

VOLUME REDUCTION SCREW GUIDELINES

1. Do not use excessive R.P.M. when purging with the screw.
2. Do not allow the screw to revolve in an empty barrel
3. If the screw is tool steel, take extra care to not drop the screw. Tool steel screws are through hardened and as a result they may be more brittle than what you are used to.
4. If the screw is tool steel, do not heat the screw unevenly or excessively to remove a tip. If heating is necessary, heat evenly around the total circumference slowly.
5. If the screw is tool steel, do not weld on the screw or drive. Do not try to “touch up” nicks in flites and drive spline, as this could induce additional stress in the metal causing the screw to fail prematurely.
6. As usual, use liberal amounts of anti-seize on male tips and female threads. This will assist the ease of removing the tip assembly and help prevent thread galling.
7. Volume reduction screws will not reduce shot size. They are a means of reducing residence time only.

If you have any questions on volume reduction or tool steel screws and their care, please feel free to call our engineers at Concor.

*Tool steel screws include:

H13, A2, D2, CPM 9V, 10V, 420V, M4, Vanadis 4, 10, 23, & C17