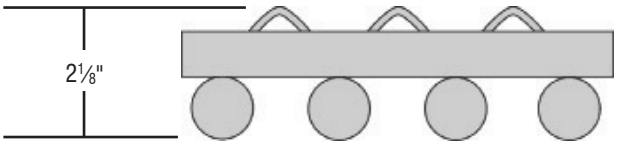
IMS LC Hopper Magnets

Basic Protection Against Tramp Ferrous Metal

- Diverters force material to flow across magnetic surfaces
- Ceramic magnet bars provide excellent holding power
- Low profile design takes up less room in the hopper
- Available for rectangular hoppers only



Standard 2" tube spacing is based on
Maximum Magnetic Flux Field Pattern
to catch the finest ferrous particles (steel, etc.)

Specifications and Prices

Diverters: 1" wide, 16 gauge, 90° bend, ⅝" legs
Space (between diverters): 1"
Webs: 11 ga.
Web Size: ¾" high
Magnetic Tubes: 1" O.D. (.049 wall)

Magnets: Ceramic
Spacing on Center: 2" bar to bar
Space Between Tubes: 1"
Construction: Tack welded 2 places each tube
Finish: 80-grit glass bead blasted
Type of Stainless: 304
Overall Height: 2⅛"

Width (Tube Length)

Length	4"		6"		8"		10"		12"	
	Item #	Prices	Item #	Prices	Item #	Prices	Item #	Prices	Item #	Prices
3½"	N/A	—	109137	**Inquire**	N/A	—	110174	**Inquire**	110156	**Inquire**
5½"	107990	**$74.86**	108161	**$99.05**	109745	**Inquire**	110084	**Inquire**	110170	**Inquire**
7½"			107321	**Inquire**	106422	**Inquire**	110106	**Inquire**	106561	**Inquire**
9½"	110078	**Inquire**	110165	**Inquire**	110145	**Inquire**	107818	**Inquire**	110116	**Inquire**
11½"	110103	**Inquire**	110093	**Inquire**	110178	**Inquire**	110161	**Inquire**	110141	**Inquire**

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IMS Economy Hopper Magnets

Great Value for Multi-Industrial Use

- Diverters force material to flow across magnetic surfaces
- Ceramic magnet bars provide excellent holding power
- Available for round or square hoppers

Now available with 60° or 90° diverters

Arrangement Of Diverters
forces material to travel
within 7⁄16" of magnetic surface

Specifications and Prices

Diverters:	1⅛" wide, 14 gauge, ¾" legs	**Magnets:**	Ceramic
Space (between diverters):	⅞"	**Spacing on Center :**	2" bar to bar
Webs:	14 ga.	**Space Between Tubes:**	1"
Web Size:	1⅞" high	**Construction:**	Punched webs plus tack welding
Magnetic Tubes:	1" O.D.	**Finish:**	Glass bead-blasted
		Type of Stainless:	304
		Overall Height:	2⅜"

Standard Type For Round Hoppers

Diameter	Item #	Diverter Angle	Unit Price	Item #	Diverter Angle	Unit Price
4"	143608	60°	**$50.55**	101181	90°	**$50.55**
6"	143609	60°	**55.97**	101168	90°	**55.97**
8"	143610	60°	**75.70**	101159	90°	**55.57**
10"	143611	60°	**71.00**	101147	90°	**154.32**
12"	143612	60°	**125.43**	101208	90°	**183.74**

Standard Type For Square/Rectangular Hoppers

Size	Item #	Diverter Angle	Unit Price	Item #	Diverter Angle	Unit Price
4" x 4"	143603	60°	**$49.63**	101227	90°	**$49.63**
4" x 6"	144386	60°	**Inquire**			
6" x 6"	143604	60°	**56.50**	101327	90°	**70.00**
6" x 8"	144387	60°	**82.51**			
8" x 8"	143605	60°	**69.60**	101309	90°	**51.43**
10" x 10"	143606	60°	**82.07**	101290	90°	**70.14**
12" x 12"	143607	60°	**139.64**	101273	90°	**248.44**

14" Units available upon request — Inquire

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Magnet Housings And Rare Earth Magnets

The Best Drawer Magnet in the Industry

Magnet Housing Features:

- Powerful rare earth magnets efficiently capture and retain ferrous metal contaminants, preventing tramp metals from entering and damaging your processing equipment.
- Slide gate with latch remains securely open during production, when closed allows you to shut off material flow for purging and color changes.
- Non-magnetized, 11-gauge stainless steel housing maintains magnetic efficiency and supports up to 10,000 lbs of symmetrical compression, delivering unmatched durability and strength.
- EPDM drawer gasket resists heat aging and compression set
- Drawer guide to facilitate drawer removal and cleaning
- High-torque, break-resistant nylon drawer locking knobs provide secure and reliable operation
- ¼" thick steel flanges, In-Stock units include slotted bottom flange!

5X More Powerful Than Ceramic Drawer Magnets

Drawer Magnet Features:

- Neodymium rare earth magnets provide 5,000 gauss of pulling and holding strength for optimal performance
- Temperature compensating magnets retain their full strength up to 180°F. (High Temperature 392°F magnets available – Inquire)
- Two rows of 1-inch tubes optimize the magnetic circuit while maintaining free material flow

Customization Options Available (inquire):

- High Temperature Magnets, 392°F
- Purge hopper
- Rear dump tube
- Liquid port

Fully customized drawer magnet housings available upon request, complete with pre-drilled flanges for quick and easy installation. Simply provide your flange mounting requirements and options by completing the form on pages 722-723.

Available in 100% Stainless Steel Housing with Stainless Steel Flanges

When all Stainless Steel Construction is Necessary - Call to Inquire

www.imscompany.com phone order toll-free (USA & Canada) **1.800.537.5375**

fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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Magnet Housings and Rare Earth Magnets

Our Best Drawer Magnet Value for Metal Separation

Stainless Steel Housings with Carbon Steel Flanges Undrilled Top Flange, Universal Bottom Flange -- IN STOCK						
Item #	**Top Opening**	**Bottom Opening**	**Magnet Size**	**Top Flange**	**Bottom Flange**	**Unit Price**
175700	2"	2"	4" x 4"	4¼" x 4¼"	4" x 4"	**$537.50**
175701	4"	2⅞"	6" x 6"	6¼" x 6¼"	6" x 6"	**610.00**
175702	6"	5½"	8" x 8"	8¼" x 8¼"	8" x 8"	**792.30**

Made to Order Customized Housings Feed Openings and Mounting Holes Drilled to your Specifications (lead time applies)				
Item #	**Machines w/Feed Screw Opening**	**Magnet Size**	**Housing Height**	**Unit Price**
133917	⅞" - 2"	4" x 4"	10½"	**$757.10**
133918	2" - 4"	6" x 6"	10⅝"	**973.60**
133919	4" - 6"	8" x 8"	11⅞"	**1,343.00**
Optional Accessories for Customized Housings **Must be installed at the time of fabrication - cannot be added to stock unitss**				
134373	Purge Hopper (Steel) - to speed clean-out of barrel			**$301.80**
134375	Rear Dump Tube (Steel) - easily empties the housing			**104.50**
134377	Liquid Port (Steel) - to inject liquid color additives			**104.40**
High Temperature 392°F Rare Earth Magnets Available				

Optional Accessories for Custom Housing cannot be added to STOCK units

175700

175701

175702

Replacement Parts for Drawer Magnets and Housings						
	— 4" x 4" —		— 6" x 6" —		— 8" x 8" —	
Magnet Housing	**Item #**	**Unit Price**	**Item #**	**Unit Price**	**Item #**	**Unit Price**
Face Plate for Drawer Front	143342	**$38.10**	126299	**$56.60**	143344	**$67.70**
Gasket for Drawer Front	123245	**39.40**	143345	**59.10**	143347	**71.40**
Drawer Magnet 2005-Present	138364	**543.80**	138365	**568.40**	138366	**686.60**
Swing Bolt Assembly (includes knob)	132570					**32.00**
Swing Bolt Knob Only	125401					**10.00**

Available in 100% Stainless Steel Housing with Stainless Steel Flanges

When all Stainless Steel Construction is Necessary - Call to Inquire

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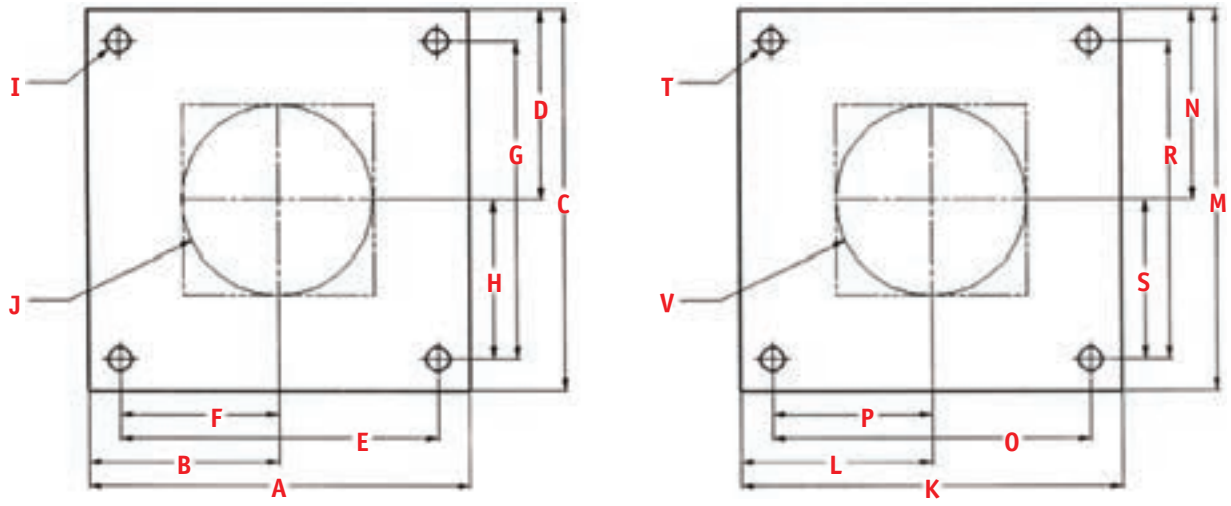
Drawer Magnet Housing Flange/Accessory Form

SPECIFY:

See next page for Isometric / 3 Dimensional View



Bottom Flange
Operator Side (Front)

A _____
B _____
C _____
D _____
E _____
F _____
G _____
H _____
I _____ (bolt size used)
J — Opening
❑ Round _____
❑ Square _____
❑ Rectangle _____
Front to Back _____
Side to Side _____

Top Flange
Operator Side (Front)

K _____
L _____
M _____
N _____
O _____
P _____
R _____
S _____
T* _____ o **Threaded Holes**
(thread size used) o **Studs**
V — Opening
❑ Round _____
❑ Square _____
❑ Rectangle _____
Front to Back _____
Side to Side _____

*Studs will be required if bolt pattern falls on housing body

Make of Press: _____ Serial Number: _____

Model: _____ Screw Size: _____ Ounce: _____

Make of Hopper: _____ Hopper Capacity: _____ lbs.

Optional Equipment:

☑ Slide Gate Shut-off
❑ With Discharge Dump Tube: ❑ Rear ❑ Other _____
❑ Tapped Hole for Liquid Dispensing System
❑ With Purge Hopper: ❑ R.H. Side ❑ L.H. Side
❑ Other _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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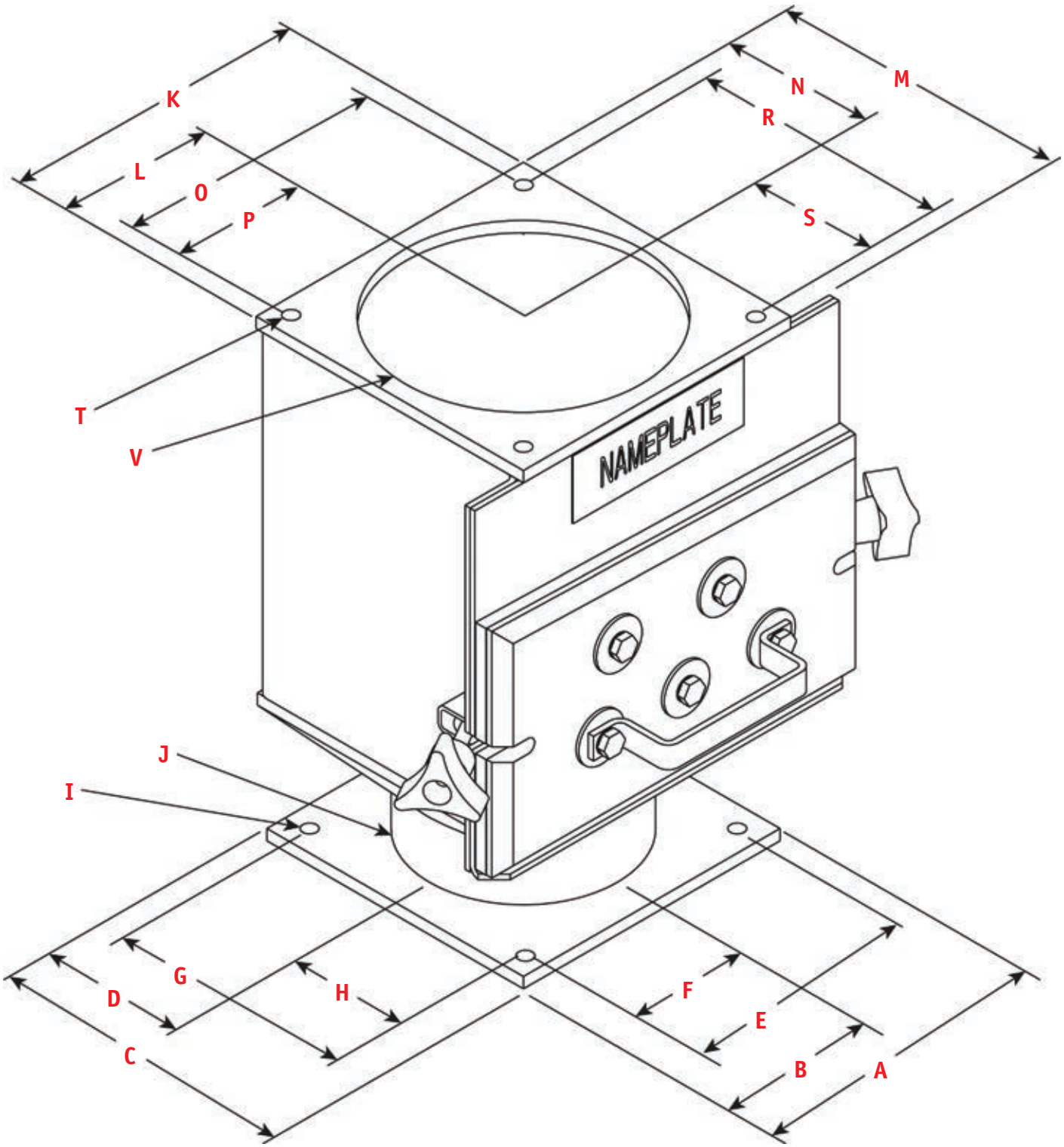
Isometric View of Flange Dimensions



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Pre-Production All-Metal Detectors

Metal removal at higher flows, prior to final processing

Gravity style design with adjustable reject time

Detects and rejects metal as small as **0.4 mm in diameter**

Works on ferrous and non-ferrous materials

CE certified - meets EU health, safety and environmental requirements

Accurate even with difficult materials

High-speed reject mechanics minimizes good material diversion

- Self-monitoring and auto-test standard
- Integral brackets simplify mounting
- Works great in plastics, recycling and other applications
- 30-200mm (1¼-8") feed hole range
- 100-240 VAC

1 Year Warranty

Item #	Feed Hole O.D.	Reject Port Diam.	Throughput lbs/hr*	Sensitivity	Dimensions Height	Width	Depth	Weight	Unit Price
161774	1 3/16" (30mm)	3⅛" (80mm)	1,000	0.4mm	16½"	13"	9⅞"	44	**$7,011.00**
161775	2" (50mm)	3⅛" (80mm)	3,000	0.4mm	16½"	13"	9⅞"	44	**7,011.00**
161776	2¾" (70mm)	3⅛" (80mm)	6,000	0.6mm	16½"	13"	9⅞"	44	**7,275.00**
161777	3⅛" (80mm)	3⅛" (80mm)	7,500	0.7mm	22¾"	16⅞"	13"	70	**8,755.00**
161778	3⅞" (100mm)	3⅞"(100mm)	12,000	0.8mm	22¾"	16⅞"	13"	70	**7,275.00**
161779	4¾" (120mm)	4¾" (120mm)	17,000	0.9mm	22¾"	16⅞"	13"	70	**10,449.00**
161780	5⅞" (150mm)	5⅞" (150mm)	27,000	1.2mm	25⅝"	18⅞"	15"	110	**11,175.00**
161781	7⅞" (200mm)	7⅞" (200mm)	48,000	1.75mm	27½"	20⅞"	18⅛"	135	**14,190.00**

*Rated at 10lbs/ft3

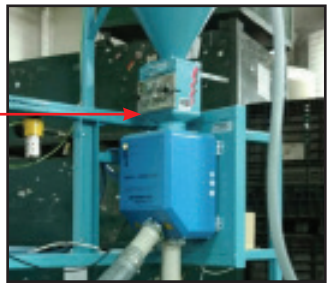
Custom Form on next page

Accessories

Drawer Magnets to minimize contaminated resin - see pages 720-721

Loader Hose and Clamps - see pages 410-414

Replacement Inlet/Outlet Stub Assemblies available - Inquire



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REQUEST FOR QUOTE: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

Custom Inline All-Metal Detector Quote Form

Product Details

1. Product (Description): _____

Characteristics of the Product (Check all that apply): ❑ Dusty ❑ High Static ❑ Product can be wet at times

❑ High percentage of carbon in the product ❑ Product is very abrasive ❑ Larger particles can be intermingled

2. Particle Size/Dimension: _____ **3.** Moisture Content: _____ %

4. Feed Rate: _____ lbs/hr **5.** Bulk Density: _____ LBS/FT^3

6. Product Temperature: _____ °F **7.** Material Feeding From: _____

Note: Freefall height to inlet of detector not to exceed 18"

8. Material Feeding To: _____

Additional Application Details: _____

_____

Detector Details

1. Feed Hole OD:
❑ 1 3/16" (30mm) ❑ 2" (50mm) ❑ 2 3/4" (70mm) ❑ 3 1/8" (80mm)
❑ 3 7/8" (100mm) ❑ 4 3/4" (120mm) ❑ 5 7/8" (150mm) ❑ 7 7/8" (200mm)

2. Detached Controls: ❑ Yes Cable Length Required: _____ feet. ***Note: Not available on all models***

3. Location: ❑ Indoor ❑ Outdoor Environment Temperature: _____ °F min / _____ °F max

Note: Inline all-metal detectors are NOT to be used in food applications. Feed rate must be calculated on a continuous basis

4. Construction:
❑ Utility grade painted construction (standard in this configuration)
❑ Painted coil with stainless frame and diverter (wipe down only)
❑ Stainless steel complete (extreme wash down with high pressure)
Note: Stainless coil required in heavy wash down or corrosive environment

5. Voltage: ❑ 110-240 VAC 50/60 Hz, Single Phase ❑ Other: _____ V / _____ Phase

6. Sensitivity Requirement: _____ FE _____ NFE _____ SS

7. Detector Options:
❑ Test Ball Retrieval Kit (Good Port) ❑ Test Ball Retrieval Kit (Reject Port)
❑ Inlet Hopper _____ ft^3 ❑ Drawer Magnet on infeed
❑ Outlet Transition (Clean Product) _____ Outlet OD ❑ Outlet Transition (Reject Product) _____ Outlet OD
❑ Floor Stand _____ Distance from floor to inlet ❑ Inlet Stub

❑ **ATEX** Hazardous Environment - Will this unit require an explosion proof rating? ATEX ratings are available on certain detectors. (ATEX is the European Union standard, which meets all of the requirements of the NEC North American Standard.) A chart is available to explain the classification terms for ATEX.
NOTE: Available only as 5.1 Touch

Requested ATEX Classification _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Made in the U.S.A

Machine Mounted All-Metal Detectors/Separators

Great for extrusion, injection and blow molding machines

Provides efficient detection and rejection of both ferrous and nonferrous metal contaminants within all materials, whether loose or encapsulated, without process interruptions. Designed for mounting on an injection molding machine or extruder as a "last chance" metal detector. This type of detector, also available in a high-temperature rated model uses a pneumatic rejection mechanism to remove metal that were detected previously in the process flow.

- Fast pneumatic rejection helps conserve good material
- Separators install directly above in-feed/feed throat
- Works on ferrous and non-ferrous materials
- CE certified - meets EU health, safety and environmental requirements
- Rugged housings allow mounting of other equipment

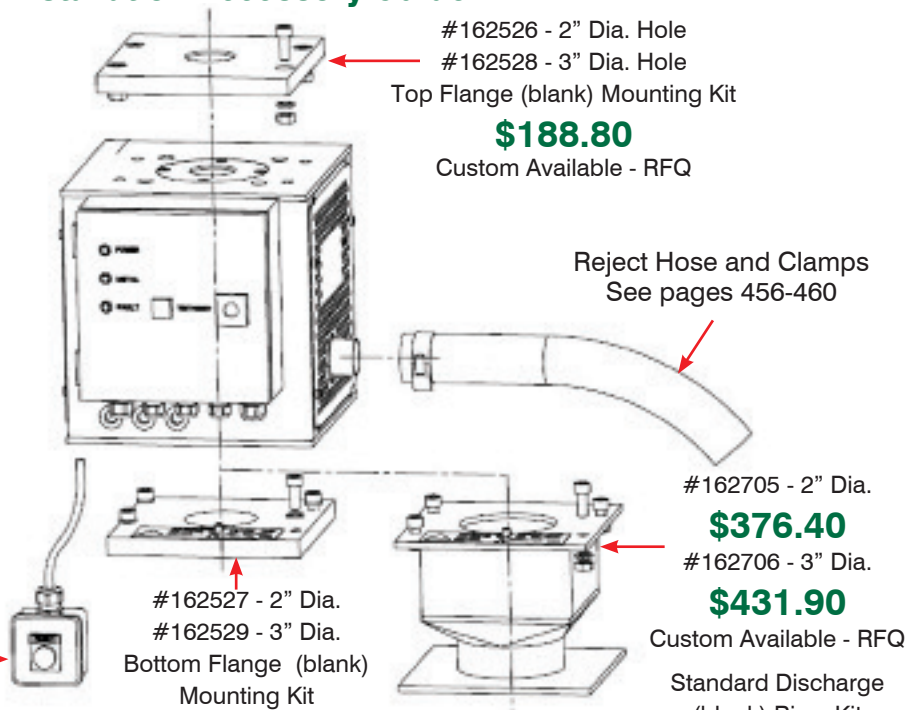
1 Year Warranty

Item #	Feed Hole Diameter	Reject Port Diam.	Throughput lbs/hr*	Min Size Detectable	Dimensions Height	Width	Depth	Weight	Unit Price
161782	2" (50mm)	3" (75mm)	1,000	0.4mm	12"	10¼"	16¾"	60	**$8,979.00**
161783	3" (75mm)	3" (75mm)	3,200	0.4mm	12"	10¼"	16¾"	60	**9,037.00**

High Temperature Units Available — Inquire / Custom Form on next page

Installation Accessory Guide

Photo shows Loader, Drawer Magnet and All-Metal Detector



#162526 - 2" Dia. Hole
#162528 - 3" Dia. Hole
Top Flange (blank) Mounting Kit
$188.80
Custom Available - RFQ

Reject Hose and Clamps
See pages 456-460

#162705 - 2" Dia.
$376.40
#162706 - 3" Dia.
$431.90
Custom Available - RFQ

Standard Discharge (blank) Riser Kit
8" sq base x 6¼" h

#162530
Remote Reset Pushbutton with 10' Cable
$232.50

#162527 - 2" Dia.
#162529 - 3" Dia.
Bottom Flange (blank) Mounting Kit
$188.80
Custom Available - RFQ

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Custom Machine Mounted All-Metal Detector Quote Form

Application Details

1. Material Type: _____

2. Regrind: _____ % Virgin: _____ % **3.** Bulk Density: _____ LBS/FT³

4. Maximum Particle Size: _____ **5.** Maximum Product Temperature: _____ °F

6. Characteristics of the Product (Check all that apply): ❑ High percentage of carbon in the product
❑ Larger particles can be intermingled ❑ Dust particles are present

7. Details on Injection or Blow Molding Operation:

Shot Size: _____ (weight) Cycle Time: _____ Seconds

8. Details on Extrusion Operation:

Flow Rate: _____ LBS/hr Bulk Density: _____ LBS/FT³

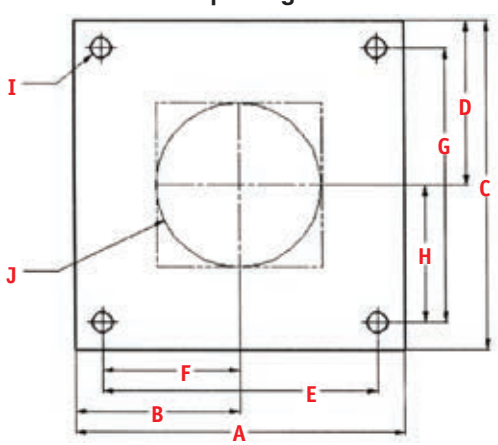
9. Material Feeding From:

❑ Vacuum Loader (intermittently) ❑ Dryer - Maximum Temperature: _____ °F

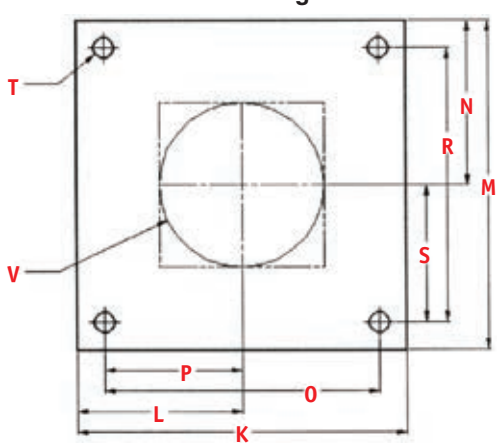
❑ Other: _____

TOTAL WEIGHT of ALL equipment on top of Metal Detector: _____ LBS

Top Flange



Bottom Flange



A _____	**H** _____	**K** _____	**S** _____
B _____	**I** _____	**L** _____	**T** _____
C _____	**J** _____	**M** _____	**V** _____
D _____	**Opening:** _____	**N** _____	**Opening:**
E _____	❑ Round _____	**O** _____	❑ Round _____
F _____	❑ Square _____	**P** _____	❑ Square _____
G _____	❑ Rectangle _____	**R** _____	❑ Rectangle _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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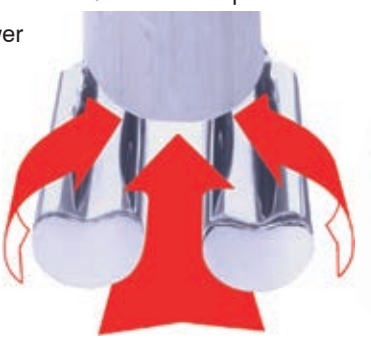
IMS Hopper Loader Probe Magnet

Hopper Loader Probe Magnet traps tramp iron as you load material from drums, gaylords, or bins. Use it in conjunction with our hopper magnets to provide an extra measure of protection against tramp iron in your plastic material. (NOT intended to be used alone.)

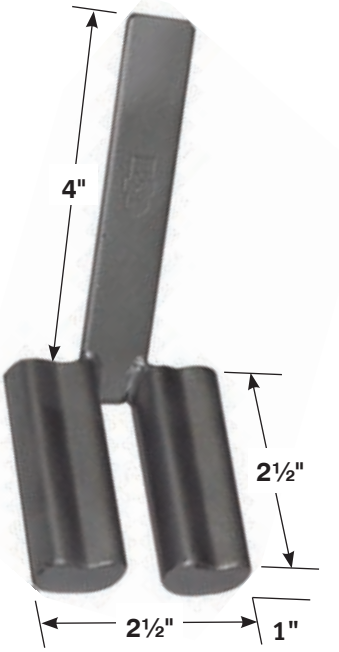
- Aids in preventing screw and barrel wear, hopper loader damage and clogged nozzles
- Powerful alnico magnets provide strong pulling power
- Easy installation
- Corrosion and abrasion resistant
- Easily adjusts to different types of plastic
- Polished stainless steel
- All welded construction
- Weight: 2 lbs.
- Stainless steel worm-drive clamps (sold separately)

Only From IMS

Unique Concave Holding Area Prevents Wipe-Off!



Plastic Flow



Item #	Description	Unit Price
108027	Hopper Loader Probe Magnet	**$73.00**

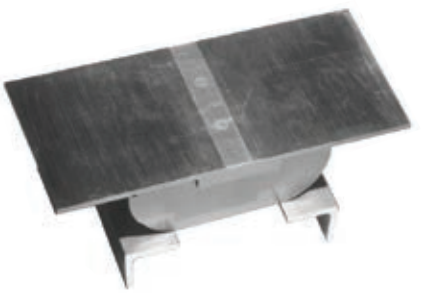
IMS Oil Tank Sludge Magnet

Removes Tramp Iron From Hydraulic Circuits

Simply place magnet in oil tank of any hydraulic circuit. It will pick up fine iron worn from valves, cylinders, etc. Cuts maintenance costs.

- Reduces filter clogging
- Lengthens pump life

Size: 6½"L x 3⅝"W x 2½"H



Item #	Description	Unit Price
105321	Oil Tank Sludge Magnet	**$120.15**

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Since
1949

IMS® Industrial Equipment

Production Equipment

Mold Temperature Controllers & Fluids
Pages 730 – 750

Chillers
Pages 751 – 758

LIME BUSTER™ Mold Water Passage Cleaners
Pages 759 – 763

Most items IN STOCK for Same Day Shipment

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Fluid Circulating Process Temperature Controllers

WATER CIRCULATING

Tank Style / Closed Loop

- Process water or water/ethylene glycol
- Process water isolated from cooling water circuit
- Can use the addition of glycol to obtain elevated temperatures above boiling and inhibit rust and corrosion

Air Cooled

IMS Hydra Air Cooled Circulator

Works great in areas where cooling water is scarce or expensive

- "Waterless" cooling system reduces operating costs and pays for itself in water, sewer or cooling tower savings
- Portable, no cooling water hook up required
- Temperature Range: Slightly above ambient air up to 250°F (with glycol)

See Pages 732-733

Water Cooled

IMS Hydra Water Cooled Circulator

Closed loop system minimizes corrosion problems

- 14 gallon stainless steel tank and pump
- Temperature Range: Up to 250°F (with glycol)
- Uses your shop cooling water supply

See Pages 736-737

No Cooling

IMS Hydra Temkon SS Circulator

Perfect for mold preheating and small mold temperature control

- 4¼ gallon stainless steel tank
- 100% non-ferrous construction
- Temperature Range: Up to 250°F (with glycol)

See Page 735

Vacuum

IMS Hydra Negative Pressure Circulator

Eliminate down time caused by coolant leaks in your process

- 4¼ gallon stainless steel tank
- Operates as either a positive or negative pressure circulator
- Temperature Range: 50°F to 205°F

See Pages 738-739

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Fluid Circulating Process Temperature Controllers

WATER CIRCULATING

Pressurized / Open Loop

- Minimum capacity process water circuit
- Cooling water combines with process water
- Pressure used to achieve elevated temperatures above boiling (212° F) up to 250° F standard
- When used in combination with chiller as cooling water source, glycol can be added to achieve elevated temperatures and as a corrosion inhibitor

IMS Hydra Pressurized Water Circulator

For precise, automatic mold temperature control

- Now up to 70% more flow
- ¾ hp to 5 hp pumps available
- Long life, 9 kW to 24 kW heating elements
- Temperature Range: Up to 250°F
- Stackable

See Pages 740-741

Shini Pressurized Hot Water Circulator

Great value for multi-industrial use

- 1 hp stainless steel centrifugal pump
- 9 kW insulated heater
- Temperature Range: Up to 250°F

See Page 743

OIL CIRCULATING

Tank Style / Closed Loop

- Process fluid is heat transfer oil, isolated from cooling water circuit
- Used for elevated temperatures up to 550° F

IMS Hydra High Heat Oil Circulator

For close tolerance molding at temperatures up to 550°F

- Oil to water heat exchanger provides better control and faster cool down
- Temperature Range: Up to 550°F
- Two 8 kW steel sheathed heating elements
- 8 gallon cold fill insulated steel tank

See Page 746-747

Shini Hot Oil Circulator

Great values for process temperature control up to 450°F

- Temperature Range: Up to 450° F
- 1 or 2 hp stainless steel pump, centrifugal and magnetic drive pumps available
- 9 kW to 24 kW stainless steel insulated heating elements

See Page 748

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Made in the U.S.A

IMS Hydra Air Cooled Mold Temperature Controller/Circulator

The Ultimate in Performance, Versatility and Efficiency!

Pays For Itself In Water, Sewer Or Cooling Tower Savings

2 Year Warranty

Hydra Circulators

Waterless Cooling System
- Minimizes water consumption, cutting overall operating costs
- A necessity for shops where water is expensive or poor quality

Portable - Does not require cooling water

Quality Components - Stainless steel pump, tank and heating element ensures long service life

Vertical Mounted Fan Design - Keeps operators and shop cool

Solid State PID Temperature Controller - Provides accuracy up to ±1° F
- 1/16 DIN size
- PID Control - Auto-tuning on cold or warm start
- Bright 0.40" (10 mm) red LED process display 0.31" (8 mm) green LED setpoint display
- Swivel casters provide mobility
- Low fluid level electrical shut off
- Operating temperature range from just above ambient to 250°F (with glycol)

Model MC90AC

How it works

(A) Return water from the mold/ process enters back into the circulator.

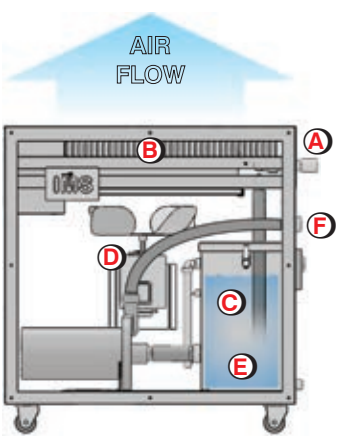
(B) The water passes through a heat exchanger into the tank.

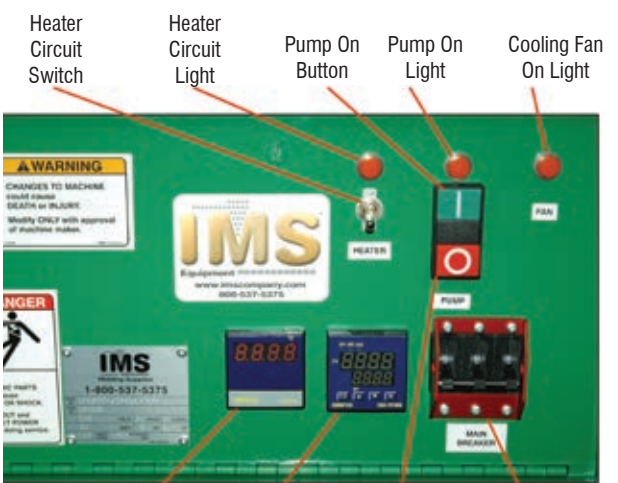
(C) Tank holds 12 gallons of water and glycol mix.

(D) A powerful fan is activated when cooling is required. Heated air is removed upwards and away from the operator.

(E) 9kW heater is activated when heat is required to raise the water temperature.

(F) Returns water to mold/process.





Production Equipment

IMS Company

www.imscompany.com

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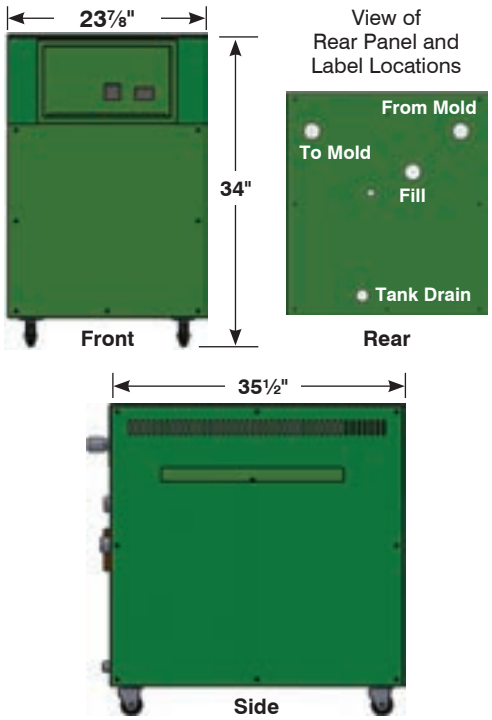
IMS Hydra Model MC90AC (continued)

GREEN Products

Made in the U.S.A

Dimensions



Full Load Amps: 30 @ 230 V — 15 @ 460 V

Controller: Control Circuit: 120 Vac
Range: Slightly Above Plant Air Temperature To 250°F
Graduation: Increments of 1°F
Accuracy: ±1°F

Cooling: Air-Cooled, Copper Tube Aluminum Finned Heat Exchanger (20" X 20" X 3½")

Fan: Horsepower: ¼
RPM: 1,725
Blade: 18" Blade, Quiet Pitch

Air Filter: 21" X 23" X 1"

Pump/Motor: Type: Centrifugal, Close-Coupled To Motor
Horsepower: 1
RPM: 3,900
GPM: 30 At 88 Foot Head (38 psi)

Heater: Wattage: 9 Kw Quantity: 1
Sheath: Copper For Water/Glycol

Tank: Capacity: 12 Gallons
Construction: Welded Stainless Steel

Mold Connections: Output To Mold: 1" N.P.T.
Return From Mold: 1" N.P.T.

Other: Overall Size: 36"L X 24"W X 38"H
Crate Size: 44"L X 32"W X 45"H
Weight: 365 Lbs. Crated / 295 Uncrated

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

IMS Hydra Air Cooled Mold Temperature Controller

Item #163525 for 230/60/3 (30 amps)
Item #164036 for 460/60/3 (15 amps)

$8,860.00

Item #	Description	Unit Price
138216	Chiller Flushing Fluid	$290.34

For Circulator Hose see pages 444-448

Common Replacement Parts

148639	230V Heating Element	$738.80
148812	460V Heating Element	588.50
148749	Heater Gasket	9.00
161851	Pump/Motor Assembly	1,430.00
162676	Standard Temp Controller	Inquire
164838	Molding Machine Interfacing Capable Temp Controller	280.00
161984	Fan Motor	271.17
162609	Filter	68.80

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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IMS Hydra Temkon SS™ Mold Circulator

For mold preheating/small mold temp control

Made in the U.S.A

Hydra Circulators

2 Year Warranty

100% non-ferrous construction - Eliminates risk of rust or contamination

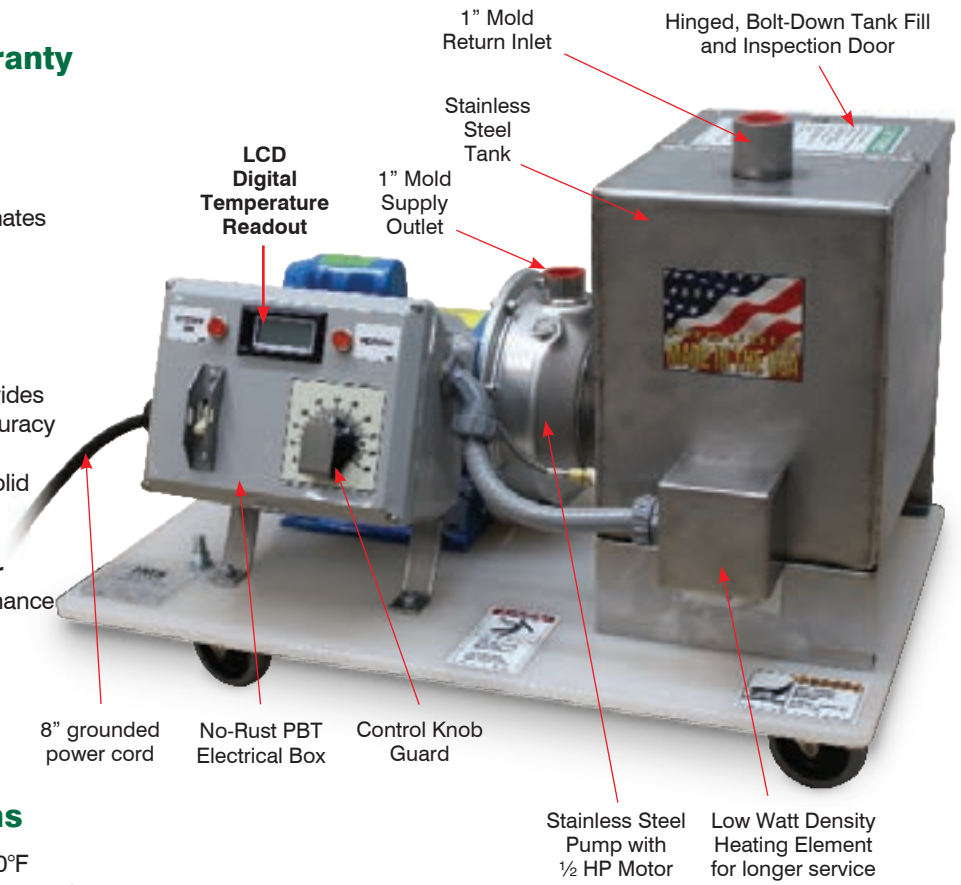
Closed-loop circuit - Decreases water consumption

Pakstat™ temperature controller - Provides simple, accurate control with ±4° accuracy

Thick polypropylene base - Provides solid mobile base that won't rust

Permanently greased pump and motor bearings - Eliminates routine maintenance

- 230/60/1 volt
- Heating light
- System on light



Specifications

Thermostat: Range: 50° To 250°F
Graduation: 2° Increments
Accuracy: ±4°F

Operating Range: 90° To 250°F

Pump/Motor: Horsepower: ½
Rpm: 3,450
Gpm: 30 At 30 Foot Head (13 Psi)

Heater: Wattage: 3,000 Quantity: 1
Sheath: Copper for water

Tank: Capacity: 4¼ Gallons
Construction: Welded Stainless Steel

Connections: Mold Supply Outlet: 1" N.P.T.
Mold Supply Inlet: 1" N.P.T.

POWER: 230/60/1 (17 Amps)
60hz, Single Phase

Other: Size Overall: 25"W X 14"D X 17"H
Weight: 90 Lbs. Crated

TEMKON SS™ is a Trademark of IMS Company
PAKSTAT™ is a Trademark of Paktronics Controls, Inc.

Item #108141
230/60/1 (17 amps)

$2,999.00

To Prevent Mold Rust

Use Ethylene Glycol and water solution (30% glycol recommended)
Good for temperatures up to 250° F
(See page 744 for UG-10 and EG-17 Ethylene Glycol Fluid)

Replacement Parts

Item #	Description	Unit Price
112360	Pump and Motor	$1,339.00
131720	Motor Only	Inquire
108448	Heater Element	11.67
121352	Pump Seal Repair Kit	152.10

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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Made in the U.S.A

IMS Hydra Water Cooled Mold Temp Controller/Circulator

The First and Still The Best "Tank Style" Circulator

Hydra Circulators

2 Year Warranty

Model MC90WC

Tank Style Design - Process water isolated from cooling circuit allows usage of ethylene glycol

Stainless Steel Base and Tank - Protects against corrosion

Compact Design - Takes up very little floor space

All Swivel Casters - Portable to all areas of your shop

Open Construction - Easy access to all components — decreasing maintenance time

Low Fluid Level Electrical Shut Off - Protects against heater and pump failure

PBT Control Box with hinged clear polycarbonate lid - Protects electrics and discourages tampering

TEC-9001 Temperature Controller

- 1/16 DIN size
- PID Control - Auto-tuning on cold or warm start
- Bright 0.40" (10 mm) red LED process display / 0.31" (8 mm) green LED setpoint display

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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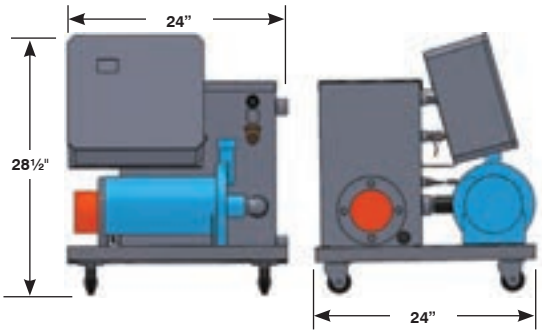
IMS Hydra Model MC90WC (continued)

Made in the U.S.A

Furnace Brazed Copper Cooling Coil

Immersed In Process Fluid Tank

Dimensions



Full Load Amps: 21.7 @ 230 V — 10.8 @ 460 V

Controller: Control Circuit: 120 Vac
Range: 120°F Up To 250°F (With Glycol)
Graduation: Increments of 1°F
Accuracy: ±1°F

Cooling: External Cold Water Supply
Inlet/Outlet: ½"

Pump/Motor: Type: Centrifugal, Close-Coupled To Motor
Horsepower: 1
Rpm: 3,500
Gpm: 30 at 88 Foot Head (38 psi)

Heater: Wattage: 9 Kw Quantity: 1
Sheath: Copper for Water/Glycol

Tank: Capacity: 14 Gallons
Construction: Welded Stainless Steel

Mold Connections: Output To Mold: 1" N.p.t.
Return From Mold: 1" N.p.t.

Other: Size Overall: 24" W X 24" D X 28½" H
Weight: 161 Lbs. Crated

IMS Hydra Water Cooled Mold Temperature Controller

Item #162713 for 230/60/3 (21.7 amps)

Item #162714 for 460/60/3 (10.8 amps)

Request for Quote

Also available with bigger pumps or as oil circulating units — Inquire

Item #	Description	Unit Price
138216	Chiller Flushing Fluid	**$225.00**
See page 747 for details		
For Circulator Hose see pages 400-402		

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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IMS Hydra Negative and Positive Pressure Mold Temperature Controller/Circulator

Eliminate downtime caused by coolant leaks in your process

Hydra Circulators

1 Year Warranty

Model RV092

Negative pressure mode - Stops leaks and decreases downtime

Tank type, closed-loop design - Minimizes corrosion and deposits in mold water passages

Stainless and non-ferrous components (pump / tank / heat exchanger / heater element sheaths) - Protects against corrosion

Vacuum adjusting valve - Eliminates leaks without pulling in air

Dual low watt density, stainless steel sheathed heater - Provides increased durability and built-in standby

Adjustable temperature deviation indicator with audible alarm and silencer - Permits easy programming of custom operating parameters

- Non-ferrous construction of all components in water bath
- Premium quality solenoid valves
- Easy to read digital readout of “To Process” and “Set Point” temperatures
- 24/7 programmable timer for automatic start/stop
- Inlet strainer to remove debris from water
- Vented cabinet with removable panels

Two Operational Modes

- In the negative pressure mode, the pump pulls fluid through the mold, creating a vacuum that eliminates leaks and prevents pulling any air into the line.
- In the positive pressure mode, the pump pushes fluid through the mold just like any standard mold temperature controller.

IMS Company

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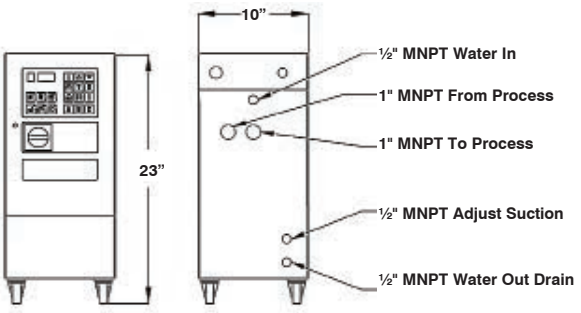
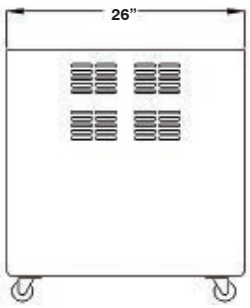
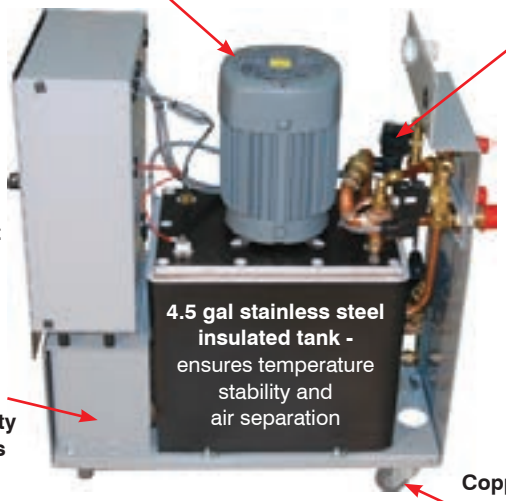
IMS Hydra Model RV092 (continued)

Dimensions





Crated Size:
14" x 27" x 33"



Powerful 2 hp stainless steel centrifugal pump provides enough flow for large molds

Powder coated cabinet provides a durable finish

Pump has non-rotating seals for greater leak resistance

Solenoid valve automatically fills tank to simplify setup and prevent heater damage

Inlet strainer protects against debris in water

Variable vacuum adjustment valve allows precise settings to meet your needs!

Copper heat exchanger

4 swivel casters for easy mobility

Vented cabinet helps pump run cooler and last longer

Dual incoloy low watt density heat elements

Rust resistant stainless steel pump, tank, and heater element sheaths

Covers removed for illustration only

Electrical

Temperature Controller: Microprocessor controls discharge temperature

Voltage: 230/60/3 or 460/60/3

Full-Load Amps: 30 @ 230V or 15 @ 460V

Control Voltage: 110 VAC

Control Range: 50° to 205°F

Accuracy: ±1° F

Incoloy sheathed Heating Elements (two, 4.5 kW): 9 kW

Pump/Motor

Type: Centrifugal pump, close-coupled to motor

Horsepower: 2

Speed: 3,400 rpm

Flow: 21 gpm @ 67 ft. head (29 psi)

Mold Connections: 1" N.P.T.

Cooling Capacity*: 50,000 btu/hour

Cooling Water Connections: ½" N.P.T.

Cooling: Copper tube heat exchanger mounted in reservoir

Tank: 4½ gallons, insulated, welded stainless steel

Tank Drain: 1/2" N.P.T.

Weight (uncrated): 100 lbs

(crated): 125 lbs

*Based on 50° F water temp, 140°▲T and 190°F set point

IMS Hydra Negative and Positive Pressure Mold Temperature Controller

Item #175698 for 230/60/3 (30 amps)

$6,810.00

Item #132944 for 460/60/3 (15 amps)

$6,415.00

Oil Units and bigger pumps also available — **Inquire**

Item #	Description	Unit Price
138216	Chiller Flushing Fluid (see page 745 for details)	**$225.00**

For Circulator Hose see pages 444-448

Common Replacement Parts

125117	Motor only (230V)
129680	Motor only (460V)
130246	Pump only
127957	Solenoid valve, no coil
127958	Solenoid coil
141685	⅜" check valve
131012	Water level sensing probe
138058	Gland for water level sensor

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Made in the U.S.A

IMS Hydra Pressurized, Open-Loop Mold Temperature Controller/Circulator

Now Up To 70% More Flow Without Increased Pump Size!

Hydra Circulators

Improved Design • In Stock

Model RQT

Maximum Performance

- High-Flow Energy Efficient Pumps
- Long Life Heaters
- Temperature Range Up to 250°F

Reliability

- High Quality 24 VDC Control Circuit Power
- Long Life Pump Seals with Integral Flush System
- Leak Proof Pump/Heater Assembly
- High Performance Modulating Valves

Ease Of Use

- User-Friendly Operator Interface
- Temperature & Pressure Display
- Tools-Free Removable Cabinet
- Automatic Air Purge
- Four Swivel Casters – Easy Movement

Exceptional Warranty

Coverage On Defects And Workmanship:

- 3 Year on Parts/Labor and 5 Year on Control Board Parts
- Lifetime Pump/Heater Casting and Standard Pump Seal
- Lifetime $175.00 Control Board Exchange

Control Panel Features:

- Automatic Air Purge with 120°F Air Purge Cancel
- Seal-Saver Program
- Digital Flow Meter
- Pump Running Hours Display
- Temperature Deviation Warnings and Alarms
- Supply and Return Temperature Display
- Alarm Horn and Silence Switch
- Modbus RTU
- Trending Data

Internal Microprocessor Control Features:

- Low voltage 24 VDC control keeps the control circuit signals free from AC interference
- Adjustable automatic air vent sequence at start-up with safety cancellation above 120°F
- Programmable high temperature safety set for 260°F

IMS Company

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IMS Hydra Model RQT (continued)

Long-life, low-watt density incoloy heaters
reduces maintenance

Removable cabinet
no tools required

Internal bypass line
protects pump and heater under low flow conditions

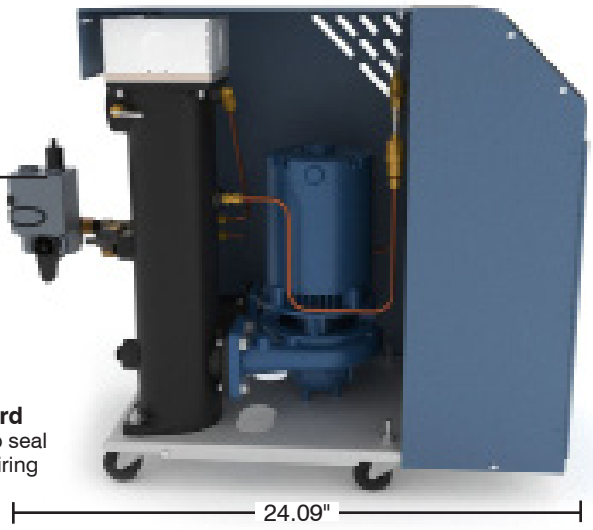
High Capacity Pump

Leak-proof, cast twin tank/pump assembly
eliminates pipe fittings
Lifetime Warranty

Modulating Cooling Valve
holds most accurate temperatures

Seal-Saver automatically cools process water down to 90°F when unit shuts off extending life of seal and for operator's safety

Extended motor power cord
motor is easily removed for pump seal replacement without electrical wiring disconnect

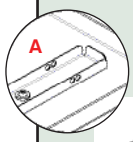


Leak-resistant, silicon carbide, severe-duty pump seal
Lifetime Warranty

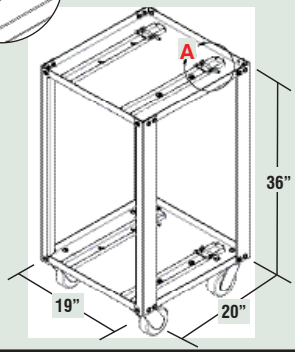
Internal pump seal flush and built-in sediment trap
extends life of pump seal by removing contaminants

Swivel Casters (4)
allow for easy movement

Maximize Your Space
Add Stacking Racks
#168515: $830.00
Stainless Steel Racks designed to hold 2 units stacked vertically to save space



Detail A (safety pins removed for clarity) Safety pins are used to hold the Hydra units in place towards the front of the rack



Key Features:

- High performance modulating cooling valve
- High capacity pump - Up to 70% more flow than previous models
- Digital Flowmeter
- Leak-resistant, silicon carbide severe-duty pump seal with seal flush
- Long-life low watt density corrosion resistant incoloy heaters
- Easy to read microprocessor controller and gauges
- Exceptional warranty
- Compact design: 25"L x 14"W x 25"H
- Supply and return temp and pressure

Back View - Inlets/Outlets

Item #	Heater	HP	GPM	PSI	Voltage	Amps	Weight	Price*
174728	9 kW	¾	50	20	230/60/3	26	280 lbs	**$3,555.00**
174729	9 kW	¾	50	20	460/60/3	13	280 lbs	**3,555.00**
174730	12 kW	¾	50	20	230/60/3	34	280 lbs	**3,650.00**
174731	12 kW	¾	50	20	460/60/3	17	280 lbs	**3,650.00**
174732	9 kW	2	75	30	230/60/3	28	300 lbs	**3,955.00**
174733	9 kW	2	75	30	460/60/3	14	300 lbs	**3,955.00**
174734	12 kW	2	75	30	230/60/3	36	300 lbs	**4,050.00**
174735	12 kW	2	75	30	460/60/3	18	300 lbs	**4,050.00**

*Price reflects mechanical heater contactor. Inquire for pricing on solid state.

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Hydra Pressurized Circulator Quote Form

Motor Size	**GPM**	**PSI**
❑ ¾ hp	40	26
❑ 1 hp	50	28
❑ 2 hp	75	30
❑ 3 hp	85	32
❑ 5 hp	100	46
❑ 7½ hp	125	54
❑ 10 hp	140	68

Motor Size | **REQUIRED** - select one

Heating Elements | **REQUIRED** - select one
- ❑ 0 kW
- ❑ 9 kW
- ❑ 12 kW
- ❑ 18 kW
- ❑ 24 kW
- ❑ 36 kW
- ❑ 48 kW

Heater Options | **OPTIONAL** - select one
- ❑ N/A
- ❑ Solid State relay heater contactor (9kW)
- ❑ Solid State relay heater contactor (12kW)
- ❑ Solid State relay heater contactor (18kW)
- ❑ Solid State relay heater contactor (24kW)
- ❑ Solid State relay heater contactor (36kW)
- ❑ Solid State relay heater contactor (48kW)**

**460 and 575 Volt Only

Power Options | **REQUIRED** - select one
- ❑ 208/3/60 - N/A for 48 kW
- ❑ 230/3/60
- ❑ 460/3/60
- ❑ 575/3/60 (Only includes 575V components, CL-UL508A option not included, must select)

Electrical Options | **OPTIONAL** - select all that apply
- ❑ Rotary Non-Fused Disconnect
- ❑ UL Branch Circuit Fusing Disconnect
- ❑ C-UL508A Industrial CP Construction

Controls and Control Options | **REQUIRED** - select one
- ❑ Standard Controller (Standard)
- ❑ PC (Premium Controller)
- ❑ PC w/ Remote Hand-Held Control Panel (Provides local pc w/HMI on the unit as well as in a remote enclosure with 50-foot cable)
- ❑ PC w/4-20mA Supply Output*
- ❑ PC w/ RS-485 port for Modbus RTU* (allows interface w/your machine)
- ❑ PC w/ RS-485 port for SPI* *not available with remote Hand-Held CP

Premium Controller Options | **OPTIONAL** - select all that apply
- ❑ Crash cool - quick circulator cool down (CC sequence disables heater and opens cooling valve for 1 minute)
- ❑ Remote heat/cool contact - remote heat/cool contact on/off

Premium Controller Mold Purge | **OPTIONAL** - select one
(Allows compressed air to purge circuit of water)
- ❑ Mold water purge non-ferrous (Select if choosing non-ferrous option in right column)
- ❑ Mold water purge ferrous

Other Control Options | **OPTIONAL** - select all that apply
- ❑ Remote Alarm Dry Contact
- ❑ Remote temp sensor, local high temp safety (Shipped loose with unit, adds a local high temp switch)
- ❑ Alarm Strobe light (red)
- ❑ Power Cord, 10' (ships loose)

Mechanical Options	**Cv‡**
❑ ¼" Solenoid Valve (Standard)	0.72
❑ ⅜" Solenoid Valve	3.00
❑ ½" Solenoid Valve	4.00
❑ ¾" Solenoid Valve	5.50
❑ 1" Solenoid Valve	11.50
❑ ½" Modulating Valve†	4.70
❑ ½" Modulating Valve†	10.00
❑ ¾" Modulating Valve†	24.00
❑ 1" Modulating Valve†	30.00

Mechanical Options | **Cv‡** | **REQUIRED** - select one

‡Cv (flow coefficient) is the flow of water through a valve at 60° F in US gallons/minute at a pressure drop of 1 PSI

†Modulating valves are used in variable-flow systems in which flow must be adjusted to slow, moderate, or full stream

Max Temp | **OPTIONAL**
- ❑ 300° F Max Set-point Operation (Only available with ¼" high-temp solenoid valve [Cv=0.24] requires a minimum if 75 psi cooling water supply)

Stainless/Non-Ferrous Options | **OPTIONAL** - select one
- ❑ Stainless/Non-Ferrous Option for 0 to 36kW, 3/4 to 3 hp
- ❑ Stainless/Non-Ferrous Option for 0 to 36kW, 5 to 10 hp
- ❑ Stainless/Non-Ferrous Option for 46kW, 3/4 to 3 hp
- ❑ Stainless/Non-Ferrous Option for 46kW, 5 to 10 hp

Other | **OPTIONAL** - select all that apply
- ❑ Special Color - requires Pantone Number
- ❑ Stacking Rack (stainless steel) for stacking two units vertically

Add-on Heat Exchangers | **OPTIONAL**
- ❑ Request Heat Exchanger Sizing

If molding at high temperatures where the return fluid temperature is higher than the process/leaving fluid temperature, your circulator may require a heat exchanger to cool the return water to an acceptable temperature.

Select this option to request more information.

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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SHINI Pressurized Hot Water Mold Circulator

Great Value For Mold Temperature Control

- **Omron PID multi-stage controller -** Maintains temperature accuracy ±1°F
- **High efficiency centrifugal pump -** Allows precise mold temperature control
- **Process alarms (phase reverse protection / low level / pump overload / over temperature) -** Allows full diagnostics and protection against loss of power, phase reversal, motor overload, high temperature and loss of water pressure
- **Siemens Electrical Components**
- **Max Temperature:** 248°F (120°C)
- **29 PSI Cooling Water Required**

1 Year Parts Warranty

Additional Features

- Inlet strainer
- Time delay pressure switch
- Stainless steel piping
- Stainless steel flanged pump with silicon carbide seal
- Copper gauge piping
- Insulated heaters
- Circuit protectors for motor and heater
- Heavy duty powder coated cabinets
- Casters
- Illuminated pump/heater on/off switches
- 10' power cord

¾ NPT Inlet/Outlet

IMS Item # 230V	IMS Item # 460V	Shini Model #	Heater (kW)	HP	Flow (GPM) @30 PSI	Amps	Control Valve Size	Dimensions H	Dimensions W	Dimensions D	Weight (LBS)	Unit Price
149617	149618	STM-910W	9	1	15	12.3/24.6	½"	23.6"	12.5"	29.3"	132	$2,635.00

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Ethylene Glycol Heat Transfer Fluids

Inhibited Against Acidity and Corrosion

A Quick Comparison Of Heat Transfer Mediums

- Water — Limited use range: 32° to 212°F. Encourages corrosion.
- Uninhibited Glycols — Allow temperatures to 250°F, but 2½ times more corrosive than water, if not neutralized.
- Automotive antifreeze — Contains corrosion inhibitors, but can foul heat transfer surfaces in less turbulent systems.
- UG-10 Ethylene Glycol — Low silicate formula provides good corrosion protection at a relatively low price.
- EG-17 Ethylene Glycol — Industrial inhibitors coat surfaces and impact pH for maximum corrosion protection.

UG-10

Moderately inhibited

EG-17

Highly inhibited

Temperature and Concentration Chart

Temperature ranges versus Ethylene Glycol concentration

° F	% Ethylene Glycol	% Water	Specific Heat in BTU/lb. at 70° F
10° to 205°	25	75	.901
3° to 208°	30	70	.886
-13° to 211°	40	60	.839
-36° to 215°	50	50	.789
-70° to 220°	60	40	.738
N/A to 230°	70	30	.688
N/A to 246°	80	20	.633
N/A to 274°	90	10	.585

NOTE: The temperature ranges shown above are for fluid systems operating at atmospheric pressure. Low temperature is freeze point. High temperature is 10° below boiling point.

Usage:

- Use at least 25% Ethylene Glycol for corrosion resistance.
- Use the lowest concentration (above 25%) for the appropriate temperature range to achieve maximum heat transfer. Use chart above as a guide.
- Avoid using over 60% if possible, since heat transfer is very low above that level.

Good Corrosion Protection at a Great Price

Contains pH adjuster and metal protectant

UG-10 Ethylene Glycol Heat Transfer Fluid

Item No.	Quantity		
125174 (5 gallon pails)	1	2-5	6+
	$109.68	104.20	98.71
125175 (55 gallon drum)	1-3	4+	
	RFQ	-	

Great Corrosion Protection at a Good Price

Multi-metal inhibitor package —beyond the UG-10 package

EG-17 Ethylene Glycol Heat Transfer Fluid

Item No.	Quantity		
105580 (5 gallon pails)	1	2-5	6+
	$104.85	99.61	94.36
105584 (55 gallon drum)	1-3	4+	
	$669.40	635.93	

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Pro-17 Inhibited Propylene Glycol

Non-Toxic Heat Transfer Fluid With Maximum Protection Against Acidity and Corrosion

- Non-toxic to people, animals and the environment
- Flushable to sewer and septic systems
- High-end corrosion inhibitor package to protect your equipment

Contains undiluted propylene glycol for environmental safety, plus our industry-leading inhibitor package to prevent corrosion - the same inhibitor as our EG-17.

Avoid the toxicity of Ethylene Glycol

Avoid the corrosive acid formation of straight Propylene Glycol

Usage:

- Use at least 30% Propylene Glycol for corrosion resistance.
- Use the lowest concentration (above 30%) that allows you to reach the required temperature (for maximum heat transfer). Use the chart at bottom/left as a guide.
- Avoid using more than 50% if possible — heat transfer is very low above that level.

Specifications

(Undiluted Pro-17)

Color:	Pink
pH:	8.5-10.0:
Flash Point:	215°F
Specific Gravity:	1.13 ± 0.01
BP @ 760 mm Hg:	310°F (154°C)
VP mm Hg @ 68°F:	<1

NOTE: In most cases, Propylene Glycol can be substituted for Ethylene Glycol. It is thicker than Ethylene Glycol and a little harder to pump; so the pump might not be able to deliver quite as much pressure.

Temperature and Concentration Chart

Temperature ranges versus Pro-17 concentration

° F	% Pro-17	% Water
9° to 216°	30	70
2° to 217°	35	65
-6° to 220°	40	60
-28° to 223°	50	50

Pro-17 Propylene Glycol Heat Transfer Fluid

132562 (5 gallon pails)	**$220.30**
132561 (55 gallon drum)	**$1,709.78**

Mold Chiller Flushing Fluid

Removes Scale and Deposits From Chiller Components

- Decreases cycle times – Improves flow and heat transfer in water and glycol systems
- Use in 1% to 2% concentration in water

Item No. 138216 (5 gallon pails)
$225.00

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Made in the U.S.A

HH16 High Heat, Oil Type Mold Temp Controller/Circulator

For Close Tolerance Molding at Temperatures up to 550°F

High Heat
Oil Circulators

Perfect for Precise, High Temperature Molding

Oil-to-water Heat Exchanger - Provides better control and faster cool-down

Self-tuning PID-Type Controller - Ensures consistent temperature

Mercury Relay - Provides fast response and long service life

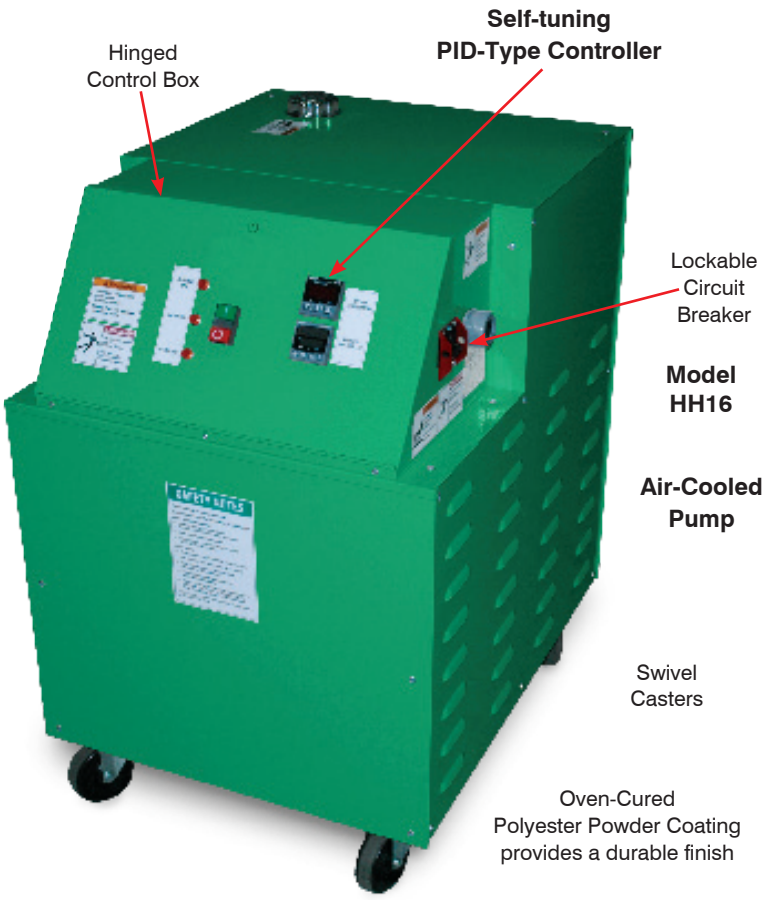
Dual 8 kW Heaters - Heats mold fast

Vented Cabinet - Helps pump run cooler and last longer

Insulated Heating Tank - Makes mold heating faster and more efficient

Hinged Control Box - Simplifies wiring

All Swivel Casters - Portable to all of your shop

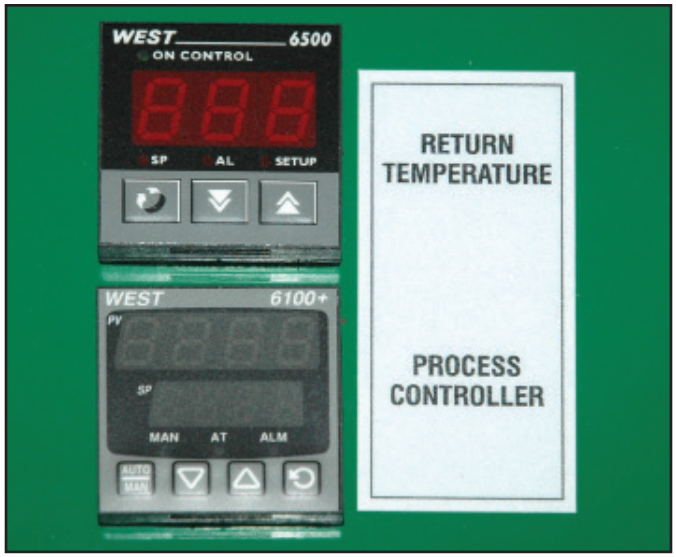


2 Year Warranty

User Friendly Control

Continuous Display:

- Setpoint
- Process
- Return Temperatures



WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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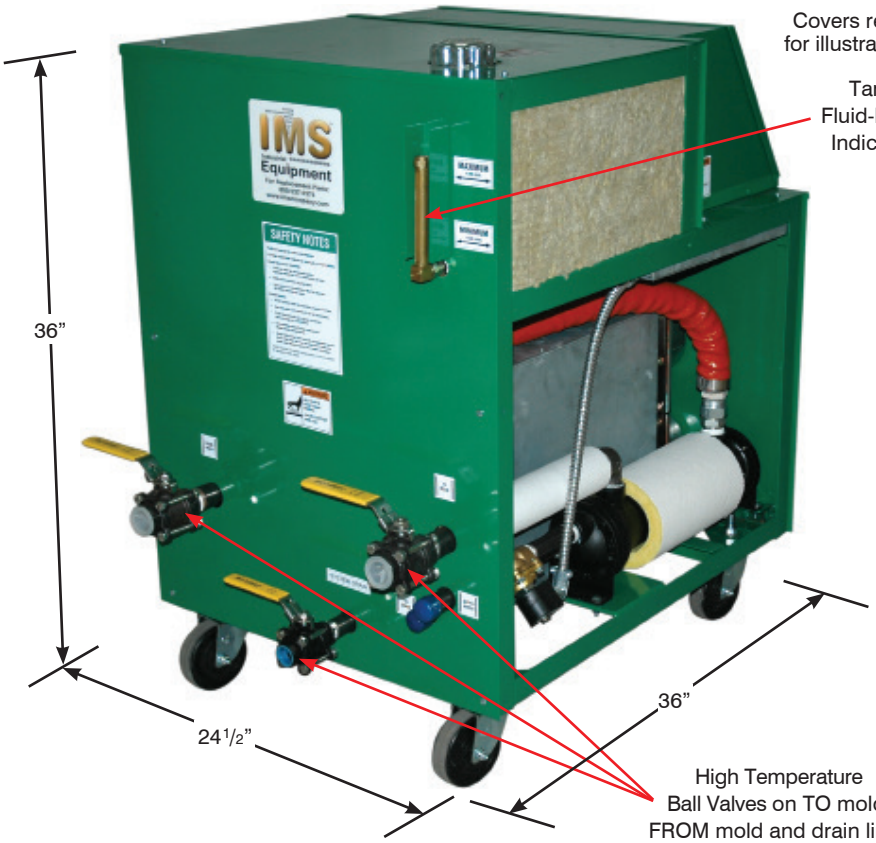
IMS Model HH16 (continued)

Made in the U.S.A



High Heat
Oil Circulators

Electrical

Temperature Controller: Self-tuning PID-type
Voltage: 230/60/3 or 460/60/3
Full-Load Amps: 39.4 @ 230V or 20.3 @ 460V
Control Voltage: 120 VAC
Control Range: Approx. 90° to 550° F
Accuracy: ±.25% of span ±LSD (1° F)
Heating Elements (two, 8 kW): 16 kW steel sheath - for use in oil

Pump/Motor

Type: Centrifugal pump, coupled to AC motor with air-cooled seal cavity
Horsepower: 1/2
Speed: 1,750 rpm
Flow: 47 gpm @ 10 ft. head (4.3 psi)
Weight: 500 lbs crated / 465 lbs uncrated
Mold Supply Outlet: 1” N.P.T.
Mold Return Inlet: 1” N.P.T.
Cooling: Oil-to-water heat exchanger mounted in reservoir
Tank: welded steel, insulated
Fluid Capacity: Min. 8 gallon
Tank Drain: 3/4” N.P.T.

IMS HH16 High Heat Oil Type Mold Temperature Controller

Item #121009 for 230/60/3 (39.4 amps)

Item #121008 for 460/60/3 (20.3 amps)

$14,850.00

See page 749 for Heat Transfer and Maintenance Fluids
High Heat Circulator Hose Required see page 402

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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SHINI Hot Oil Mold Circulator

Process Temperature Control up to 500°F

Omron PID multi-stage controller - Maintains temp accuracy ±1°F

Process alarms (low level / pump overload / over temperature) - Allows easy operation and performance management

Heavy duty powder coated cabinet - Stands up to the harshest operating conditions

Siemens Electrical Components

Magnetic "seal-less" drive pump* - Decreases maintenance downtime by eliminating pump seal failures

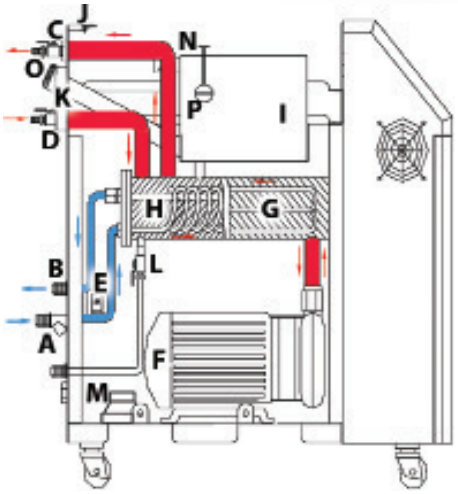
*See chart for available models

29 psi Cooling Water Required

- Automatic by-pass line and air vent
- Low pressure switch
- Y strainer
- Stainless steel tank and pipe heaters
- Phase reverse protection
- Shell and tube closed loop cooling
- Expansion tank with sight glass
- Main disconnect
- Completely insulated
- Casters

1 Year Parts Warranty

A. Cooling water inlet
B. Cooling water outlet
C. To process
D. From process
E. Cooling solenoid valve
F. Magnetic-drive pump
G. Heater
H. Heat exchanger
I. Reservoir
J. Pressure gauge
K. Sight glass
L. Oil drain
M. Temp sensor
N. Level switch
O. Oil inlet
P. Level Indicator



IMS Item # 230V	IMS Item # 460V	Shini #	Temp Rating	Heater (kW)	Flow (GPM)	Pump Style	Dimensions Height	Dimensions Width	Dimensions Depth	Weight (LBS)	Unit Price
160208	160209	STM-910	375°F	9	15	Centrifugal	31.5"	13.5"	33.5"	221	**$3,245.00**
149595	149596	STM-1220	375°F	12	20	Centrifugal	31.5"	13.5"	33.5"	221	**4,670.00**
149423	149594	STM-2440	375°F	24	40	Centrifugal	35.5"	15.5"	37.0"	320	**6,595.00**
158418	158419	STM-1220-M	375°F	12	20	Magnetic Drive	31.5"	13.5"	33.5"	221	**5,240.00**
160210	160211	STM-907-HT	500°F	9	10	Magnetic Drive	31.5"	13.5"	32.5"	221	**5,010.00**
149597	149598	STM-1215-HT	500°F	12	15	Magnetic Drive	31.5"	13.5"	32.5"	221	**7,265.00**

Construction to comply with worldwide electrical safety standards (CE, UL, CSA, JIS etc.) available — Inquire

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Hi-Heat Transfer & System Maintenance Fluids

for IMS HH16 and other Oil Type Circulators

GREEN Products

PG-1 Hi-Heat Transfer Fluid

The Ultimate, Non-Toxic Fluid For Non-Pressurized Heating To 600°F

Features

- Totally Non-Toxic (certified for both FDA and USDA requirements for service with food and pharmaceuticals — contains no PCB's or MCB's)
- Colorless, Odorless and Tasteless
- Non-Corrosive, Stable, Non-Carbonizing
- Non-Fouling; carbon granules stay in suspension and will not build up deposits
- High Flash & Flammability Points
- Excellent heat transfer and flow
- Excellent BTU/GPM rate
- Low Pumping HP — allows use of smaller pumps, which cost less to buy, rebuild maintain and operate
- Non-irritating to skin or eyes
- Insoluble in (won't mix with) water
- Disposable by local motor oil recyclers

CAUTION: Avoid mixing water or any other fluid with High-Heat Fluids

Physical Characteristics

Pour Point, ASTM D97	-40°F (-40°C)
Density @ 75° (24°C)	7.27 lb/gal.
Specific Heat at 75° F	0.452 BTU/lb.
at 400° F	0.609 BTU/lb.
Fire Point, coc, ASTM D92	340°F (171°C)
Autoignition Temperature, ASTM D2155	690°F (366°C)
Atmospheric Boiling Point, (10%) ASTM D1160	657°F (347°C)
Average Molecular Weight	350
Optimum Use Range	150° to 600°F (66° to 316°C)
Pumpable, Centrifugal @ 2000 centipoise	-13°F (-25°C)
Weight (5 gal. pail)	40 lbs
(55 gal. drum)	463 lbs

PG-1 Heat Transfer Fluid

Item No. 105578	Item No. 106519
5 gal. pail	55 gal. drum

FF-1 Oil System Flushing Fluid

Improves heat transfer for faster cycles

- Can flush your Hot Oil Circulators while they're still operating
- Flushes fouled oil in existing systems; flushes out solder pieces and weld splatter in new systems

NOTE: FF-1 is meant for flushing. To clean varnished or cooked-on oil, use PSC Plus below.

FF-1 Oil System Flushing Fluid
Item No. 137087: 5 gal. pail

PSC Plus Oil System Cleaner

Maximizes heat transfer for more parts and increased quality

- Cleans your Hot Oil Circulators while they're still operating
- Non-Hazardous — non corrosive, non toxic, non flammable (flash point: 392°F)
- Inexpensive — only 4% concentration needed

Blend with your existing oil to create a powerful cleaning solution. Run system for 48 hours. Drain oil when cool enough to handle. Refill with fresh oil. If badly fouled, clean and flush for two days before filling with fresh oil.

PSC Plus Oil System Cleaner

Item No. 137086
1 gal. pail

Hi-Heat Transfer and System Maintenance Kit

Item No. 149590: 5 gal. pail PG-1, 5 gal. pail FF-1 and 1 gal. pail PSC Plus

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Made in the U.S.A

IMS Select Lockouts

Works With All Iec Circuit Breakers

- **Keep your machines running safely**
- **Protects against accidental turn on/off**
- **Anodized aluminum construction**
- **Red or black color**
- **Compatible with Airpax/Sensata, Heinemann, Carling Switch, Potter-Brumfield, CBI and more**

Custom Lockouts Available — Inquire

Contact the Sales Team for pricing and additional information: **sales@imscompany.com**
OR Call: **1.886.467.9001**

Made in the U.S.A

IMS Select Switch Guards

Great for the Aerospace, Medical and Food Industries

- **Prevents operator from accidentally turning on/off important switches to the process**
- **Stainless steel construction**

Contact the Sales Team for pricing:
sales@imscompany.com

IEC Circuit Breakers

- **All OEM's available -** Heinemann, Carling Switch, CBI and more
- **1, 2, 3 or 4 poles**

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Chillers

IMS Hydra Air Cooled Chillers

Maximum cooling capacity for multi-industrial use

- 1 Ton to 30.6 Ton Standard
- **20°-80°F** Set Point Standard on NQ Series (4+ Ton)
  20°-65°F Set Point Standard on EQ Series (1-3 Ton)
- Maximum Cooling Capacity: Tonnage rated at 50°F fluid leaving temperature with 95°F ambient air
- Many Options Available to meet your requirements
- Casters Standard on All Sizes

18 Month Warranty

IMS Hydra J Series Air Cooled Chillers

Great Cooling Capacity for Smaller Jobs

Removable Panel "Lift Out Doors" - Allows easy access and maintenance of internal components

Stainless Steel Cabinet - Heavy duty anti-corrosive enclosure

Digital Temperature Controller - Allows for easy operation

18 Month Warranty

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Tech Tip

Sizing a Chiller for Injection Molding

The Right Type

Most refrigeration is designed for static loads, like in a meat cooler. In plastics processing, heat is added to and removed from the mold during every cycle. Select a chiller designed for active heat loads.

The Right Size

Although an undersized chiller will cost less to buy, the chiller will be running at full capacity, resulting in higher operating costs. And even then, you may have trouble consistently keeping the mold cold.

Chillers are rated in tons; one ton equals the ability to transfer 12,000 BTUs/hr. The tonnage rating should be stated at a specific "leaving water temperature and at a specific ambient temperature".

Choose a chiller that can achieve the anticipated water temperature that your process will need and the rate of BTU's required. Producing colder water than necessary will cost in two ways; initially for the equipment and continually to operate it.

IMS Chillers are Rated based on actual testing. Avoid arbitrary Tonnage claims and select the chiller producing enough BTU's and a temperature required for your process.

Water Flow through the Mold

At a flow of 10 gpm, chilled water must rise 12°F through the mold to remove 1,000 BTU/minute. At a flow of 3 gpm, the temperature must rise 40°F to remove 1,000 BTU.

If low flow is due to the mold's design, the only solution is having the mold reworked. But if normally occurring water deposits are clogging the lines, water line cleaner, IMS Lime Buster III, can greatly boost mold flow and increase heat transfer.

Computing Size for IMS TrueTon™ Chillers (2 Methods)

Method 1 (Based on coolant temperature and flow rate)

To determine chiller tonnage required, you must calculate the delta T between the inlet and outlet water temperatures and the rate of flow in gallons per minute. Measuring the delta T requires a thermocouple or thermometer. To perform a load test: 1.) Strap a thermocouple to the inlet water line of the processing equipment and wrap it with tape to hold it in place. 2.) Strap a thermocouple on the outlet water line of the processing equipment to record the amount of heat the water is picking up in your equipment.

To measure flow rate of the water place a flow meter on the outlet water line of your equipment. If a flow meter is not available, simply disconnect the outlet line and let the water pour into a five gallon bucket while you time it with a watch. This provides you with the "GPM" (gallons per minute) rate of discharge.

Now you have the necessary information to size a unit properly. Use the following formula to calculate your equipment's BTU's of required cooling.

BTU = Constant (weight of water) x GPM x Temperature Differential

Multiply the fluid flow (GPM) by 500. Multiply the result by the temperature differential or rise (return water temperature minus the input or supply water temperature). Divide the result by 12,000 and you now have your required rating.

Example: 500 Constant (weight of water)
x 10 GPM (gallons per minute)
5000
x 12° Temperature Differential (or rise)
60,000 Required BTU's per hour
12,000 EACH 12,000 BTU's requires 1 Ton of Cooling
= 5 Ton (This equipment would require a 5 Tons capacity)

Method 2 (Based on material use and melt temperature)

You can also calculate the proper tonnage using the following formula:

$$\text{Tonnage} = \frac{A \times (B - C)}{\text{Removal Capacity}}$$

where: A = Material use in lbs./hr. Use actual lbs./hr., not machine's capacity rating
B = Temperature of melt
C = Temperature of part when it comes out of mold
Removal system Capacity losses, 20°F, = 12,000 BTU/hr./ton removal capacity of chiller set at 50°F, which includes estimated radiation etc. At 40°F, use 8,000. At 30°F, use 6,100. At use 5,800.

Example: 100 lbs./hr.
450° F melt temperature
150° F part temperature when mold opens

$$\text{Tonnage} = \frac{100 \times (450 - 150)}{12{,}000}$$

$$= \frac{100 \times 300}{12{,}000}$$

$$\frac{30{,}000}{12{,}000}$$

$$= 2.5$$

Use the next size up, in this case a three ton chiller, to avoid problems caused by using an undersized chiller.

For assistance with sizing, contact the IMS Equipment Team at sales@imscompany.com

www.imscompany.com
phone order toll-free (USA & Canada) 1.800.537.5375
fax order toll-free (USA & Canada) 1.888.288.6900
phone order toll-free (Mexico) 001.888.304.1307
tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

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Sizing a Chiller (continued)

Blow Molding

40#/Hr HDPE = 1 Ton
45#/Hr LDPE = 1 Ton
40#/Hr PET = 1 Ton
45#/Hr PP = 1 Ton
Minimum process flow = 4.8 GPM/ton @ 65 PSI

Extrusion

Coating

40#/Hr LDPE = 1 Ton
Process flow required = 12 GPM/ton for direct roll cooling

Pipe & Profile

80 #/Hr ABS = 1 ton
90#/Hr PVC = 1 Ton

Sheet

40#/Hr UHMWPE = 1 Ton
55#/Hr PP = 1 Ton
80#/Hr PVC = 1 Ton
50#/Hr HDPE = 1 Ton
75#/Hr PS = 1 Ton
55#/Hr LDPE = 1 Ton
75#/Hr ABS = 1 Ton
Process flow = 8 GPM/ton for direct roll cooling

Equipment Cooling

Gearbox cooling = 0.5 Ton/Inch of extruder barrel
Screw cooling = 0.5 Ton/Inch of extruder barrel
Feed throat cooling = 0.33 Ton/ Inch of extruder barrel
Barrel cooling = 1 Ton/Inch of extruder barrel
Eddy current clutch (light load) = 0.2 Ton/HP
Eddy current clutch (normal operation) = 0.05 Ton/HP

Injection Molding

Mold Cooling

30#/Hr HDPE = 1 Ton
40#/Hr Nylon = 1 Ton
65#/Hr PVC = 1 Ton
35#/Hr LDPE = 1 Ton
50#/Hr PS = 1 Ton
40#/Hr PET = 1 Ton
35#/Hr PP = 1 Ton
50#/Hr ABS = 1 ton
Hot runner molds = 1 Ton/10.5 KW hot runner

Machine Cooling

10 HP Hydraulic Motor HP = 1 Ton
Feed throat cooling = 1 Ton (machines under 400 ton use 1/2 ton)

Thermoforming

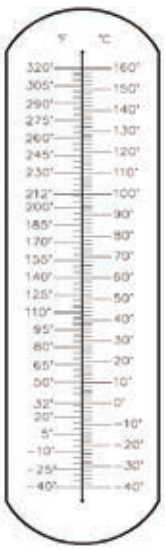
180#/Hr PE = 1 Ton
250#/Hr HIPS = 1 Ton
240#/Hr PVC = 1 Ton
Rail Cooling = 3 Tons
Minimum process flow of 4.8 GPM/Ton

Other

Mold room heating = 25 BTU/FT2 Vacuum pump = 0.1 Ton/HP
Non-mold room heating = 50 BTU/FT2 Water pump = 0.2 Ton/HP
Mold room cooling = 80 BTU/FT2
Air compressor without after cooler = 0.15 Ton/HP
Air compressor with after cooler = 0.20 Ton/HP

Common Conversion Factors

To Convert From	To	Multiply By
Boiler HP	Btu/Hour	33445.7
Cubic Centimeters	Gallons (US)	0.00026
Cubic Feet	Gallons (US)	7.48052
Cubic Inches	Gallons (US)	0.00433
Cubic Meters	Gallons (US)	264.172
Feet	Meters	0.3048
Gallons (US)	Cubic Meters	0.003785
Gallons (US)	Liters	3.7854
Gallons (US)/Minute	Liters/Second	0.06309
Inches	Millimeters	25.4
Kilowatts	Btu/Hour	3414.4
Motor HP	Btu/Hour	2547.16
Motor HP	KW	0.746
Ounces	Grams	28.3495
Pounds	Kilograms	0.4536
Pounds/Sq Inch	Bar	0.06895
Pounds/Sq Inch	Kilograms/Sq Cm	0.07031
Pounds/Sq Inch	Kilopascals	6.89476
Pounds/Sq Inch	Feet of Water	2.3067
Square Feet	Square Meters	0.0929
Square Inch	Square Centimeter	6.4516



(°F-32) x 5/9=°C
(°C x 9/5) +32=°F

Weighted Water Tests

$\frac{GPM \times \Delta T}{24}$ = Chill Ton

$\frac{\#/Min \times \Delta T}{200}$ = Chill Ton

$\frac{GPM \times \Delta T}{30}$ = Twr Ton

$\frac{\#/Min \times \Delta T}{250}$ = Twr Ton

% Ethylene Glycol by Volume	vs Freeze Protection
10%	25°F
20%	15°F
30%	0°F
40%	-15°F
50%	-40°F

Flow Rates vs Temp Difference Per Ton

1.2 GPM = 20°F ΔT
4.8 GPM = 5°F ΔT
2.4 GPM = 10°F ΔT
9.6 GPM = 2.5°F ΔT

Pipe Sizing Guide for Schedule 40 Steel Pipe
(10'HD/100' Run,10'/Sec Velocity Max)

½" = 3 GPM	1¼" = 25 GPM	2½" = 120 GPM	6" = 900 GPM
¾" = 6 GPM	1½" = 40 GPM	3" = 200 GPM	8" = 1500 GPM
1" = 12 GPM	2" = 75 GPM	4" = 400 GPM	10" = 2400 GPM

Commonly Used Equivalents & Formulae

1 HP = 2547.16 Btu/Hr
1 Cu Ft = 7.48 gallons (water)
1 Gallon = 8.33 lbs (water)
1 KW = 3414.4 Btu/Hr
1 KW = 1.341 HP
Q = 4.5xCFMxDH = Btu (air cooling)

$PSI = \frac{ft\ of\ head}{2.31}$

$Pump\ HP = \frac{GPM \times P(feet\ of\ head)}{3960x(0.65\ to\ 0.75)\ (Pump\ Eff)}$

$KW = \frac{Amps \times Volts \times 0.85 \times 1.73}{1,000}$

Tower water make-up requirements: untreated 2% of flow rate, treated 1.5% of flow rate.

Water cooled requires 3 GPM/Min/Ton

Lose 1.5% capacity per degree lower than rating

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IMS Hydra Air Cooled Chillers

Maximum Cooling Capacity For Multi-Industrial Use

Allows you to mold better parts in less time with fewer rejects.

Set Point Temperature as low as 20°F Standard

Made in the U.S.A

7" Color Touch Screen Microprocessor controller - accurate temperature control (±1° F) and extensive diagnostics

Galvanized multi-blade propeller fans

- Manufactured at an ISO 9001:2015 facility
- Tested at full capacity prior to shipping

Primary Chiller Controller

– PLC with 7" Color Touch Screen
– (7) Display Parameters
– (10) Alarms and Warnings
– (4) Communications and Remote Interfaces

Direct Drive Scroll Compressors

– Hermetically sealed
– Low maintenance
– Efficient

Compressor Protection Technology

– Start-to-start logic limits cycling under low-load, extends compresssor life, via hot gas by-pass capacity control

Stainless & Non-ferrous Process Circuit

– Insulated poly tank
– Stainless, braze-plate evaporator, pump

Process Protections

– Phase monitor
– Low reservoir alarm
– Temperature deviation alarms with time adjustability
– Compressor and pump run-time display
– Evaporator inlet, contaminant strainer

Physical

– Heavy-gauge, no-tools, easy access door panels
– Low noise fans, high efficiency, top mounted for operator comfort
– Removable, cleanable air filter

Warranty

– 18 month parts
– 12 months labor in your facility

Exceptional Warranty

No manufacturer offers a better/more comprehensive warranty:

- 18 months on parts
- One full year on labor
- Five full years on micro-processor with lifetime controller exchange price of $200

Inlet air filter
cleanable, durable and ensures maximum operating efficiency

External sight glass
fill/drain connection

1 to 3 Ton units have one of the smallest footprints in the industry.

See next page for additional specifications and pricing.

www.imscompany.com phone order toll-free (USA & Canada) **1.800.537.5375**

fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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IMS Hydra Air Cooled Chillers (continued)

- **Non-ferrous construction -** Includes reservoir, evaporator, pump and piping to resist corrosion
- **Air-cooled condenser -** Generously sized for industrial environments with ambient temp up to 115°F
- **Removable side panel -** Allows easy access to interior components
- **Internal insulated polyethylene reservoir -** With removable top
- **Process Y-strainer -** Protects the evaporator from contaminants in the water
- **Evaporator freeze-up protection**
- **Heavy gauge steel cabinet**
- **Casters standard on all sizes**
- **Refrigerant: R454B** (EQ Series), **R410A** (NQ Series)

Mechanical Features:

- **Scroll compressor(s) -** Energy efficient and reliable
- **Generously sized copper tube/aluminum finned air-cooled condensers** - Designed for industrial environments (includes air inlet filters)
- **Stainless steel process pump with pressure gauge**
- **Refrigerant TXV, filter/drier and sight glass**
- **Stainless steel brazed plate evaporator -** Higher heat transfer coefficients due to reduced fouling
- **Electronic hot gas bypass -** Handles varying load conditions
- **Freezestat safety switch with solid state sensor**
- **Encapsulated high and low refrigerant pressure safeties**

EQ Series Chillers (Set Point Range: 20°- 65° F)

Cooling Capacity	IMS Item # 230/60/3	IMS Item # 460/60/3	AMPS 230V	AMPS 460V	Tank (GAL)	Pump HP	Flow (GPM)	PSI	In/Out NPT	Dimensions (in) L	W	H	Weight (LBS)	Unit Price
1 Ton	149619*	N/a	11	N/A	3	¼	2	80	1"	34	19	28	255	**$7,840.00**
2 Ton	149620	149621	16	8	11	1	5	39	1"	40	24	42	423	**9,855.00**
3 Ton	149622	150186	22	11	11	1	7	38	1"	40	24	42	430	**11,350.00**

*230/60/1

NQ Series Chillers - Refrigerant R454B (Set Point Range: 20°- 80° F)

Cooling Capacity	IMS Item # 230/60/3	IMS Item # 460/60/3	AMPS 230V	AMPS 460V	Tank (GAL)	Pump HP	Flow (GPM)	PSI	In/Out NPT	Dimensions (in) L	W	H	Weight (LBS)	Unit Price
4 Ton	175405	175406	32	16	14	2	10	43	1½"	48	34	61	720	**$14,625.00**
5 Ton	175407	175408	33	18	14	2	12	41	1½"	48	34	61	720	**16,550.00**
8 Ton	175409	175410	52	26	30	2	19	41	1½"	75	34	61	1,195	**18,420.00**
11 Ton	175411	175412	62	31	30	3	27	48	1½"	75	34	61	1,195	**20,840.00**
13 Ton	175413	175414	74	37	30	3	30	46	1½"	75	34	61	1,215	**24,740.00**
15 Ton	175415*	175416	88	44	60	3	36	40	2"	87	41	94	3,200	**28,465.00***
21 Ton	175417•	175418	111	56	60	5	48	45	2"	87	41	94	3,300	**31,910.00•**
26 Ton	175419†	175420	140	70	67	5	60	48	2"	105	41	94	3,800	**45,705.00†**
31 Ton	175421‡	175422	166	83	67	5	72	43	2"	105	41	94	4,150	**48,730.00‡**

*230V: $245 upcharge •230V: $295 upcharge †230V: $465 upcharge ‡230V: $760 upcharge

Inquire about Water Cooled Chillers, Remote Condensers and Tankless Chillers

Accessories: S = Standard O = Optional NA = Not Available

Description	EQ	NQ	Description	EQ	NQ
C-UL508A Controls with a 7" color touch screen PLC	NA	S	(Available on Refrigerant R454B Types only)		
Alarm Horn and Silence Switch	O	S	Low Water Level Light	O	S
Automatic Water Makeup & Low Level Light	O	O	Remote Alarm Dry Contact	O	NA
Extend Set Point Range to 80° F (1-3 Ton)	O	S	Remote On/Off Contacts	O	O
Extend Set Point Range to 80° F (5.5 Ton)	O	S	Return Water Temperature Display	O	S
Hand Held Remote with 50' cable	O	O	Special Color Air Dry Enamel Paint	O	O
SPI Communications Port	O	O	3-Phase Monitor	O	S
SPI Communications Port	O	O	3-Phase Monitor	O	S
Inlet Air Filter (for #149622 and #150186)	S	S	575 volt add	O	O

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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IMS Hydra J Series Air Cooled Chillers

Great Cooling Capacity for Smaller Jobs

Made in the U.S.A

Hydra Chillers

⅛ to 1½ Ton Sizes Available

18 Month Warranty

Removable Panel "Lift Out Doors" - Allows easy access and maintenance of internal components

Stainless Steel Cabinet - Heavy duty anti-corrosive enclosure

Digital Temperature Controller - Allows for easy operation

- 50-80°F Set Point Range
- Ambient Temperature Range: 50-95°F
- Closed-Loop Style
- UL 1995 Certified
- Casters Standard
- R-513A Refrigerant
- Indoor Use Only
- Corrosion-Free Reservoir
- Non-Ferrous Welded Components
- Submersed Copper Coil
- High Flow Re-Circulating Pump

Item #	Cooling Capacity*	Voltage	AMPS (FLA)	Pump HP	Flow GPM @ PSI	Tank (GAL)	In/Out NPT	Dimensions W	D	H	Weight (lb)	Unit Price
176057	2100	115/60/1	11.7	1/3	2 @ 50	5	1/2"	21 1/8"	22"	28 5/8"	245	**$5,668**
176058	4300	115/60/1	16	1/3	4 @ 50	5	1/2"	21 1/8"	26 ½"	28 5/8"	310	**6,239**
176059	4300	230/60/1	9.3	1/3	4 @ 50	5	1/2"	21 1/8"	26 ½"	28 5/8"	310	**6,634**
176060**	12000	230/60/3	12.6	1	10 @ 35	10	1"	25 1/8"	31 1/8"	33 ¼"	450	**10,058**
176061	12000	460/60/3	7	1	10 @ 35	10	1"	25 1/8"	35 ½"	33 ¾"	450	**10,159**
176062**	12000	230/60/3	12	1/2	4 @ 50	10	1/2"	25 1/8"	31 1/8"	33 3/8"	450	**10,132**
176063**	12000	460/60/3	6.1	1/2	4 @ 50	10	1/2"	25 1/8"	35 ½"	33 3/8"	450	**10,057**
176064**	18000	230/60/1	24	1/3	4 @ 50	10	1/2"	25 1/8"	35 ½"	33 3/8"	490	**9,455**
176065**	18000	230/60/3	17	1/2	4 @ 50	10	1/2"	25 1/8"	31 1/8"	33 ¼"	490	**10,428**
176066**	18000	460/60/3	7.5	1/2	4 @ 50	10	1/2"	25 1/8"	35 ½"	33 3/8"	490	**10,060**

***Rated in BTU per Hour 65°F fluid leaving temp @ 95°F ambient**
12,000 BTUs = 1 Ton. (ex: 5040 BTU / 12,000 = .42 Tons)

**** Includes Auto Water Fill - automatically maintains the water level of the reservoir. Customer needs to supply water line to the automatic valve**

IMS Company

www.imscompany.com phone order toll-free (USA & Canada) **1.800.537.5375**

fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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SHINI Portable Air Cooled Chillers

Great Value for Multi-Industrial Use

Vertical Discharge - Allows/affords operator comfort

Hot Gas Bypass Valve - Handles varying load conditions

Automatic Water Bypass Valve - Protects against freeze up

Non-Proprietary Temp Controller - Maintains an accuracy of ± 1°F

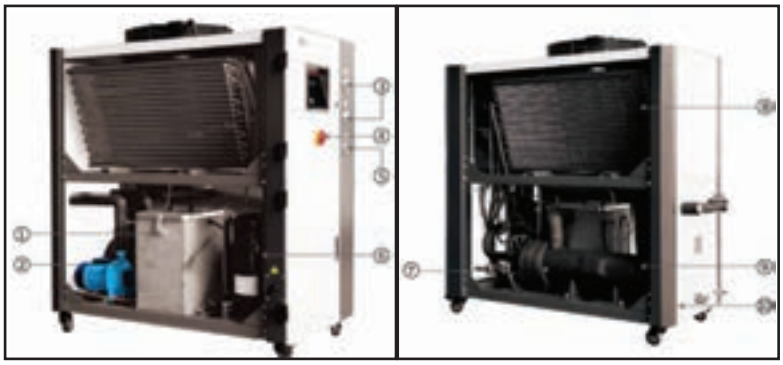
Siemens Electrical Components

Compressor and Pump Overload Protection

- 45°-70°F Operational Temperature Range
- Full Diagnostics Panel
- Non-Ferrous Water Components
- Fully Insulated Stainless Steel Reservoir
- Heavy Duty Powder Coated Cabinet
- Automatic Fill Valve
- Casters standard for portability
- R-407C/R410A* Refrigerant (*both available on some models)
- 10' Power Cord

Most Sizes In Stock
1 Year Warranty

1. Stainless steel water tank
2. Big flow 3-phase pump
3. High / low system pressure gauges
4. Main power switch
5. Pump pressure gauge
6. Copeland scroll compressor(s) for super high efficiency and low noise
7. Expansion valve for accurate adjustment of R-407C refrigerant
8. Condenser features quick heat transfer and heat radiation
9. Shell-and-tube evaporator ensures efficient cooling
10. Powder coated frame



IMS Item # 230/60/3	460/60/3	Shini #	Ton*	Compressor HP	Pump HP	Flow Rate (GPM)†	Tank Size (gal)	In/Out NPT	Dimensions H	W	D	Weight (LBS)	Unit Price 230V	460V
173627	173628	SIC-12A-R2-P	5	5	1	11	13	1"	59"	30"	51"	450	$8,995.00	$9.670.00
173629	-	SIC-24A-R2-P	10	10	1.5	22	22	1½"	59"	36"	51"	500	13,250.00	-
173631	173632	SIC-38A-R2-P	15.3	15	3	32	40	1½"	59"	30"	51"	850	19,995.00	19,995.00

*Tonnage rated @ 50° F fluid leaving temperature with 90°F ambient air

† Gallons per minute @ 40 psi

Inquire about Water Cooled Chillers

Worldwide electrical safety standards available (CE, UL, CSA, JIS etc.) — Inquire

IMS Company

www.imscompany.com

phone order toll-free (USA & Canada) 1.800.537.5375

fax order toll-free (USA & Canada) 1.888.288.6900 | phone order toll-free (Mexico) 001.888.304.1307 | tech support toll-free (USA & Canada) 1.866.467.9001 | e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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GREEN Products

The Original

IMS Select Lime Buster Water-Passage Descaler

Made in the U.S.A

Quickly Dissolves and Flushes Away Scale, Rust, Lime and Calcium Deposits from Internal Mold Passages, Water Lines and Heat Exchangers

The Problem:

Water circulators provide mold temperature control, but water can leave deposits that insulate the mold from the circulating water; as little as 1/64" can reduce heat transfer 40%. Full temperature change takes longer. Cycle times and electricity use go up as part quality goes down.

The Solution:

The IMS Lime Buster circulates a mild acid through your mold water passages, dissolving mineral deposits and flushing them away. Circulating water can then have direct contact with the metal in the mold, restoring heat transfer. You'll see shorter cycles and better parts.

Easy to use! Proven for Over 30 Years!

Before

Minerals in water passages block heat transfer. You lose time every cycle. You can even lose temperature control in parts of your mold.

After

Lime Buster flushes deposits from passages. Heat transfer becomes faster; cycles get shorter. You get full temperature control over the entire mold.

Just 1/64" of scale in your mold water-passages can reduce the heat transfer rate up to 40%

Designed for all mold materials & Heat Exchangers

Routine Use of Lime Buster Keeps Molds Running at Peak Performance!

IMS Company

www.imscompany.com phone order toll-free (USA & Canada) **1.800.537.5375**

fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

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Made in the U.S.A

IMS Lime Buster III™ Water-Passage Descaler

Keeps mold productivity UP and press operating costs DOWN!

Designed for all Mold Materials & Heat Exchangers

Only from IMS!

Combination Handle & Cord Wrap for added convenience

High-Flow CPVC Plastic Pump with Thermally Protected Continuous Duty Motor

5 ft. Grounded Power Cord with Plug

PVC Manifolds and supplied Plumbing Kit speed and simplify mold hook-up

Easy-Pour Wide-Mouth Tank Fill and Drain

Durable Welded Polypropylene Construction

Integral Grounded Switch Box

Quality All-Swivel Casters with Rubber Wheels for easy positioning

Plastic Frame, Tank, Pump, Fittings and Hardware ensure corrosion resistance and long life

SOLVENTOL® 2409 changes from purple to yellow as it cleans, indicating acid strength.

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

After cleaning water passages use IMS Foaming Rust Inhibitor to ensure rust-free mold storage.

See Page 139

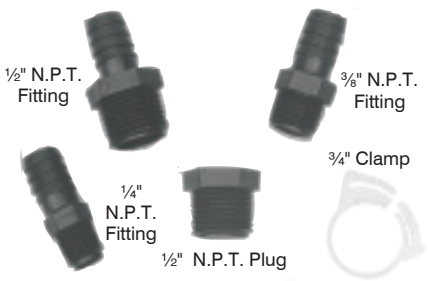
Convenient Plumbing Kit

Now standard equipment to make mold hook-up fast & easy!

#110469 Kit Includes:

Barbed Polyethylene Fittings:	Qty.
½" I.D. x ½" N.P.T.	16
½" I.D. x ½" N.P.T.	8
½" I.D. x ¼" N.P.T.	8
Plugs (for unused ports in manifold) ½" N.P.T.	6
¾" Nylon Hose Clamps	16

See Next Page for Pricing



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IMS Lime Buster III™

Made in the U.S.A

Use as Scheduled Mold Maintenance or Whenever a Mold is Removed for Storage

Plumbing Kit includes an assortment of fittings, plugs and clamps

Why do you need an acid and a neutralizer?

- Non-acid solvents don't dissolve mineral scale nearly as well as acid does. That is simple chemistry.
- The EPA requires acids to be neutralized before disposal.
- IMS Gardacid 4294 acid powder has a color marker to help you know when the solution is acidic (ready to use as a descaler) or neutral (ready for disposal).

Safe for all Mold Types!

Gardacid 4294 Acid (powder)

Supplier's Tip

Avoid "watered-down", premixed descaling solutions that use more fluid, require more time and end up costing more money.

Specifications

Operating Capacity: ..... 5 to 11 gal.
Maximum Operating Temp: ..... 140° F
Pump/Motor: Centrifugal Pump, Close Coupled to AC Motor
- Voltage 115V
- Full Load Amps 2.8
- Power ..... ⅕ hp
- Speed..... 3450 rpm
- Flow ..... 18 gpm Open Discharge

Inlet & Outlet Connections: ..... ½" N.P.T.
Base Dimensions: ..... 18" wide x 23" long
Height Overall: ..... 34"
Weight (crated) Lime Buster only: ..... 96 lbs
Lime Buster Complete Kit: ..... 180 lbs

Tech Tips

The general rule of thumb is ½ lb of acid per gallon of water.

Lime Buster III™ is a trademark of IMS Company

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Item #175140

Complete with one 41-lb container of Gardacid 4294 Powdered Acid, one 5-gal container of Gardobond® Additive H 7212 Neutralizer, Plumbing Kit, 50 ft of Vinyl Hose, one vial of Neutral Litmus Paper Strips, Instructions and one 16 oz. can of IMS Foaming Water-Passage Rust Inhibitor with hose, fitting and clamp.

$3,005.00

For 115/60/1 operation

#110226	**IMS LIME BUSTER III™ ONLY** Complete with Plumbing Kit and 50 ft. of vinyl hose	**$2,384.00**
	— Supplies and Spare Parts —	
#110221	Gardacid 4294 (41 lbs)	**$418.09**
#175200	Gardobond® Additive H 7212 Neutralizer (5 gal)	**335.85**
#110469	Plumbing Kit, Standard Size	**45.00**
#110504	½" I.D. Vinyl Hose	**0.75/ft.**
#121711	Vial of 100 Neutral Litmus Paper Strips	**5.86**
#155320	Chemical Resistant Gloves (pair)-Neoprene	**7.10**
#145852	Chemical Resistant Apron-Nitrile Coated	**18.68**
#113406	Pump and Motor Assembly	**675.95**

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Made in the U.S.A

IMS Lime Buster XL™ Water-Passage Descaler

Keeps Mold Productivity Up And Press Operating Costs Down!

- Designed for all Mold Materials & Heat Exchangers
- Big 30 Gallon tank capacity

Only from IMS!

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

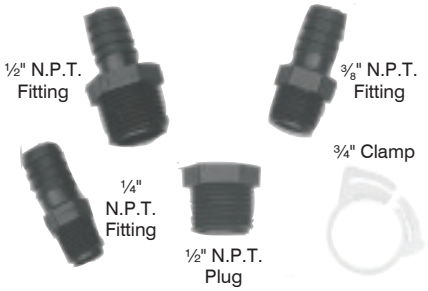
Optional XL Plumbing Kit #144843

INCLUDES (2) 4 Port PVC Manifolds with ½" Ports, Fitting Kit*, Hose and Hose Clamps

#110469 Kit Includes:

Barbed Polyethylene Fittings:	Qty.
½" I.D. x ½" N.P.T.	16
½" I.D. x ⅜" N.P.T.	8
½" I.D. x ¼" N.P.T.	8
Plugs (for unused ports in manifold) ½" N.P.T.	6
¾" Nylon Hose Clamps	16

See Next Page for Pricing



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Please refer to imscompany.com for current pricing

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IMS Lime Buster XL

Made in the U.S.A

Use as Scheduled Mold Maintenance

Designed with the user in mind!

Why do you need an acid and a neutralizer?

- Non-acid solvents don't dissolve mineral scale nearly as well as acid does. That is simple chemistry.
- The EPA requires acids to be neutralized before disposal.
- IMS Gardacid 4294 acid powder has a color marker to help you know when the solution is acidic (ready to use as a descaler) or neutral (ready for disposal).

Safe for all Mold Types!

Gardacid 4294 Acid (powder)

After cleaning water passages use IMS Foaming Rust Inhibitor to ensure rust-free mold storage.

See Page 139

— Supplier's Tip —

Avoid "watered-down", premixed descaling solutions that use more fluid, require more time and end up costing more money.

Item #175150

Complete with one 1" Female NPT Flowmeter, two 41-lb containers of Gardacid 4294 Powdered Acid, one 5-gal container of Gardobond® Additive H 7212 Neutralizer, two vials of Neutral Litmus Paper Strips, Plumbing Kit (Manifolds/Fittings/Hose)* and Instructions.

$3,896.00

For 115/60/1 operation

Specifications

Operating Capacity: ..... 30 gal.
Maximum Operating Temp: ..... 140° F
Pump/Motor: Centrifugal Pump, Close Coupled to AC Motor
- Voltage 115V
- Full Load Amps 3.8
- Power ..... ¼ hp
- Speed ..... 2850 rpm
- Flow ..... 44 gpm Open Discharge

Inlet & Outlet Connections: ..... 1½" N.P.T.
Base Dimensions: ..... 27" wide x 35" long
Height Overall: ..... 32½"
Weight (crated): ..... 154 lbs

Tech Tips

The general rule of thumb is ½ lb of acid per gallon of water.

Lime Buster XL™ is a trademark of IMS Company

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

#136666	**IMS LIME BUSTER XL™ ONLY** Complete with one 1" Female NPT Flowmeter	**$3,000.00**
	— Supplies and Spare Parts —	
#110221	Gardacid 4294 Powdered Acid (41 lbs)	**$418.09**
#175200	Gardobond® Additive H 7212 Neutralizer (5 gal)	**335.85**
#103776	Foaming Mold Water Passage Rust Inhibitor (16 oz)	**8.40**
#121711	Vial of 100 Neutral Litmus Paper Strips	**7.10**
#144843	*Plumbing Kit: Includes (2) 4 Port Manifolds with ½" Ports, Fitting Kit, 50' of Hose and Hose Clamps	**318.00**
#110504	½" I.D. Vinyl Hose	**0.75/ft.**
#145211	1" Female NPT Flow Meter	**179.31**
#155320	Chemical Resistant Gloves (pair)-Neoprene	**5.40**
#145852	Chemical Resistant Apron-Nitrile Coated	**30.00**
#131295	Pump and Motor Assembly	**1,105.00**

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Process Trouble-Shooting Guidelines				
Problem	CRYSTALLINE MATERIALS		AMORPHOUS MATERIALS	
	Lower/Reduce	Raise/Increase	Lower/Reduce	Raise/Increase
Splay	Injection Pressure	Melt Temp	Melt Temp	Mold Temp
	Holding Pressure Time	Mold Temp	Moisture Content	Gate Size
	Injection Speed	Gate Size	Injection Pressure	
	Mold Release Spray		Screw Speed	
			Hold Pressure Time	
			Venting	
Flash	Melt Temp	Clamp Pressure	Melt Temp	Clamp Pressure
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Injection Speed	
	Injection Speed			
Voids	Melt Temp	Mold Temp	Melt Temp	Mold Temp
	Moisture Content	Gate Size	Moisture Content	Gate Size
	Cooling Time	Injection Pressure	Cooling Time	Injection Presure
		Back Presure	Injection Speed	Back Pressure
		Hold Pressure Time		Hold Pressure Time
Warpage	Melt Temp	Cooling Time	Melt Temp	Hold Pressure Time
	Mold Temp	Injection Pressure	Mold Temp	Cooling Time
	Injection Pressure		Injection Pressure	
			Back Pressure	
Sinks	Mold Temp	Melt Temp	Mold Temp	Gate Size
		Gate Size		Injection Pressure
		Injection Pressure		Hold Pressure Time
		Hold Pressure Time		Injection Speed
		Injection Speed		Venting
		Cushion		
		Venting		
Short Shot		Melt Temp		Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
				Venting
Glossiness	Mold Release Spray	Melt Temp	Mold Release Spray	Melt Temp
		Mold Temp		Mold Temp
		Injection Pressure		Injection Pressure
		Injection Speed		Hold Pressure Time
		Venting		Injection Speed
				Venting
Parts Sticking	Melt Temp	Mold Release Spray	Melt Temp	Mold Release Spray
	Mold Temp		Mold Temp	
	Injection Pressure		Injection Pressure	
	Hold Pressure Time		Hold Pressure Time	
	Cooling Time		Cooling Time	
	Injection Speed		Injection Speed	
Brittleness	Melt Temp	Gate Size	Moisture Content	Gate Size
	Moisture Content	Venting	Injection Pressure	Venting
	Injection Pressure		Back Pressure	
	Back Pressure		Screw Speed	
	Screw Speed		Hold Pressure Time	
	Hold Pressure Time		Cushion	
	Cushion		Regrind	
	Regrind		Mold Release Spray	
	Mold Release Spray			
Burn Marks	Injection Pressure	Venting	Melt Temp	Gate Size
	Injection Speed		Injection Pressure	Venting
Delamination	Melt Temp	Mold Temp	Moisture Content	Mold Temp
	Injection Speed	Gate Size		Gate Size
Weld Lines	Moisture Content	Melt Temp	Moisture Content	Melt Temp
		Mold Temp		Mold Temp
		Gate Size		Gate Size
		Injection Pressure		Injection Pressure
		Hold Pressure Time		Hold Pressure Time
		Injection Speed		Injection Speed
		Venting		Venting
Jetting	Injection Speed	Melt Temp	Injection Speed	Melt Temp
	Hold Pressure Time	Mold Temp		Mold Temp
	Injection Pressure	Gate Size		Gate Size

Since
1949

IMS
Industrial
Equipment

Post-Production Equipment

Part Drop Chutes, Skirts, Trays & Diverting Systems
Pages 766 – 775

Part/Runner Conveyors & Separators
Pages 776 – 783

Plastic Granulators, Accessories & Services
Pages 784 – 800

Most items IN STOCK for Same Day Shipment

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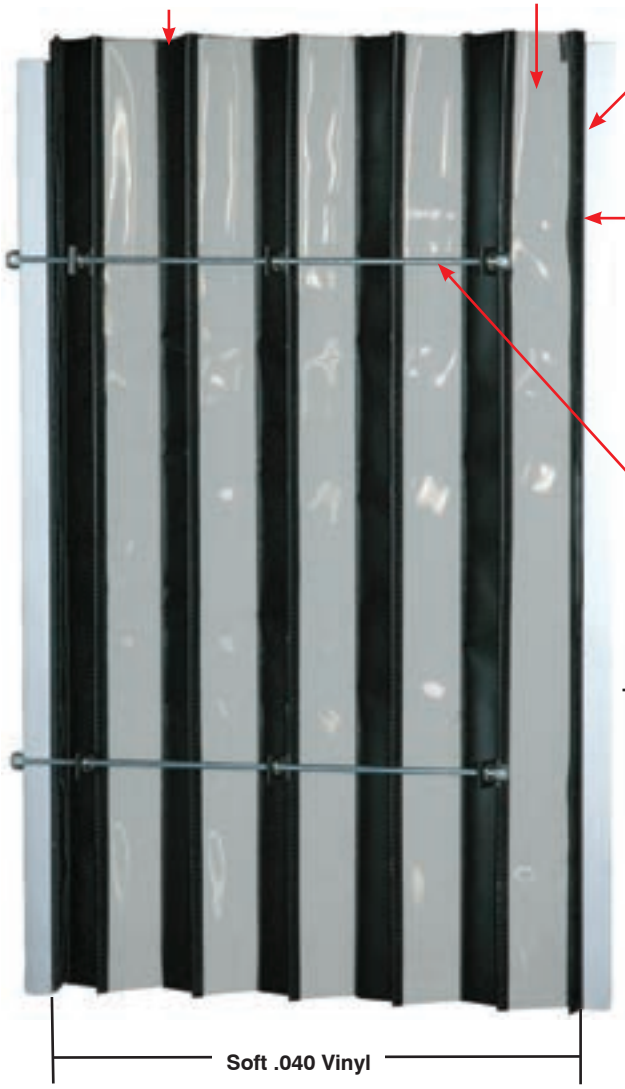
Made in the U.S.A

Mold Side Curtains

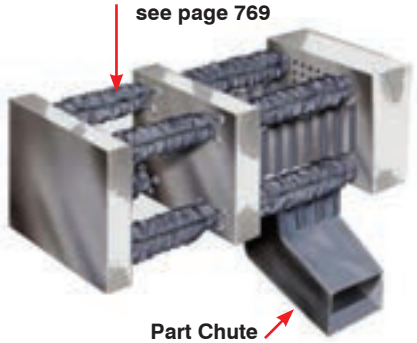
Effectively Contain Molded Parts of Multi-Cavity Molds That Have a Tendency to Fly Out The Sides

Help Reduce the Risk of Part Contamination, Loss or Damage



Typical Installation

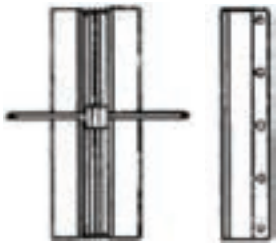
Tie bar sleeves sold separately
For custom Tie Bar Sleeves see page 769



144429-144432 (4" to 10" Mold Open) NO Alignment Rod Required

144433 (12" Mold Open) One Alignment Rod in the Center Required

144434-144437 (14" and 20" Mold Open) Two Alignment Rods Required (as shown)



INCLUDE: Two 1½" x ¾" aluminum angle mounting brackets for attaching to the mold; Velcro for attaching the curtain to the brackets. ¼" Steel Alignment Rods may or may not be included depending on size of curtain (see above).

Item #	Mold Open	Approximate Mold Close	Length	Unit Price
144429	4"	¾"	12"	**$69.41**
144430	6"	¾"	15"	**86.88**
144431	8"	1"	18"	**100.00**
144432	10"	1¼"	21"	**116.13**
144433	12"	1¼"	24"	**124.31**
144434	14"	1½"	27"	**150.00**
144435	16"	1¾"	30"	**159.67**
144436	18"	1¾"	33"	**175.66**
144437	20"	2"	36"	**196.66**

NOTE: The Curtains above are Standard and will fit a variety of applications for custom curtains. Use form on the following page.

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phone order toll-free (USA & Canada) 1.800.537.5375
fax order toll-free (USA & Canada) 1.888.288.6900
phone order toll-free (Mexico) 001.888.304.1307
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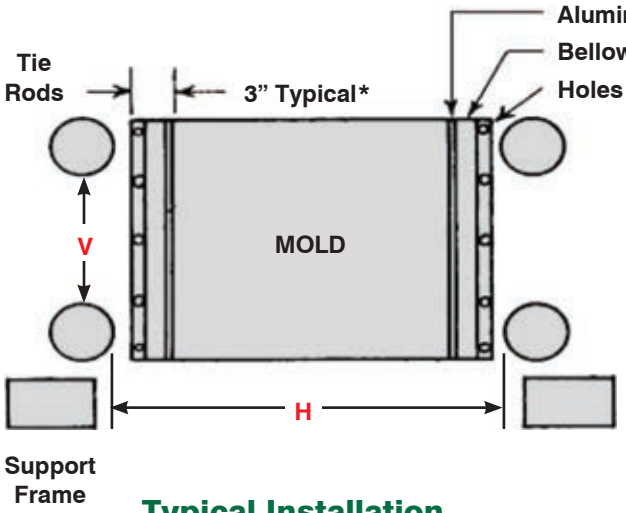
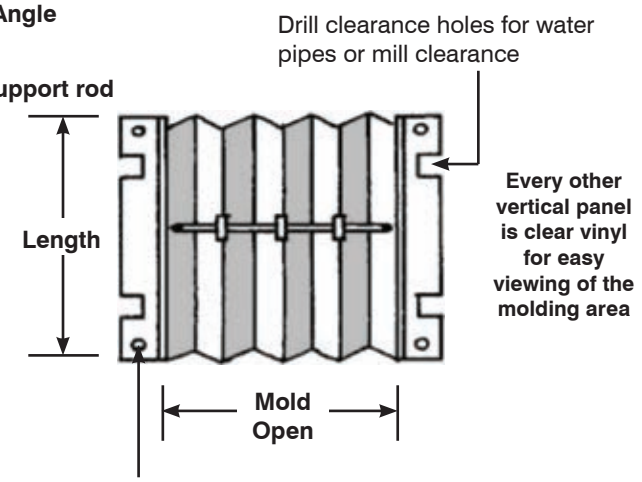
Custom Mold Side Curtains Request Form



Typical Installation



Drill clearance holes in aluminum angle. Drill and tap mold base to accept mounting screws.

***Note:**

Side curtains require 3" gap between mold and tie bar. The curtain can only be as long as the tie bar spacing if adequate space does not exist.

Ensure adequate clearance between waterline fittings on the parting line, to allow the curtain to collapse in between when the mold is closed.

Curtain open stroke and curtain length should not exceed 36".

Mounting Bracket is always 1" shorter than the curtain length.

Curtain length received will be ½" shorter than ordered for adjustment purposes.

Mold Open	Approximate Mold Close
3" - 6"	½" bellows + ¼" for mounting bracket
7" - 9"	¾" bellows + ¼" for mounting bracket
10" - 12"	1" bellows + ¼" for mounting bracket
13" - 15"	1¼" bellows + ¼" for mounting bracket
16" - 18"	1½" bellows + ¼" for mounting bracket
19" - 21"	1¾" bellows + ¼" for mounting bracket
22" - 24"	2" bellows + ¼" for mounting bracket
25" - 27"	2¼" bellows + ¼" for mounting bracket
28" - 30"	2-½" bellows + ¼" for mounting bracket
31" - 32"	2¾" bellows + ¼" for mounting bracket
33" - 36"	3" bellows + ¼" for mounting bracket

1. (H) Distance between Tie Rods: _____ (V) Distance between Tie Rods: _____

2. Mold Width: _____ Mold Height: _____

3. Mold Open: _____

4. Curtain Length: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Made in the U.S.A

Tie Bar Sleeves

Inexpensive Method to Reduce Contamination of Molded Parts While Extending the Life of Tie Bars and Bushings

Shown In Extended Mold Open Position

Shown in Mold Closed Position

MAX Use Temp: 240° F

- Prevent tie bar grease from contacting molded parts
- Protect tie bars and bushings from abrasive airborne particles
- Opens and closes with mold stroke to provide continuous provide continuous protection
- Provides a cleaner, more professional appearance at the press
- Constructed of Neoprene Coated Nylon
- Custom made to any tie bar diameter and length
- Sized to the molding press, not individual molds

Tabs with Eyelets

Used with the magnetic mounting kit to connect to the mold

Air Vent

Allows air flow while mold is closing

Post-Production Equipment

IMS Company

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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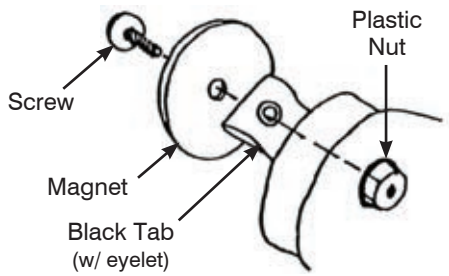
Tie Bar Sleeves

Made in the U.S.A

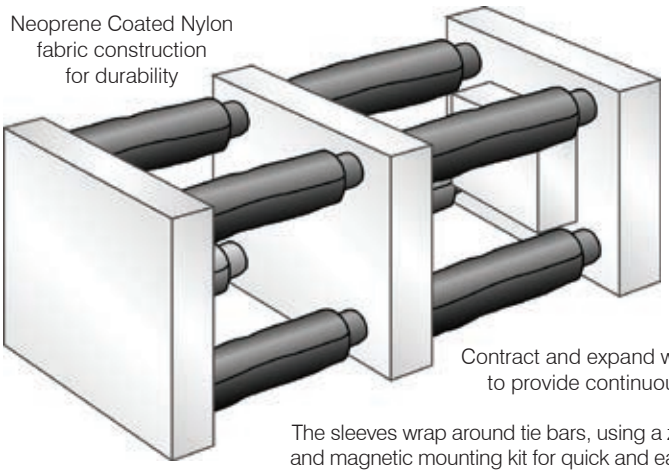
Keep Tie Bar Grease In / Keep Abrasive Airborne Particles Out

Easy Installation

Magnetic Mounting Kit



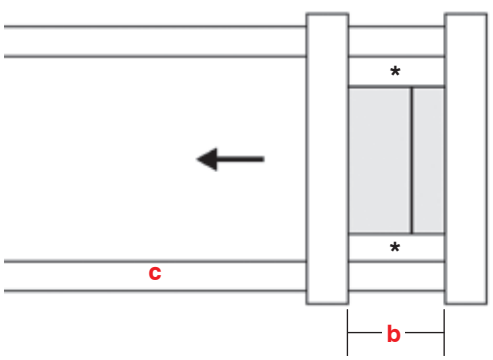
Neoprene Coated Nylon fabric construction for durability



Contract and expand with mold stroke to provide continuous protection

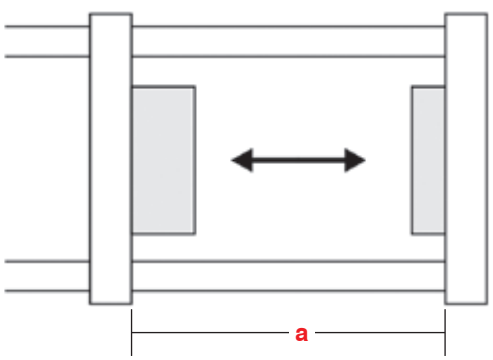
The sleeves wrap around tie bars, using a zipper, Velcro® and magnetic mounting kit for quick and easy installation.

Custom Made To Any Tie Bar Diameter And Length



*1½" clearance required between mold and tie bar.

Mold closed min. platen to platen



Mold opened max. platen to platen

Specify:

a. Mold Open: _____

b. Mold Closed: _____

max open length = 3X closed length (max ratio = 3:1)

c. Tie Bar Diameter: _____

d. Quantity: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Made in the U.S.A

Detachable Part Chute Guideskirts

Great For Automating Injection Machine Part Distribution and Sorting

8 Styles to Suit Most Any Application

HB Hard Bottom Style

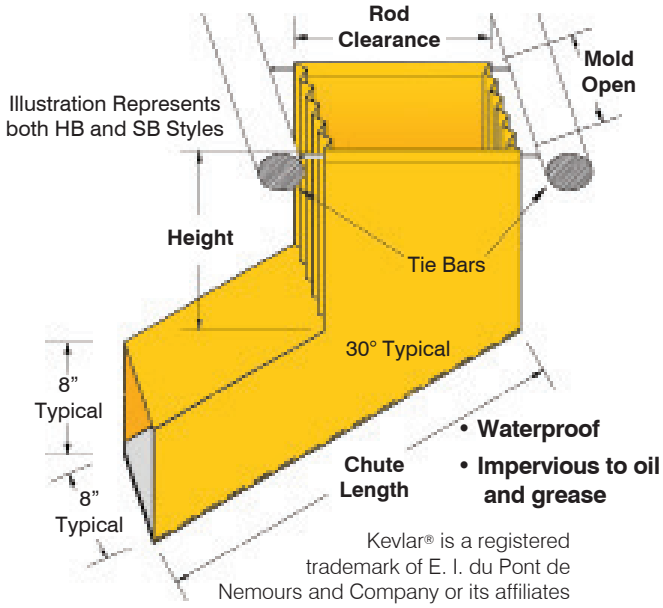
Detachable Chute Guideskirts with cushion insert is specifically designed to transfer molded parts by gravity from under the machine to a conveyor or container

Item #	Mold Open	Rod Clearance	Height	Chute Length	Unit Price
144450	6"	12"	8"	24"	**$188.32**
144451	12"	18"	10"	30"	**225.42**
144452	18"	22"	12"	34"	**255.84**
144453	18"	26"	14"	38"	**291.38**
144454	18"	30"	16"	42"	**321.54**

SB Soft Bottom Style

Soft Chute Guideskirts are made of soft, pliable, abrasion resistant material to protect delicate parts from surface damage, typical applications are conical or spherical shaped small parts below 200°F

Item #	Mold Open	Rod Clearance	Height	Chute Length	Unit Price
144455	6"	12"	8"	24"	**$116.22**
144456	12"	18"	10"	30"	**123.25**
144457	18"	22"	12"	34"	**147.40**
144458	18"	26"	14"	38"	**166.00**
144459	18"	30"	16"	42"	**172.30**



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Common Specifications

Metal Side Plates

- Provide rigidity and extended life to Guideskirts
- Available in 26 ga. stainless steel or .025" thick aluminum
- Can be mounted to the inside or outside the skirting system

Magnets (Item #124325)

- Includes (4) high pull-strength magnets with J-bolts

Additional unique styles from which to choose

Item #	Mold Open	Rod Clearance	Height	Unit Price
T Tapered Style				
144460	6"	12"	18"	**$100.81**
144461	12"	18"	18"	**102.00**
144462	18"	22"	26"	**104.63**
144463	18"	26"	26"	**131.82**
144464	18"	30"	26"	**135.66**
S Tapered Style				
144465	6"	12"	18"	**95.01**
144466	12"	18"	18"	**104.36**
144467	18"	22"	26"	**108.32**
144468	18"	26"	26"	**131.25**
144469	18"	30"	26"	**140.00**
SS Side/Side Divided Style				
144475	6"	12"	14"	**$455.46**
144476	12"	18"	16"	**480.42**
144477	18"	22"	18"	**515.52**
144478	18"	26"	20"	**559.97**
144479	18"	30"	22"	**594.29**

Item #	Mold Open	Rod Clearance	Height	Unit Price
FR Front/Rear Style				
144480	6"	12"	8"	**$216.03**
144481	12"	18"	10"	**291.00**
144482	18"	22"	12"	**287.00**
144483	18"	26"	14"	**360.31**
144484	18"	30"	16"	**372.58**
SL Split Leg Style				
144485	6"	12"	18"	**$150.80**
144486	12"	18"	18"	**158.87**
144487	18"	22"	26"	**175.80**
144488	18"	26"	26"	**191.93**
WSL Walking Split Leg Style				
144489	6"	12"	18"	**$206.45**
144490	12"	18"	20"	**214.51**
144491	18"	22"	26"	**222.58**
144492	18"	26"	26"	**245.96**

See form for Custom Detachable Guideskirts on pages 771-772

Optional Hi-Temp material for thermoset parts
PTFE-coated, 10 mil. Kevlar® is recommended when parts ejected from the mold retain heat in excess of 300°F

IMS Company

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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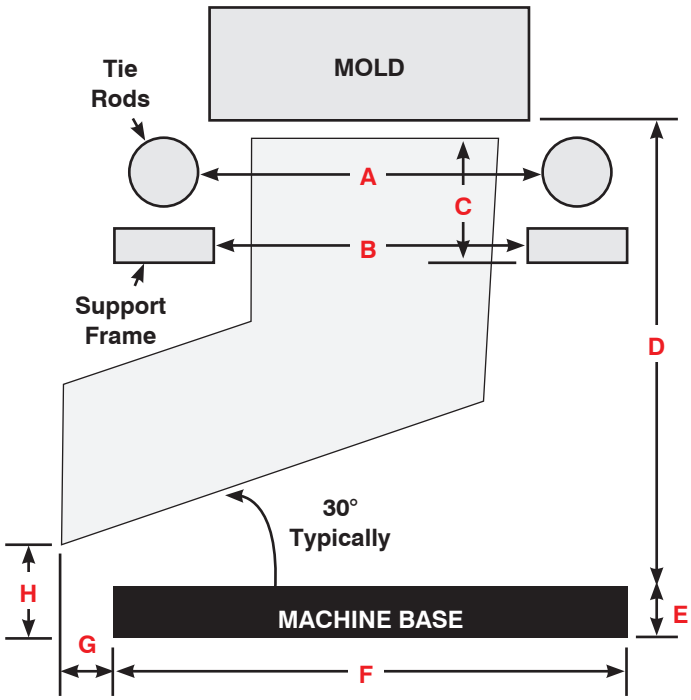
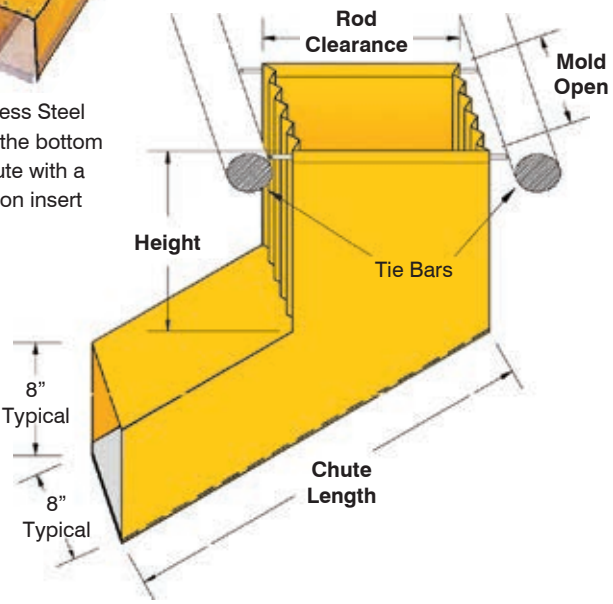
Custom Detachable Guideskirts Request Form



Stainless Steel tray on the bottom of chute with a cushion insert



1. Mold Open (daylight): _____ (24" Max)
2. (A) Width between tie rods: _____
3. (B) Width between frame: _____
4. (C) Clearance Height (chute): _____
5. (D) Machine Clearance mold to base: _____
6. (E) Base to floor: _____
7. (F) Width of base: _____
8. (G) Desired extension past base: _____
9. (H) Desired discharge height: _____
10. Size of parts: _____ L x _____ W x _____ H
11. Runner system: ❑ No ❑ Yes
12. Size of runner: _____ L x _____ W x _____ H
13. Do you require high temp material (for parts over 180°): ❑ No ❑ Yes
14. Style: ❑ Hard Bottom ❑ Soft Bottom

All dimensions must be completed in order for a Quote to be given.

All guideskirts come with mounting hardware.

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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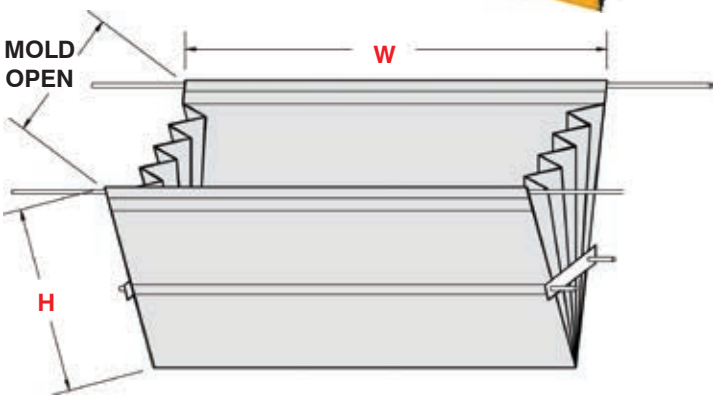
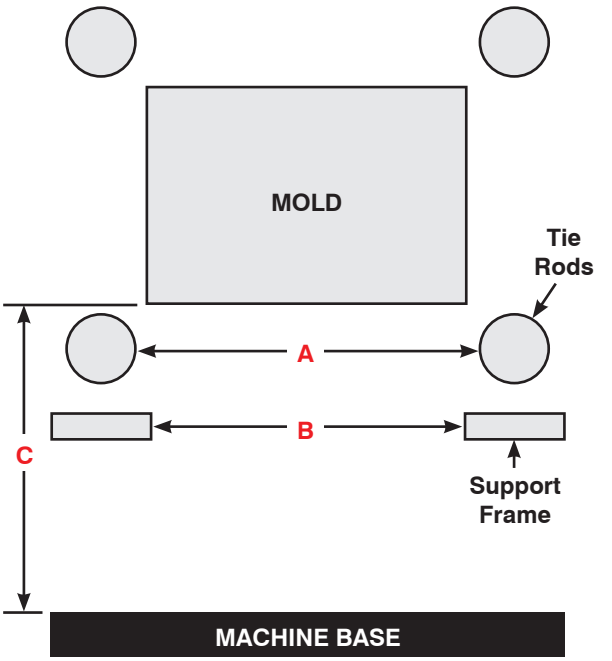
Custom Delay Drop Part Chute Guideskirts (Soft Drop) Form

Drop End Closes When Mold Opens – Opens When Mold Closes

Acts Like A Baffle!



Delayed drops have metal side plates sewn into sides to keep sides rigid.



1. Mold Open (daylight): _____
2. (A) Width between tie rods: _____
3. (B) Width between frame: _____
4. (C) Machine clearance mold to base: _____
5. (H) Desired height of guideskirt: _____
6. (W) Desired width of guideskirt: _____
7. Size of parts:_____ L x _____ W x _____ H
8. Number of mold cavities: _____
9. Runner system: ❑ No ❑ Yes
10. Size of runner: _____ L x _____ W x _____ H
11. Do you require a divider:

    ❑ No ❑ One ❑ Two ❑ Three
12. Do you require high temp material (for parts over 180°):

    ❑ No ❑ Yes

All dimensions must be completed in order for a Quote to be given.

All guideskirts come with mounting hardware.

Date:_____ Quantity:_____ Phone:(_____)_____ Fax: (_____) _____

Name:_____ Title:_____

Company Name: _____ Email: _____

Address:_____

City: _____ State:_____ Zip:_____

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Part Diverting Systems

Automatically Sort Bad Parts From Good Parts

Made in the U.S.A

General Description: A part diverter is used to change the direction of a shot of parts, the discharge of a complete cycle or cycles of parts from an injection molding machine. IMS offers two different styles of part diverters (also known as "part discriminators" in the injection molding industry) custom built to your specifications.

1) **Under the press part diverters:** Units sit or hang directly from the injection molding machine and based upon a specified signal from a IMM or process controller a pneumatically operated tipping tray internal to the diverter housing will discharge parts out the opposite end from where all "Good" shots discharge. The two different styles of under press part diverters are a free standing unit and a quick change type:

A) **Free standing S1:** The free standing S1 diverter is either a square or rectangular stainless steel housing with an internal pivoting tray actuated by a pneumatic air cylinder positioned either under the internal tray, or alongside the housing. The unit is typically supported by a mild steel T-type support stand that is 20" tall and allows the housing to adjust vertically. An air control kit consisting of a ready to mount plate supporting a solenoid valve with filter and regulator/gauge and ¼" air hose from air valve to cylinder is included. Optional chute extensions in standardized lengths are available to add to the housing on either side to aid in part discharge.

B) **Quick Change Rail S1:** The quick change rail S1 type is a square or rectangular stainless steel housing with an internal pivoting tray actuated by a pneumatic air cylinder positioned either under the internal tray, or alongside the housing. This unit is typically supported by an optional QCRA1 or QCRA2 quick change rail attachment kit for either press depths up to 36" or 48" deep. The rail attachments support the load and provide for easy installation, removal or movement. An air control kit consisting of a ready to mount plate supporting a solenoid valve with filter and regulator/gauge and ¼" air hose from air valve to cylinder is included.

Optional chute extensions in standardized lengths are available to add to the housing on either side to aid in part discharge. Many other options are available.

2) **Conveyor Mounted Part Diverters:** IMS offers 6 different orientations for conveyor mounted parts diverters. These are used either at the in-feed or discharge end of the conveyors. Four of the six may be used with a flat or cleated type conveyor belts. Uses at the in-feed end of a conveyor are primarily when the IMM cycle time is very fast, and/or where a reversing belt conveyor may not be feasible. Primary use at the discharge end is when the good part container and bad part container need to be on the same side of the IMM.

A) **PD1:** Pneumatically operated rail that has a pivot point and an air cylinder to angle the rail across the belt surface to side discharge the product. Includes air control kit. This is for non-cleated belts only, must use slider bed on conveyor frame and hard durometer belt surface.

B) **PD2:** Similar to PD1 without the pneumatic controls.

PD3: QCRS1 style housing in standard dimensions with flanged bottom to mount to either the conveyor frame or the side rails, when using a top return on rails. The unit is mounted at the in-feed end and directs products in the direction of belt travel for good parts and off the end of the conveyor for rejected parts. Includes air control kit package.

D) **PD4:** QCRS1 style housing in standard dimensions with flanged bottom or flanged top to mount with special brackets to the discharge end of the conveyor, which may be the drive end or the idle end. The unit is mounted at the discharge end and directs the flow of products in the direction of belt travel for good parts and off the end of the conveyor for rejected parts. Includes air control kit package.

E) **PD5:** QCRS1 style housing in standard dimensions with flanged bottom to mount to either the conveyor frame or the side rails, when using a top return on rails. The unit is mounted at the in-feed end and directs the flow of products perpendicular to the direction of belt travel. Includes air control kit package.

F) **PD6:** QCRS1 style housing in standard dimensions with flanged bottom or flanged top to mount with special brackets to the discharge end of the conveyor, which may be the drive end or the idle end. The unit is mounted at the discharge end and directs the flow of products perpendicular to the direction of belt travel. Includes air control kit package.

See Form on Next Page

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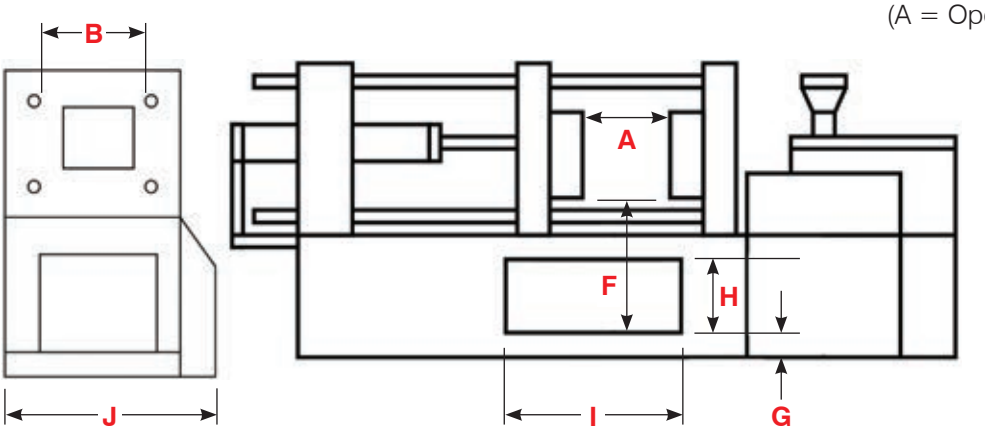
Part Diverting Systems Request Form — Part 1 of 2

SPECIFY:

Please indicate dimensions in inches or feet
(A = Operating Mold Open)



A: _____

B: _____

F: _____

G: _____

H: _____

I: _____

J: _____

S1-Sorter

(shown with optional extensions and leg stand)

Will the S1-Sorter be discharging into a container?: ❑ Yes ❑ No

If Yes: Length:_____ Width:_____ Depth: _____

If No, than what?: _____

Are there any obstructions?: ❑ Yes ❑ No

If Yes: Length:_____ Width:_____ Depth: _____

Position: _____

Optional Extensions

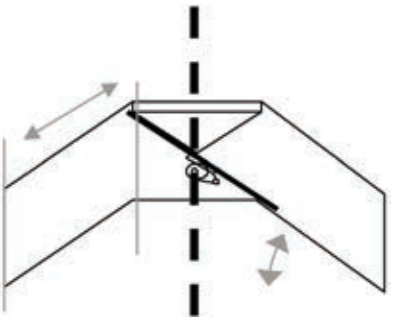
Desired extension length:

❑ 6” ❑ 12”

❑ 18” ❑ Other_____ “

(Custom charges may apply for lengths over 18”)

❑ No extensions desired



Desired angle:

❑ 25° ❑ 30° (Standard)

❑ Other_____ °

(Custom charges may apply for angles over 30°)

Leg Stand

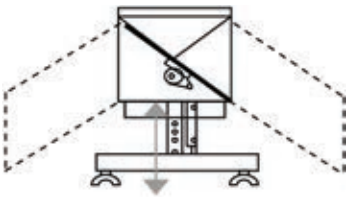
Required height from the floor:

❑ 7” ❑ 7” – 12”

❑ 12” – 20” ❑ Other _____ “

(Custom charges may apply for heights over 20”)

❑ No leg stand desired



(Continued on next page)

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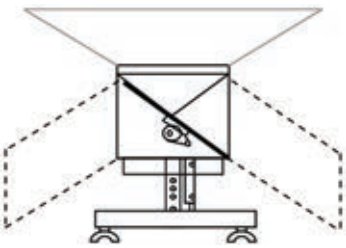
Part Diverting Systems Request Form — Part 2 of 2

Optional Flared Top (Not available with Quick-Change Rail System — below)

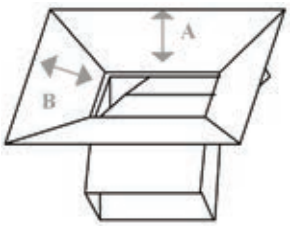


Desired Flare length:

A: ❑ 4” ❑ 6” ❑ 8” Other: _____

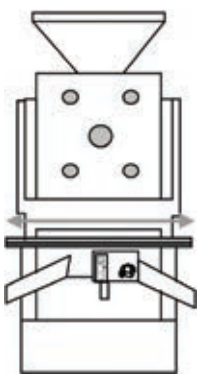
B: ❑ 4” ❑ 6” ❑ 8” Other: _____

(A & B are normally the same length custom charges may apply for lengths over 8”)



Optional Quick-Change Rail System

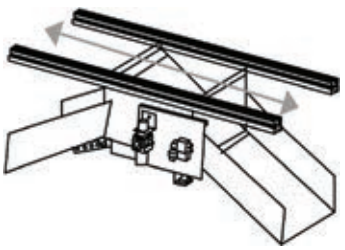
(This system mounts to the press with our “Sliding Track System”)

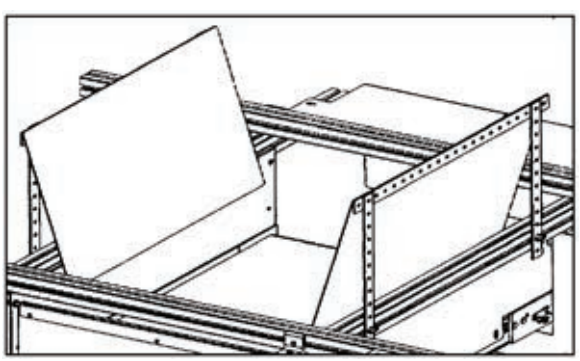


What is the depth of your press?:

❑ Up to 36” deep

❑ Up to 48” deep





Quick-Change Containment Package

These components are used to create custom part containment. This is designed for the end-user to cut to fit. Includes standard hardware.

❑ Yes, please include this package on my quotation.

❑ No, I am not interested in this optional package.

(Serves as a hopper for the QCRS System)

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Made in the U.S.A.

IMS Line Conveyors

Durable Conveyors Built for Injection Molders

Horizontal, Incline & Horizontal to Incline Conveyors in a variety of sizes

Top Quality at a Great Value

Designed & Built by Experts in the Plastic Molding Industry

Powder Coated Steel Frame

Available with: Standard Variable Speed OR Advanced Variable Speed Control

OVERVIEW

- **Frequency Drive Controlled Motor -** UL & CSA Listed
- **Direct Drive Gear Box -** No drive belts or chains
- **White two-ply PVC laced belt -** FDA approved

Custom Conveyors Available — see page 781

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

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IMS Line Conveyors

Durable Low Maintenance Conveyors Built with High Quality Components

IMS Select Line Conveyors were designed and built with the molder in mind. These portable and versatile conveyors, even under heavy shop use, will provide years of trouble free service.

Compare the **features** of our conveyors to the competition and you'll find dollar for dollar "**IMS Select Line**" Conveyors are designed, engineered, and built better.

Frames/Structures

- Heavy duty 14 gauge formed steel powered coated side rails
- Welded tubular steel connector bars
- 18 gauge steel slider beds
- 4½" tall aluminized steel part deflectors

Legs

- Rugged welded steel legs with 3" dia. swivel locking casters
- Adjustable conveyor angle with pivoting leg holder design

Belts

Every IMS Select Line conveyor comes with a resilient 2-ply PVC coated monofilament belt which is FDA approved and has a 160°F continuous temperature rating.

All belts include a stainless steel Uni-Bar clipper lace making them easy to replace should they reach the end of their life cycle.

Attached to the bottom of the belt is a solid center-lined V-Guide to track the belt with the matching V-Guided rollers.

Incline conveyors come with 1" high bonded cleats that are equally spaced 18" apart. The amount of cleats varies with the length of the conveyor.

*Other belt designs, temperature ratings, colors and styles are available with short lead times.

Rollers

- Precision made welded steel
- 2½" dia. rollers with ¾" dia. shaft and V-Guide

Belt Tensioners

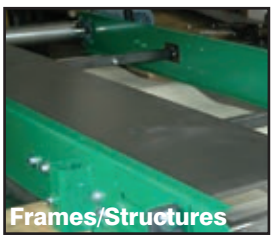
- Engineered, custom fabricated spring loaded belt tensioners
- Easily adjustable

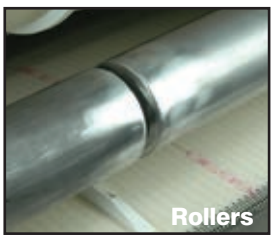
Frequency Drive Controlled Motor

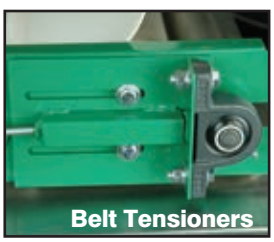
- Strong worm geared 1/3 HP motor standard.
- Motor housing, bearing covers and terminal boxes made of corrosion resistant aluminum die castings.
- Aluminum die cast rotor ensures high reliability at high starting torques and low starting currents

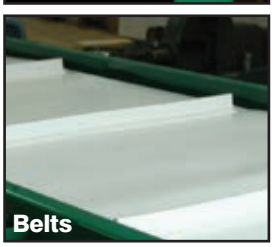
Direct Drive Gear Box
No drive belts or chains

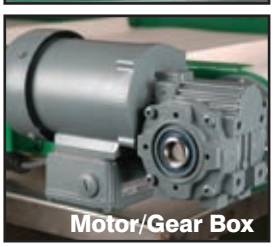
- Right angle – compact direct drive gear box is ideal for preventing lubrication loss and dirt build-up
- Gear wheels made of high tensile strength case hardened steel
- Low noise gearing
- Impervious to shock
- Completely enclosed, sealed against messy shop dust and/or water spray
- Designed to operate under harsh conditions





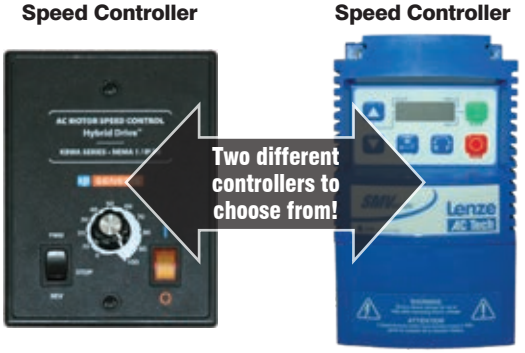






Model KBWA
Standard Variable Speed Controller

Model ESV25
Advanced Variable Speed Controller



Conveyor Controllers

Versatility to fit your application!

IMS offers two different control style choices to give you options. Choose from either a "Standard Variable Speed" Controller or an "Advanced Programmable Variable Speed" Controller. Both Controllers are prewired, ready to plug in and are set to run up to 30 feet per minute, which is suitable for most applications. They both include: Motor Overload Protection / 120/60/1 VAC Operation / 8 foot grounded power cord.

Standard Variable Speed Controller Model KBWA (Item #164889) has a selectable Forward/Stop/Reverse switch and a simple speed dial control for ease of operation.

Advanced Programmable Variable Speed Controller Model ESV25 (Item #164866) has user adjustable settings such as max speed, indexing ability, photo-eye capability and can interface with a signal from the Molding Machine.

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Made in the U.S.A

IMS Horizontal Conveyors

High Quality Part Handling At A Great Price

Shown with Controller
(sold separately)
see below

Direct drive / No belts or chains
- Provides low maintenance

Powder coated steel frame
- Increases durability

- Belt Speed: Up to 30' per minute
- Adjustable Height: 15" to 42"
- Heavy duty 2½" diameter rollers with ¾" diameter shaft
- 160°F continuous belt temperature rating
- FDA approved, non-cleated, white two-ply PVC laced belt standard

Leg pivot design - easily changes angle of conveyor

3" diameter locking swivel casters - improves portability throughout shop

2 Year Warranty

Other belt designs, temperature ratings, colors and styles are available — Inquire

For more details see page 777

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Belt Width	Length	Overall Width	Model #	Item #	Unit Price	Spare Belt	Unit Price
12"	6'	21¼"	SLH-1206	165041	**$3,400.00**	161918	**$209.70**
	8'		SLH-1208	165044	**3,200.00**	161921	**258.00**
18"	6'	27¼"	SLH-1806	165042	**3,550.00**	161919	**287.70**
	8'		SLH-1808	165045	**3,600.00**	161922	**356.00**
24"	6'	33¼"	SLH-2406	165043	**3,600.00**	161920	**374.30**
	8'		SLH-2408	165046	**3,800.00**	161923	**462.40**

Controller Required - Choose Standard Or Advanced When Ordering

Prewired w/8 Foot Cord & Plug	Power	Model #	Item #	Unit Price
Standard Variable Speed Controller	120/60/1	KBWA	164889	**$427.00**
Advanced Variable Speed Controller		ESV25	164866	**505.00**
Spare Parts				
#160815 Direct Drive Motor and Gearbox	**$673.30**	#161076 Idler Side Flange Bearing		**$24.70**
#161077 Drive Side Pillow Block Bearing	**$37.80**			

Custom Conveyors Available — see page 781

IMS Company

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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IMS Incline Conveyors

High Quality Part Handling At A Great Price

Made in the U.S.A

Direct drive / **No belts or chains -** provides low maintenance

Powder coated steel frame - increases durability

- Belt Speed: Up to 30' per minute
- Adjustable Height: 18" to 48"
- Heavy duty 2½" diameter rollers with ¾" diameter shaft
- 160°F continuous belt temperature rating
- FDA approved, cleated, white two-ply PVC laced belt standard

Other belt designs, temperature ratings, colors and styles are available — Inquire

4½" tall aluminized steel part deflectors

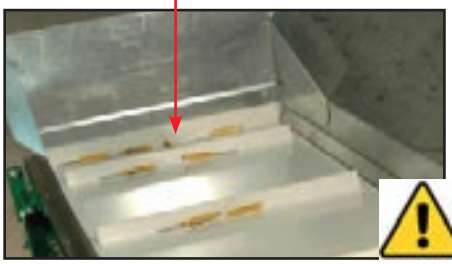
For more details see page 777

Shown with Controller (sold separately) see below

Infeed Chute Included!

2 Year Warranty

Flexible in-feed chute part retaining flap - prevents parts from sliding backward



WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

Leg pivot design - easily changes angle of conveyor

3" diameter locking swivel casters - improves portability throughout shop

Width	Length	In Feed Height	Discharge Height	Model #	Item #	Unit Price	Spare Belt	Unit Price
12"	6'	14"	52"	SLI-1206	165047	**$3,450.00**	162505	**$296.00**
	8'	15"	53"	SLI-1208	165050	**3,600.00**	162508	**376.70**
18"	6'	14"	52"	SLI-1806	165048	**3,650.00**	162506	**384.30**
	8'	15"	53"	SLI-1808	165051	**3,900.00**	162509	**488.70**
24"	6'	14"	52"	SLI-2406	165049	**4,130.00**	162507	**481.10**
	8'	15"	53"	SLI-2408	165052	**4,100.00**	162510	**609.30**

Controller Required - Choose Standard Or Advanced When Ordering

Prewired w/8 Foot Cord & Plug	Power	Model #	Item #	Unit Price
Standard Variable Speed Controller	120/60/1	KBWA	164889	**$427.00**
Advanced Variable Speed Controller		ESV25	164866	**505.00**

Spare Parts			
#160815 Direct Drive Motor and Gearbox	**$673.30**	#161076 Idler Side Flange Bearing	**$24.23**
#161077 Drive Side Pillow Block Bearing	**21.22**		

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Please refer to imscompany.com for current pricing

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Made in the U.S.A

IMS Select Horizontal to Incline Conveyors

High Quality Part Handling At A Great Price

Direct drive / **No belts or chains -** Provides low maintenance

Powder coated steel frame - Increases durability

- Belt Speed: Up to 30' per minute
- Horizontal x Incline: 3' x 6'
- Heavy duty 2½" diameter rollers with ¾" diameter shaft
- 160° F continuous belt temperature rating
- FDA approved, cleated, white two-ply PVC laced belt standard

Other belt designs, temperature ratings, colors and styles are available — Inquire

WARNING: Cancer, Birth Defects and Reproductive Harm. For more information go to www.P65Warnings.ca.gov.

2 Year Warranty

Discharge Chute Included!

For more details see page 777

Leg pivot design - easily changes angle of conveyor

3" diameter locking swivel casters - improves portability throughout shop

Belt Width	Overall Width	In Feed Height	Discharge Height	Model #	Item #	Unit Price	Spare Belt	Unit Price
12"	21.79"	10" to 21"	56" to 73"	SLX-120306	163544	**$4,988.00**	163796	**$442.30**
18"	27.86"			SLX-180306	163545	**5,000.00**	163797	**573.90**
24"	33.86"			SLX-240306	163546	**5,582.00**	163798	**715.70**

Controller Required - Choose Standard Or Advanced When Ordering

Prewired w/8 Foot Cord & Plug	Power	Model #	Item #	Unit Price
Standard Variable Speed Controller	120/60/1	KBWA	164889	**$375.00**
Advanced Variable Speed Controller		ESV25	164866	**505.00**

Spare Parts			
#165078 Direct Drive Motor and Gearbox	**$807.00**	#161076 Idler Side Flange Bearing	**$24.23**
#161077 Drive Side Pillow Block Bearing	**21.22**		

Custom Conveyors Available — see page 781

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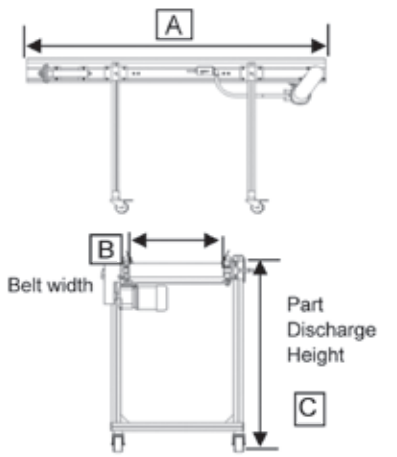
IMS Custom Conveyors

Select Type

Horizontal ☐

Style: (select one)
- Flat top ☐
- 3" Std side rails ☐
- Other (specify) ☐

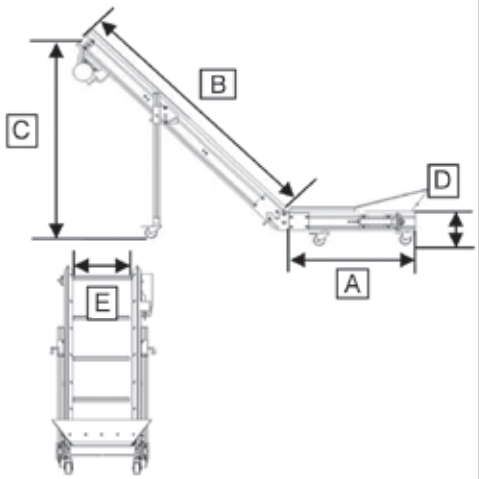


Overall Length **(A)** _____

Belt Width **(B)** _____

Height **(C)** _____

Horizontal to Incline ☐



Horizontal Length **(A)** _____

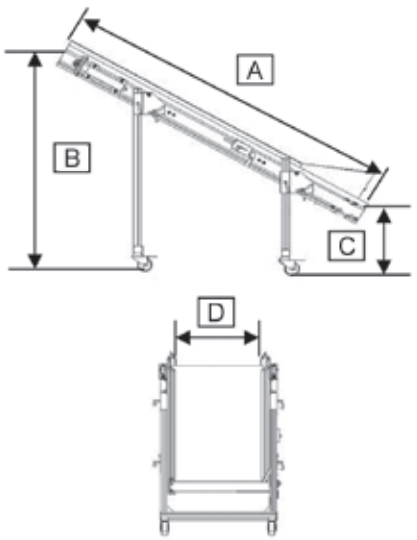
Incline Length **(B)** _____

Discharge Height **(C)** _____

Infeed Height **(D)** _____

Belt Width **(E)** _____

Incline ☐



Overall Length **(A)** _____

Discharge Height **(B)** _____

Infeed Height **(C)** _____

Belt Width **(D)** _____

Belt - (Standard Lacing) ☐

Optional - Seamless Belt ☐

Select one:

Color Green ☐ Black ☐ White ☐ Other ☐

Other color specify : _____

Temperature / Type of Material Conveyed : _____

Cleats - Yes ☐ No ☐

Std Cleat Height is 1.5" : other _____

Cleats spacing 18" Standard

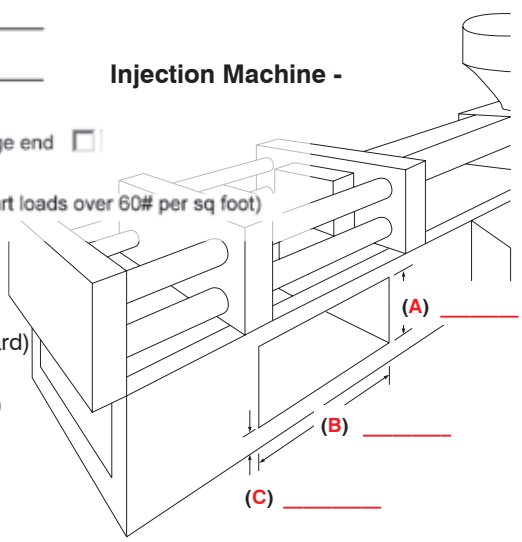
Other than standard -

Cleat spacing required : _____

Note:
If overall width of conveyor is critical, please specify max width dimension:

_____

Injection Machine -



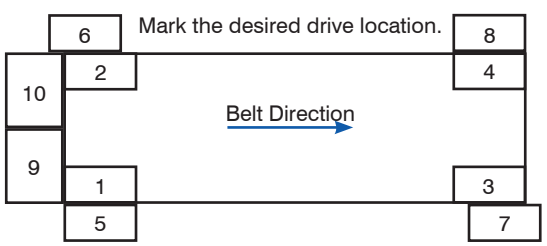
Motor - (check one)

- Std - 19 fpm ☐
- Variable speed - 0-27.5 fpm ☐
- Other - _____

Options - (check one or more)

- Indexing - Specify ☐
- Reversing ☐
- Heavy Duty Slider Bed ☐ (to withstand heavier part loads over 60# per sq foot)
- Part deflector at discharge end ☐
- Photoelectric eye ☐

Motor Position -



1, 2, 3, 4 - Mounted underneath. (standard)

5, 6, 7, 8 - Mounted on side. (up-charge)

9, 10 - Mounted on end. (up-charge

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Replacement Conveyor Belts

Conveyor Model: _____ Serial No.: _____

A) Belt Width : _____ (in.)

B) Belt Overall Length: _____ (in./ft.)

C) Overall Belting Thickness: _____

D) Number of Plies: _____ Carcass: _____ Bottom Cover: _____ Color: _____

E) Cleat Information: Height: _____ Width: _____ Centers: _____ Type: _____

Indent: _____

F) V-Guide Information: Location: _____ Notched: _____

V-Guide Size (Base x Height): ❑ OO-section ($\frac{5}{16}$" x $\frac{3}{16}$") ❑ O-section ($\frac{3}{8}$" x $\frac{1}{4}$")

❑ A-section ($\frac{1}{2}$" x $\frac{5}{16}$") ❑ B-section ($\frac{5}{8}$" x $\frac{3}{8}$") ❑ C-section ($\frac{7}{8}$" x $\frac{7}{16}$")

G) Splice Type: ❑ Laced ❑ Vulcanized ❑ Endless ❑ Prepared Ends

H) Food Grade: ❑ Yes ❑ No

Other Information (If Applicable):

I) Head Pulley Size : _____ (in.) **J)** Tail Pulley Size : _____ (in.)

K) Temperature and type of material being conveyed: _____

L) Size and weight of product being conveyed: _____

M) Horizontal or Incline Conveyor: _____ **N)** Degrees of Incline: _____

O) Chemicals or Petroleum products contacting belt: _____

Other Specifications: _____

Typical Specifications

Plies: Lightweight belting applications are generally 1, 2 or 3 plies.

Carcass: Type of fabric that is used in plies: interwoven polyester, spun polyester, monofilament.

Belt Covers: Top cover is usually smooth, and the bottom cover is a friction surface (FS).

Overall Belt Gauge or Thickness: This dimension is usually used as a possible check of the belt specification and to assure correct fit under and over side rails and nose bars.

Cleat Information: Standard tee cleats are available from $\frac{1}{2}$" to 3" in height and can be welded on most center-to-center distances. All cleat types can be increased to fit under rails or guides.

V-Guides: V-guides are available in O, A, B or C sizes; V-guides are usually located on the bottom centerline of the belting.

Splice Type: Usually the splice will be mechanically laced; vulcanized splices are more expensive and time consuming to install.

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Drum Type Part/Runner Separator

Rugged Construction for High Volume Operations

Made in the U.S.A

Fast Separation - Keeps up with fast-cycling presses and multiple-cavity molds

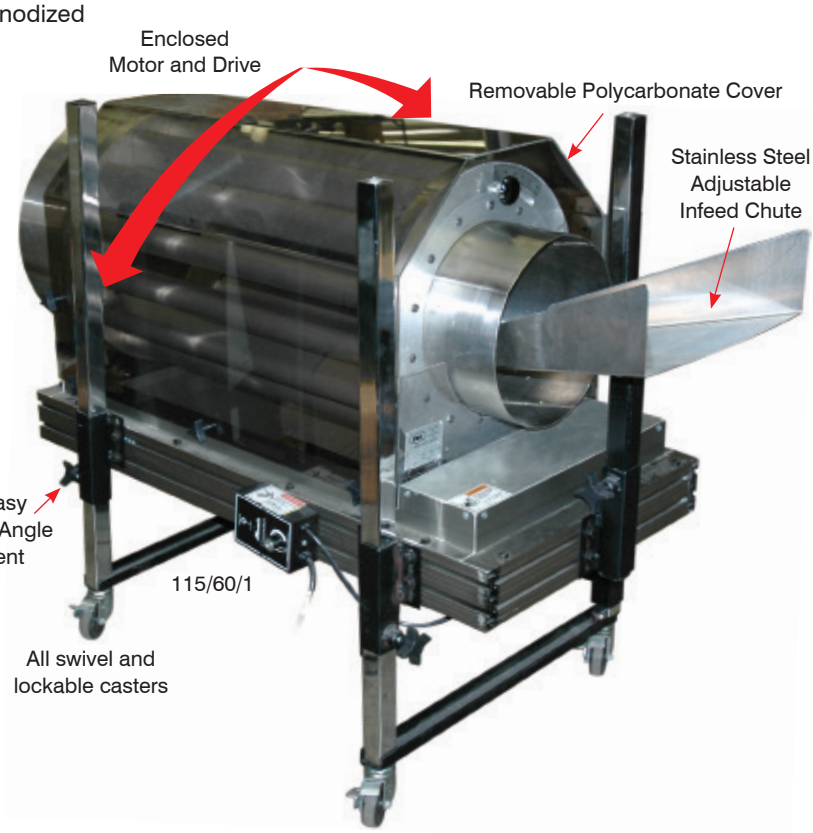
Unique Single-Point Gap Adjustment - Moving just one knob sets all the vanes at the same time

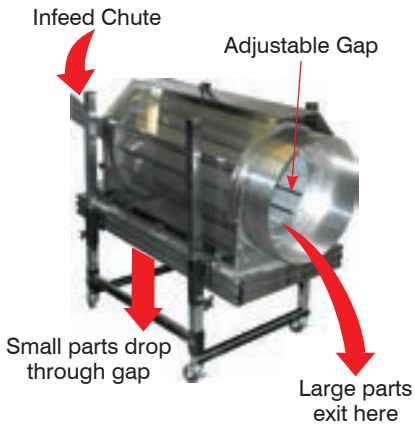
Use With Any Conveyor Up To 18" Wide

Rugged Steel Support Frame - with extruded and anodized aluminum upper frame, side rails and drum

0-15 RPM Variable Speed Control

Built Tough For Continuous 24 Hour, 7 Day Use!





Here's How It Works

Adjust gap between vanes so smaller pieces drop through gaps into box or conveyor. Larger pieces remain in drum and exit through the discharge ring.

Gap size is easily adjusted from a single knob. Drum speed and angle, and infeed chute height and angle are also adjustable to provide complete sorting.

Specifications

Part Drop Gap Width	0-1 5/16"
Drive Motor	1/12 hp, variable-speed DC gearmotor with flexible drive coupling and 7 ft grounded power cord
Dimensions	44"L x 25"W x 29" to 44" infeed height
Shipping Weight	320 lbs.

Price Complete As Shown, Item No. 115675

$7,549.00

Send us a box of your parts and runners for a free automation evaluation and quote.
Please call for an RA number before shipping.

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REQUEST FOR QUOTE: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

Granulator Quotation Request/Order

Application: ❑ Central ❑ Beside-the-press ❑ Under-the-press ❑ Other _____

Largest Part

Material _____: (chemical description)
❑ Cold ❑ Hot _____° F ❑ Filled _____
❑ Unfilled ❑ Other _____

Size of Parts _____: (dimensions)
❑ Sprues/Runners ❑ Pipe/Profile ❑ Film
❑ Sheet ❑ Thermoformed ❑ Blow Molded ❑ Other _____

Heaviest Or Toughest Part

Material _____: (chemical description)
❑ Cold ❑ Hot _____° F ❑ Filled _____
❑ Unfilled ❑ Other _____

Size of Parts _____: (dimensions)
❑ Sprues/Runners ❑ Pipe/Profile ❑ Film
❑ Sheet ❑ Thermoformed ❑ Blow Molded ❑ Other _____

Requested Particle Size _____:
Recommended Screen Size
❑ 1/8" ❑ 3/16" ❑ 1/4" ❑ 5/16" ❑ 3/8" ❑ Other _____

Industry: ❑ Injection ❑ Blow Molding ❑ Extrusion ❑ Recycling ❑ Other _____

Mode of Feeding: ❑ Manual/Hand ❑ Robot ❑ Conveyor
❑ Feed Roll _____ (line speed min/max)

Desired Throughput _____ Pounds/Hour

Mode of Discharge: ❑ Bin with 1 1/8" Takeoff ❑ Blower/Cyclone with Fine Separation System

Electrical _____ V/3PH/60HZ ❑ Other _____

Audial Requirement: ❑ Soundproofed (Standard) ❑ Non-Soundproofed

Existing Granulator for Similar Application: Manufacturer _____ Model Number _____
Throat Size _____ HP _____ Rotor Design _____
Options _____

Requested Delivery Date _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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SHINI Screenless Granulators

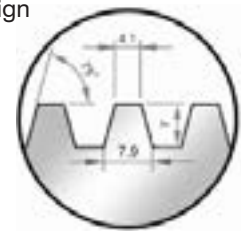
High Quality Regrind Material With Minimal Dust And Fines

Shini SG-24 Series Screenless Granulators are top feed / low speed which create fewer fines and less dust than standard high speed grinders. These models are ideal for grinding sprues, runners, and rejected parts and produce consistent high quality regrind with minimal noise. The SG-24N models use a single heavy duty gear motor while the SG-24T series use two gear motors and two cutting chambers to work simultaneously.

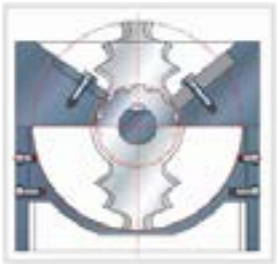
1 Year Warranty

Features:

- Top-Feed hopper
- Screenless Low Dust/Low Noise Design
- Auto Reverse prevents blockage
- Heavy Duty Gear Motor
- Transparent Polycarb Hopper
- 1½" Material Take-off Port
- Casters Standard



Standard Teeth Cutter
(only for SG-24N)



Section View of
Trapezoid Teeth Cutter

SG-24T
Double Teeth Cutter

IMS Item #	Shini #	Power Supply	Motor HP	RPM	Cutting Chamber	Blades	Through-put	Dimensions* L	W	H	Weight (lbs)	dBA	Unit Price
173295	SG-2427N	460/60/3	1.2	33	9.4" x 10.6"	2 Staggered/ 3 Teeth	15 lbs/hr	34.4"	16.7"	52.4"	529	80-85	**9,035.00**
173916		230/60/3											
173871	SG-2436N	460/60/3	2.3	33	9.4" x 14.4"	3 Staggered/ 4 Teeth	20 lbs/hr	38.2"	16.7"	52.4"	567	80-85	**11,105.00**
173917		230/60/3											
173872	SG-2446N	460/60/3	3.4	33	9.4" x 18.1"	4 Staggered/ 5 Teeth	25 lbs/hr	42.1"	16.7"	58.3"	728	80-85	**15,025.00**
173918		230/60/3											
173873	SG-2446T	460/60/3	3.4 x2	33	19.9" x 18.1"	9 Large & 2 Small Staggered (Dual)	55 lbs/hr	53.7"	30.4"	53.5"	1235	80-85	**24,595.00**
173919		230/60/3											

More Granulator Options Available
Pages 786 - 789

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GREEN Products

SHINI Beside-the-Press Granulators

For Consistently High-Quality Regrind

Top Feed hopper - Allows manual or robot feed

Sound-proof material hopper - Brings a quieter operation environment

Obstruction alarm - Notifies operator when blockage occurs

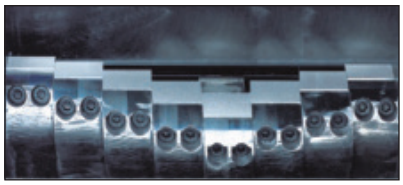
Clamshell cutting chamber - Allows easy cleaning

Siemens electrical components

- Emergency stop
- No specialty tools required for maintenance
- Reversible screen
- Low energy consumption
- Main power disconnect
- Casters included

1 Year Warranty

Tilt back hopper makes components accessible for easy cleaning, maintenance and quick blade replacement.



Staggered blade design made of hardened D2 steel.

Blade design doesn't require adjustment after resharpening.

IMS Item # 230/60/3	IMS Item # 460/60/3	Shini #	HP	RPM	Opening	Throat Size	Throughput (lbs/hr)	Screen Size	Dimensions L	Dimensions W	Dimensions H	Weight (lbs)	Unit Price
164890	149562	SG-1635NH	4	348	15" x 18.5"	13.5" x 6.3"	170	5mm	24"	24"	51"	565	**5,940.00**
158414	150659	SG-2042NH-C	5.5	348	16.5" x 22"	16.5" x 7.8"	280	6mm	28"	24"	51"	763	**7,345.00**

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SHINI Staggered Blade Central Granulators

High Capacity Granulator For Medium To Large Parts

GREEN Products

Sound-proofed material hopper - Provides a quieter operating environment

Cyclone dust separator and blower - Removes dust from regrind and evacuates material

Collection Bag - Traps contamination for easy disposal

Adjustable angle on inlet chute - Increases ease of part feeding

- Low energy consumption
- High amp alarm and amp meter
- Safety interlocks
- Motor overload relays
- Reversible screen
- No specialty tools required for maintenance
- Vacuum bin discharge
- Tangential feed
- Outboard sealed bearings

1 Year Warranty

Staggered blade design made of hardened D2 steel.

Decentralized working load to increase efficiency.

Air spring assisted tilt back adjustable hopper makes components accessible for easy cleaning, maintenance and quick blade replacement.

IMS Item # 230/60/3	IMS Item # 460/60/3	Shini #	HP	RPM	Throat Size	Throughput (lbs/hr)	Screen Size	Dimensions* L	W	H	Feed Height	Weight (lbs)	Unit Price
149569	149570	SG-2324	8.4	320	9” x 9.4”	250	8mm	54”	38”	57”	45”	1041	**$10,645.00**
149571	149572	SG-2336	11.5	320	9” x 14.2”	300	8mm	54”	42”	57”	45”	1151	**10,975.00**
149573	149574	SG-2348	16.9	320	9” x 19”	400	8mm	54”	47”	57”	45”	1332	**12,365.00**

***Dimensions do not include dust collector**

Post-Production Equipment

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GREEN Products

SHINI Open Rotor Central Granulators

High Capacity Granulator For Large Parts

Sound-proofed material hopper - Provides a quieter operating environment

Cyclone dust separator and blower - Removes dust from regrind and evacuates material

Collection Bag - Traps contamination for easy disposal

Adjustable angle on inlet chute - Increases ease of part feeding

Low energy consumption

- High amp alarm and amp meter
- Safety interlocks
- Motor overload relays
- Reversible screen
- No specialty tools required for maintenance
- Vacuum bin discharge
- Tangential feed
- Outboard sealed bearings

1 Year Warranty

Open rotor blade design made of hardened D2 steel.
Decentralized working load to increase efficiency.

Paddle-Type Rotor Design

V-Type Rotor Design

Air spring assisted tilt back adjustable hopper with 3 angle positions makes components accessible for easy cleaning, maintenance and quick blade replacement

IMS Item # 230V	IMS Item # 460V	Shini #	HP	RPM	Rotor	Throat Size	Throughput (lbs/hr)	Screen Size	Dimensions L	Dimensions W	Dimensions H	Weight (lbs)	Unit Price
149582	149583	SG-3060HP	25	500	Paddle	12” x 24”	600	8mm	59”	52”	87”	1634	**17,795.00**
149579	148757	SG-3675P	40	650	Paddle	14” x 29”	1900	10mm	61”	80”	124”	3814	**29,820.00**
160213	160214	SG-4360H	55	630	Paddle	17” x 24”	2000	10mm	75”	84”	124”	5181	**45,145.00**
160215	160216	SG-4390H	70	630	V Type	17” x 32”	2500	10mm	75”	92”	124”	6019	**48,225.00**

*Dimensions do not include dust collector

IMS Company

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Please refer to imscompany.com for current pricing

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SHINI Granulator Common Replacement Parts

Specifications and Prices			
Item #	**For Shini Model**	**Description**	**Unit Price**
159748	SG-2042 Models	Rotating (Staggered Cut) Blade	**RFQ**
159749	SG-2042 Models	Stationary Blade	**RFQ**
163676	SG-2348 Models	Stationary Blade	**RFQ**
163675	All SG-23 Series All SG-30 Series	Rotating (Staggered Cut) Blade	**RFQ**
169244	All SG-16(N) Series Only Does NOT fit other SG-16 Series	Rotating (Staggered Cut) Blade	**RFQ**
169245	SG-1635(N) Models Only Does NOT fit other SG-1635 Series	Stationary Blade	**RFQ**
159747	All SG-20 Series	Drive Belt	**RFQ**

Call for More Options

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Converting Fractional Inches To Decimals And Millimeters

Fraction	Decimal	MM
1/64"	.015625”	0.3969
1/32"	.03125”	0.7938
3/64"	.046875”	1.1906
1/16"	.0625”	1.5875
5/64"	.078125”	2.3812
3/32"	.09375”	2.3812
7/64"	.109375”	2.7781
1/8"	125”	3.175
9/64"	.140625”	3.5719
5/32"	.15625”	3.9688
11/64"	.171875”	4.3656
3/16"	.1875”	4.7625
13/64"	.203125”	5.1594
7/32"	.21875”	5.5562
15/64"	.234375”	5.9531
1/4"	.25”	6.35
17/64"	.265625”	6.7469
9/32"	.28125”	7.1438
19/64"	.296875”	7.5401
5/16"	.3125”	7.9375
21/64"	.328125”	8.3344
11/32"	.34375”	8.7312
23/64"	.359375”	9.1281
3/8"	.375”	9.525
25/64"	.390625”	9.9219
13/32"	.40625”	10.3188
27/64"	.421875”	10.7156
7/16"	.4375”	11.1125
29/64"	.453125”	11.5094
15/32"	.46875”	11.9063
31/64"	.484375”	12.3031
1/2"	.5”	12.7

Fraction	Decimal	MM
33/64"	.515625”	13.0969
17/32"	.53125”	13.4938
35/64"	.546875”	13.8906
9/16"	.5625”	14.2875
37/64"	.578125”	14.6844
19/32"	.59375”	15.0812
39/64"	.609375”	15.4781
5/8"	.625”	15.875
41/64"	.640625”	16.2719
21/32"	.65625”	16.6688
43/64"	.671875”	17.0656
11/16"	.6875”	17.4625
45/64"	.703125”	17.8594
23/32"	.71875”	18.2563
47/64"	.734375”	18.6531
3/4"	.75”	19.05
49/64"	.765625”	19.4469
25/32"	.78125”	19.8438
51/64"	.796875”	20.2406
13/16"	.8125”	20.6375
53/64"	.828125”	21.0344
27/32"	.84375”	21.4312
55/64"	.859375”	21.8281
7/8"	.875”	22.225
57/64"	.890625”	22.6219
29/32"	.90625”	23.0188
59/64"	.921875”	23.4156
15/16"	.9375”	23.8125
61/64"	.953125”	24.2094
31/32"	.96875”	24.6062
63/64"	.984375”	25.0031
1"	1.0”	25.4

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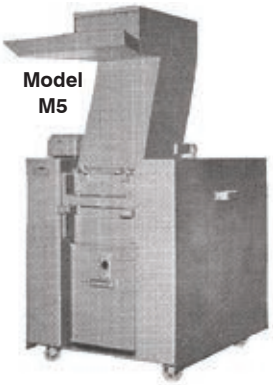
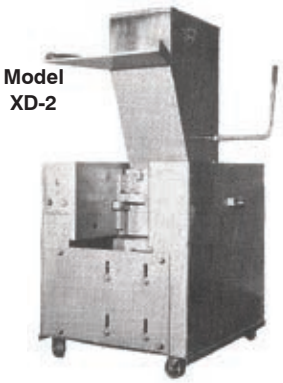
Typical IMS Granulators

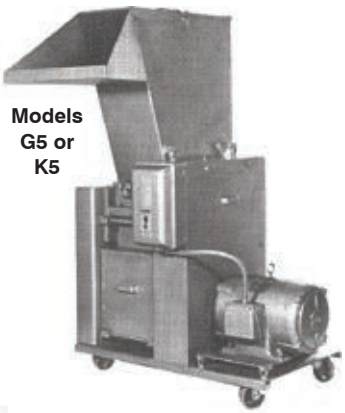
(Since 1956)



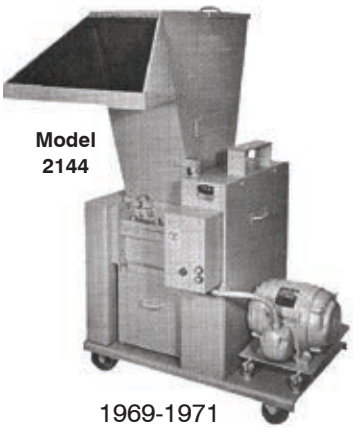
"M" Series
1956-1965



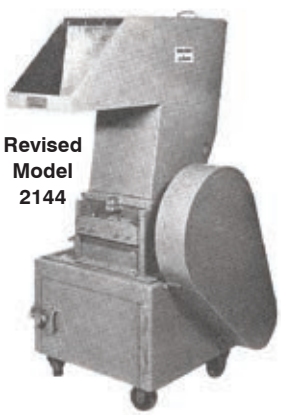
"XD" Series
1961-1965



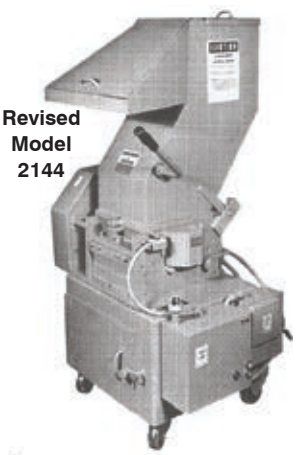
"G" and "K" Series
1966-1968



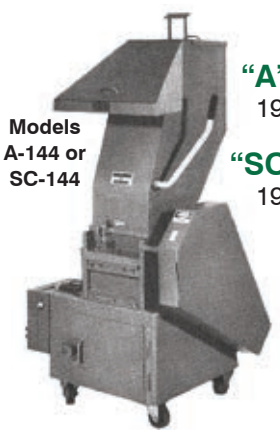
1969-1971



1972-1973



1974-1976



"A" Series
1977-1984

•

"SC" Series
1982-1984

Which Series IMS Grinder Do You Have?

Before ordering replacement parts, use this chart to help identify your granulator, it will help us serve you better.

Tech Tip

Sizing a Granulator

- What plastic material do you want to grind?
- What size is the scrap or part?
- How much do you want to grind?
- How will you feed the granulator?
- What will you do with the regrind?

Complete form on page 784 and let our technicians help properly size your next granulator.

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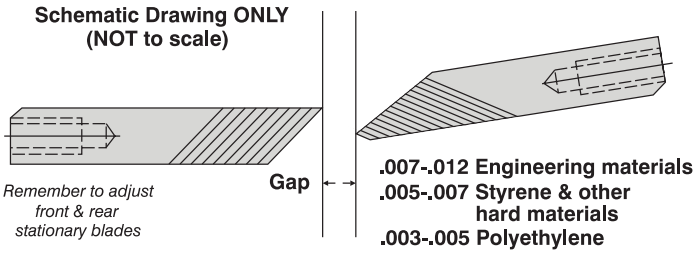
Replacement Blades for IMS Grinders

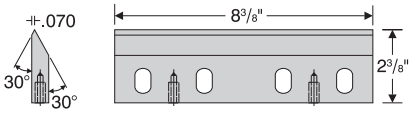
IMS can furnish blades for any IMS Granulator ever made. When ordering blades for older grinders, always give machine serial number.

IMS can quote almost any brand of replacement grinder blades. Please provide the manufacturer, model number, serial number and blade dimensions if possible. Please call 866.467.9001 or email: sales@imscompany.com for more information.

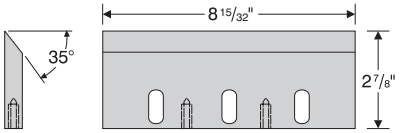


For Grinder Model LP86 And Others With 10" X 8½" Throat

Also for Models: A-86, AG-86-6, AG-86-8 and IMS Auger Grinder AG-86-KH



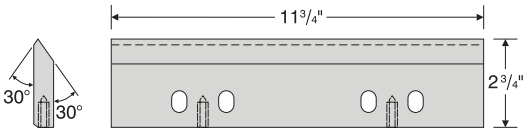
Rotating Blades (2 required)	
#106904	$248.05 ea.



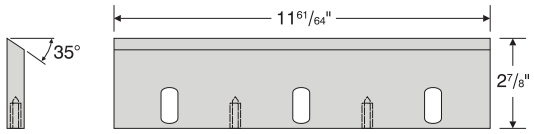
Stationary Blades (2 required)	
#106914	$110.00 ea.

For Grinder Model LP120 And Others With 12” X 10” Throat

Also for Models: LP120-3 and A-120-3



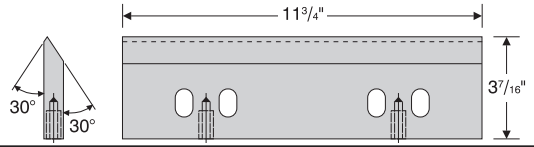
Rotating Blades (2 required)	
#163655	RQF



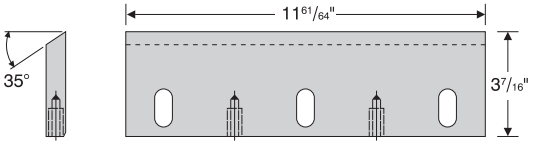
Stationary Blades (2 required)	
#163724	$290.07 ea.

For Grinder Models LP144-3, Lp288-3 And Others With 12” X 12” Throat

Also for Models: LP1442, A-144 and A-144-3



Rotating Blades (2 or 3 required*)	
#106933	$97.15 ea.



Stationary Blades (2 required**)	
#106762	$90.39 ea.

*LP288-3 requires 6 **LP288-3 requires 4

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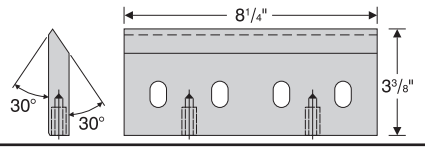
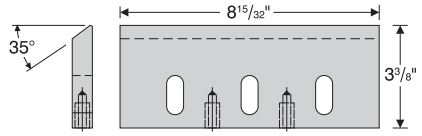
Replacement Blades for IMS Grinders

For Grinder Model LP187 And Others With 17” X 11” Throat

Also for Model: A-187



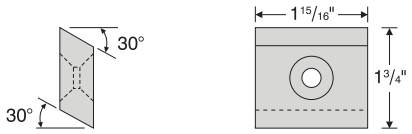
Rotating Blades (4 required)	
#144406	**$162.29 ea.**



Stationary Blades (4 required)	
#106772	**RFQ**

For Stagger-Cut Grinder Models LP120SC, LP144SC And LP288SC

Also for Models: A-120-SC, A-144-SC, A-288-SC, AGA-120-SC and AGU-120-SC
(Older Models — advise Serial Number)

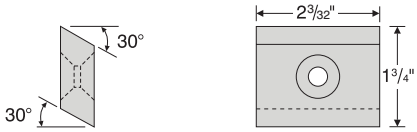


Rotating Blades (18 or 36 required)	
#112919	**$11.97 ea.**

Stationary Blades
Refer to straight-blade model for correct stationary blade part number

For Stagger-Cut Grinder Model LP187SC

Also for Models: A-86-SC, A-187-SC, AG-86-KH-SC, AG-86-6-SC and AG-86-8-SC

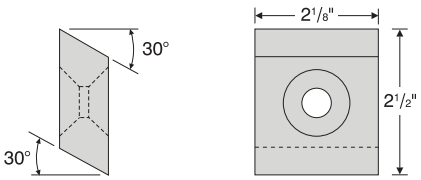


Rotating Blades (8, 12 or 24 required)	
#166054	**$13.52 ea.**

Stationary Blades
Refer to straight-blade model for correct stationary blade part number

For Stagger-Cut Grinder Model LP288SC With 24” X 12” Throat

(Newer Models — advise Serial Number)



Rotating Blades (33 required)	
#130639	**$27.00 ea.**

Stationary Blades
Refer to straight-blade model for correct stationary blade part number

Don’t see what you need? Contact our Equipment Team today: sales@imscompany.com

Available in several material options — Inquire

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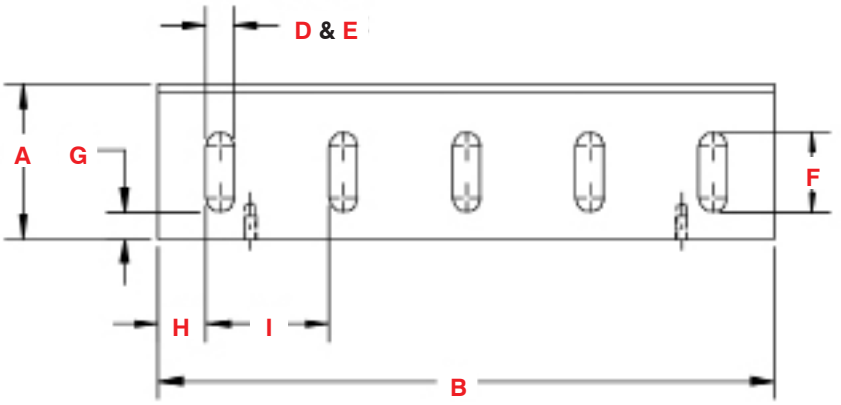
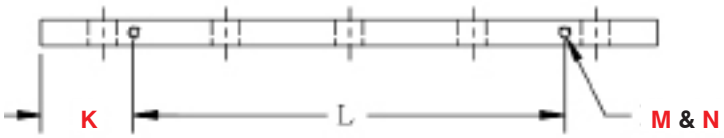
Granulator Bed Knife Form





SPECIFY:

Granulator Make: _____

Granulator Model: _____

OEM# (if available): _____

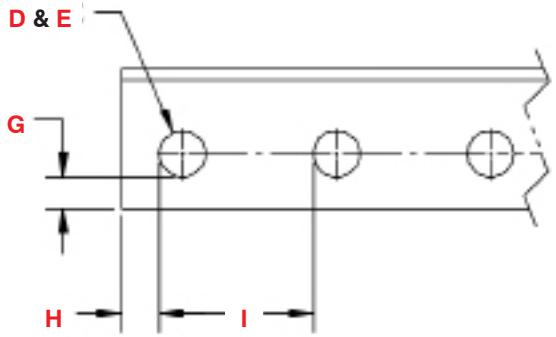
1) Note any part numbers or markings on the knife:

_____

A. Height: _____

B. Length: _____

C. Thickness: _____



2) Hole/Slot information:

Type of holes: _____

D. Quantity of holes: _____

E. Slot width/Hole diameter: _____

F. Slot length: _____

G. Bottom edge to hole/slot edge: _____

H. End to first hole/slot edge: _____

I. Typical hole/slot spacing: _____

J. Bevel angle: _____

3) Tapped hole information:

K. End to tapped hole center: _____

L. Tapped hole center to center: _____

M. Quantity of tapped holes: _____

N. Tapped hole size & pitch: _____

O. Tapped hole depth: _____

4) Note any special features:

_____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

Granulator Fly Knife Form

Specify:

Granulator Make: _____

Granulator Model: _____

OEM# (if available): _____

1) Note any part numbers or markings on the knife:

_____

A. Height: _____

B. Length: _____

C. Thickness: _____

2) Hole/Slot information:

Type of holes: _____

D. Quantity of holes: _____

E. Hole diameter: _____

F. C'bore/C'sink diameter: _____

G. Bottom edge to hole/slot edge: _____

H. End to first hole/slot edge: _____

I. Typical hole/slot spacing: _____

J. C'bore/C'sink depth: _____

3) Taper angle (if applies):

K. Taper angle: _____

L. Bevel angle (1): _____

M. Bevel angle (2): _____

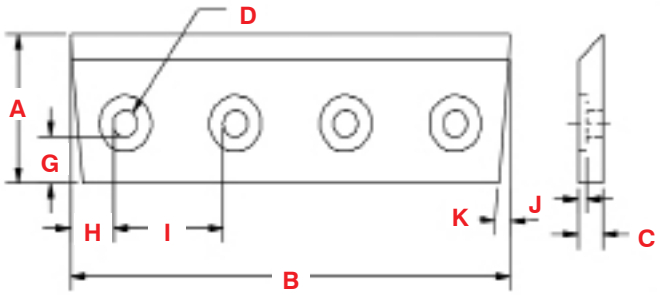
N. Horizontal bevel point: _____

4) Note any special features:

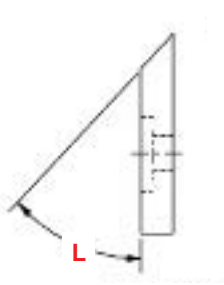
_____

_____

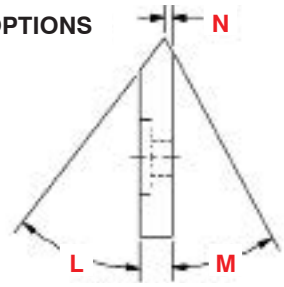
_____



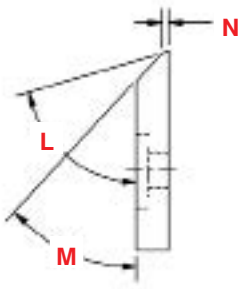
BEVEL OPTIONS



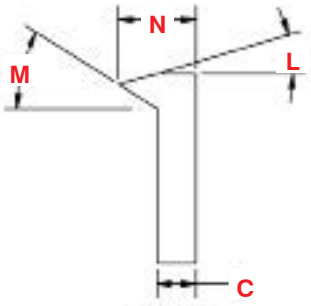
Keen Edge



Reverse Bevel

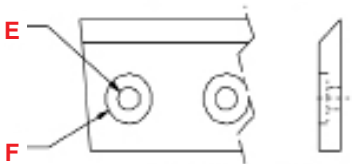


High Shear

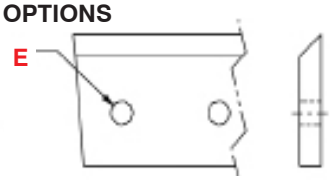


Hook Fly

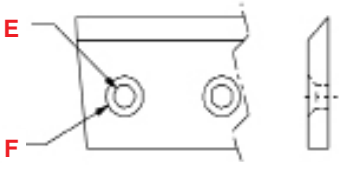
HOLE OPTIONS



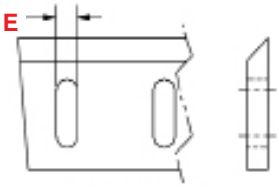
Counterbored Hole



Through Hole



Countersunk Hole



Slotted Hole

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

IMS Replacement Granulator Catchpans

Heavy-Duty Polypropylene

Do you have an older Model IMS Granulator?

Did you know that parts are still available?

For instance the following LP Series Granulator catchpans are still available — call to inquire.

For Granulator Model	Item #	Dimensions L	W	H	Handles	Unit Price
LP49	107083	14”	14”	9¼”	2	Inquire
LP86	107073	14½”	14½”	9¼”		
LP120	107064	15”	15”	9¼”		
LP144	107053	15¼”	17¼”	9¼”		
LP187	107042	13⅞”	18½”	9⅞”	4	
LP288 (Right)	107099	18”	12¾”	11½”		
LP288 (Left)	107113	18”	12¾”	11½”		

IMS Granulator Catchpan Metal Trap™ Magnets

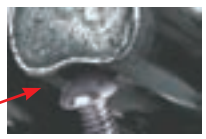
Help Keep Tramp Metal Out of Your Regrind

We custom manufacture these magnets to fit the dimensions of your catchpan. The close 9/16" spacing between bars eliminates the need for diverters.

- Ceramic inserts provide excellent holding ability (Alnico or rare earth available)
- Exclusive concave Metal Trap™ retains metal pieces

How to order:
Contact the IMS Equipment Team with exact inside dimensions (length x width) of your catchpan. Also include the wall thickness of the catchpan if it is more than ⅛". The length measurement (also magnet rod length) is the distance front to back of your granulator catchpan. Magnets will hang about 1" below the top of the catchpan.

Concave metal trap™ under rods holds ferrous scrap like no round-bar magnet can



Large contact area under magnetic rod grabs ferrous object and protects it from being wiped off by material flowing around magnetic bar.

Specifications
Magnet bar spacing: 9/16"

Description	Price
Granulator Catchpan Metal Trap™ Magnets — custom sized (Tubes run lengthwise and are spaced across pan width)	Inquire for Details

www.imscompany.com
phone order toll-free (USA & Canada) 1.800.537.5375
fax order toll-free (USA & Canada) 1.888.288.6900
phone order toll-free (Mexico) 001.888.304.1307
tech support toll-free (USA & Canada) 1.866.467.9001
e-mail sales@imscompany.com

Please refer to imscompany.com for current pricing

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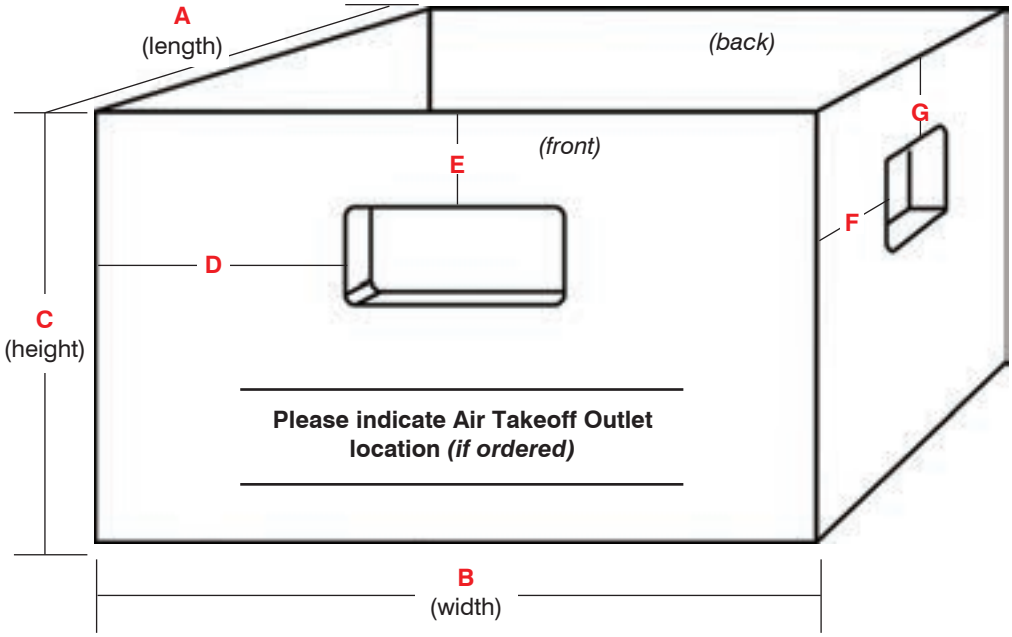
Granulator Catchpan



Catchpan Dimensions: Outside	
A: (Length)	_____
B: (Width)	_____
C: (Height)	_____

2❑ or 4❑ Handle Locations:

Front/Back		Sides	
D:	_____	**F:**	_____
E:	_____	**G:**	_____

Standard recessed handles are 4 1/2" long x 1 3/4" high x 1" deep

Granulator Make: _____ Model: _____ Serial #: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.
-17.8	**0**	32.0
-17.2	**1**	33.8
-16.7	**2**	35.6
-16.1	**3**	37.4
-15.6	**4**	39.2
-15.0	**5**	41.0
-14.4	**6**	42.8
-13.9	**7**	44.6
-13.3	**8**	46.4
-12.8	**9**	48.2
-12.2	**10**	50.0
-11.7	**11**	51.8
-11.1	**12**	53.6
-10.6	**13**	55.4
-10.0	**14**	57.2
- 9.44	**15**	59.0
- 8.89	**16**	60.8
- 8.33	**17**	62.6
- 7.78	**18**	64.4
- 7.22	**19**	66.2
- 6.67	**20**	68.0
- 6.11	**21**	69.8
- 5.56	**22**	71.6
- 5.00	**23**	73.4
- 4.44	**24**	75.2
- 3.89	**25**	77.0
- 3.33	**26**	78.8
- 2.78	**27**	80.6
- 2.22	**28**	82.4
- 1.67	**29**	84.2
- 1.11	**30**	86.0
- 0.56	**31**	87.8
0	**32**	89.6
0.56	**33**	91.4
1.11	**34**	93.2
1.67	**35**	95.0
2.22	**36**	96.8
2.78	**37**	98.6
3.33	**38**	100.4
3.89	**39**	102.2
4.44	**40**	104.0
5.00	**41**	105.8
5.56	**42**	107.6
6.11	**43**	109.4
6.67	**44**	111.2
7.22	**45**	113.0
7.78	**46**	114.8
8.33	**47**	116.6
8.89	**48**	118.4
9.44	**49**	120.2
10.0	**50**	122.0
10.6	**51**	123.8
11.1	**52**	125.6
11.7	**53**	127.4
12.2	**54**	129.2
12.8	**55**	131.0
13.3	**56**	132.8
13.9	**57**	134.6
14.4	**58**	136.4
15.0	**59**	138.2
15.6	**60**	140.0
16.1	**61**	141.8
16.7	**62**	143.6
17.2	**63**	145.4
17.8	**64**	147.2
18.3	**65**	149.0
18.9	**66**	150.8
19.4	**67**	152.6
20.0	**68**	154.4
20.6	**69**	156.2
21.1	**70**	158.0
21.7	**71**	159.8
22.2	**72**	161.6
22.8	**73**	163.4
23.3	**74**	165.2
23.9	**75**	167.0
24.4	**76**	168.8
25.0	**77**	170.6
25.6	**78**	172.4
26.1	**79**	174.2
26.7	**80**	176.0
27.2	**81**	177.8
27.8	**82**	179.6
28.3	**83**	181.4
28.9	**84**	183.2
29.4	**85**	185.0
30.0	**86**	186.8
30.6	**87**	188.6
31.1	**88**	190.4
31.7	**89**	192.2
32.2	**90**	194.0
32.8	**91**	195.8
33.3	**92**	197.6
33.9	**93**	199.4
34.4	**94**	201.2
35.0	**95**	203.0
35.6	**96**	204.8
36.1	**97**	206.6
36.7	**98**	208.4
37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.
38	**100**	212
43	**110**	230
49	**120**	248
54	**130**	266
60	**140**	284
66	**150**	302
71	**160**	320
77	**170**	338
82	**180**	356
88	**190**	374
93	**200**	392
99	**210**	410
100	**212**	413.6
104	**220**	428
110	**230**	446
116	**240**	464
121	**250**	482
127	**260**	500
132	**270**	518
138	**280**	536
143	**290**	554
149	**300**	572
154	**310**	590
160	**320**	608
166	**330**	626
171	**340**	644
177	**350**	662
182	**360**	680
188	**370**	698
193	**380**	716
199	**390**	734
204	**400**	752
210	**410**	770
216	**420**	788
221	**430**	806
227	**440**	824
232	**450**	842
238	**460**	860
243	**470**	878
249	**480**	896
254	**490**	914
260	**500**	932
266	**510**	950
271	**520**	968
277	**530**	986
282	**540**	1004
288	**550**	1022
293	**560**	1040
299	**570**	1058
304	**580**	1076
310	**590**	1094
316	**600**	1112
321	**610**	1130
327	**620**	1148
332	**630**	1166
338	**640**	1184
343	**650**	1202
349	**660**	1220
354	**670**	1238
360	**680**	1256
366	**690**	1274
371	**700**	1292
377	**710**	1310
382	**720**	1328
388	**730**	1346
393	**740**	1364
399	**750**	1382
404	**760**	1400
410	**770**	1418
416	**780**	1436
421	**790**	1454
427	**800**	1472
432	**810**	1490
438	**820**	1508
443	**830**	1526
449	**840**	1544
454	**850**	1562
460	**860**	1580
466	**870**	1598
471	**880**	1616
477	**890**	1634
482	**900**	1652
488	**910**	1670
493	**920**	1688
499	**930**	1706
504	**940**	1724
510	**950**	1742
516	**960**	1760
521	**970**	1778
527	**980**	1796
532	**990**	1814
538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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Converting Fahrenheit To Celsius/Celsius To Fahrenheit

0 to 99 (in 1° increments)

C.		F.	C.		F.
-17.8	**0**	32.0	10.0	**50**	122.0
-17.2	**1**	33.8	10.6	**51**	123.8
-16.7	**2**	35.6	11.1	**52**	125.6
-16.1	**3**	37.4	11.7	**53**	127.4
-15.6	**4**	39.2	12.2	**54**	129.2
-15.0	**5**	41.0	12.8	**55**	131.0
-14.4	**6**	42.8	13.3	**56**	132.8
-13.9	**7**	44.6	13.9	**57**	134.6
-13.3	**8**	46.4	14.4	**58**	136.4
-12.8	**9**	48.2	15.0	**59**	138.2
-12.2	**10**	50.0	15.6	**60**	140.0
-11.7	**11**	51.8	16.1	**61**	141.8
-11.1	**12**	53.6	16.7	**62**	143.6
-10.6	**13**	55.4	17.2	**63**	145.4
-10.0	**14**	57.2	17.8	**64**	147.2
- 9.44	**15**	59.0	18.3	**65**	149.0
- 8.89	**16**	60.8	18.9	**66**	150.8
- 8.33	**17**	62.6	19.4	**67**	152.6
- 7.78	**18**	64.4	20.0	**68**	154.4
- 7.22	**19**	66.2	20.6	**69**	156.2
- 6.67	**20**	68.0	21.1	**70**	158.0
- 6.11	**21**	69.8	21.7	**71**	159.8
- 5.56	**22**	71.6	22.2	**72**	161.6
- 5.00	**23**	73.4	22.8	**73**	163.4
- 4.44	**24**	75.2	23.3	**74**	165.2
- 3.89	**25**	77.0	23.9	**75**	167.0
- 3.33	**26**	78.8	24.4	**76**	168.8
- 2.78	**27**	80.6	25.0	**77**	170.6
- 2.22	**28**	82.4	25.6	**78**	172.4
- 1.67	**29**	84.2	26.1	**79**	174.2
- 1.11	**30**	86.0	26.7	**80**	176.0
- 0.56	**31**	87.8	27.2	**81**	177.8
0	**32**	89.6	27.8	**82**	179.6
0.56	**33**	91.4	28.3	**83**	181.4
1.11	**34**	93.2	28.9	**84**	183.2
1.67	**35**	95.0	29.4	**85**	185.0
2.22	**36**	96.8	30.0	**86**	186.8
2.78	**37**	98.6	30.6	**87**	188.6
3.33	**38**	100.4	31.1	**88**	190.4
3.89	**39**	102.2	31.7	**89**	192.2
4.44	**40**	104.0	32.2	**90**	194.0
5.00	**41**	105.8	32.8	**91**	195.8
5.56	**42**	107.6	33.3	**92**	197.6
6.11	**43**	109.4	33.9	**93**	199.4
6.67	**44**	111.2	34.4	**94**	201.2
7.22	**45**	113.0	35.0	**95**	203.0
7.78	**46**	114.8	35.6	**96**	204.8
8.33	**47**	116.6	36.1	**97**	206.6
8.89	**48**	118.4	36.7	**98**	208.4
9.44	**49**	120.2	37.2	**99**	210.2

100 to 1000 (in 10° increments)

C.		F.	C.		F.
38	**100**	212	288	**550**	1022
43	**110**	230	293	**560**	1040
49	**120**	248	299	**570**	1058
54	**130**	266	304	**580**	1076
60	**140**	284	310	**590**	1094
66	**150**	302	316	**600**	1112
71	**160**	320	321	**610**	1130
77	**170**	338	327	**620**	1148
82	**180**	356	332	**630**	1166
88	**190**	374	338	**640**	1184
93	**200**	392	343	**650**	1202
99	**210**	410	349	**660**	1220
100	**212**	413.6	354	**670**	1238
104	**220**	428	360	**680**	1256
110	**230**	446	366	**690**	1274
116	**240**	464	371	**700**	1292
121	**250**	482	377	**710**	1310
127	**260**	500	382	**720**	1328
132	**270**	518	388	**730**	1346
138	**280**	536	393	**740**	1364
143	**290**	554	399	**750**	1382
149	**300**	572	404	**760**	1400
154	**310**	590	410	**770**	1418
160	**320**	608	416	**780**	1436
166	**330**	626	421	**790**	1454
171	**340**	644	427	**800**	1472
177	**350**	662	432	**810**	1490
182	**360**	680	438	**820**	1508
188	**370**	698	443	**830**	1526
193	**380**	716	449	**840**	1544
199	**390**	734	454	**850**	1562
204	**400**	752	460	**860**	1580
210	**410**	770	466	**870**	1598
216	**420**	788	471	**880**	1616
221	**430**	806	477	**890**	1634
227	**440**	824	482	**900**	1652
232	**450**	842	488	**910**	1670
238	**460**	860	493	**920**	1688
243	**470**	878	499	**930**	1706
249	**480**	896	504	**940**	1724
254	**490**	914	510	**950**	1742
260	**500**	932	516	**960**	1760
266	**510**	950	521	**970**	1778
271	**520**	968	527	**980**	1796
277	**530**	986	532	**990**	1814
282	**540**	1004	538	**1000**	1832

To convert from Fahrenheit to Celsius: Find Fahrenheit temperature in center column. Look to left column for Celsius conversion.

To convert from Celsius to Fahrenheit: Find Celsius temperature in center column. Look to right column for Fahrenheit conversion.

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 Please refer to imscompany.com for current pricing

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IMS COMPANY
TERMS AND CONDITIONS OF SALE

Seller's Terms and Conditions of Sale apply to all purchases made by Buyer from Seller and all Invoices, emails, packing lists, or any other method of confirming an Order conveyed from Seller to Buyer. All Orders shall be subject only to Seller's Terms and Conditions unless Seller expressly agrees otherwise, in writing, making express reference to Seller's Terms and Conditions.

1. Definitions

(a) Seller: IMS Company;

(b) Buyer: a business or individual customer who purchases Goods from Seller through any method offered by Seller, including any successor thereof;

(c) Goods: any products and materials manufactured, imported, supplied and/or delivered for or by Seller to Buyer;

(d) Invoice: Issued by Seller in confirmation of an Order received from Buyer, which shall include, among other information, the part descriptions, quantity, the total order price, tracking numbers, order date, shipping date, billing information, shipping information, and payment method; and

(e) Order: Goods that Buyer has requested delivery of and are confirmed in Seller's packing list, Invoice, or by any other means, and which shall be subject only to Seller's Terms and Conditions unless otherwise specified in writing by Seller.

2. Offer

Seller's Terms and Conditions constitute an immediately acceptable offer to sell Goods to Buyer. Buyer shall be bound by Seller's Terms and Conditions upon purchase of Goods from Seller. Seller shall be bound by Seller's Terms and Conditions when Buyer's Order is received by Seller.

ANY TERMS PROPOSED IN BUYER'S ACCEPTANCE (WHETHER IT BE IN A PRINTED PURCHASE ORDER OR IN ANY OTHER WRITING, OR OTHERWISE) THAT DELETE, ADD TO, OR WHICH COULD IN ANY WAY BE CONSTRUED AS VARYING FROM OR CONFLICTING WITH THE TERMS AND/OR CONDITIONS STATED HEREIN, ARE HEREBY OBJECTED TO AND REJECTED. SUCH PROPOSED TERMS AND/OR CONDITIONS SHALL BE VOID AND THE TERMS AND CONDITIONS HEREOF SHALL CONSTITUTE THE COMPLETE AND EXCLUSIVE STATEMENT OF THE TERMS AND CONDITIONS OF THE CONTRACT BETWEEN BUYER AND SELLER AND MAY HEREAFTER BE MODIFIED ONLY BY WRITTEN INSTRUMENT EXECUTED BY AN AUTHORIZED REPRESENTATIVE OF SELLER.

IF SELLER'S TERMS AND CONDITIONS HAVE BEEN ISSUED BY SELLER IN RESPONSE TO AN OFFER MADE BY BUYER, AND IF ANY OF SELLER'S TERMS AND CONDITIONS ARE ADDITIONAL TO OR DIFFERENT FROM BUYER'S TERMS AND CONDITIONS, THEN THE ISSUANCE OF SELLER'S TERMS AND CONDITIONS SHALL CONSTITUTE AN ACCEPTANCE OF BUYER'S OFFER, SUBJECT TO THE EXPRESS CONDITION PRECEDENT THAT BUYER ASSENT TO SUCH ADDITIONAL OR DIFFERENT TERMS AND ACKNOWLEDGE THAT SELLER'S TERMS AND CONDITIONS CONSTITUTE THE ENTIRE AGREEMENT BETWEEN BUYER AND SELLER WITH RESPECT TO THE SUBJECT MATTER OF BUYER'S OFFER. BUYER SHALL BE DEEMED TO HAVE ACKNOWLEDGED AND ASSENTED TO SELLER'S TERMS AND CONDITIONS UNLESS BUYER NOTIFIES SELLER IN WRITING WITHIN TEN (10) DAYS OF PLACING AN ORDER, WHICH IS SUBJECT TO SELLER'S TERMS AND CONDITIONS. BUYER AGREES THAT NO CONTRACT SHALL EXIST BETWEEN SELLER AND BUYER EXCEPT AS EXPRESSLY SET FORTH HEREIN.

3. Price and Specification

The selling price of each product is specified for each Order. Seller's product specifications and prices are subject to change without notice. For the most up-to-date information, please refer to the Seller's website: imscompany.com.

4. Sales Tax

Seller charges state and local sales tax for all sales unless Buyer has provided Seller with a Sales Tax Exemption Certificate. To receive an exemption, Seller must have a copy of an up-to-date Tax Exemption Certificate prior to Buyer placing an Order or sales tax will be added, without exception, to that Order. Seller may request a Tax Exemption Certificate from Buyer if Seller does not have one on file.

5. Disclaimer of Offer to Sell where Legally Prohibited

By placing an Order, Buyer represents to Seller that it has the authority to order and/or use the Goods purchased without violating any federal, state or local law. To the extent that any federal, state or local law precludes the sale and/or use of specific aerosols, chemicals or other products described on Seller's website or in Seller's catalog, Seller makes NO OFFER TO SELL such regulated Goods, nor does viewing Seller's webpage or receipt of Seller's catalog by Buyer constitute an offer to sell such Goods.

6. Delivery

Seller charges for shipping and handling on all Orders. Special delivery services are available for an additional charge; including a courier service, urgent delivery, prepaid freight and air, and 3-day-select shipment of aerosol/chemical products. All Orders are sold F.O.B. Seller's place of shipment. Time is not of the essence with respect to delivery dates. Also, unless otherwise notified, Seller may make a reasonable adjustment to the delivery date at its sole discretion. The acceptance of a shipment by Buyer shall constitute proper delivery. Unless otherwise specified in writing authorized by Seller, all charges, expenses or taxes associated with the delivery, including but not limited to, shipping and

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handling, charges for special delivery services, and for refused deliveries, shall be paid by the Buyer; unless Buyer's refusal is for damaged Goods (see Returns, ¶7). Freight charges for refused shipments will be charged to Buyer. Buyer can get shipping information, including C.O.D. charges, freight charges, and special services by calling IMS Technical Sales/Service Team at (440) 543-1615 or (800) 537-5375. Seller requests that Buyer call for additional details.

Seller recommends that Buyer's receiving personnel ask for a redelivery rather than refusing a shipment on the first day if the shipment cannot be identified, or if there is no payment ready for a C.O.D., etc. (UPS will make three delivery attempts before returning a package to Seller). Buyer can receive additional shipping information, including C.O.D. charges, freight charges, and special services by calling Seller's Technical Sales/Service Team at (440) 543-1615.

7. Returns

Regardless of the nature of a return, Buyer shall call Seller before attempting to make the return in order to obtain a Return Authorization Number (R/A #). Buyers wishing to make a return may call Seller at (800) 537-5375 to coordinate Buyer's request. Requests for a return must be made to, and authorized by, Seller within 30 days after the Invoice Date. Returns requested more than 30 days after the Invoice Date will not be honored unless the request relates to a defective product as part of a warranty claim. Goods must be returned to and received by Seller within 30 days of the return authorization date.

Returned Goods must be in new and resalable condition, in its original packaging with all original accessories, manuals and warranty registration cards, etc. In addition, a return must be adequately packed. Buyer will be responsible for items damaged during return shipment. Goods approved for return must be sent standard ground freight prepaid. Seller will not pay for freight brokerage fees.

Seller may refuse to receive any returned Goods that are returned without a R/A # clearly noted on the package or shipping documents/label. Buyer assumes the responsibility to reconcile the returned freight cost. Seller will not issue credit for any used, damaged, or incomplete Goods or for Goods returned without a R/A #.

Any approved returns due to Buyer error, decision change, or any other customer/subjective reason will be subject to a 15% restocking charge. A defective product can be returned at any time within the product's warranty period, under the terms of Seller's Limited Warranty. Buyer must call for details to receive a R/A # BEFORE sending anything back.

Custom and/or made-to-order Goods of any kind, discontinued Goods, and any special sale or promotional Goods cannot be returned for any reason unless defective or agreed to in writing by Seller.

If a return is needed for a repair or warranty claim, Buyer must call Seller for information and a R/A #. If a return relates to a repair, Seller will contact the Buyer and quote a price before a repair is done. An inspection fee will be charged if the Buyer chooses not to have the necessary repairs made; unless the customer immediately places an order to purchase a new replacement item that directly replaces the inspected item.

8. Free Testing Service

Seller provides free testing as a service to help Buyers choose IMS's products best suited to their needs. Buyer shall provide a sample on which Seller can test the Goods. Buyer's use of this testing service may prevent returns. In order to utilize testing service, Buyer must call Seller's Sales/Service Team for information; and to receive a R/A # for the sample.

9. Export Shipments

"Exports" shall be defined as shipments to Buyers located outside the United States. For Buyers who are export customers, all amounts, including freight and insurance, shall be required in advance for all Exports. This pre-payment may be waived for Buyers who are existing and established export customers. Foreign Buyers with an established open account can maintain that status as long as all Invoices are paid within 30 days. New accounts may be opened for foreign Buyers when a corporate guarantee from a U.S. parent company, four U.S. trade references, bank references and appropriate financial data are supplied and approved by IMS. Payment on open accounts is required in U.S. funds. Export crating or packaging will be an additional charge (time and materials) on some items if required.

10. Risk of Loss and Damage/Transfer of Title

The risk of loss or damaged Goods passes to Buyer upon shipment of Goods as specified herein. Title to Goods shall pass to Buyer upon receipt of valid payment by Seller.

11. Changes

Seller may at any time change the method of shipment or the manner of packing the Goods ordered. If any change causes an increase or decrease in cost of, or time required for performance, an equitable adjustment shall be made in price or delivery schedule or both. No claim by Buyer for adjustment shall be allowed unless made in writing within 20 days from the date notice of such change is received by Buyer.

12.Limited Warranty

All Seller's auxiliary and testing equipment are warranted to be free of defective material or workmanship for a period of 2 years from the date of shipment from Seller; unless a different warranty term is specified in writing by Seller, without limitation, in its catalog or product manuals. All basic consumables, including, but not limited to, consumable machinery components and commodity items including, but not limited to, fuses, heater bands, immersion heaters, elements, brushes, belts, O-rings and otherwise renewable parts shall be warranted against defects for a period of 90 days from the date of purchase. If any product is found by Seller to

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be defective, Seller's sole obligation under this limited warranty shall be, at its option, the repair or replacement of such product or any part(s) thereof, at no charge to Buyer. Seller's limited warranty does not cover, and Seller EXPRESSLY DISCLAIMS AND WARRANTS with respect to, any defect, failure, deficiency or error which is: *see next page* (a) not reported to Seller within the applicable warranty period and returned to Seller within 30 days of notification of Buyer's warranty claim; (b) due to product modification, abuse, misuse, improper storage, unauthorized repair or maintenance or abnormal conditions of temperature, humidity, dirt or corrosive matter; (c) due to the application of the product, either intentional or otherwise, in an improper manner; or (d) due to normal wear and tear of the product or any part(s) thereof. For processing a warranty claim, see instructions under Returns, ¶7.

SELLER'S LIMITED WARRANTY IS IN LIEU OF AND EXCLUDES ANY AND ALL OTHER WARRANTIES REGARDING PRODUCTS, EXPRESS OR IMPLIED, INCLUDING, WITHOUT LIMITATION, THE IMPLIED WARRANTY OF MERCHANTABILITY, THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE, IMPLIED WARRANTIES AGAINST DEFECTS IN DESIGN, MATERIALS AND WORKMANSHIP, AND THE WARRANTY AGAINST REDHIBITORY DEFECTS. BUYER AGREES THAT THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE WARRANTIES CONTAINED HEREIN. BUYER WAIVES ALL OTHER CLAIMS AGAINST SELLER.

SELLER'S TOTAL LIABILITY RELATED TO ANY PRODUCT IS LIMITED TO THE REPAIR OR REPLACEMENT OF SUCH PRODUCT AND IN NO EVENT SHALL EXCEED THE PURCHASE PRICE OF SUCH PRODUCT PAID TO SELLER BY BUYER. SELLER SHALL NOT BE LIABLE FOR ANY INCIDENTAL, CONSEQUENTIAL, SPECIAL, INDIRECT OR EXEMPLARY DAMAGES ARISING OUT OF OR IN CONNECTION WITH THE PURCHASE, STORAGE OR USE OF THE PRODUCT, INCLUDING, BUT NOT LIMITED TO: (A) DAMAGES FOR LOSS OF USE, INCOME OR PROFIT; (B) LOSSES SUSTAINED AS A RESULT OF INJURY (INCLUDING DEATH) TO ANY PERSONS; AND/OR (C) DAMAGES TO PROPERTY, OTHER THAN THE PRODUCT.

13. Confidentiality and Proprietary Information

Seller retains ownership of all Proprietary Data and other information that may be disclosed or discoverable by Buyer in connection with the Order. "Proprietary Data" includes, but is not limited to, all design, engineering and technical information (whether patentable or not) and other information concerning Seller's trade secrets, customer lists and specification for Goods.

14. Patent, Trademark and Copyright

Buyer agrees to indemnify and hold harmless Seller from and against any and all losses, costs, damages and expenses, including any and all attorneys' fees, for any infringement or alleged infringement of any U.S. or foreign patent, trademark or copyright by reason of the sale or use of any Goods sold to Buyer. Seller will promptly notify Buyer of any claim for infringement and cooperate, at Buyer's request, in the defense thereof.

15. Credit and Payment Policy

(a) Requests for Open Credit. Seller offers 30-day-net credit terms to customers with approved credit. To apply for credit, all interested parties must complete a credit application with Seller, provide trade references with fax numbers and emails, and sign page 2 of the credit application. Once complete, the credit application can be emailed to credit@imscompany.com or faxed to (440) 543-1070. Upon approval of credit application by Seller, a credit limit will be established by Seller and the customer will be notified that the account is open with net 30 day terms.
Any Buyer who has not placed any orders within the most recent 36-month period is considered an Inactive Buyer. An Inactive Buyer may place an Order, but shall first resubmit a new credit application and be approved by Seller. Upon approval of Buyer's new credit application by Seller, a credit limit will be established and Buyer will be notified that the account is open with Net 30 day terms.
If any Order exceeds a Buyer's existing credit limit, Seller's credit department may request updated credit information from Buyer or run a D&B report. If approved, Buyer's credit limit will be raised accordingly and the Order will be released. If not approved, Seller may cancel Buyer's Order and allow Buyer to resubmit the Order when sufficient credit is obtained. The Buyer is liable for all collection expenses including any and all legal fees when outside debt collection efforts are required.

(b) Payment by Check. Buyer shall make check payable to IMS Company. Buyer shall send checks to:
IMS Company
P.O. Box 75799
Cleveland, Ohio, 44101-4755

There will be a $30.00 charge assessed to Buyer for insufficient funds to Seller.

(c) Domestic Electronic (ACH) and Wire Transfer Policy. Buyer shall contact Seller for routing numbers for ACH and wire transfers. There is no charge for domestic electronic transfer (ACH). A charge shall be assessed to Buyer for any domestic and international wire transfers. The charge assessed will be a minimum of $15.00.

(d) Acceptable Advance Payment Methods for Exports. Foreign wire transfer (SWIFT) to Seller's bank are preferred for Exports and will help expedite shipment of an Order. Buyer shall pay any fees or deductions associated with such a wire transfer.

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Direct international transfers to:
Huntington National Bank
7 Easton Oval (EA2W47)
Columbus, Ohio 43219
Swift Address: HUNTUS33
Contact Seller for routing numbers.

(e) Payment by Credit Card. Seller accepts only VISA, MasterCard, American Express and Discover.

(f) Payment by International Money Orders. Seller generally accepts payment by international money order if approved by Seller's bank. Any fees charged to Seller related to payment by international money order shall be passed on to Buyer.

(g) Payment by Foreign Checks. Seller accepts payment by foreign check only if drawn in U.S. dollars on a U.S. bank. Buyer's Order will be processed only after final collection of funds covering Goods and all fees associated with the Order are paid by Buyer.

(h) Irrevocable Letters of Credit. Seller generally accepts payment by irrevocable letters of credit if approved by Seller's Bank. Buyer must pay all confirmation charges and other fees associated with payment by irrevocable letters of credit.

16. Shipment of Catalogs to Potential Foreign Customers

Catalogs will be shipped to foreign customers only if the foreign customer's Federal Express, DHL, United Parcel Service, or other acceptable freight account number can be utilized.

17. Compliance with Laws

Buyer warrants that by placing an Order with Seller it will comply with all applicable federal state and local laws, rules, regulations or orders, and the same shall be deemed incorporated herein by this reference. Such reference includes, but is not limited to, applicable requirements of Federal Acquisition Regulations, Consumer Products Act, the Electronic Signatures in Global and National Commerce Act, the Occupational Safety and Health Act, Toxic Substances Control Act, the Fair Labor Standards Act, Workers' Compensation laws, the U.S. Department of Labor, EEOC, the Civil Rights Act of 1964 and Executive Order 11246, all of which may be amended from time to time. Upon Seller's request, Buyer will furnish Seller with certification of compliance with the foregoing.

18. Enforceability of Electronic Signature and Records

By agreeing to Seller's Terms and Conditions, Buyer also agrees that information relating to any transaction with Seller (the "Record") may be provided to Buyer in electronic form. For all Orders placed, an electronic Record will be sent to Buyer via email for Buyer's reference after the Order is shipped. Buyer has the option to withdraw consent to receiving the Record in electronic form and may choose to receive the Record in paper or other non-electronic form for each Order. Choosing to receive the Record in non-electronic form may result in Buyer being charged reasonable costs or fees associated with production of the non-electronic Record and Seller may choose to terminate its relationship with Buyer. Buyer's consent to receive an electronic record shall apply to all future orders unless Buyer informs Seller in writing of its decision to receive the Record in a non-electronic form and provides Seller with updated contact information for non-electronic delivery of the Record to Buyer.

19. Assignment

Except as otherwise provided, Seller's Terms and Conditions shall be binding upon and inure to the benefit of the parties' successors and lawful assigns.

20. Severability

The invalidity of any part of Seller's Terms and Conditions shall not affect the remaining provisions.

21. Limitation of Period for Action on Contract

Parties agree, notwithstanding the applicable statute of limitations prescribed under Ohio law, no action, regardless of form, arising out of any transaction between Buyer and Seller under these Terms and Conditions may be brought by Buyer more than one year after the cause of action has accrued.

22. Choice of Law

Seller's Terms and Conditions, or any contract based hereon and any question with respect to the construction, interpretation or performance hereof shall be governed by and determined in accordance with the laws of the State of Ohio.

23. Consent to Jurisdiction and Venue

Seller and Buyer agree that any dispute arising in relationship to Seller's Terms and Conditions or any contract created between them, shall be resolved in the Court of Common Pleas located in Geauga County, Ohio, and in the Federal District Court for the Northern District of Ohio, Eastern Division, and that no action shall be filed in any other court pertaining to any dispute arising out of, or connected to Seller's Terms and Conditions. Seller and Buyer also hereby waive any issues of personal jurisdiction or venue for purposes of carrying out this provision.

24. Entire Agreement

Seller's Terms and Conditions and the operative provisions of any Invoice issued by Seller, sets forth the entire agreement and understanding among the parties as to the subject matter hereof, and merges and supersedes all prior discussions, agreements, and understandings of every kind and nature among them.

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IMS Company

10373 Stafford Road Chagrin Falls, OH 44023-5296
Tel: 440.543.1615 Fax: 440.543.1070
Toll-Free Tel (USA & Canada): 800.537.5375
Toll-Free Tel (Mexico): 001.888.304.1307
Toll-Free Fax (USA & Canada): 888.288.6900

Tech-Support Hot Line Toll-Free Tel
(USA & Canada): 866.467.9001

Online Catalog:
www.imscompany.com

E-mail: credit@imscompany.com

Business Credit Application

(Confidential)

Please complete, sign and send the IMS credit application to credit@imscompany.com if you have a standard sheet with your company's credit information, including references, you can send it in lieu of completing the trade reference section.

Company Name: _____ Date: _____

Billing Address:

_____ City: _____ State: _____ Zip:_____

Accounts Payable Contact: _____ Accounts Payable Phone: (____) _____

Accounts Payable E-mail: _____ Accounts Payable Fax: (____) _____

Shipping address:

_____ City: _____ State: _____ Zip:_____

Phone: (____) _____ Fax: (___) _____ E-mail:_____

Business Organization: Proprietorship ❑ Partnership ❑ Corporation ❑

If Incorporated: State of Inc.: _____ Year of Inc.: _____ NAICS code: _____

Type of Business: Manufacturing ❑ Resale ❑ (provide resale certificate)

Owner or key management members:

Name: _____ Last 4 of SS#: _____

Date business established:_____ Years at present location: _____ # of employees:_____

D&B #: _____ Tax I.D. #: _____ - _____ - _____

If any bankruptcy, please provide date(s): _____

Sales Tax Exemption # (if applicable): _____ **(copy of certificate required)**

Banking Information:

Bank Name: _____ Branch Name: _____

Routing #: _____ Account #: _____

Contact Name: _____ Phone: (_____)_____

Address:

_____ City: _____ State:_____ Zip: _____

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Business Credit Application

(Confidential)

Please Send Completed Credit Application to credit@imscompany.com

Trade References (Preferably U.S. Accounts)**:**

1. Name: _____ Acct#: _____ Phone:(_____) _____

E-mail: _____ Fax:(_____) _____

Address:_____ City: _____ State:_____ Zip: _____

2. Name: _____ Acct#: _____ Phone:(_____) _____

E-mail: _____ Fax:(_____) _____

Address:_____ City: _____ State:_____ Zip: _____

3. Name: _____ Acct#: _____ Phone:(_____) _____

E-mail: _____ Fax:(_____) _____

Address:_____ City: _____ State:_____ Zip: _____

❑ **I have read, understand and accept IMS Company Terms and Conditions of Sale**

Officer's Consent:

I/we authorize the creditor to make whatever inquiries are necessary in connection with this credit application or in the course of the review or collection of any credit extended. I/we authorize any person or consumer reporting agency to compile and furnish to the lender any information in response to credit inquiries and agree that this information shall remain your property whether or not credit is extended. All information on the application is true and for the purpose of obtaining the credit requested.

Printed Name: _____ Date: _____

Signature: _____ Title: _____

Printed Name: _____ Date: _____

Signature: _____ Title: _____

Company terms of Net 30. A credit limit will be set at the discretion of IMS Company. A credit application may be denied if the customer's credit references, payment history or financial records indicate any potential difficulty in meeting IMS Company's payment policy.

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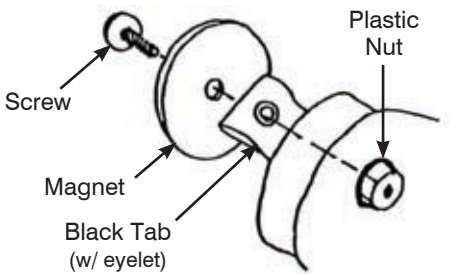
TIE BAR SLEEVES

Keep tie bar grease in / Keep abrasive airborne particles out

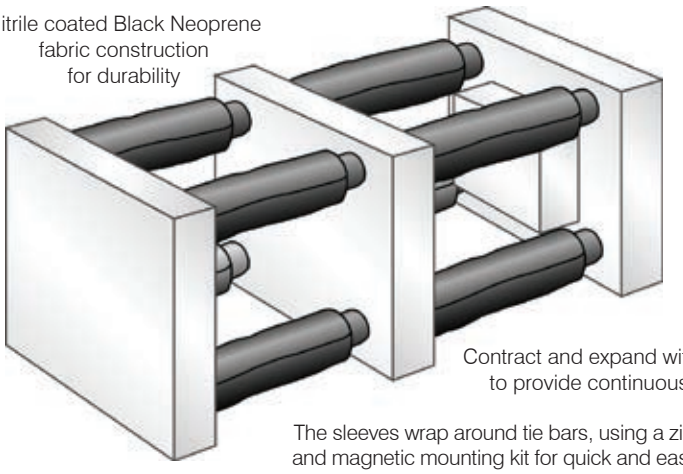
Made in the U.S.A

Easy Installation

Magnetic Mounting Kit



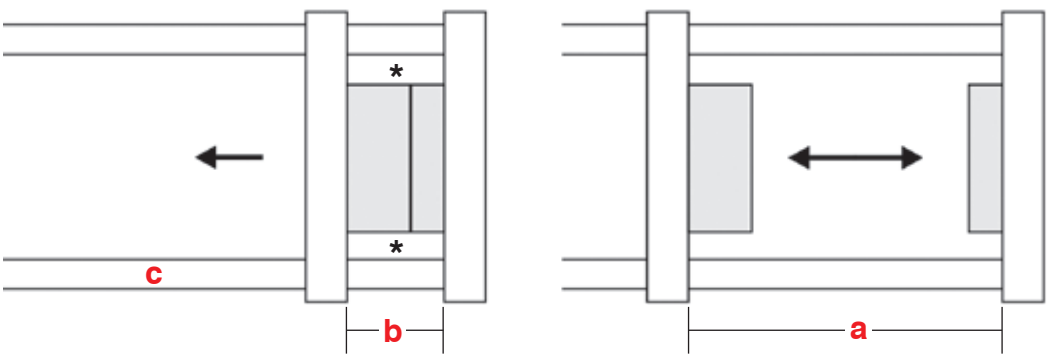
Nitrile coated Black Neoprene fabric construction for durability



Contract and expand with mold stroke to provide continuous protection

The sleeves wrap around tie bars, using a zipper, Velcro® and magnetic mounting kit for quick and easy installation.

Custom Made To Any Tie Bar Diameter And Length



*1½" clearance required between mold and tie bar.

Mold closed min. platen to platen

Mold opened max. platen to platen

Specify:

a. Mold Open: _____

b. Mold Closed: _____

c. Tie Bar Diameter: _____

d. Quantity: _____

max open length = 3X closed length (max ratio = 3:1)

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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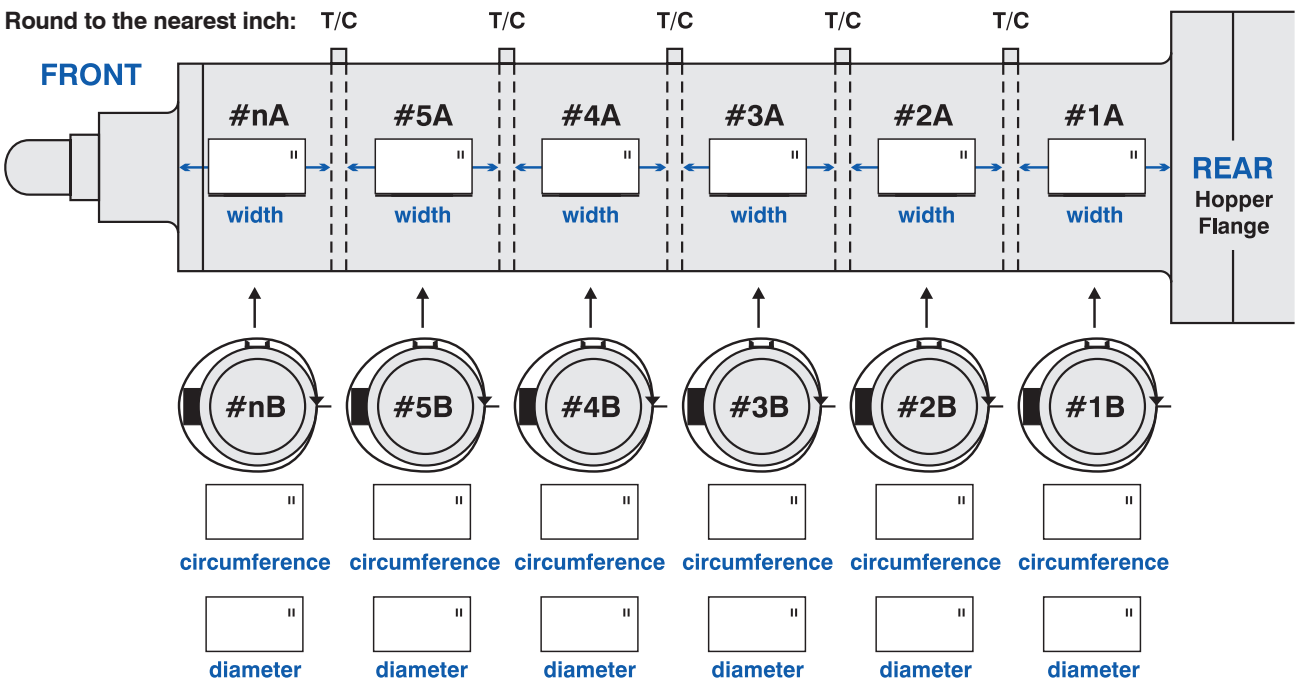
Custom UniVest® Barrel Insulation Form

Measuring Procedure (in inches):
Use form below

- The hopper is at the rear of the machine.
- Measure parts of the barrel from the operator's side, starting from the rear.
- Measure from face of the hopper flange to first thermocouple – round to closest whole inch and write it down on the form.
- Continue to measure from thermocouple to thermocouple, moving from rear to front.
- The front blanket width will end with the large diameter barrel (the start of the nozzle adapter).
- Measure the circumference of the barrel for each of the widths identified below. Include all obstructions and projections, such as a junction box. Write this in the Circumference box below.
- Divide the circumference by 3.141 to get the barrel outside diameter. This is the I.D. (inside diameter) of the UniVest® Barrel Insulation.
- Write the I.D. in the diameter box below.

UniVest® is a registered trademark of UniTherm Insulation Systems



	Brand	oz./ton	Press#
Injection			
Extrusion			
Blow Mold			
Other			

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

www.imscompany.com phone order toll-free (USA & Canada) **1.800.537.5375**

fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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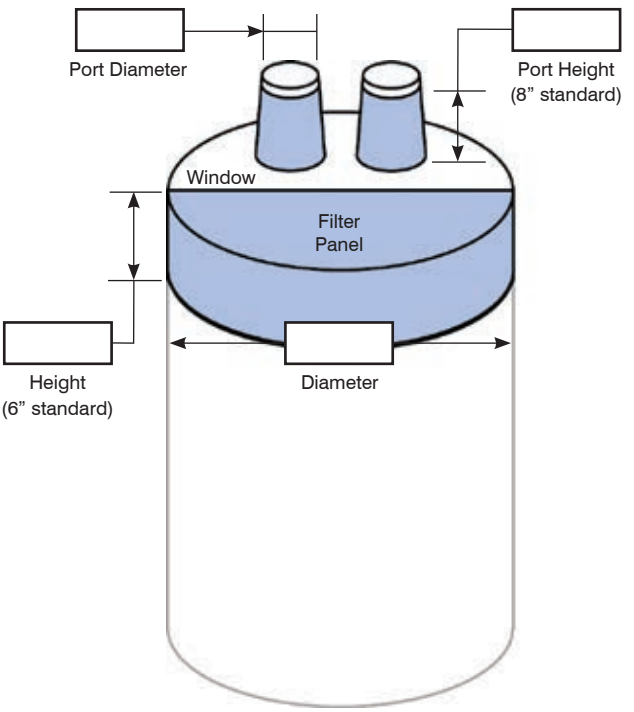
Custom Drum Cover Form

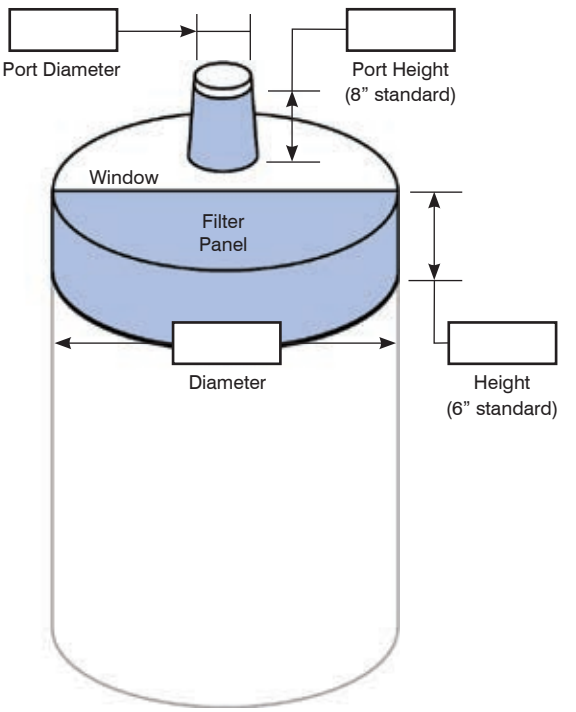
Fill in the appropriate dimension blanks

DP Style
(Featuring Two Ports)



DP Style Quantity: ___

DN Style
(Featuring One Port)



DN Style Quantity: ___

Specify:

1.Color ❑ Blue or ❑ Brown

Please enclose a drawing if more custom items are needed.

If you would like your logo silk screened in lieu of the IMS Logo please provide art file (JPEG, EPS or TIFF) —

Minimum Order Quantity: 25
Price: $150 for 1 color / Additional $25 for PMS color matching / Additional $6 per location for 2 color print
Lead Time required — Call for details
Contact the IMS Supplies Team at **sales@imscompany.com** for details.

Date:_____ Quantity:_____ Phone:(_____)_____ Fax: (_____)_____

Name:_____ Title:_____

Company Name: _____ Email: _____

Address:_____

City: _____ State: _____ Zip:_____

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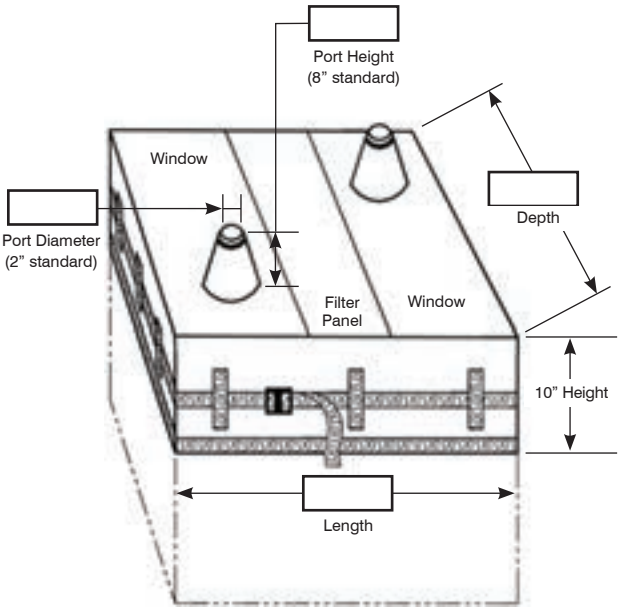
Custom Gaylord Cover Form

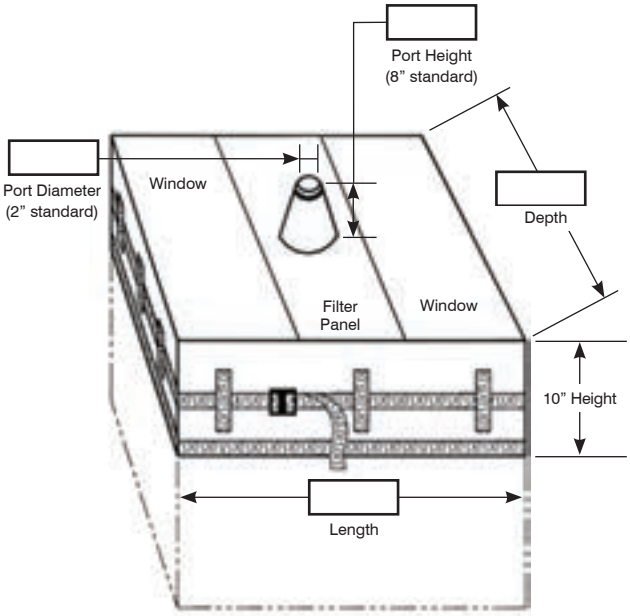
Fill in the appropriate dimension blanks

Negative Pressure - GN
(Used for Withdrawal)



GN Style Quantity: _____

Positive Pressure - GP
(Used for Filling)



GP Style Quantity: ___

Specify:

1. **How many ports?** _____
2. **Location of Ports:** _____
3. **Are you** ❑ **Filling or** ❑ **Withdrawing Material?**

If Filling:

1. **Blower Size:** _____
2. **Blower Air Output:** _____
3. **Other Filling Type:** _____

Please enclose a drawing if more custom items are needed.

If you would like your logo silk screened in lieu of the IMS Logo please provide art file (JPEG, EPS or TIFF) —
Minimum Order Quantity: 25
Price: $150 for 1 color / Additional $25 for PMS color matching / Additional $6 per location for 2 color print
Lead Time required — Call for details
Contact the IMS Supplies Team at **sales@imscompany.com** for details.

Date:_____ Quantity:_____ Phone:(_____)_____ Fax: (_____)_____

Name:_____ Title:_____

Company Name: _____ Email: _____

Address:_____

City: _____ State: _____ Zip:_____

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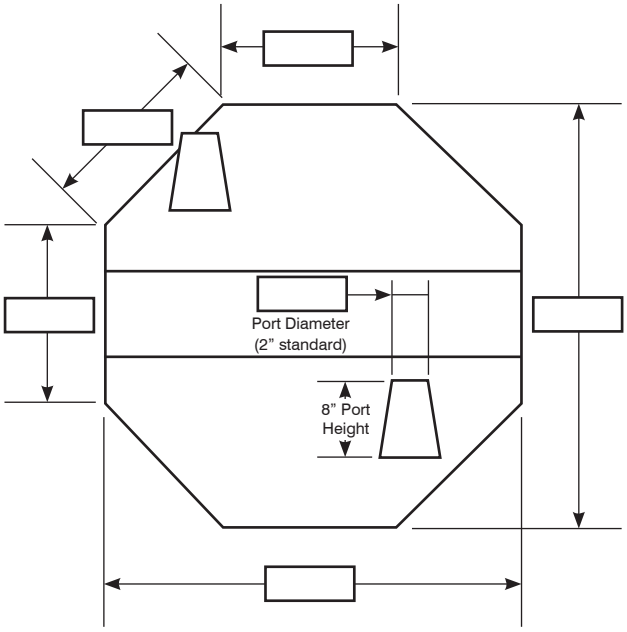
Custom Octagon Gaylord Cover Form

Fill in the appropriate dimension blanks

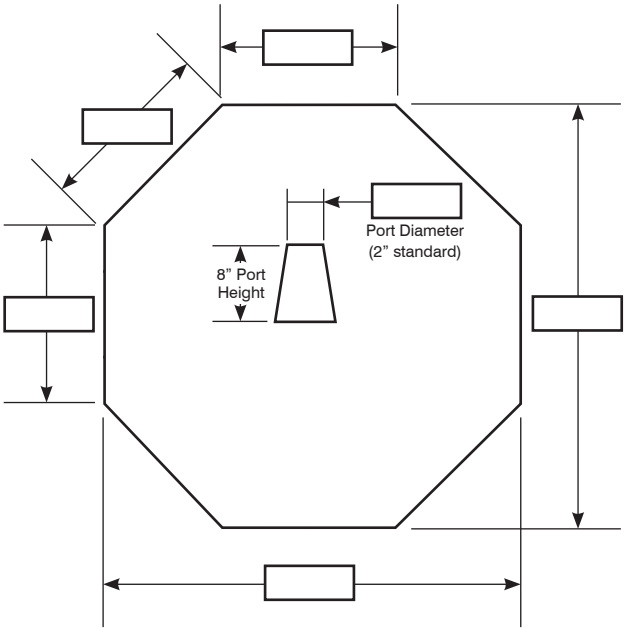
Negative Pressure
(Used for Withdrawal)



Quantity: ____

Features: Two access ports 2" in diameter and 8" tall (standard height). Breathable filter panel and two vinyl windows for quick visual level checks. The skirt is 10" long and has an elastic band and belt with buckle to hold the cover securely in place.

Positive Pressure
(Used for Filling)



Quantity: ____

Features: One center port 8" tall (standard height). Breathable filter panel and two vinyl windows for quick visual level checks. The skirt is 10" long and has an elastic band and belt with buckle to hold the cover securely in place.

Ports can be located elsewhere if needed — please mark the appropriate drawing above if you prefer this option

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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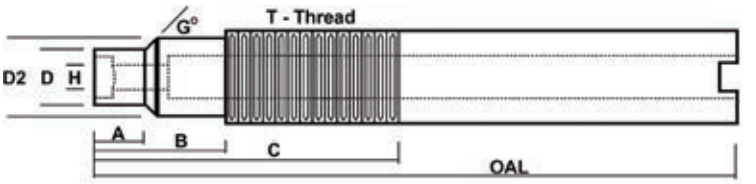
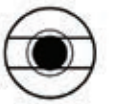
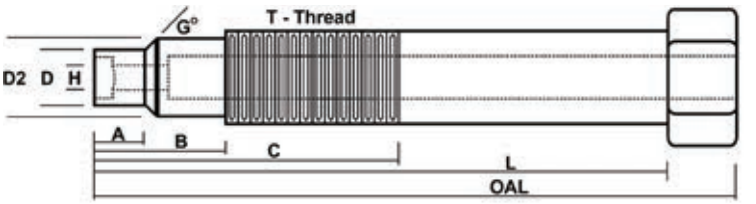
Custom Melt Pressure Extruder Rupture Disk Quote Form

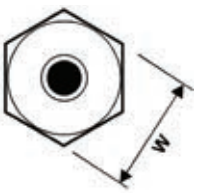
SCREWDRIVER SLOT STYLE



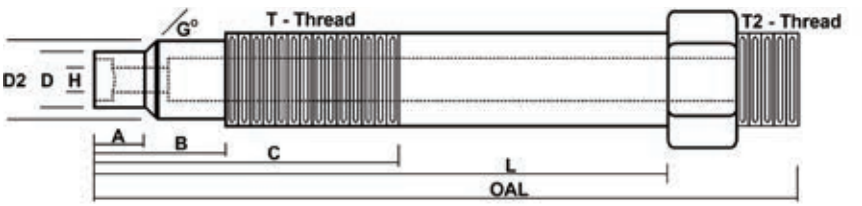


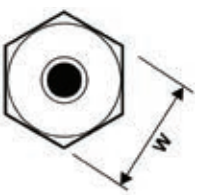
HEX HEAD STYLE



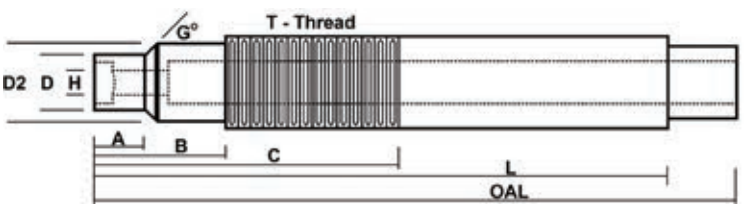


NPT THREAD STYLE





FLAT END STYLE



SPECIFY

1. Style: ❑ Screwdriver Slot ❑ Hex Head ❑ NPT Thread ❑ Flat End
2. Body Material: ❑ 304 Stainless Steel ❑ Other _____
3. Disc Material: ❑ Inconel ❑ Other _____
4. Pressure Rating : _____ PSIG @ _____ °F
5. Dimensions:
   H _____ D _____ D2 _____ A _____ B _____ C _____
   L _____ OAL _____ W _____ G _____ T _____ T2 _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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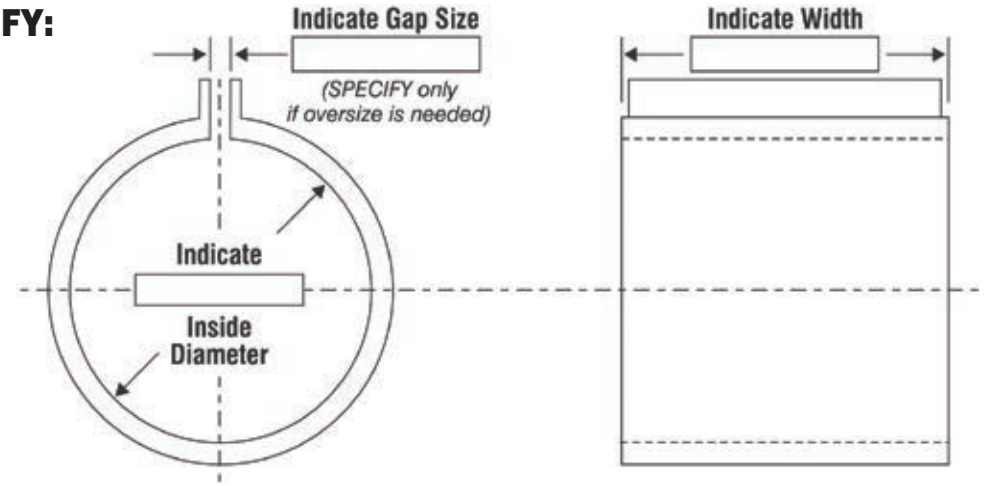
Non-Stock Heater Band Form

SPECIFY:



A good rule of thumb for figuring the maximum available heater band wattage: 3.14 x band I.D. x band width x 35

Quantity: _____

Mfg. *(if known)*: _____

Mfg. Part No. *(if known)*: _____

Wattage: _____

Voltage: _____

Type: Nozzle Band O Plastic Proof O
Key Lock O High Watt Density O
Adjustable I.D. O

Construction

One-Piece o Two-Piece o

Other (describe): _____

_____

Insulation

Mica ❑ Compacted Mineral ❑ Ceramic ❑

Lock-up

Flange ❑* Strap ❑* Key (Wedge) ❑
Barrel Nut ❑

* Standard Screws ❑ Spring Bolts ❑

Other (describe): _____

_____

_____

Electrical Connections/Terminations

Select One Only

NOTE
Illustrate location of connection on diagrams above.

Flex Leads: ❑ ____ long
Flex Leads with Armor Sleeving: ❑ ____ long
Flex Leads with Braided Wire Sleeving: ❑ ____ long

OR

Post Terminals: ❑

Post Terminals with Terminal Box: ❑

Post Terminals with Voltraps: ❑

Post Terminals with Terminal Caps: ❑

• • •

Plug Connector (Blade): ❑

Plug Connector (European): ❑

Expedited 24-48 Hour Service: ❑

Special

For holes, cut-outs and notches,
indicate size and location on drawings above.

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Custom Strip Heater Form

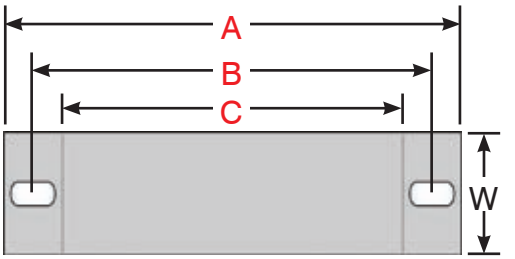
SPECIFY: o MICA OR o CERAMIC

MICA DIMENSIONS

Length (A): _____
2-½" MIN

Length (B): _____

Length (C): _____



CERAMIC DIMENSIONS

Length (A): _____
4" MIN

Length (B): _____

Length (C): _____

Width: ❑ ¾" ❑ 1" ❑ 1-½" ❑ 2"

Thickness: ❑ ¼" ❑ 5/16"

Mounting Slot/Hole: ❑ ¼" x ⅜" (Standard)
❑ Custom
Specify: _____

Width: ❑ 1" ❑ 1-½"

Thickness: ❑ ¼" ❑ 5/16" ❑ ⅜"

Mounting Slot/Hole: ❑ 5/16" x ½" (Standard)
❑ Custom
Specify: _____

Mounting Tabs:
❑ Yes ❑ No

Voltage: _____ **Wattage:** _____

Post Terminals Styles:

❑ 1
(**Mica:** 3/4" MIN Width) (**Ceramic:** 1" MIN Width)

❑ 2
(**Mica:** 1-1/2" MIN Width) (**Ceramic:** 1-1/2" MIN Width)

❑ 3
(**Mica:** 1" MIN Width) (**Ceramic:** 1" MIN Width)

❑ 4
(**Mica:** 2" MIN Width) (**Ceramic:** 1-1/2" MIN Width)

OR

Lead Locations:

(**Mica:** 3/4" MIN Width)
(**Ceramic:** 1" MIN Width)

(**Mica:** 1" MIN Width) (**Ceramic:** 1-1/2" MIN Width)

12" Leads standard o Other / Specify: _____

OPTIONS:
❑ Stainless steel braid over leads
❑ Flexible armor over leads
❑ Strain relief bracket
❑ T/C hole (indicate location on drawing)
❑ Appliance pins

❑ Dual voltage
Specify: _____
❑ Grounding stud
❑ Other
Specify: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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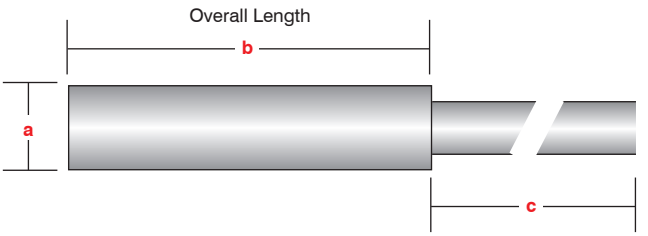
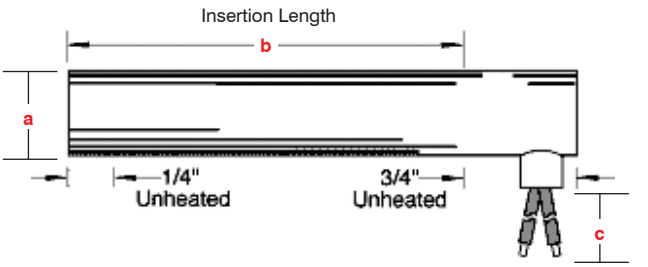
Non-Stock Cartridge Heaters

SPECIFY:

Standard



Right Angle



Style: ❑ Standard ❑ Right Angle

a) Outside Diameter: _____

b) Overall or Insertion Length: _____

c) Lead Length: _____

Lead Type: _____

(Standard, stainless steel braided and armored available)

Voltage: _____

Wattage: _____

Built-in Type J Thermocouple? ❑ Yes ❑ No

Is Heater for an Internally Heated Nozzle? ❑ Yes ❑ No

Maximum Use Temperature: _____ ° F

24-48 Hour Expedite Service? ❑ Yes ❑ No

If the heater you need isn't in stock,
We'll have it made
And then get it to you in just
24-48 HOURS!
expedite charges apply

NOTE: In the manufacture of non-stock products, it is necessary to allow for losses in production. We reserve the right to ship the following variations in quantities.

Quantity Ordered	Shipping Variations
1-5	No variation
6-10	+/- 1 unit
11-25	+/- 2 units
26-50	+/- 3 units
51-75	+/- 4 units
76-99	+/- 5 units
100 +	+/- 5 Percent

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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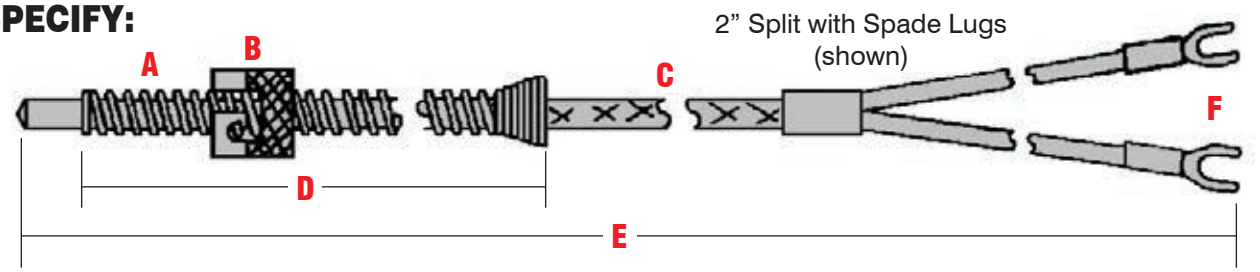
Non-Stock Spring Adjustable Immersion Thermocouples

SPECIFY:



Thermocouple Type: ❑ J ❑ K ❑ Other_____

Junction: ❑ Grounded ❑ Ungrounded

Conductor Wire: ❑ Solid ❑ Stranded

A) Tip and Spring O.D. (NOTE: Tip O.D. will indicate Spring O.D.)

Tip O.D.	Spring O.D.
❑ .125"	.203"
❑ .188"	.263"
❑ .250"	.324"

B) Bayonet Cap Style: ❑ 7⁄16" I.D. Single Slot (standard) ❑ 15 mm I.D. Dual Slot ❑ 12 mm I.D. Slot ❑ Positive Seat Indicating ❑ 12 mm O.D. Pin

C) Lead Type: ❑ Fiberglass Insulation ❑ Stainless Steel Braid ❑ Stainless Steel Armor

D) Spring Length: _____

E) Overall Length with Lead Wire Termination: _____

F) Terminations: ❑ Leads Not Stripped ❑ Standard Male Plug ❑ Mini Male Plug ❑ 2" Split, ¼" Stripped ❑ Standard Female Jack ❑ Mini Female Jack ❑ 2" Split with Spade Lugs ❑ 2" Split with ¼" Female Disconnects

Options: ❑ Mating Connector ❑ Cable Clamp ❑ Box Connector

If you have any questions, contact the IMS Supplies Team at sales@imscompany.com

Date:_____ Quantity:_____ Phone:(_____)_____ Fax: (_____)_____

Name:_____ Title:_____

Company Name: _____ Email: _____

Address:_____

City: _____ State: _____ Zip:_____

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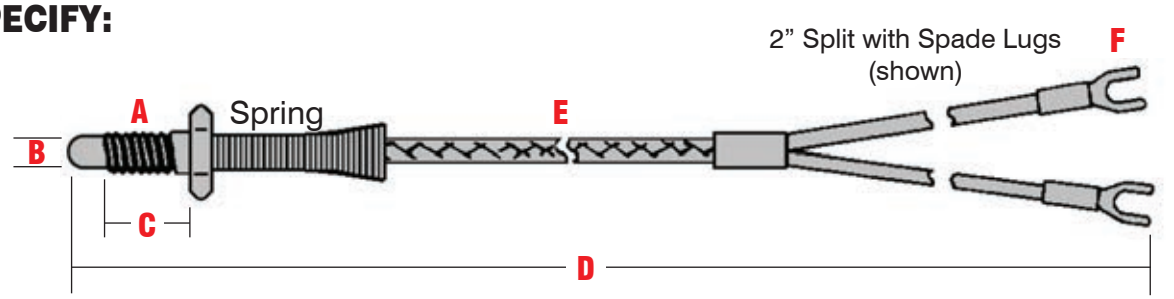
Non-Stock Threaded Nozzle Thermocouples

SPECIFY:



Thermocouple Type: ❑ J ❑ K ❑ Other_____

Junction: ❑ Grounded ❑ Ungrounded

Conductor Wire: ❑ Solid ❑ Stranded

A) Thread Size	**B) Tip O.D.**	**C) Thread Length** (NOTE: Thread Size will indicate Tip O.D. and Thread Length)
❑ ¼"-28	3⁄16"	3⁄8"
❑ 3⁄8"-24	¼"	½"
❑ 6mm X 1mm	3⁄16"	10mm
❑ 8mm X 1.25mm	¼"	10mm

D) Overall Length with Lead Wire Termination: _____

E) Lead Type: ❑ Fiberglass Insulation ❑ Stainless Steel Braid ❑ Stainless Steel Armor

F) Terminations: ❑ Leads Not Stripped ❑ Standard Male Plug ❑ Mini Male Plug
❑ 2" Split, ¼" Stripped ❑ Standard Female Jack ❑ Mini Female Jack
❑ 2" Split with Spade Lugs ❑ 2" Split with ¼" Female Disconnects

Options: ❑ Mating Connector ❑ Cable Clamp ❑ Box Connector

If you have any questions, contact the IMS Supplies Team at sales@imscompany.com

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Name:_____ Title:_____

Company Name: _____ Email: _____

Address:_____

City: _____ State: _____ Zip:_____

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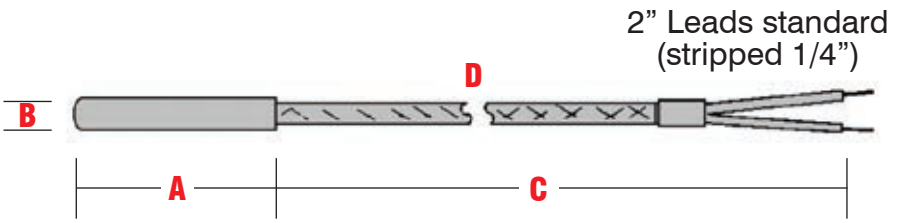
Non-Stock Cartridge Type Thermocouple

SPECIFY:



Thermocouple Type: ❑ J ❑ K ❑ Other ___

Junction: ❑ Grounded ❑ Ungrounded

A) Sheath Length: _____

B) Sheath Diameter: _____

C) Lead Length: _____

D) Lead Type: ❑ Stainless Steel Braid ❑ Stainless Steel Armor ❑ Other _____

E) Terminations: ❑ Leads Not Stripped ❑ Standard Male Plug ❑ Mini Male Plug
❑ 2" Split, ¼" Stripped ❑ Standard Female Jack ❑ Mini Female Jack
❑ 2" Split with Spade Lugs ❑ 2" Split with ¼" Female Disconnects

Options: ❑ Mating Connector ❑ Cable Clamp ❑ Box Connector

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Custom Mold and Cable Checkers Form

SPECIFY:

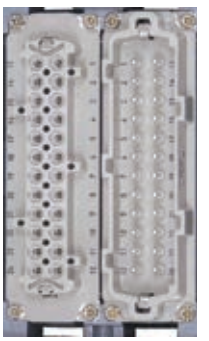
1. ❑ MoldXChecker™ ❑ CableXChecker™ 2. ❑ Single Latch ❑ Double Latch (Connector Hood)

3. Common Connector Styles:

10 HA - Male

10 HA - Female

32 HBE - Female/Male


48 HBE - Female/Male

32 EE - Male

32 EE - Female

46 EE - Male

46 EE - Female

Amphenol
Round Military Style - Male

Amphenol
Round Military Style - Male

Amphenol
Round Military Style - Female

Amphenol
Round Military Style - Female

6 HBS - Male

6 HBS - Female

25 HD
- Male

25 HD -
Female

40 HD - Male

40 HD - Female

64 HD - Male

64 HD - Female

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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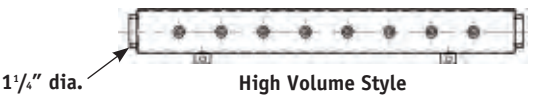
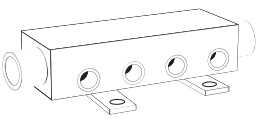
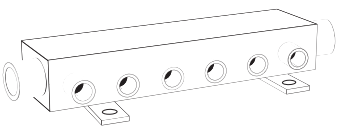
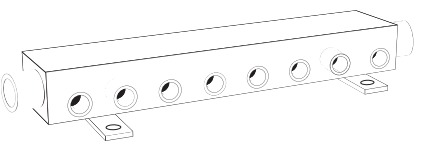
Manifold Styles

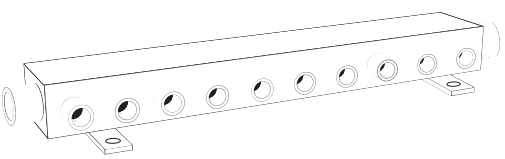


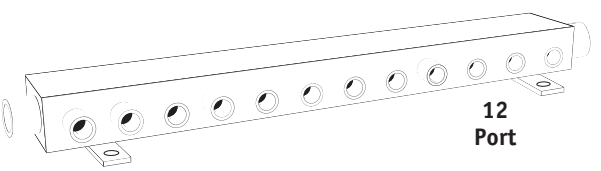
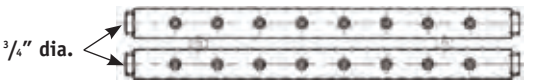
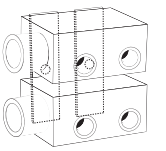
High Volume Straight-Through and Straight-Through Styles


4 Port

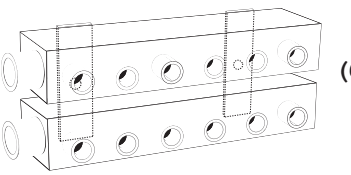

6 Port

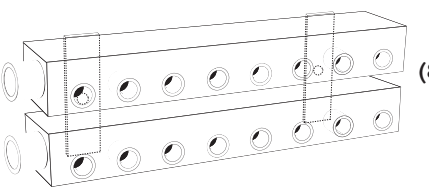

8 Port

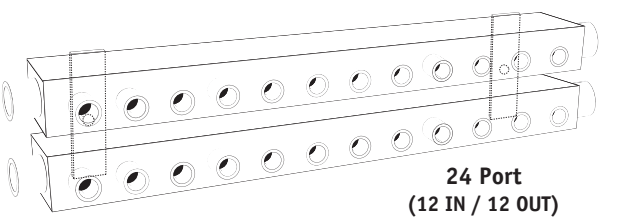

10 Port

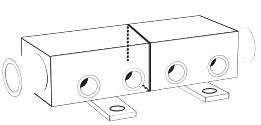

12 Port


4 Port (2 IN / 2 OUT)

Stacked Style

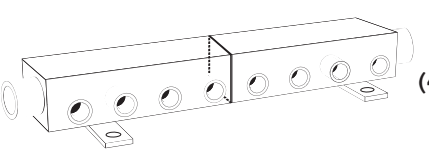

12 Port (6 IN / 6 OUT)

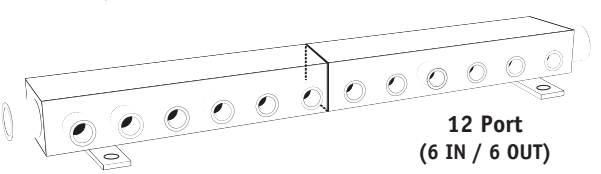

16 Port (8 IN / 8 OUT)

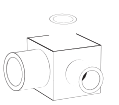

24 Port (12 IN / 12 OUT)


4 Port (2 IN / 2 OUT)

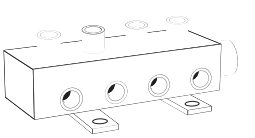
Split Bulkhead Style

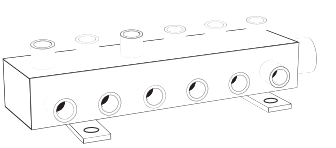

8 Port (4 IN / 4 OUT)

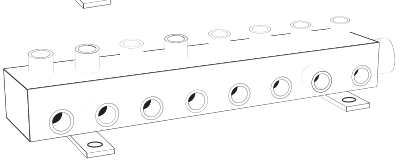

12 Port (6 IN / 6 OUT)


2 Port

Multiple Sided Port Locations


8 Port


12 Port


16 Port

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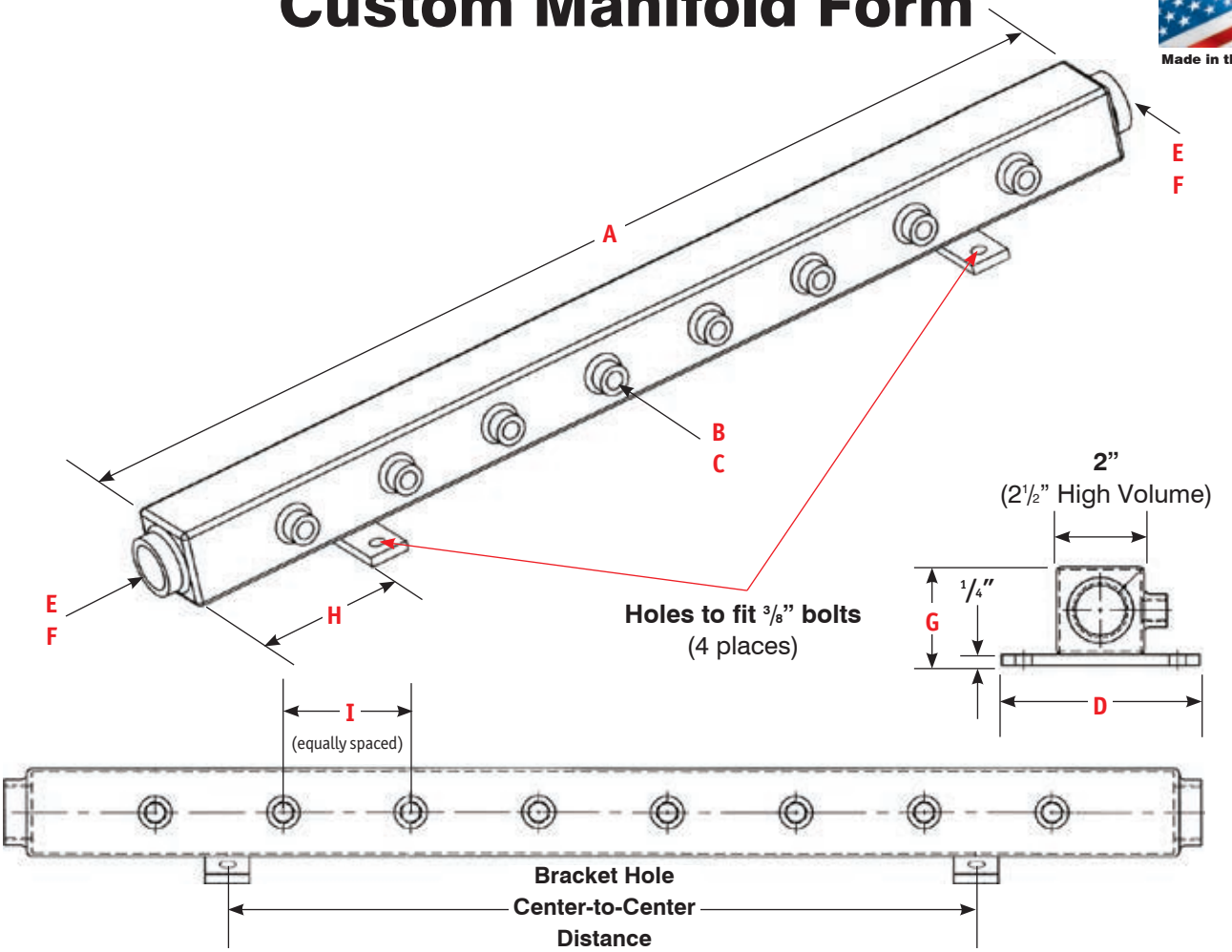
Custom Manifold Form

Made in the U.S.A



A) Overall Length: _____

B) Port Size (N.P.T.): _____ C) Number of Ports: _____

D) Width (includes mounting bracket): _____

E) Inlet/Outlet Size (N.P.T.): _____ F) Number of Inlet/Outlets: _____

G) Depth: _____ H) Mounting Bracket Distance: _____

I) Distance Between Ports (center-to-center): _____

J) Style: ☐ High Volume ☐ Straight-Through ☐ Split (Bulkhead) ☐ Stacked ☐ Multi-Sided Ports

K) Material: ☐ Stainless Steel ☐ Steel (Green) ☐ Steel (Custom Paint - Specify _____)

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Custom One-Piece Nozzle Form

SPECIFY:

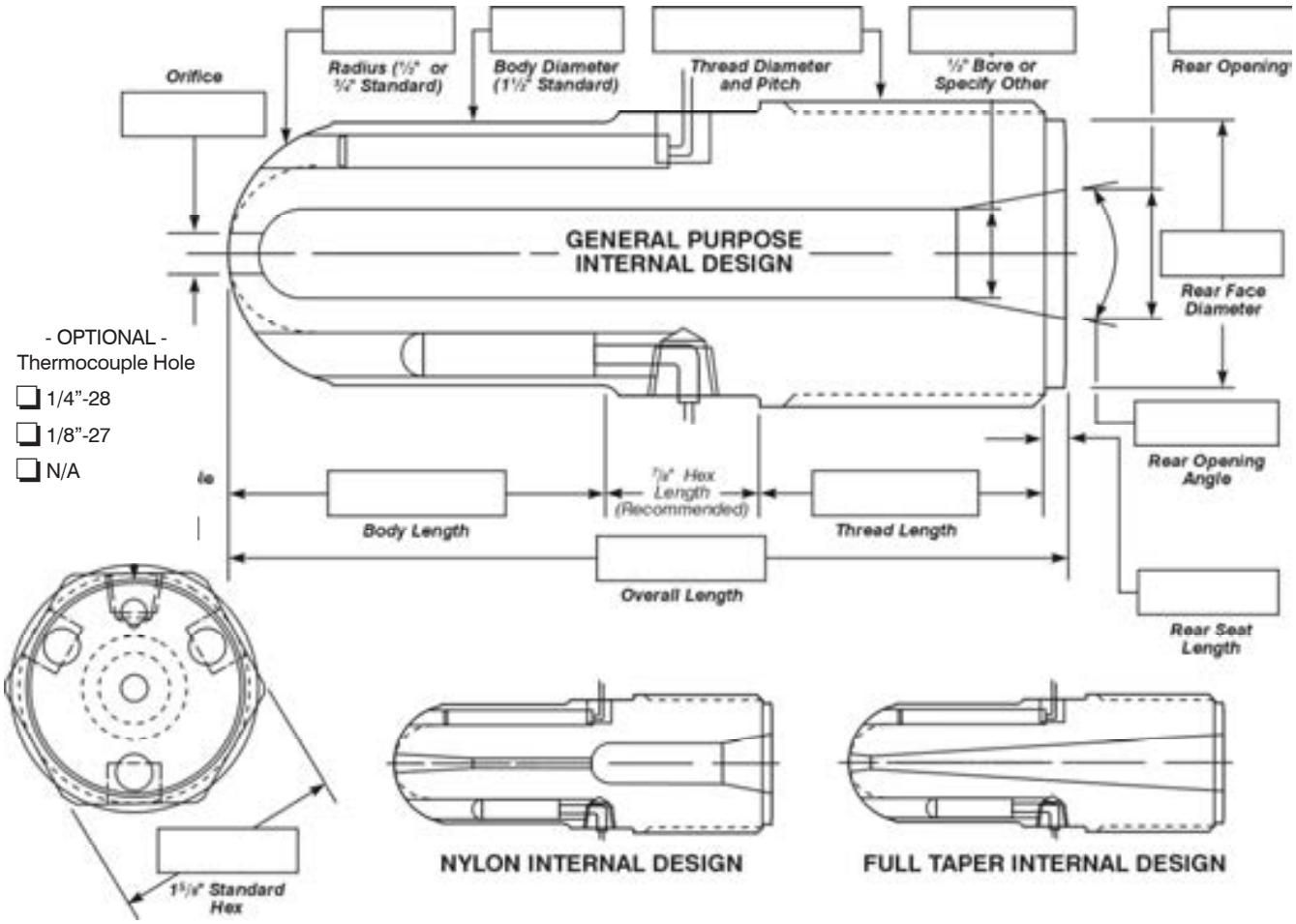
1. Internal Design:

❑ General Purpose ❑ Nylon ❑ Full-Taper

2. Heating:

❑ External

Fill in the following basic dimension blanks



Optional:

3. Press Make _____

and Model _____

4. Material To Be Molded _____

5. Operating Temperature _____

6. Thermocouple _____

Thread Size and Location _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Custom Removable Tip Nozzle Form

SPECIFY:

1. Internal Design:

❑ General Purpose ❑ Nylon ❑ Full-Taper

2. Heating:

❑ External

Fill in the following basic dimension blanks

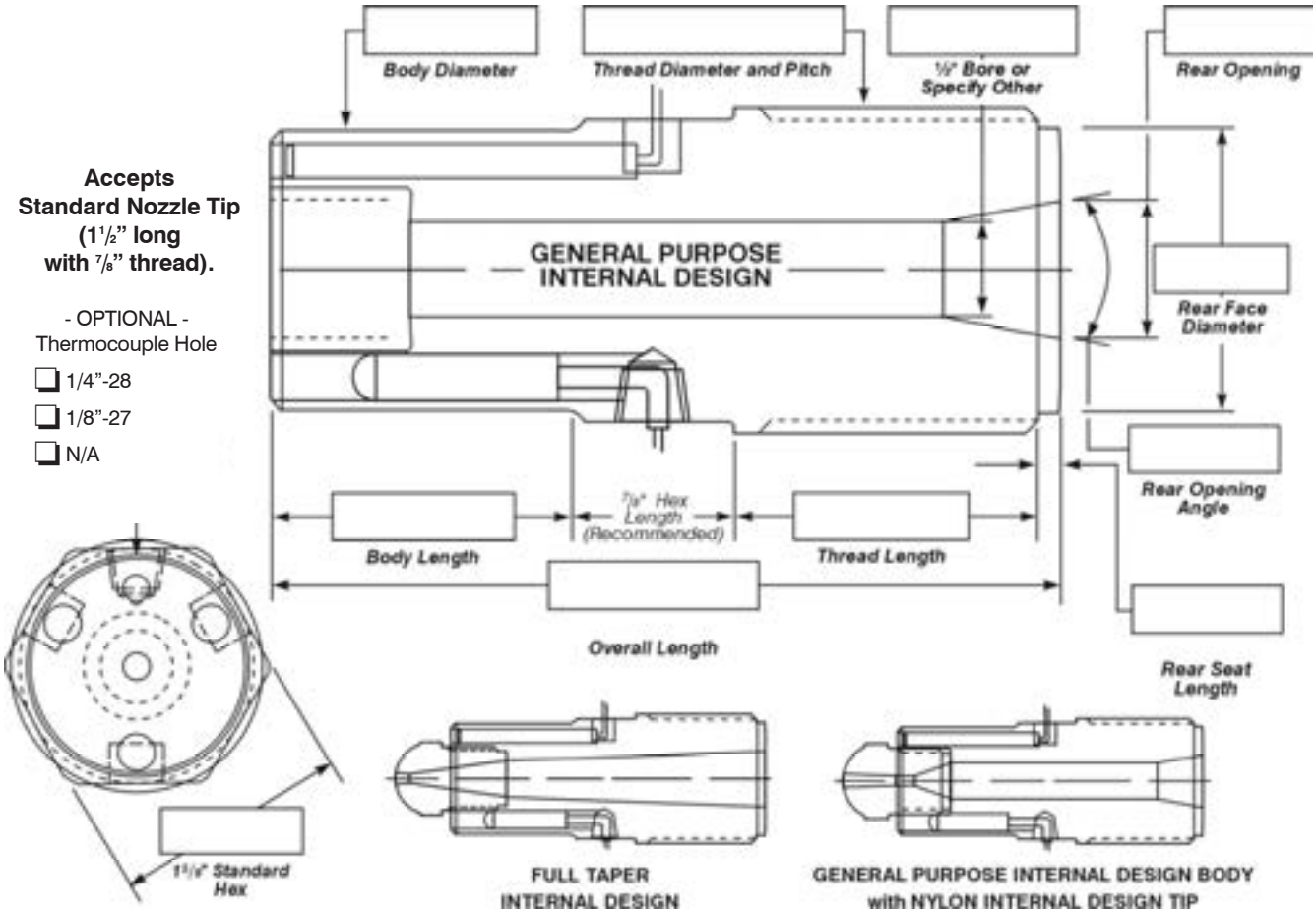
Accepts Standard Nozzle Tip (1½" long with ⅞" thread).

- OPTIONAL - Thermocouple Hole

❑ 1/4"-28

❑ 1/8"-27

❑ N/A



Optional:

3. Press Make _____

and Model _____

4. Material To Be Molded _____

5. Operating Temperature _____

6. Thermocouple _____

Thread Size and Location _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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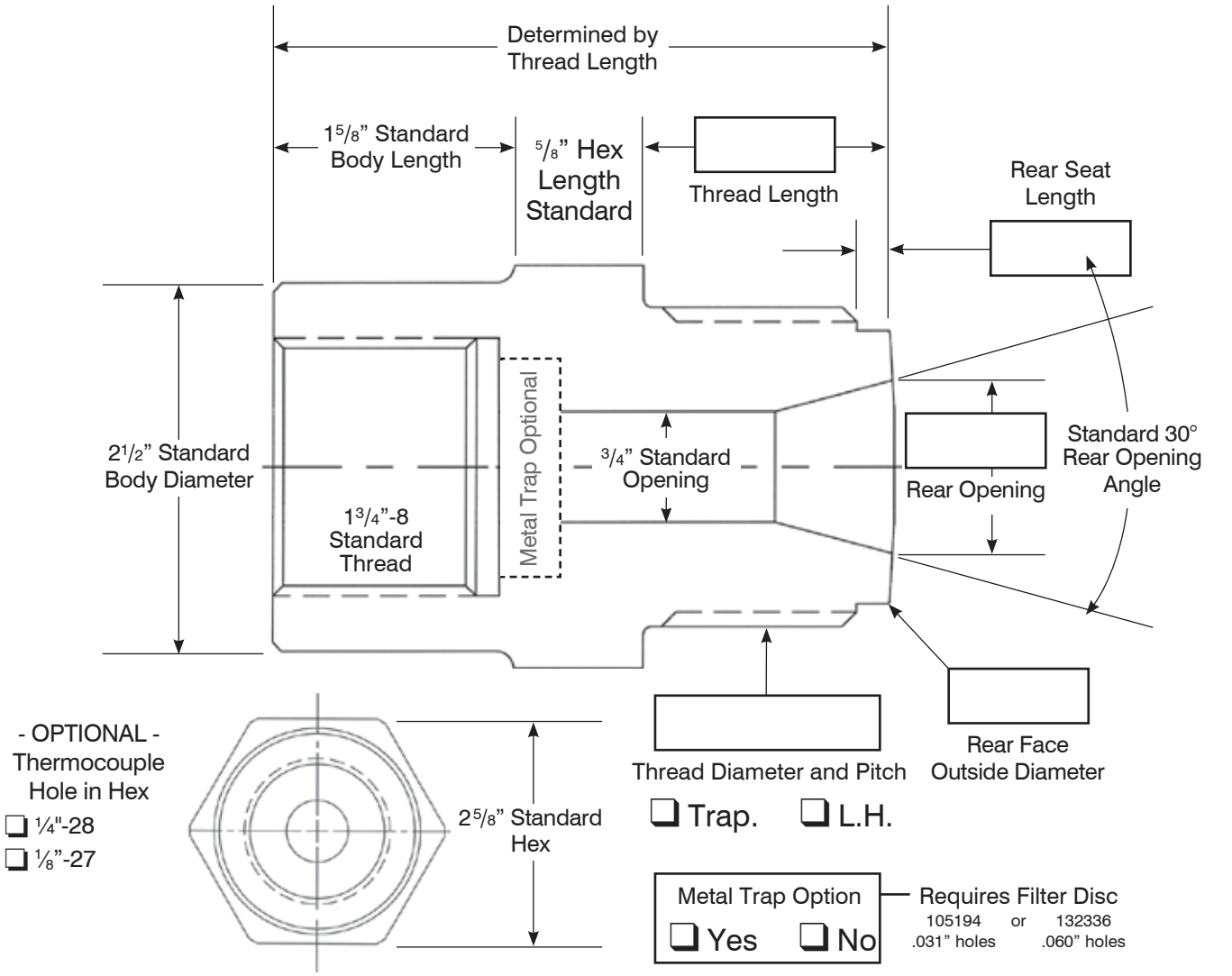
Custom Nozzle Thread Adapter Form

Converts any thread to industry standard 1¾"-8

Fill in the following basic dimension blanks



Required:

1. Press Make _____ **and Model** _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Custom Nozzle Tip Form

Made in the U.S.A

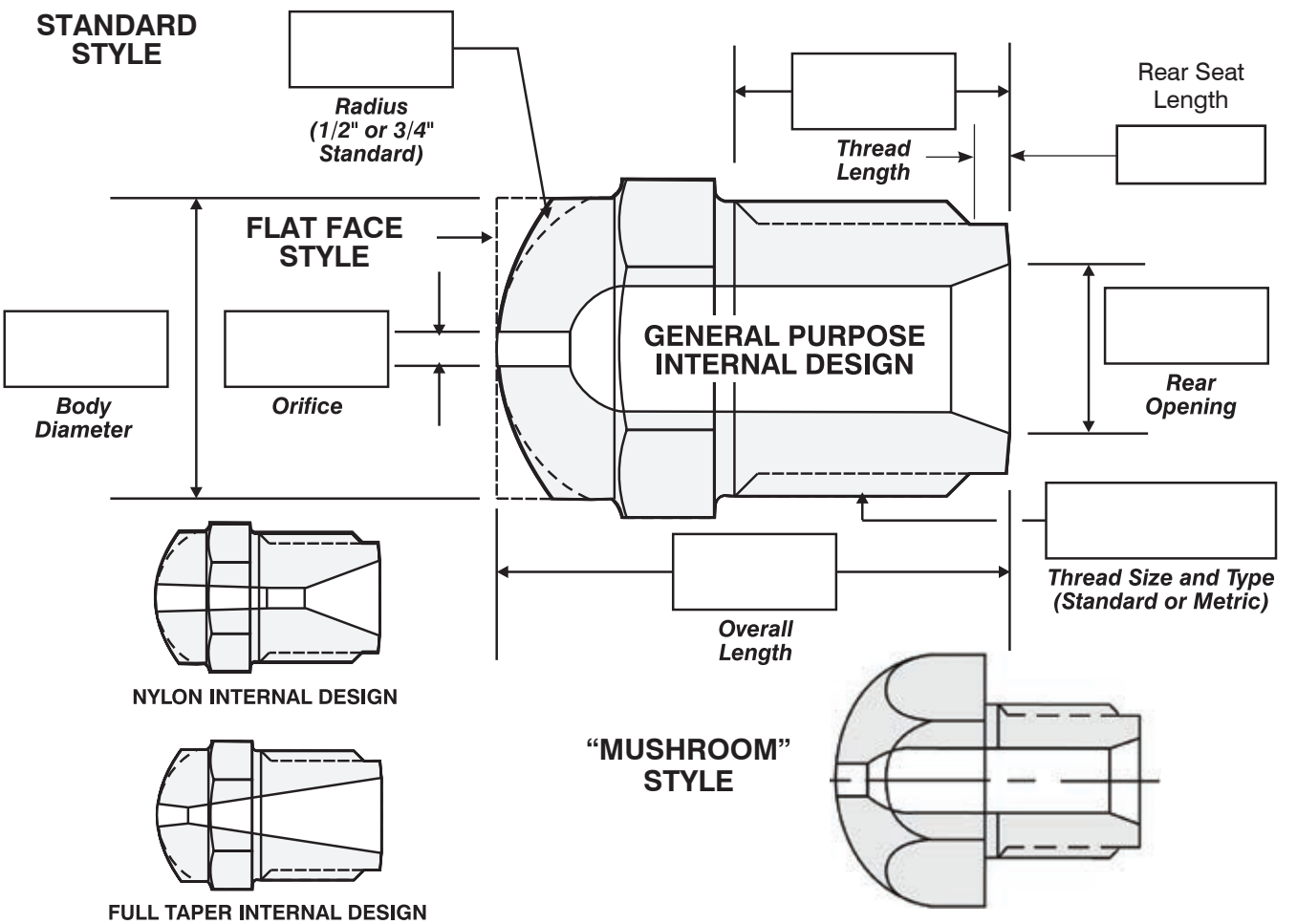
SPECIFY:

1. External Style of Nozzle Tip:
❑ Standard ❑ "Mushroom" ❑ Flat Face*

*Diameter (if other than standard) _____

2. Internal Design of Nozzle Tip:
❑ General Purpose ❑ Nylon ❑ Full-Taper

Fill in the following basic dimension blanks



Optional:

3. Material To Be Molded _____ **4. Operating Temperature** _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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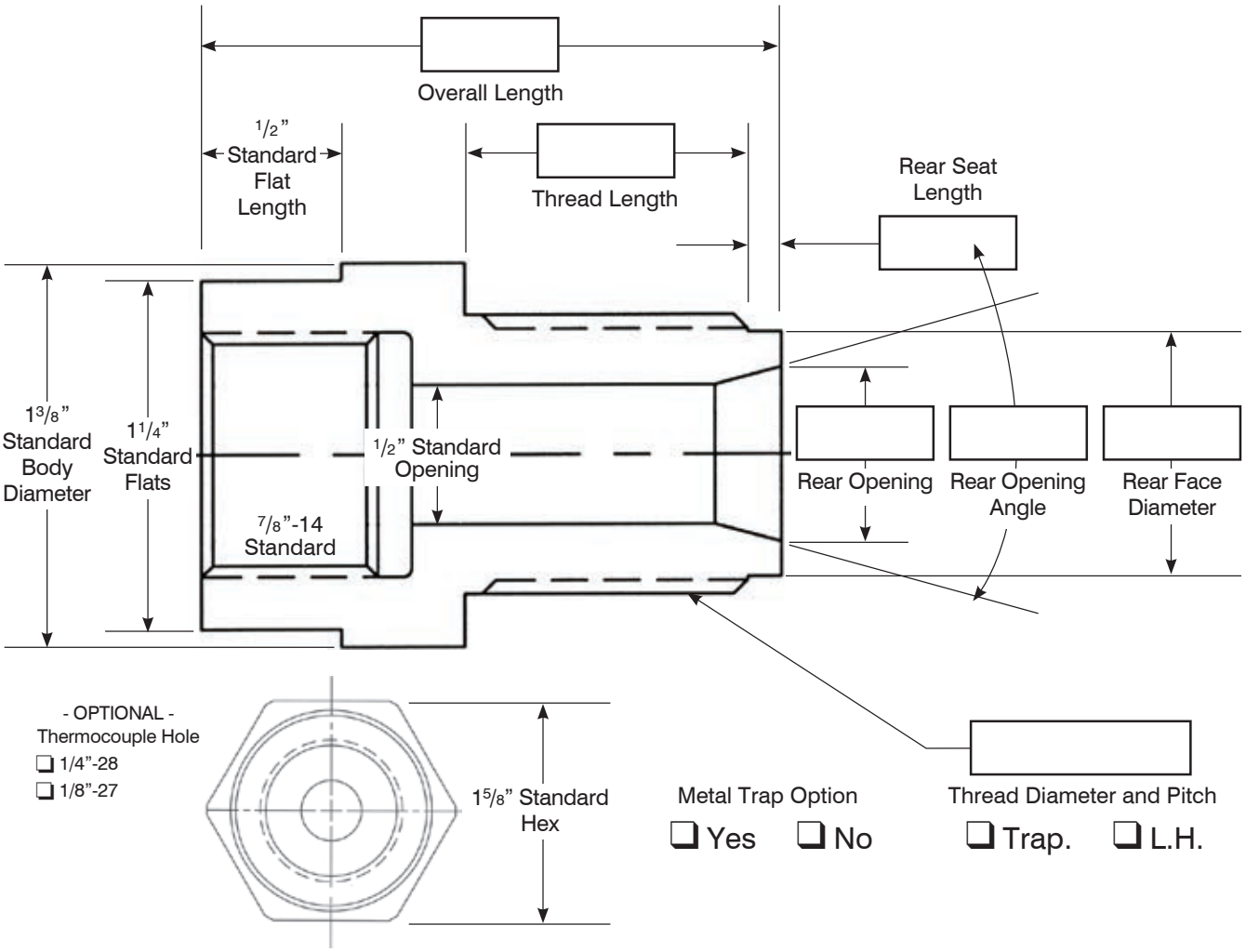
Custom Nozzle Tip Thread Adapter Form

Converts any thread to industry standard 7/8"-14

Fill in the following basic dimension blanks



Optional:

1. Press Make _____
and Model _____

2. Optional Thermocouple
Thread Size and Location _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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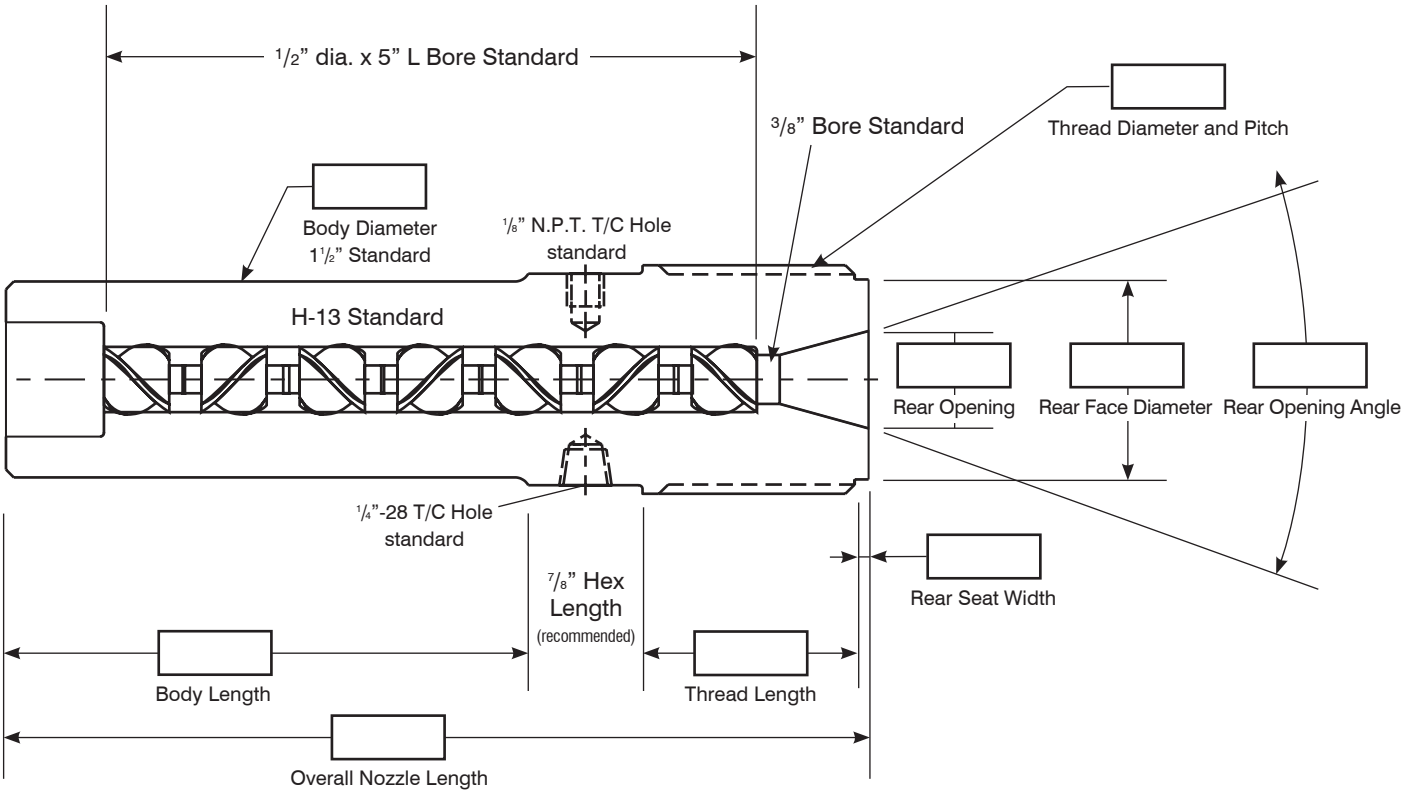
Non-Stock In-Line Color Mixing Nozzle Body Form

Fill in the following basic dimension blanks



Specify:

NOTE: External heating standard

1. **Press Make** _____
   and Model _____

2. **Thermocouple**
   Thread Size and Location _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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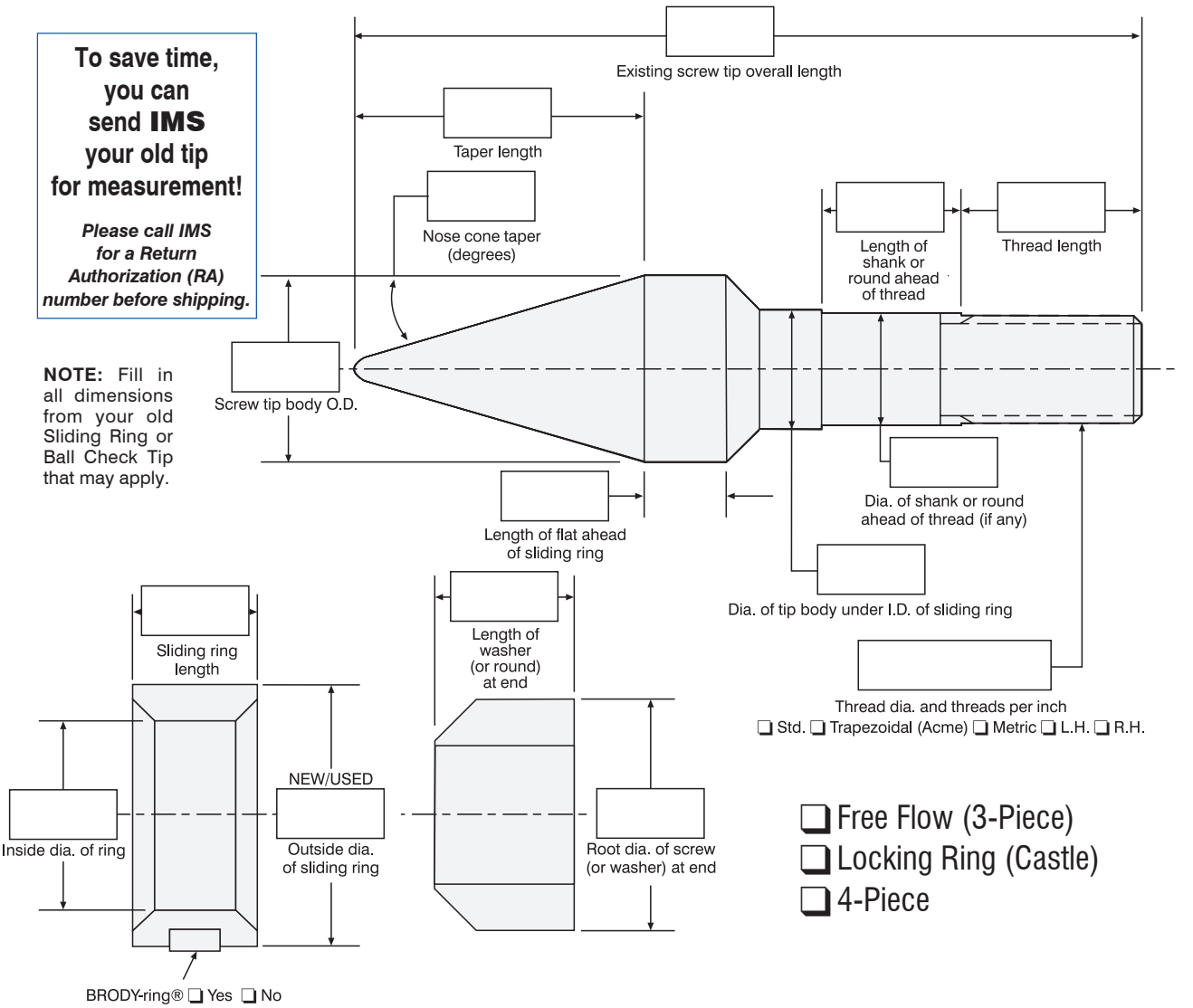
Made-to-order Screw Tip Form

To save time, you can send IMS your old tip for measurement!

Please call IMS for a Return Authorization (RA) number before shipping.

NOTE: Fill in all dimensions from your old Sliding Ring or Ball Check Tip that may apply.



❑ Free Flow (3-Piece)
❑ Locking Ring (Castle)
❑ 4-Piece

(Please give diameters and lengths of sliding ring valves in decimals only)

Specify:

1. Press Make _____

Model _____

Serial Number _____

and Year _____

2. Material to be Molded _____

3. Operating Temperature _____

4. Inside Diameter of Barrel in Ring Travel Zone:

NEW _____

USED _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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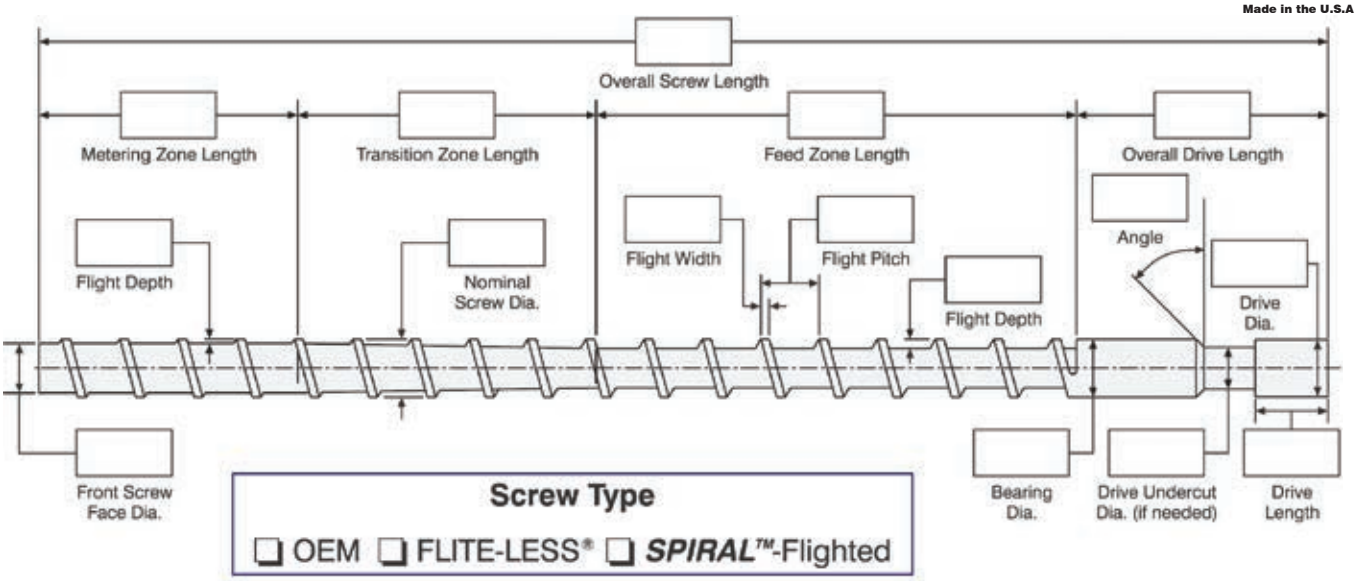
Non-Stock or Custom Reciprocating Screw Form

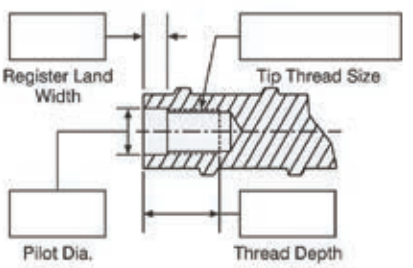
Made in the U.S.A



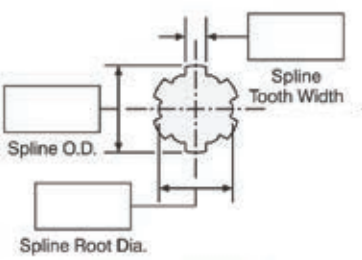
Screw Type

❑ OEM ❑ FLITE-LESS® ❑ *SPIRAL™*-Flighted

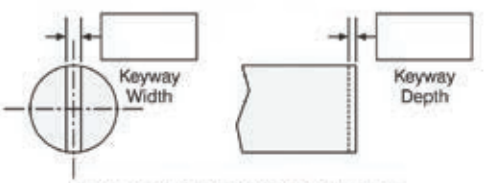
Screw Face Detail



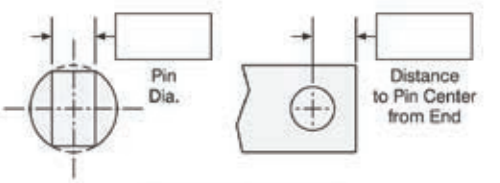
Drive Type — Enter dimensions for your machine



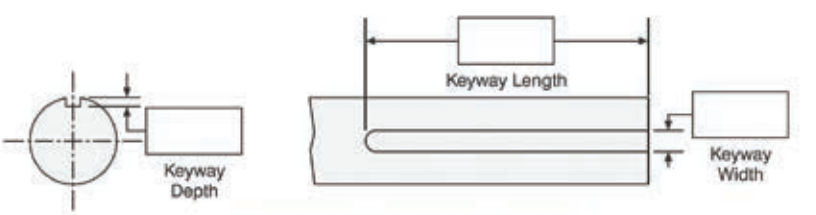
SPLINE DRIVE



REAR FACE KEYWAY DRIVE



PINNED DRIVE



STANDARD KEYWAY DRIVE

IMS Engineering & Machining Services

See next page to complete Injection Screw Form.

See page 903 to complete Extrusion Screw Form.

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Injection Screw Design Form

SPECIFY:

Intent: ❑ Improve Process ❑ New Project ❑ Screw Repair

1. Machine Information:

OEM: _____ Type: _____

Machine Age: _____

Nominal Screw Size: _____ in / mm L/D: _____:1

MAX. Screw Stroke: _____ in / mm Drive: ❑ Electric ❑ Hydraulic

MAX. Screw RPM / KPM: _____ in / mm MAX Torque: _____ FT. LB. NM

2. Resin Information:

Type: _____ Material No: _____ MFG: _____

MFI: _____ Filler _____ % Additives: _____

❑ Color ❑ Master Batch ❑ Powder ❑ Liquid

3. Existing Problems:

❑ Recovery ❑ Quality ❑ Corrosion ❑ Temperature

❑ Wear Of ❑ Screw Flights ❑ Screw Root ❑ Screw Tip

Please be specific: _____

_____

_____

4. Expectation:

Recovery: _____ OZs per SEC / Grams per SEC

Dispersion: _____ (Mixing Device is Mandatory)

Change of MAX. Shot Size Required: ❑ Yes ❑ No

5. Existing Equipment Information:

Mixing Device: ❑ Yes ❑ No ❑ (Located) Transition ❑ Metering

Describe Mixing Device: _____

6. Process Information:

Shot Size: _____ oz. / grams Existing Recovery Time: _____ SEC

Existing RPM: _____ Backpressure: _____ PSI

Screw Stroke: _____ in / mm Recovery Time Target: _____ SEC

Nozzle Shut Off Available: ❑ Yes ❑ No

What Products are Molded: _____

7. State Any Other Information That May Help to Recognize and Understand the Situation:

_____

_____

_____

_____

_____

_____

_____

_____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

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Extrusion Screw Design Form

SPECIFY:

Intent: ❑ Improve Process ❑ New Project ❑ Screw Repair

1. Machine Information:

OEM: _____ Type: _____

Machine Age: _____

Nominal Screw O.D.: _____ in / mm L/D: _____:1

MAX. HP: _____ MAX. RPM: _____ Typical Operating RPM: _____

MAX. AMPS: _____ Typical Operating AMPS: _____

Base Motor Speed (1750, 2300, etc): _____ Gear Reduction Ratio: _____

PSI @ Discharge End: _____

2. Resin Information:

Type: _____ Grade: _____ Manufacturer: _____

Melt Index: _____ Melt Flow Rate: _____ % Regrind: _____

Bulk Density: _____ Melt Density: _____ ❑ Pellets OR ❑ Powder

Viscosity VS Shear Rate Curves: _____

❑ Yes ❑ No Additive / Filler Types: _____

3. Existing Problems:

❑ Rate ❑ Quality ❑ Temperature ❑ Surging

Type Wear (Flight, Root): _____

_____

_____

_____

4. Expectation:

Rate: _____ LBS/HR Melt Temp: _____ °F or ° C Color Mix: _____

Please Explain: _____

_____

5. Existing Equipment Information:

Mixing Device: ❑ Yes ❑ No ❑ (Located) Transition ❑ Metering

Type Mixing Devices: ❑ Maddock ❑ Short Barrier ❑ Helical Pins ❑ X201
❑ Slotted Rings ❑ Blister Ring ❑ Long Barrier ❑ Straight Pins ❑ Other

Compression Ratio: ____ :1 Screw Meter Depth: _____ No. of Stages: ____

Vented Barrel: ❑ Yes ❑ No What Gasses: _____ Vent Vacuum: ❑ Yes ❑ No

Injection Ports Used: ❑ Yes ❑ No What is Injected: _____

Grooved Feed Machine: ❑ Yes ❑ No Number of Grooves: _____

6. Process Information:

Existing Rate: _____ LBS/HR @ _____ RPM Existing Melt Temp: _____

Temp Measured by: _____ No. of Barrel Zones: _____

Machine Temp Settings from Feed: _____

Products Extruded: _____

7. State Any Other Information That May Help to Recognize and Understand the Situation:

_____

_____

_____

_____

_____

_____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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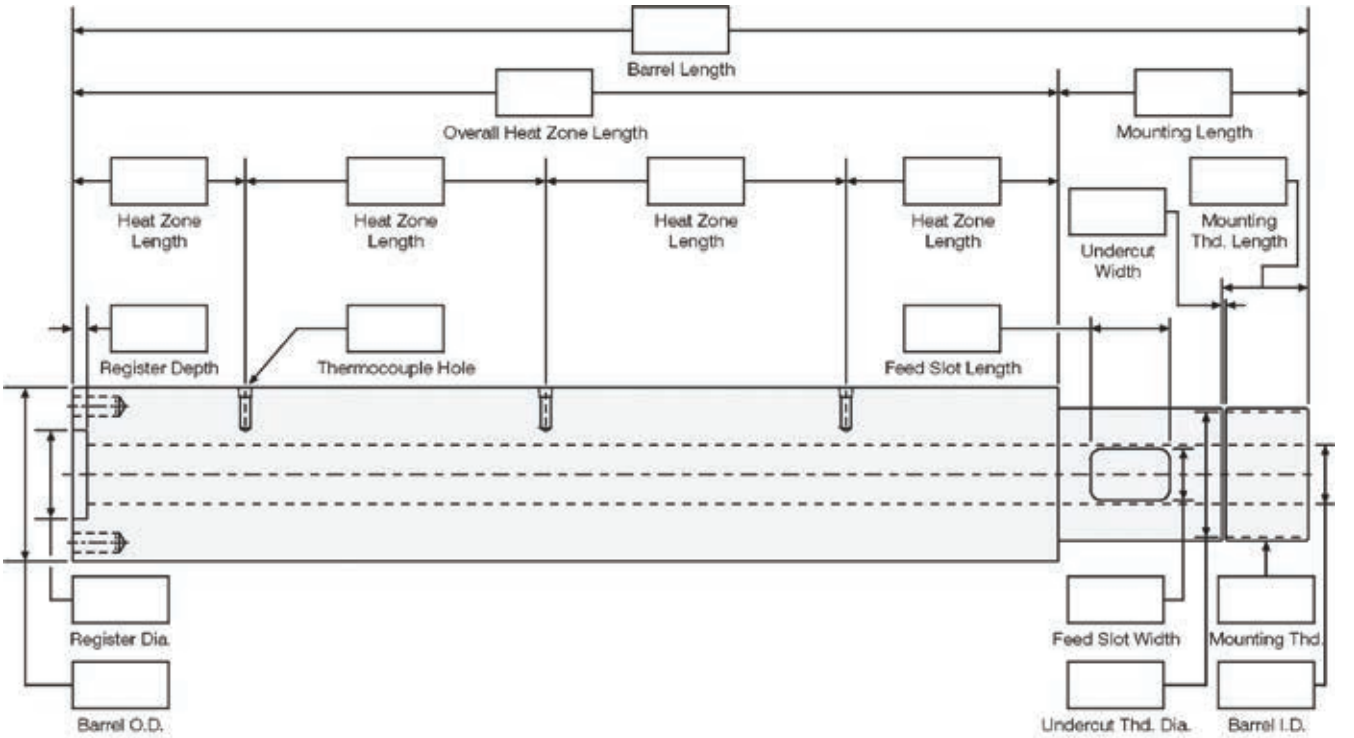
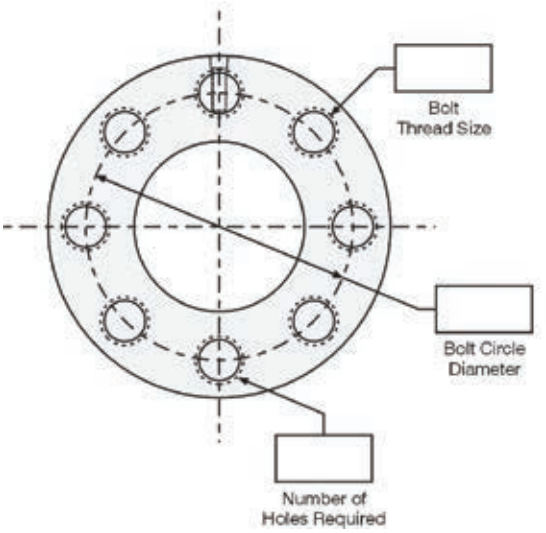
Non-Stock or Custom Barrel Form





Other Information Required:

Liner (Partial or Full): _____

Liner Material Type: _____

Machine Make: _____

Machine Model: _____

Size (Ton and Ounce): _____

Stroke Length: _____

Base Material: _____

Optional Barrel Straightening: YES ☐ NO ☐

Optional Pressure Ports: YES ☐ NO ☐

Optional Vents: YES ☐ NO ☐

Optional Feed Slot: YES ☐ NO ☐

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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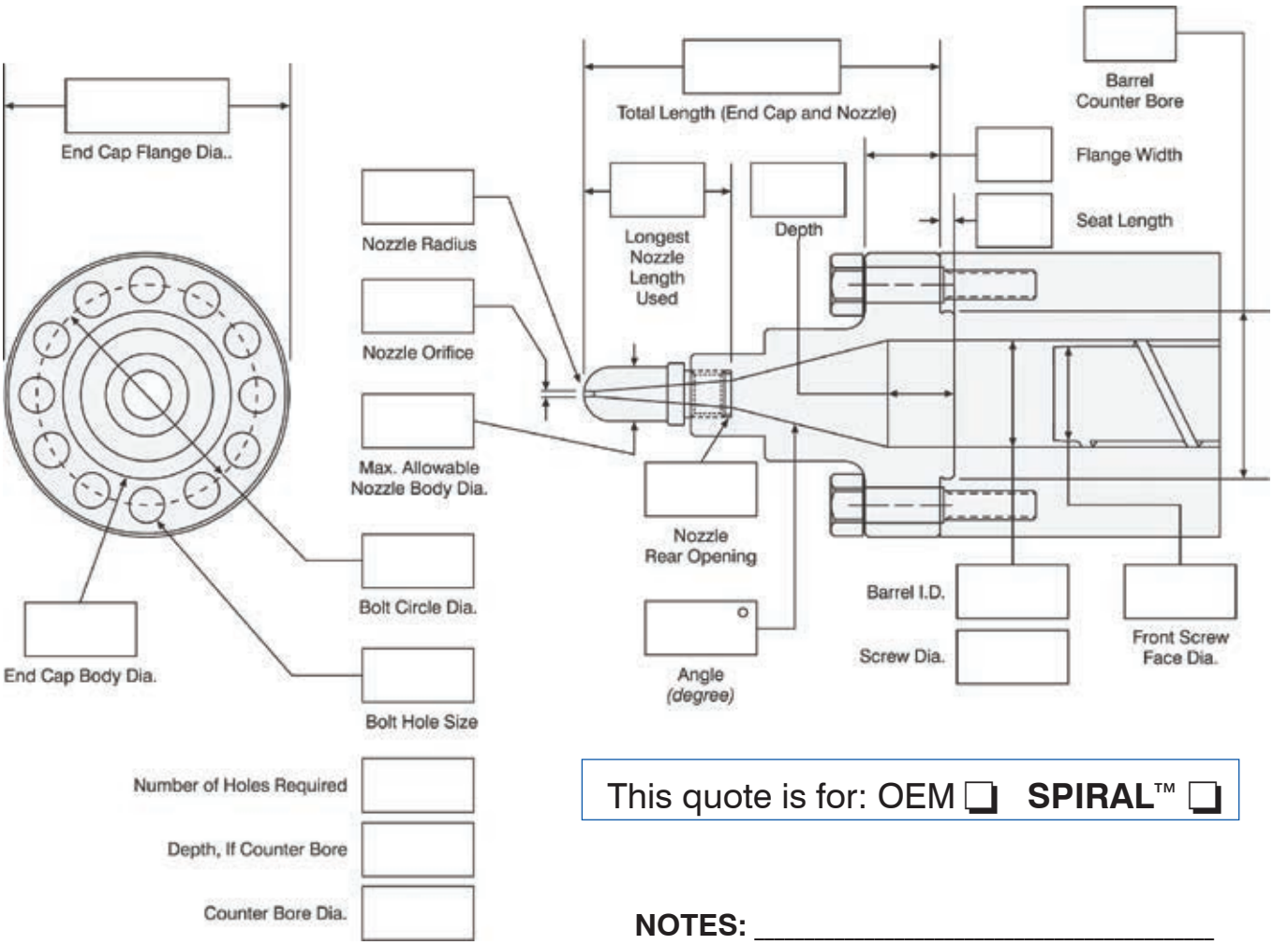
Non-Stock or Custom Front End Cap Form



This quote is for: OEM ❑ **SPIRAL™** ❑

Specify:

1. Press Make _____

Model _____

Serial Number _____

and Year _____

NOTES: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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IMS Heavy Duty Mobile Storage Hoppers Quote Form

Specify:

1. **Quantity:** _____

2. **Capacity:** ❑ 700 lbs / 20 cu ft ❑ 1,050 lbs / 30 cu ft ❑ 1,400 lbs / 40 cu ft ❑ 1,750 lbs / 50 cu ft ❑ 2,100 lbs / 60 cu ft

3. **Slope Angle:** ❑ 45° ❑ 60°

4. **Vacuum Ports (4)** ❑ Yes ❑ No

5. **Covers (No Cover STD):**	Item #	Unit Price
❑ Hopper Cover – one piece	143851	**$193.00**
❑ Hopper Cover – one piece with 8" dia. hole	107918	**$320.00**
❑ Hopper Cover – two piece, hinged	107904	**$199.00**

6. **Slide Gates** (4" Slide Gate STD)**:**

❑ 6"	143871	Inquire
❑ 8"	143872	Inquire
❑ 10"	143873	Inquire

NOTE: Hoppers with slide gates larger than 4" can't have vacuum ports

7. **Distribution Box for vacuum removal:**

1 Hole	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**$260**
2 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**$317**
3 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**$356**

8. **Distribution Box Probe (required for Distribution Box):**

❑ 1.5" **$110** ❑ 2" **$118** ❑ 2.5" **$151** ❑ 3" **$205** ❑ 4" **$269**

NOTE: One probe required per distribution box hole

9. **Caster Package:** ❑	133639	**$461.00**

10. **Paints/Coatings:**		
❑ Paint inside of hopper	143878	**$226.00**
❑ Epoxy coat inside of hopper (clear)	143877	**$226.00**
❑ Paint outside (custom color)	143870	**$298.00**

11. **Misc.**		
❑ 4-way fork-lift pockets (2-way STANDARD)	142836	Inquire
❑ Pallet Jack Option	143854	Inquire
❑ Push Bar (for when casters are installed)	143853	**$179.00**
❑ 52" high Discharge Stand	107859	**$2,133.00**
❑ Loading Platform	107889	**$Inquire**
❑ Grate Magnet	143852	**$532.00**
❑ View Window	142837	$Inquire
❑ Vibrator Mounting Pads	143876	**$355.00**
❑ Removable Bag Break Grate	143876	**$522.00**
❑ Lexan Card Holder	158382	**$62.00**

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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IMS Heavy Duty Surge Bins Quote/Ordering Form

Specify:

1. **Quantity:** _____

2. **Capacity:**

❑ 1,008 lbs / 29 cu ft	❑ 4,060 lbs / 116 cu ft	❑ 7,196 lbs / 206 cu ft	❑ 12,796 lbs / 366 cu ft
❑ 1,624 lbs / 46 cu ft	❑ 4,816 lbs / 138 cu ft	❑ 8,008 lbs / 229 cu ft	❑ 14,392 lbs / 411 cu ft
❑ 2,408 lbs / 69 cu ft	❑ 5,328 lbs / 161 cu ft	❑ 9,604 lbs / 274 cu ft	❑ 16,016 lbs / 458 cu ft
❑ 3,192 lbs / 91 cu ft	❑ 6,384 lbs / 182 cu ft	❑ 11,200 lbs / 320 cu ft	

3. **Slope Angle:** ❑ 45° ❑ 60°

4. **Covers** (One piece with 12" x 14" lid door STANDARD)**:**

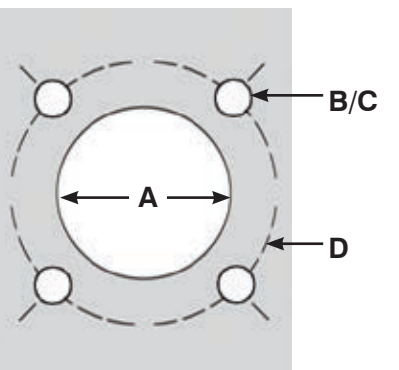
	Loader Cut Out for Cover	
❑ Hopper Cover (Split ⅓, ⅔ design)	143879	**$457.00**

5. **Slide Gates:**

❑ Rack & Pinion with wheel	143880	**$890.00**
❑ Manual	143881	**$399.00**
❑ Gate & Drain (for 45° bins)	143882	**$526.00**
❑ Gate & Drain (for 60° bins)	143883	**$526.00**
❑ Gate & Drain (for 45° bins-butterfly)	143884	**$619.00**
❑ Gate & Drain (for 60° bins-butterfly)	143885	**$619.00**

6. **Distribution Box for vacuum removal:**

1 Hole	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**$243**
2 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**$288**
4 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**$325**
9 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**$649**
13 Holes	❑ 1.5"	❑ 2"	❑ 2.5"	❑ 3"	❑ 4"	**$783**



(**A**) Loader Cut Out Dia:

(**B**) Mounting Hole Dia:

(**C**) Number of Mounting Holes:

(**D**) Mounting Hole Pattern: _____

7. **Distribution Box Probe (required for Distribution Box):**

❑ 1.5" **$110** ❑ 2" **$118** ❑ 2.5" **$151** ❑ 3" **$205** ❑ 4" **$269**

NOTE: One probe required per distribution box hole

8. **Indicator Panel** (Number of Bins)**:**

❑ 1 **$900** ❑ 2 **$1,030** ❑ 3 **$1,161** ❑ 4 **$1,290**

9. **Paints/Coatings:**

❑ Clear epoxy coat inside of hopper (up to 72" x 72")	143891	**$658.00**
❑ Clear epoxy coat inside of hopper (84" x 84" or more)	143892	**$885.00**
❑ Paint outside (custom color)	143870	**$298.00**

10. **Misc.**

❑ 60" Flange to Floor Clearance (20" STD)	143888	**$585.00**
❑ 80" Flange to Floor Clearance (20" STD)	143889	**$762.00**
❑ Grating inside bin (replaces cover)	143893	**$837.00**
❑ Hatchway Door Air Filter	143886	**$108.00**
❑ Additional View Windows (2 standard)	142837	**$Inquire**
❑ Low Level Indicator (paddle blade style)	147688	**$396.00**
❑ High Level Indicator (paddle blade style)	147689	**$396.00**
❑ Level Indicator Flange (extra)	158380	Inquire

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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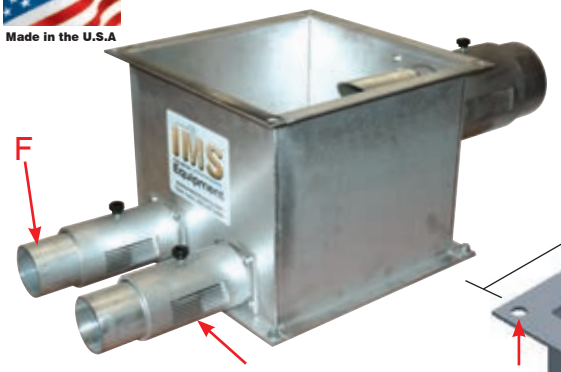
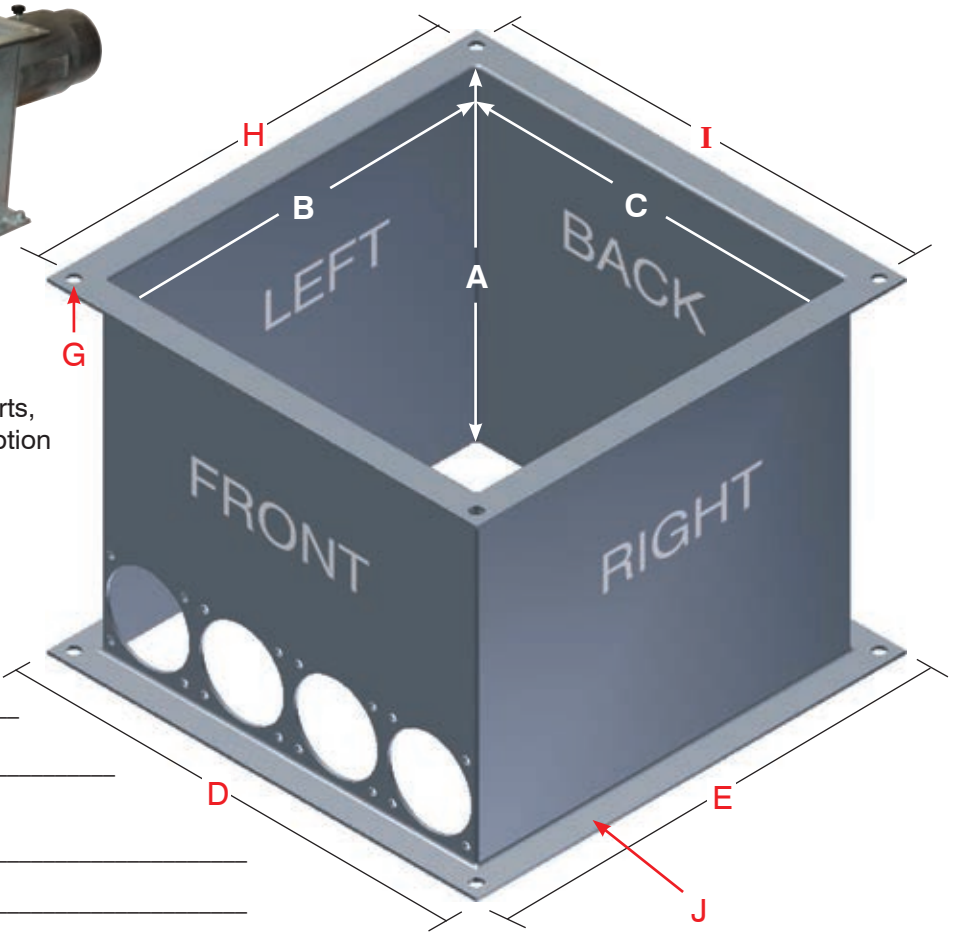
Custom Takeoff Box Quote/Ordering Form



Example shown with 2 front ports,
1 rear port and air adjustment option



SPECIFY:

1. Material: ❑ Aluminum (standard)
   ❑ Other: _____
2. (A) Height: _____
3. (B) Inside Depth: _____
4. (C) Inside Width : _____
5. Flange Size - (D): _____ x (E): _____
6. (F) Number of Ports: _____

(F) Port #1 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No
(F) Port #2 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No
(F) Port #3 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No
(F) Port #4 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No
(F) Port #5 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No
(F) Port #6 OD: _____	Location:	❑ Front	❑ Back	❑ Left	❑ Right	Air Adjustment:	❑ Yes	❑ No

7. (G) Hole Diameter: _____ Hole Center to Hole Center (H): _____ x (I) : _____
8. (J) Bottom Cleanout: ❑ Hinged or ❑ Bolted

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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IMS Stainless Steel Hoppers and Accessories

Hopper: (A) Item # _____

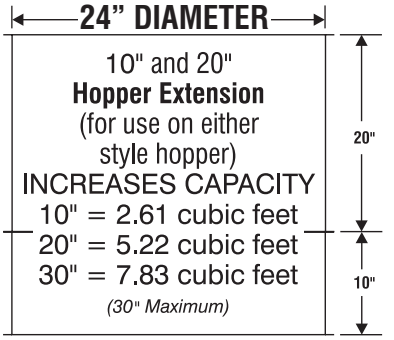
Options: (B) Item # _____

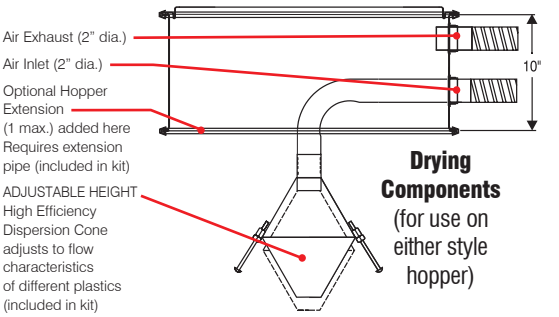
(C) Item # _____

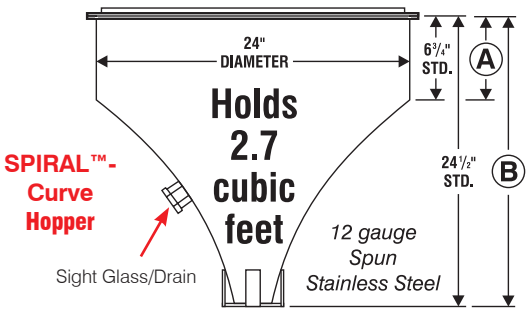
(D) Item # _____

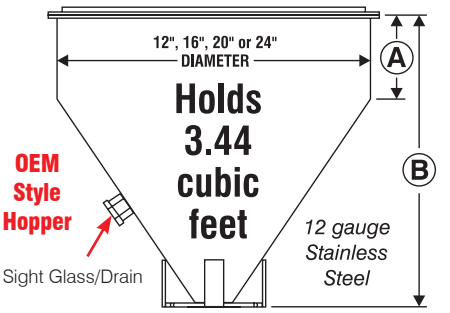
(E) Item # _____

(F) Item # _____



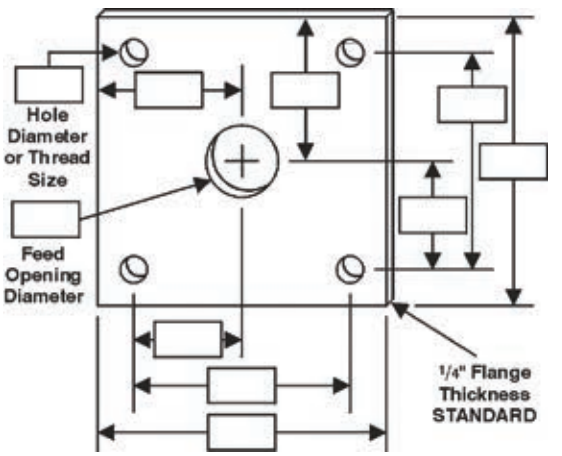






	HOPPER DIMENSIONS	
Dia.	**A**	**B**
12"	7"	15 7/8"
16"	9 3/8"	21 3/4"
20"	10"	25 1/2"
24"	6 3/4"	26"

Custom Mounting Flange Dimensions (Specify)



Date: _____

P.O.#: _____

Name: _____

Title: _____

Company: _____

Address: _____

City: _____

State: _____

Zip: _____

Phone: (_____) _____

FAX: (_____) _____

E-mail: _____

Machine Make: _____

Tonnage: _____

I understand that this item will be made to my specifications. No changes can be made after receipt of order. It is a non-returnable item unless defective or IMS error.

Signature: _____

Note: Other flange configurations will be promptly quoted from your sketch or blueprint.

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Custom Volumetric Feeder Quote Form

PRESS INFORMATION

1. Press Number (optional): _____

2. Press Manufacturer (optional): _____ **3.** Press Model (optional): _____

4. Press Tonnage: _____

5. Press Shot Weight Range (min to max) : _____ including runner

6. Screw Recovery Times (min to max): _____

7. Preferred Base Unit Size: ❑ 8" X 8" or ❑ 10" x 10"

NOTE: Feeders are normally shipped with blank, aluminum adapters to be drilled by the user.
Predrilling can be done at the plant for a reasonable fee. Include drawing if this service is preferred.

AUGER OPTIONS: SINGLE OR DUAL FEED

	Auger #1	**Auger #2 (for dual-feed units)**
1. Additive Type (regrind, color, etc.)	_____	_____
2. Additive % Range (min to max)	_____	_____
3. Preferred Auger Size (if known) ½", ¾", 1", 1½" or 2"	_____	_____

NOTE: Auger size is selected to match feed rate. Each auger size can cover a relatively large range of feed rates.
For large changes in feed rate, a larger or smaller auger assembly can be installed very easily.

NOTE: Augers normally employ a square pitch (½" auger has ½" flight length).
Custom pitches can be manufactured to accomodate the rare applications where they might be useful.

TYPICAL OPTIONS

Control Panel Options (for dual-feed units): ❑ dual-control panel ❑ two single-feed controllers

❑ Low Speed Motor (18 RPM, for very low feed rates)

❑ Intermixer (3, 5 or 10 pound available)

❑ 1.25 cu ft Hopper (40 pound capacity @ 35 lbs/cu ft) NOTE: Standard hopper is 0.5 cu ft -- 17.5 lbs @ 35 lbs/cu ft

❑ Drying Hopper (specify size) _____

❑ Offset Hopper Adapter (to provide additional clearance around machine's hopper.)

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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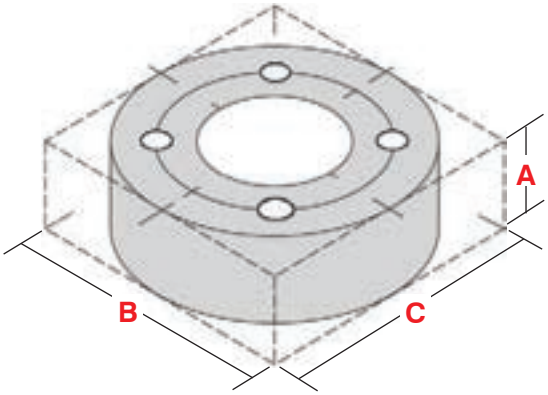
Combination Hopper Lid and Loader Stand Request for Quote Form

- **Seals hopper from dirt**
- **Protects loader**
- **Keeps loaders upright for maintenance on bench or floor**
- **Custom made, quickly and affordably**
- **Square or round hoppers**
- **Aluminum or stainless steel standard**

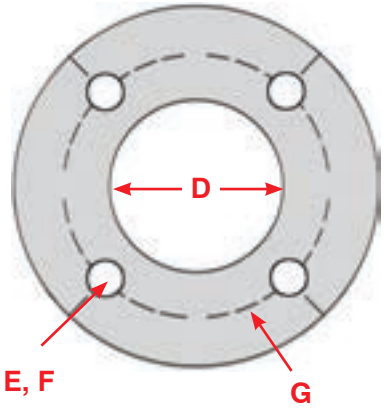


Hopper Dimensions Needed

A: Vertical space required below your loader flange when the dump flap is fully extended, PLUS 1" clearance.

B: If your hopper is Round or Square, measure the OUTSIDE of your hopper at the widest point (width - including the lip), PLUS 1" clearance.

C: For Rectangular hoppers, also measure the outside of the hopper at the longest point (length - including the lip), PLUS 1" clearance.



SPECIFY:

1. Material: ❑ Painted Steel / Color: _____
   ❑ Aluminum ❑ Stainless Steel
2. (A) Height: _____
3. (B) Diameter/Width: _____
4. (C) Length (Rectangular Only) : _____
5. (D) Loader Cut Out Diameter: _____
6. (E) Mounting Hole Diameter: _____
7. (F) Number of Mounting Holes: _____
8. (G) Diameter of Lid at the Center of Mounting Holes: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Custom Drying Oven Quote Form

1. PROCESS (Description): _____

2. MATERIAL HEATED: _____

Size: _____ Weight: _____ Thickest Cross Section: _____

Condition of Pieces: ❑ Wet ❑ Dry ❑ Oily ❑ Other (explain under comments)

3. FLAMMABLE SOLVENTS OR VAPORS INVOLVED IN PROCESS

Type: _____ Amount: _____ gallons per batch (or per hour of continuous processing)

4. INERT ATMOSPHERE (if required): ❑ Nitrogen ❑ Argon ❑ Other (explain under comments)

6. TEMPERATURE

Operating Temperature: _____ °F Maximum Temperature: _____ °F

Required Dwell Time at Operating Temperature: _____ (Include time for parts to heat up; assume preheated equipment)
This information must be supplied for continuous processing such as belt and conveyor or rotary hearth.

Required Uniformity within Workspace: _____

6. MATERIAL HANDLING

Batch: ❑ Shelf ❑ Tray ❑ Basket ❑ Fixture ❑ Other (explain under comments)

Quantity of Parts: _____ per Batch or Production Rate
Continuous: ❑ Belt Conveyor ❑ Rotary Hearth ❑ Roller Hearth ❑ Chain Conveyor ❑ Other (explain under comments)

Length Load Zone: _____ Length Unload Zone: _____

Pass Line: _____ Production Rate: _____

Length Cooling Zone: _____ Exit Temperature from Cooling Zone: _____ °F

7. CLEAN ROOM/PHARMACEUTICAL

❑ backwelded seams
❑ door locks/interlock
❑ pressurizing blower
❑ one pass granulation drying
❑ #4 brushed stainless steel exterior
❑ HEPA fresh air inlet
❑ automation depyrogenation cycle
❑ front welded ground seams 1/2" radius interior corners
❑ door at both ends for pass through
❑ alarms for filters/temperature
❑ motorized intake and exhaust dampers

8. DESIGN

Type of Equipment:: _____ Similar to Standard Model: _____

Work Space Size: _____ Wide x _____ Deep x _____ High
Air Flow: ❑ Horizontal ❑ Combination ❑ Vertical Up ❑ Vertical Down ❑ Other (explain under comments)

Special Features: _____

_____

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Custom Drying Oven Quote Form (continued)

9. SPECIFICATIONS APPLICABLE:

Condition of Pieces: ❑ JIC ❑ FM ❑ IRI ❑ MIL Military Specification # _____

10. SERVICES

Electrical Service: _____ Volts ❑ 1 or ❑ 3 Phase ❑ 50 or ❑ 60 Hz

To Be Heated By: ❑ Electric ❑ Natural Gas ❑ Propane ❑ Steam ❑ Other (explain under comments)

11. EQUIPMENT TO BE INCLUDED IN BASE PRICE: _____

_____

12. EQUIPMENT TO BE INCLUDED AS OPTIONS: _____

_____

13. BUILDING DATA

Smallest Opening through which unit must pass: _____ Wide x _____ High
Don't forget doorways, elevators and existing machinery, pipes, or ducts.

Floor space Limitations: _____ Wide x _____ Deep

Headroom Limitations: _____

_____

Floor or Elevator Load Limitations: _____

14. ADDITIONAL COMMENTS OR EXPLANATIONS: _____

_____

_____

_____

_____

_____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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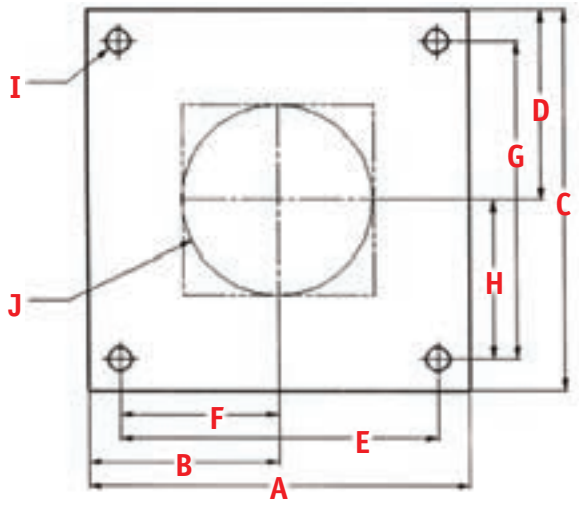
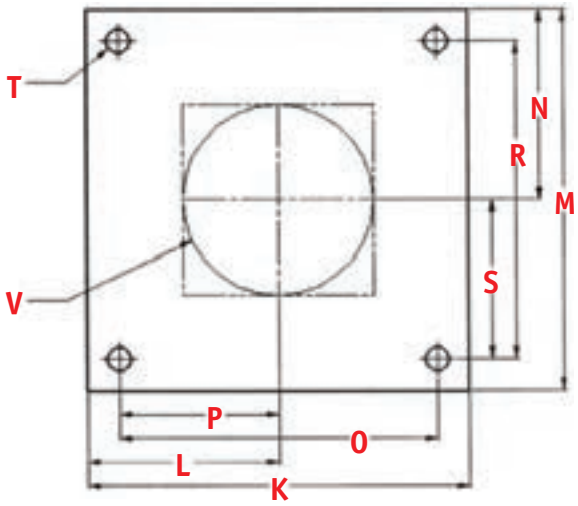
Drawer Magnet Housing Flange/Accessory Form

SPECIFY:

See next page for Isometric/ 3 Dimensional View



Bottom Flange
Operator Side (Front)



Top Flange
Operator Side (Front)

A _____
B _____
C _____
D _____
E _____
F _____
G _____

H _____
I _____ (bolt size used)
J — Opening
❑ Round _____
❑ Square _____
❑ Rectangle _____
Front to Back _____
Side to Side _____

K _____
L _____
M _____
N _____
O _____
P _____
R _____

S _____
T* _____ ❑ **Threaded Holes**
(thread size used) ❑ **Studs**
V — Opening
❑ Round _____
❑ Square _____
❑ Rectangle _____
Front to Back _____
Side to Side _____

*Studs will be required if bolt pattern falls on housing body

Make of Press: _____ Serial Number: _____

Model: _____ Screw Size: _____ Ounce: _____

Make of Hopper: _____ Hopper Capacity: _____ lbs.

Optional Equipment:

☑ Slide Gate Shut-off
❑ Tapped Hole for Liquid Dispensing System
❑ Other _____
❑ With Discharge Dump Tube: ❑ Rear ❑ Other _____
❑ With Purge Hopper: ❑ R.H. Side ❑ L.H. Side

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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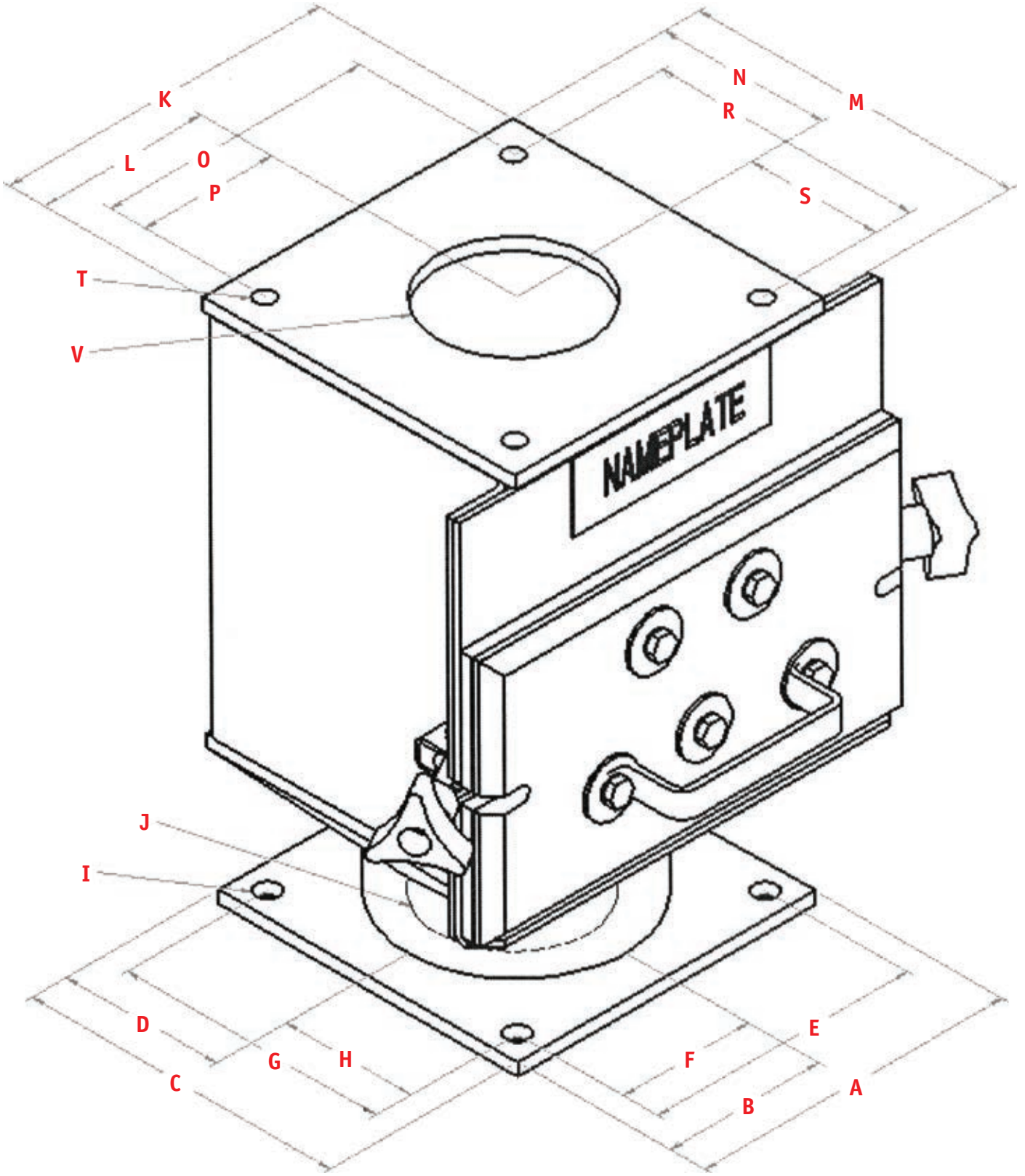
Isometric View of Flange Dimensions



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Custom Inline All-Metal Detector Quote Form

Product Details

1. Product (Description): _____

Characteristics of the Product (Check all that apply): ❑ Dusty ❑ High Static ❑ Product can be wet at times

❑ High percentage of carbon in the product ❑ Product is very abrasive ❑ Larger particles can be intermingled

2. Particle Size/Dimension: _____ **3.** Moisture Content: _____ %

4. Feed Rate: _____ lbs/hr **5.** Bulk Density: _____ LBS/FT^3

6. Product Temperature: _____ °F **7.** Material Feeding From: _____

Note: Freefall height to inlet of detector not to exceed 18"

8. Material Feeding To: _____

Additional Application Details: _____

_____

Detector Details

1. Feed Hole OD: ❑ 1-3/16" (30mm) ❑ 2" (50mm) ❑ 2-3/4" (70mm) ❑ 3-1/8" (80mm)
❑ 3-7/8" (100mm) ❑ 4-3/4" (120mm) ❑ 5-7/8" (150mm) ❑ 7-7/8" (200mm)

2. Detached Controls: ❑ Yes Cable Length Required: _____ feet. **Note: Not available on all models**

3. Location: ❑ Indoor ❑ Outdoor Environment Temperature: _____ °F min / _____ °F max

Note: Inline all-metal detectors are NOT to be used in food applications
Feed rate must be calculated on a continuous basis

4. Construction:
❑ Utility grade painted construction (standard in this configuration)
❑ Painted coil with stainless frame and diverter (wipe down only)
❑ Stainless steel complete (extreme wash down with high pressure)
Note: Stainless coil required in heavy wash down or corrosive environment

5. Voltage: ❑ 110-240 VAC 50/60 Hz, Single Phase ❑ Other: _____ V / _____ Phase

6. Sensitivity Requirement: _____ FE _____ NFE _____ SS

7. Detector Options:
❑ Test Ball Retrieval Kit (Good Port) ❑ Test Ball Retrieval Kit (Reject Port)
❑ Inlet Hopper _____ ft^3 ❑ Drawer Magnet on infeed
❑ Outlet Transition (Clean Product) _____ Outlet OD ❑ Outlet Transition (Reject Product) _____ Outlet OD
❑ Floor Stand _____ Distance from floor to inlet ❑ Inlet Stub

❑ **ATEX** Hazardous Environment - Will this unit require an explosion proof rating? ATEX ratings are available on certain detectors. (ATEX is the European Union standard, which meets all of the requirements of the NEC North American Standard.) A chart is available to explain the classification terms for ATEX.
NOTE: Available only as 5.1 Touch

Requested ATEX Classification _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Custom Machine Mounted All-Metal Detector Quote Form

Application Details

1. Material Type: _____

2. Regrind: _____ % Virgin: _____ % **3.** Bulk Density: _____ LBS/FT³

4. Maximum Particle Size: _____ **5.** Maximum Product Temperature: _____ °F

6. Characteristics of the Product (Check all that apply): ❑ High percentage of carbon in the product

❑ Larger particles can be intermingled ❑ Dust particles are present

7. Details on Injection or Blow Molding Operation:

Shot Size: _____ (weight) Cycle Time: _____ Seconds

8. Details on Extrusion Operation:

Flow Rate: _____ LBS/hr Bulk Density: _____ LBS/FT³

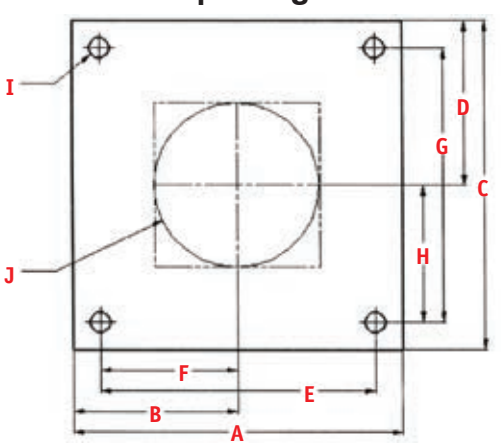
9. Material Feeding From:

❑ Vacuum Loader (intermittently) ❑ Dryer - Maximum Temperature: _____ °F

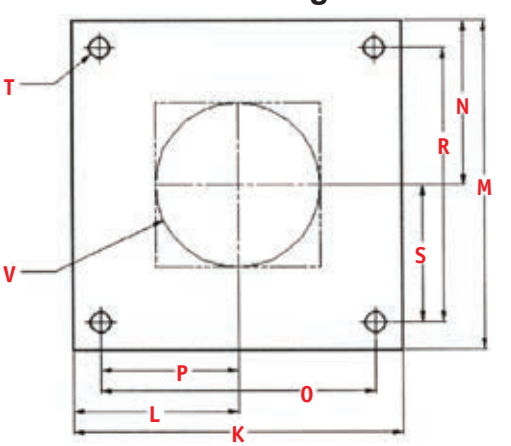
❑ Other: _____

TOTAL WEIGHT of ALL equipment on top of Metal Detector: _____ LBS

Top Flange



Bottom Flange



A _____	H _____	K _____	S _____
B _____	I _____	L _____	T _____
C _____	J _____	M _____	V _____
D _____	**Opening:** _____	N _____	**Opening:**
E _____	❑ Round _____	O _____	❑ Round _____
F _____	❑ Square _____	P _____	❑ Square _____
G _____	❑ Rectangle _____	R _____	❑ Rectangle _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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REQUEST FOR QUOTE: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

Hydra Pressurized Circulator Quote Form

Motor Size	**GPM**	**PSI**	**Required** - select one
❑ 3/4 hp	40	26	
❑ 1 hp	50	28	
❑ 2 hp	75	30	
❑ 3 hp	85	32	
❑ 5 hp	100	46	
❑ 7-½ hp	125	54	
❑ 10 hp	140	68	

Heating Elements	**REQUIRED** - select one	**Heater Options**	**OPTIONAL** - select one
❑ 0 kW		N/A	
❑ 9 kW	.....	❑ Solid State relay heater contactor (9kW)	
❑ 12 kW	.....	❑ Solid State relay heater contactor (12kW)	
❑ 18 kW	.....	❑ Solid State relay heater contactor (18kW)	
❑ 24 kW	.....	❑ Solid State relay heater contactor (24kW)	
❑ 36 kW	.....	❑ Solid State relay heater contactor (36kW)	
❑ 48 kW	.....	❑ Solid State relay heater contactor (48kW)**	

**460 and 575 Volt Only

Power Options | Required - select one
- ❑ 208/3/60 - N/A for 48 kW
- ❑ 230/3/60
- ❑ 460/3/60
- ❑ 575/3/60 (Only includes 575V components, CL-UL508A option not included, must select)

Electrical Options | OPTIONAL - select all that apply
- ❑ Rotary Non-Fused Disconnect
- ❑ UL Branch Circuit Fusing Disconnect
- ❑ C-UL508A Industrial CP Construction

Controls and Control Options | Required - select one
- ❑ Standard Controller (Standard)
- ❑ PC (Premium Controller)
- ❑ PC w/ Remote Hand-Held Control Panel (Provides local pc w/HMI on the unit as well as in a remote encolsure with 50-foot cable)
- ❑ PC w/4-20mA Supply Output*
- ❑ PC w/ RS-485 port for Modbus RTU* (allows interface w/your machine)
- ❑ PC w/ RS-485 port for SPI* *not available with remote Hand-Held CP

Premium Controller Options | Optional - select all that apply
- ❑ Crash cool - quick circulator cool down (CC sequence disables heater and opens cooling valve for 1 minute)
- ❑ Remote heat/cool contact - remote heat/cool contact on/off

Premium Controller Mold Purge | OPTIONAL - select one
(Allows compressed air to purge circuit of water)
- ❑ Mold water purge non-ferrous (Select if choosing non-ferrous option in right column)
- ❑ Mold water purge ferrous

Other Control Options | OPTIONAL - select all that apply
- ❑ Remote Alarm Dry Contact
- ❑ Remote temp sensor, local high temp safety (Shipped loose with unit, adds a local high temp switch)
- ❑ Alarm Strobe light (red)
- ❑ Power Cord, 10' (ships loose)

Mechanical Options	**Cv‡**	**Required** - select one
❑ 1/4" Solenoid Valve (Standard)	0.72	
❑ 3/8" Solenoid Valve	3.00	
❑ 1/2" Solenoid Valve	4.00	
❑ 3/4" Solenoid Valve	5.50	
❑ 1" Solenoid Valve	11.50	
❑ 1/2" Modulating Valve†	4.70	
❑ 1/2" Modulating Valve†	10.00	
❑ 3/4" Modulating Valve†	24.00	
❑ 1" Modulating Valve†	30.00	

‡Cv (flow coefficient) is the flow of water through a valve at 60° F in US gallons/minute at a pressure drop of 1 PSI

†Modulating valves are used in variable-flow systems in which flow must be adjusted to slow, moderate, or full stream

Max Temp | OPTIONAL
- ❑ 300° F Max Set-point Operation (Only available with 1/4" high-temp solenoid valve [Cv=0.24] requires a minimum if 75 psi coolingwater supply)

Stainless/Non-Ferrous Options | OPTIONAL - select one
- ❑ Stainless/Non-Ferrous Option for 0 to 36kW, 3/4 to 3 hp
- ❑ Stainless/Non-Ferrous Option for 0 to 36kW, 5 to 10 hp
- ❑ Stainless/Non-Ferrous Option for 46kW, 3/4 to 3 hp
- ❑ Stainless/Non-Ferrous Option for 46kW, 5 to 10 hp

Other | OPTIONAL - select all that apply
- ❑ Special Color - requires Pantone Number
- ❑ Stacking Rack (stainless steel) for stacking two units vertically

Add-on Heat Exchangers | OPTIONAL
- ❑ Request Heat Exchanger Sizing

If molding at high temperatures where the return fluid temperature is higher than the process/leaving fluid temperature, your circulator may require a heat exchanger to cool the return water to an acceptable temperature.

Select this option to request more information.

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

Please refer to imscompany.com for current pricing

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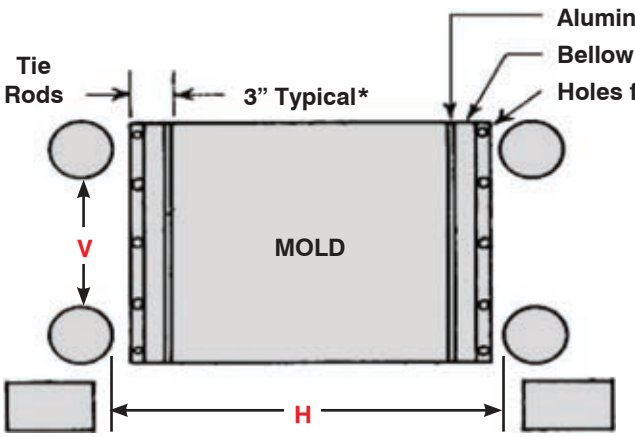
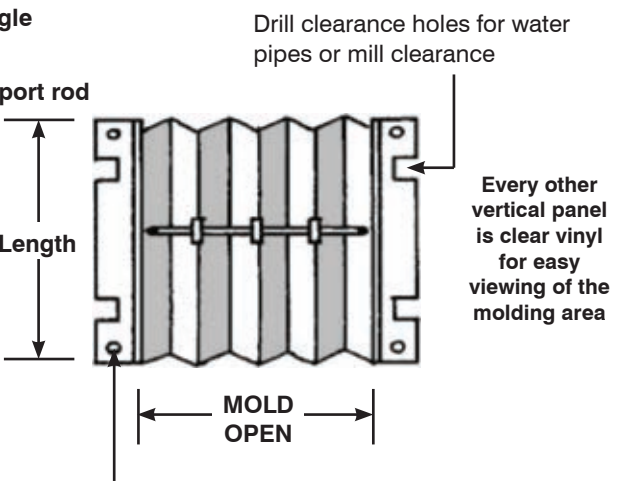
Custom Mold Side Curtains Request Form



TYPICAL INSTALLATION



***Note:**

Side curtains require 3" gap between mold and tie bar. The curtain can only be as long as the tie bar spacing if adequate space does not exist.

Ensure adequate clearance between waterline fittings on the parting line, to allow the curtain to collapse in between when the mold is closed.

Curtain open stroke and curtain length should not exceed 36".

Mounting Bracket is always 1" shorter than the curtain length.

Curtain length received will be 1/2" shorter than ordered for adjustment purposes.

Drill clearance holes in aluminum angle. Drill and tap mold base to accept mounting screws.

Mold Open	Approximate Mold Close
3" - 6"	½" bellows + ¼" for mounting bracket
7" - 9"	¾" bellows + ¼" for mounting bracket
10" - 12"	1" bellows + ¼" for mounting bracket
13" - 15"	1-¼" bellows + ¼" for mounting bracket
16" - 18"	1-½" bellows + ¼" for mounting bracket
19" - 21"	1-¾" bellows + ¼" for mounting bracket
22" - 24"	2" bellows + ¼" for mounting bracket
25" - 27"	2-¼" bellows + ¼" for mounting bracket
28" - 30"	2-½" bellows + ¼" for mounting bracket
31" - 32"	2-¾" bellows + ¼" for mounting bracket
33" - 36"	3" bellows + ¼" for mounting bracket

1. (H) Distance between Tie Rods: _____ (V) Distance between Tie Rods: _____

2. Mold Width: _____ Mold Height: _____

3. Mold Open: _____

4. Curtain Length: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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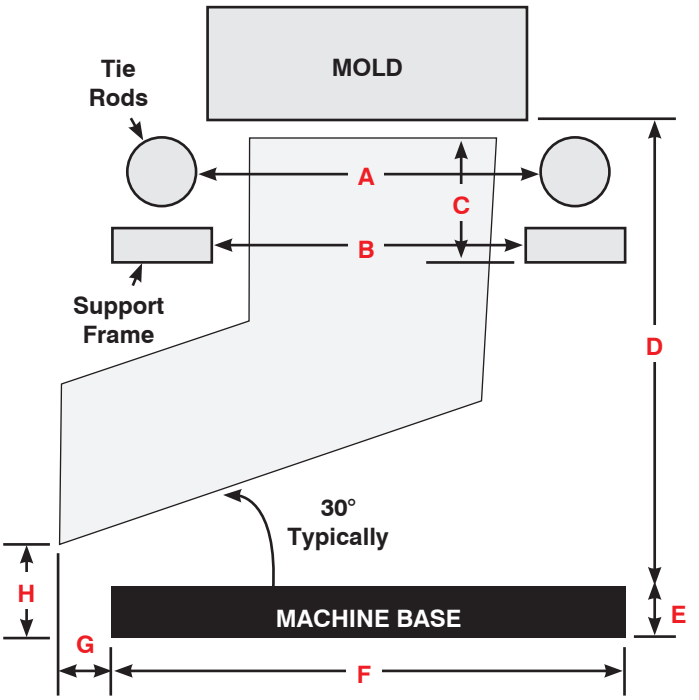
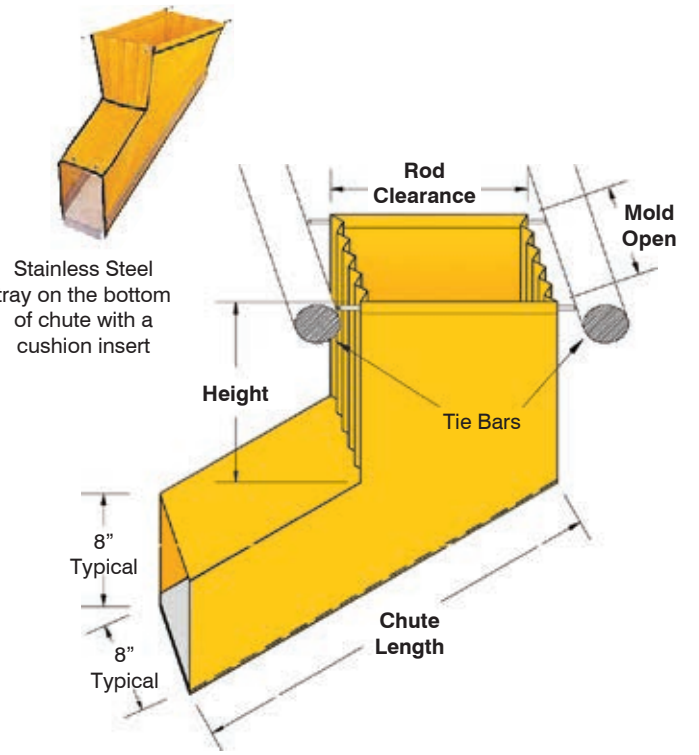
Custom Detachable Guideskirts Request Form





1. Mold Open (daylight): _____ (24" Max)
2. (A) Width between tie rods: _____
3. (B) Width between frame: _____
4. (C) Clearance Height (chute): _____
5. (D) Machine Clearance mold to base: _____
6. (E) Base to floor: _____
7. (F) Width of base: _____
8. (G) Desired extension past base: _____
9. (H) Desired discharge height: _____
10. Size of parts: _____ L x _____ W x _____ H
11. Runner system: ❑ No ❑ Yes
12. Size of runner: _____ L x _____ W x _____ H
13. Do you require high temp material (for parts over 180°): ❑ No ❑ Yes
14. Style: ❑ Hard Bottom ❑ Soft Bottom

All dimensions must be completed in order for a Quote to be given.

All guideskirts come with mounting hardware.

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

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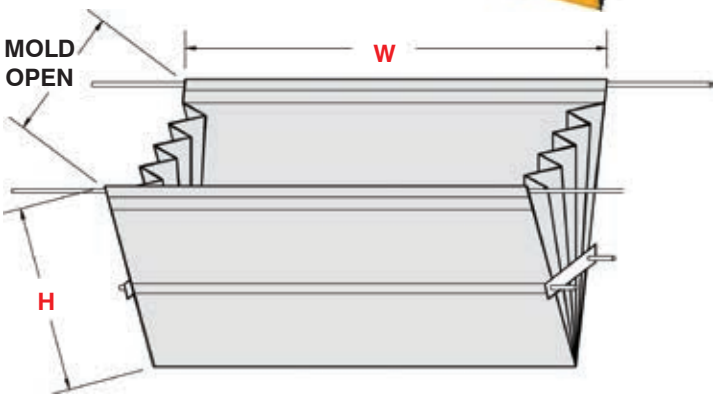
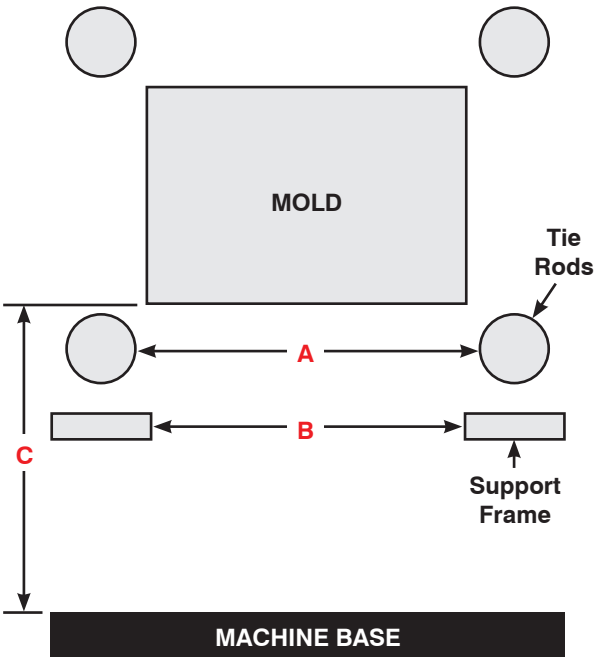
Custom Delay Drop Part Chute Guideskirts (Soft Drop) Form

Drop end CLOSES when mold opens – OPENS when mold closes

Made in the U.S.A

ACTS LIKE A BAFFLE!





Delayed drops have metal side plates sewn into sides to keep sides rigid.

1. Mold Open (daylight): _____
2. (A) Width between tie rods: _____
3. (B) Width between frame: _____
4. (C) Machine clearance mold to base: _____
5. (H) Desired height of guideskirt: _____
6. (W) Desired width of guideskirt: _____
7. Size of parts: _____ L x _____ W x _____ H
8. Number of mold cavities: _____
9. Runner system: ❑ No ❑ Yes
10. Size of runner: _____ L x _____ W x _____ H
11. Do you require a divider:
    ❑ No ❑ One ❑ Two ❑ Three
12. Do you require high temp material (for parts over 180°): ❑ No ❑ Yes

All dimensions must be completed in order for a Quote to be given.

All guideskirts come with mounting hardware.

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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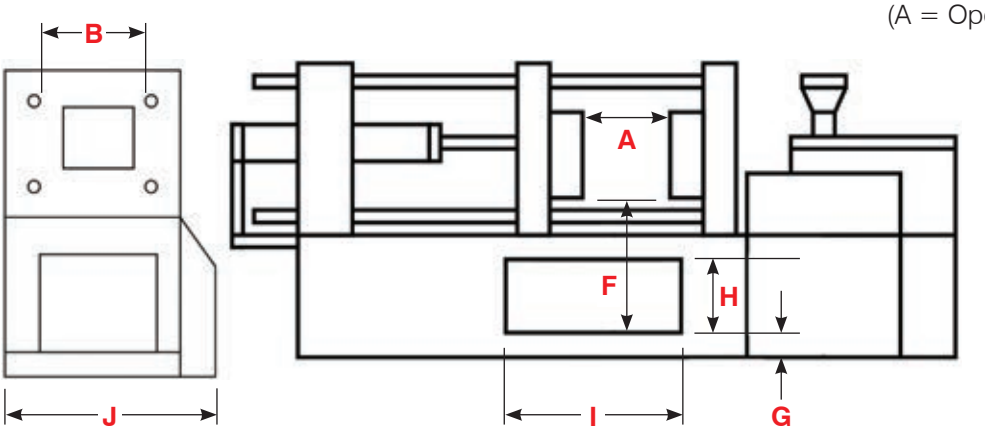
Part Diverting Systems Request Form — Part 1 of 2

SPECIFY:

Please indicate dimensions in inches or feet
(A = Operating Mold Open)



A: _____
B: _____
F: _____
G: _____
H: _____
I: _____
J: _____

S1-Sorter

(shown with optional extensions and leg stand)

Will the S1-Sorter be discharging into a container?: ❑ Yes ❑ No

If Yes: Length:_____ Width:_____ Depth:_____

If No, than what?: _____

Are there any obstructions?: ❑ Yes ❑ No

If Yes: Length:_____ Width:_____ Depth:_____

Position: _____

Optional Extensions

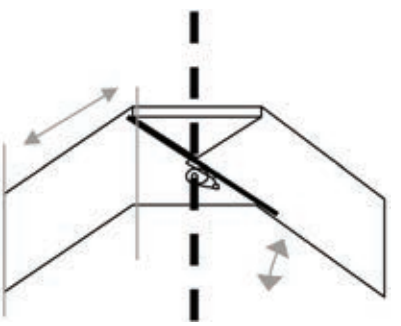
Desired extension length:

❑ 6” ❑ 12”

❑ 18” ❑ Other_____ “

(Custom charges may apply for lengths over 18”)

❑ No extensions desired



Desired angle:

❑ 25° ❑ 30° (Standard)

❑ Other _____°

(Custom charges may apply for angles over 30°)

Leg Stand

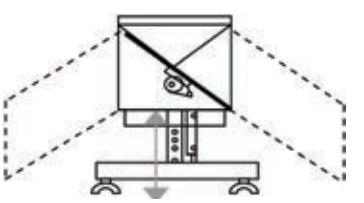
Required height from the floor:

❑ 7” ❑ 7” – 12”

❑ 12” – 20” ❑ Other_____ “

(Custom charges may apply for heights over 20”)

❑ No leg stand desired



(Continued on next page)

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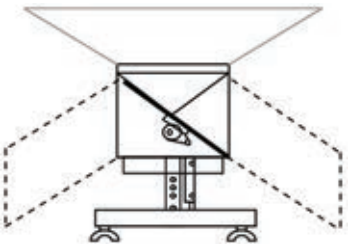
Part Diverting Systems Request Form — Part 2 of 2

Optional Flared Top (Not available with Quick-Change Rail System — below)



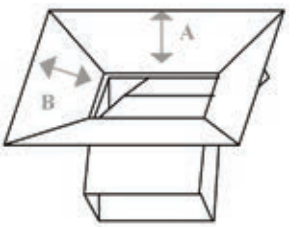
Desired Flare length:

A: ❑ 4” ❑ 6” ❑ 8” Other: _____

B: ❑ 4” ❑ 6” ❑ 8” Other: _____

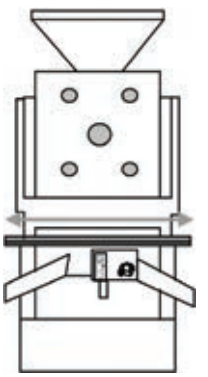
(A & B are normally the same length)

(custom charges may apply for lengths over 8”)



Optional Quick-Change Rail System

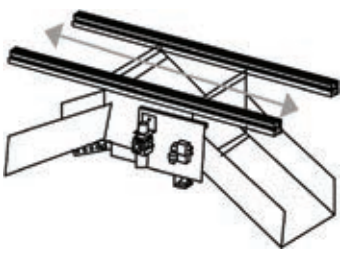
(This system mounts to the press with our “Sliding Track System”)

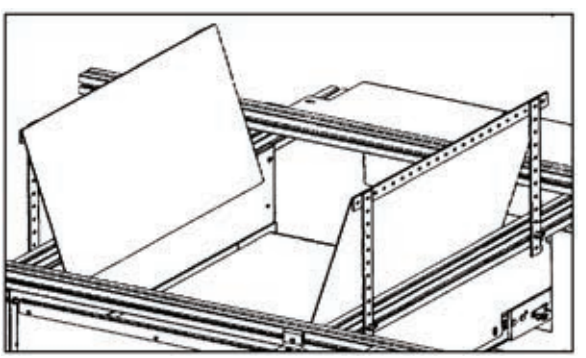


What is the depth of your press?:

❑ Up to 36” deep

❑ Up to 48” deep





Quick-Change Containment Package

These components are used to create custom part containment. This is designed for the end-user to cut to fit. Includes standard hardware.

❑ Yes, please include this package on my quotation.

❑ No, I am not interested in this optional package.

(Serves as a hopper for the QCRS System)

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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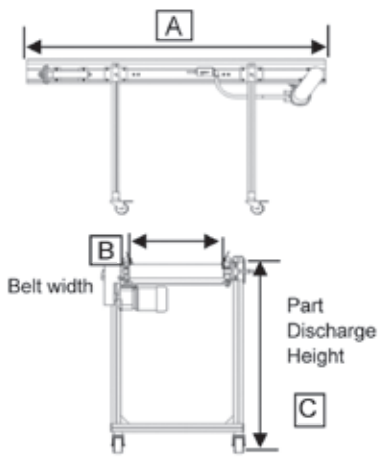
REQUEST FOR QUOTE: Make a copy. Scan and email to **sales@imscompany.com** or Fax: **1 888 288 6900** (Form online at **www.imscompany.com**)

IMS Custom Conveyors

Select Type:

Horizontal ☐

Style: (select one)
- Flat top ☐
- 3" Std side rails ☐
- Other (specify) ☐

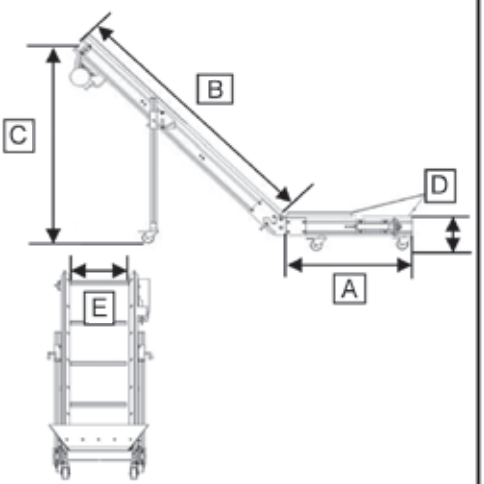


Overall Length **(A)** _____

Belt Width **(B)** _____

Height **(C)** _____

Horizontal to Incline ☐



Horizontal Length **(A)** _____

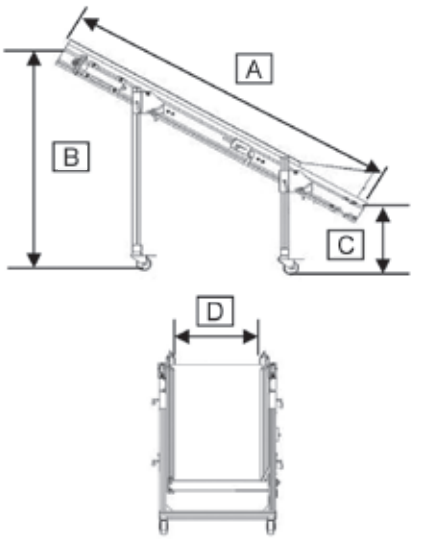
Incline Length **(B)** _____

Discharge Height **(C)** _____

Infeed Height **(D)** _____

Belt Width **(E)** _____

Incline ☐



Overall Length **(A)** _____

Discharge Height **(B)** _____

Infeed Height **(C)** _____

Belt Width **(D)** _____

Belt - (Standard Lacing) ☐

Optional - Seamless Belt ☐

Select one :

Color Green ☐ Black ☐ White ☐ Other ☐

Other color specify : _____

Temperature / Type of Material Conveyed : _____

Cleats - Yes ☐ No ☐

Std Cleat Height is 1.5" : other _____

Cleats spacing 18" Standard

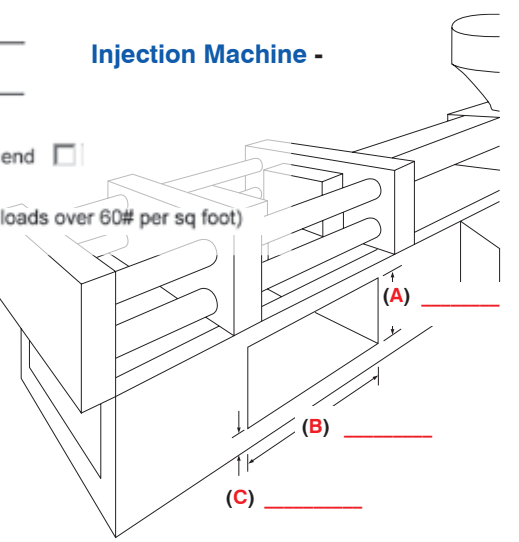
Other than standard -

Cleat spacing required : _____

Note:
If overall width of conveyor is critical, please specify max width dimension:

_____

Injection Machine -



Motor - (check one)

Std - 19 fpm ☐

Variable speed - 0-27.5 fpm ☐

Other - _____

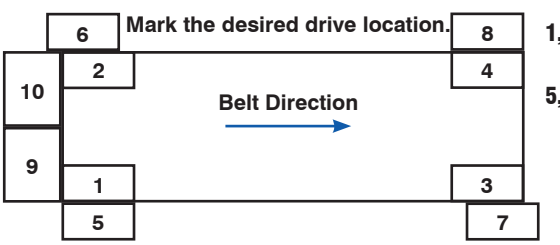
Options - (check one or more)

Indexing - Specify ☐ Part deflector at discharge end ☐

Reversing ☐ Photoelectric eye ☐

Heavy Duty Slider Bed ☐ (to withstand heavier part loads over 60# per sq foot)

Motor Position -



1, 2, 3, 4 - Mounted underneath. (standard)

5, 6, 7, 8 - Mounted on side. (up-charge)

9, 10 - Mounted on end. (up-charge

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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Replacement Conveyor Belts

Conveyor Model: _____ Serial No.: _____

A) Belt Width :_____ (in.)

B) Belt Overall Length: _____ (in./ft.)

C) Overall Belting Thickness: _____

D) Number of Plies: _____ Carcass _____ Bottom Cover _____ Color _____

E) Cleat Information: Height_____ Width_____ Centers _____ Type _____ Indent _____

F) V-Guide Information: Location _____ Notched _____

V-Guide Size (Base x Height): ❑ OO-section (5/16" x 3/16") ❑ O-section (3/8" x 1/4")

o A-section (1/2" x 5/16") ❑ B-section (5/8" x 3/8") ❑ C-section (7/8" x 7/16")

G) Splice Type: ❑ Laced ❑ Vulcanized ❑ Endless ❑ Prepared Ends

H) Food Grade: ❑ Yes ❑ No

Other Information (If Applicable):

I) Head Pulley Size : _____ (in.) **J)** Tail Pulley Size : _____ (in.)

K) Temperature and type of material being conveyed:_____

L) Size and weight of product being conveyed:_____

M) Horizontal or Incline Conveyor: _____ **N)** Degrees of Incline: _____

O) Chemicals or Petroleum products contacting belt: _____

Other Specifications: _____

Typical Specifications

Plies: Lightweight belting applications are generally 1, 2 or 3 plies.

Carcass: Type of fabric that is used in plies: interwoven polyester, spun polyester, monofilament.

Belt Covers: Top cover is usually smooth, and the bottom cover is a friction surface (FS).

Overall Belt Gauge or Thickness: This dimension is usually used as a possible check of the belt specification and to assure correct fit under and over side rails and nose bars.

Cleat Information: Standard tee cleats are available from 1/2" to 3" in height and can be welded on most center-to-center distances. All cleat types can be increased to fit under rails or guides.

V-Guides: V-guides are available in O, A, B or C sizes; V-guides are usually located on the bottom centerline of the belting.

Splice Type: Usually the splice will be mechanically laced; vulcanized splices are more expensive and time consuming to install.

Date:_____ Quantity: _____ Phone:(_____)_____ Fax: (_____)_____

Name:_____ Title:_____

Company Name: _____ Email: _____

Address:_____

City: _____ State: _____ Zip:_____

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Granulator Quotation Request/Order

Application: ❑ Central ❑ Beside-the-press ❑ Under-the-press ❑ Other _____

LARGEST PART

Material _____: ❑ Cold ❑ Hot _____° F ❑ Filled _____
(chemical description) ❑ Unfilled ❑ Other _____

Size of Parts _____: ❑ Sprues/Runners ❑ Pipe/Profile ❑ Film
(dimensions) ❑ Sheet ❑ Thermoformed ❑ Blow Molded ❑ Other _____

HEAVIEST OR TOUGHEST PART

Material _____: ❑ Cold ❑ Hot _____° F ❑ Filled _____
(chemical description) ❑ Unfilled ❑ Other _____

Size of Parts _____: ❑ Sprues/Runners ❑ Pipe/Profile ❑ Film
(dimensions) ❑ Sheet ❑ Thermoformed ❑ Blow Molded ❑ Other _____

Requested Particle Size _____: Recommended Screen Size
❑ 1/8" ❑ 3/16" ❑ 1/4" ❑ 3/16" ❑ 3/8" ❑ Other _____

Industry: ❑ Injection ❑ Blow Molding ❑ Extrusion ❑ Recycling ❑ Other _____

Mode of Feeding: ❑ Manual/Hand ❑ Robot ❑ Conveyor
❑ Feed Roll _____ (line speed min/max)

Desired Throughput _____ Pounds/Hour

Mode of Discharge: ❑ Bin with 1 1/8" Takeoff ❑ Blower/Cyclone with Fine Separation System

Electrical _____ V/3PH/60HZ ❑ Other _____

Audial Requirement: ❑ Soundproofed (Standard) ❑ Non-Soundproofed

Existing Granulator for Similar Application: Manufacturer _____ Model Number _____
Throat Size _____ HP _____ Rotor Design _____
Options _____

Requested Delivery Date _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

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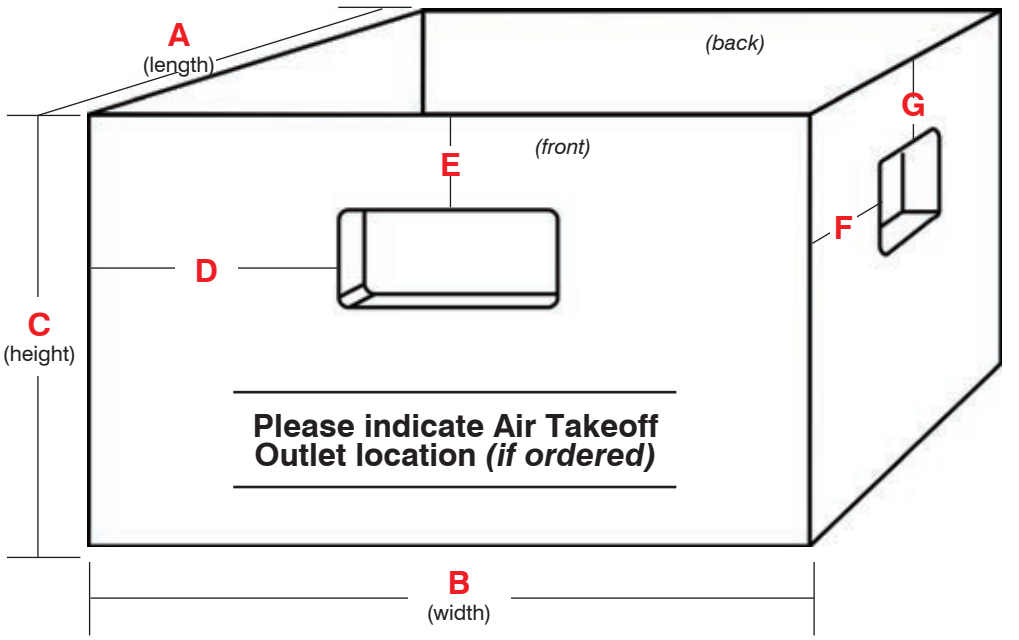
Granulator Catchpan



Catchpan Dimensions:	2❑ or 4❑ Handle Locations:	Air Takeoff Outlet
Outside	**Front/Back** **Sides**	*(If used)*
A: (length) _____	**D:** _____ **F:** _____	**O.D.:** _____
B: (width) _____	**E:** _____ **G:** _____	**Length:** _____
C: (height) _____	*Standard recessed handles are 4 1/2" long x 1 3/4" high x 1" deep*	(from outside of pan)
		Location: Sketch on drawing *(along with ACTUAL dimensions)*

Granulator Make: _____ Model: _____ Serial #: _____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

— FOR IMS USE ONLY —

IMS Part No.: _____ Price Quoted: _____ Ship Date: _____

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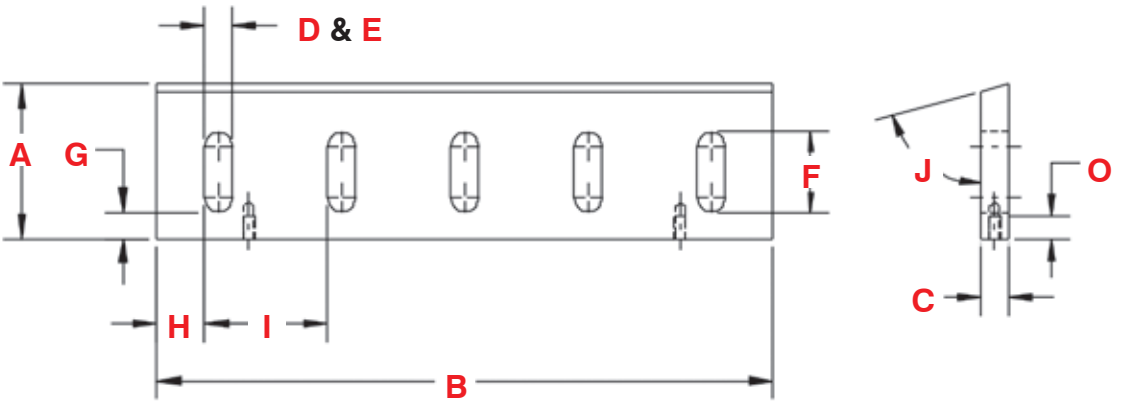
Granulator Bed Knife Form

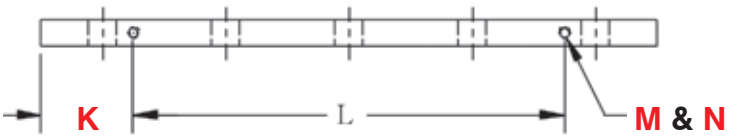


SPECIFY:

Press Make: _____

Press Model: _____

OEM# (if available): _____



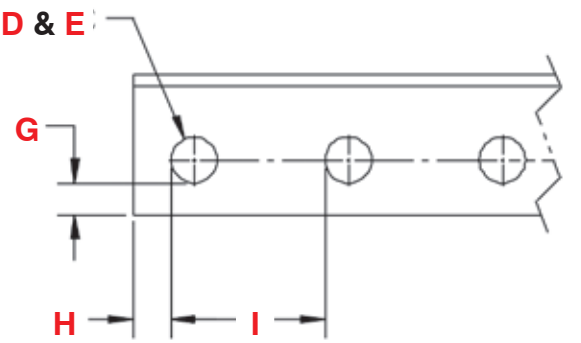
1) Note any part numbers or markings on the knife:

_____

A. Height: _____

B. Length: _____

C. Thickness: _____



2) Hole/Slot information:

Type of holes: _____

D. Quantity of holes: _____

E. Slot width/Hole diameter: _____

F. Slot length: _____

G. Bottom edge to hole/slot edge: _____

H. End to first hole/slot edge: _____

I. Typical hole/slot spacing: _____

J. Bevel angle: _____

3) Tapped hole information:

K. End to tapped hole center: _____

L. Tapped hole center to center: _____

M. Quantity of tapped holes: _____

N. Tapped hole size & pitch: _____

O. Tapped hole depth: _____

4) Note any special features:

_____

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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fax order toll-free (USA & Canada) **1.888.288.6900** | phone order toll-free (Mexico) **001.888.304.1307** | tech support toll-free (USA & Canada) **1.866.467.9001** | e-mail **sales@imscompany.com**

Please refer to imscompany.com for current pricing

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Granulator Fly Knife Form

SPECIFY:

Press Make: _____

Press Model: _____

OEM# (if available): _____

1) Note any part numbers or markings on the knife:

_____

A. Height: _____

B. Length: _____

C. Thickness: _____

2) Hole/Slot information:

Type of holes: _____

D. Quantity of holes: _____

E. Hole diameter: _____

F. C'bore/C'sink diameter: _____

G. Bottom edge to hole/slot edge: _____

H. End to first hole/slot edge: _____

I. Typical hole/slot spacing: _____

J. C'bore/C'sink depth: _____

3) Taper angle (if applies):

K. Taper angle: _____

L. Bevel angle (1): _____

M. Bevel angle (2): _____

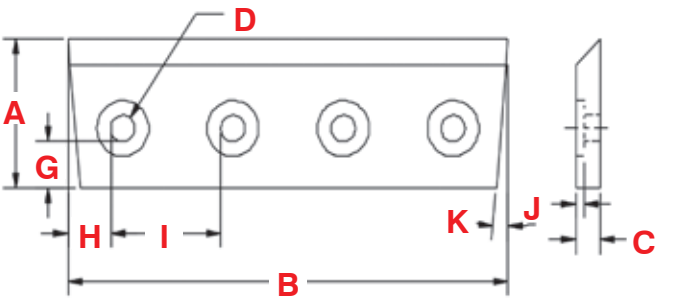
N. Horizontal bevel point: _____

4) Note any special features:

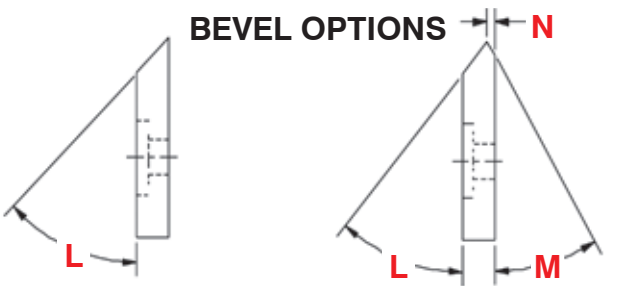
_____

_____

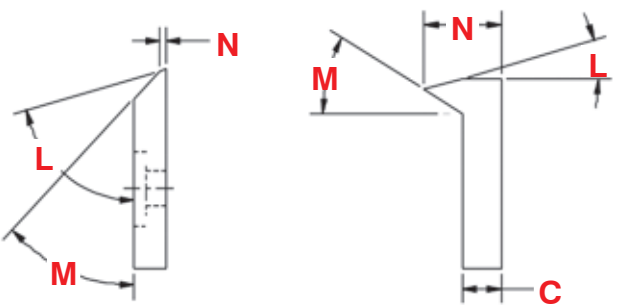
_____



BEVEL OPTIONS

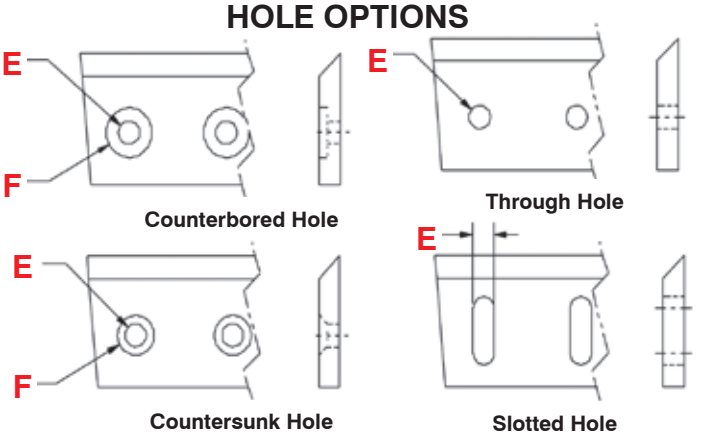


Keen Edge | Reverse Bevel



High Shear | Hook Fly

HOLE OPTIONS



Counterbored Hole | Through Hole | Countersunk Hole | Slotted Hole

Date: _____ Quantity: _____ Phone: (_____) _____ Fax: (_____) _____

Name: _____ Title: _____

Company Name: _____ Email: _____

Address: _____

City: _____ State: _____ Zip: _____

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