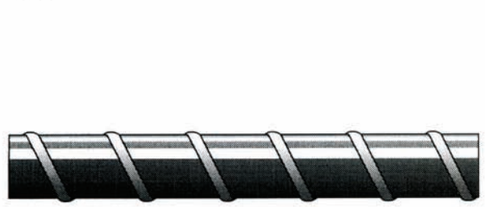
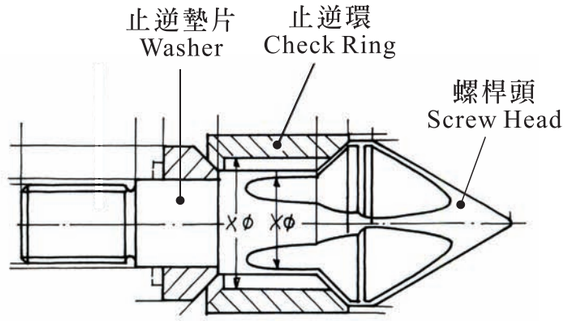
射出機配件：

螺桿 Screw





建議材料：HIP 622、HIP 267

Kennametal HTM 公司的材料

類型	硬度 (HRC)	基材	W = 耐磨損 C = 耐腐蝕
HIP 126	52-56	Co-Basis	W+(C)
HIP 127	47-50	Co-Basis	W+(C)
HIP 926	56-60	Ni-Basis	W+C
HIP 927	56-59	Ni-Basis (Fe<1%)	W+C
HIP 622	60-64	Fe-C-V-Alloy	W
HIP 267	60-64	Fe-C-Cr-V-Alloy	W+C
HIP 263	60-63	Fe-C-Cr-V-Alloy	W
HIP 269	60-63	Fe-C-Cr-V-Alloy	W+C

CICS APPROVED — NATIONAL ACCREDITATION OF CERTIFICATION BODIES

Nr. 99 377-ISO 9001

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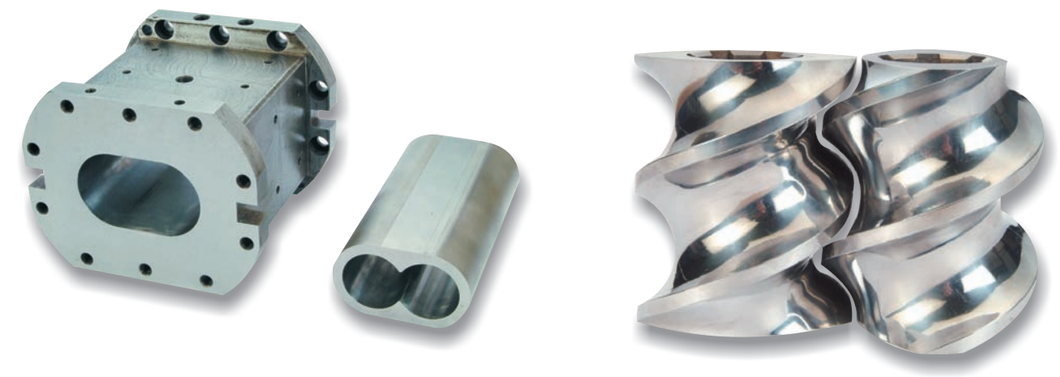
  Sole Agency for Taiwan, Malaysia , Thailand, Singapore, Cambodia and Vietnam.

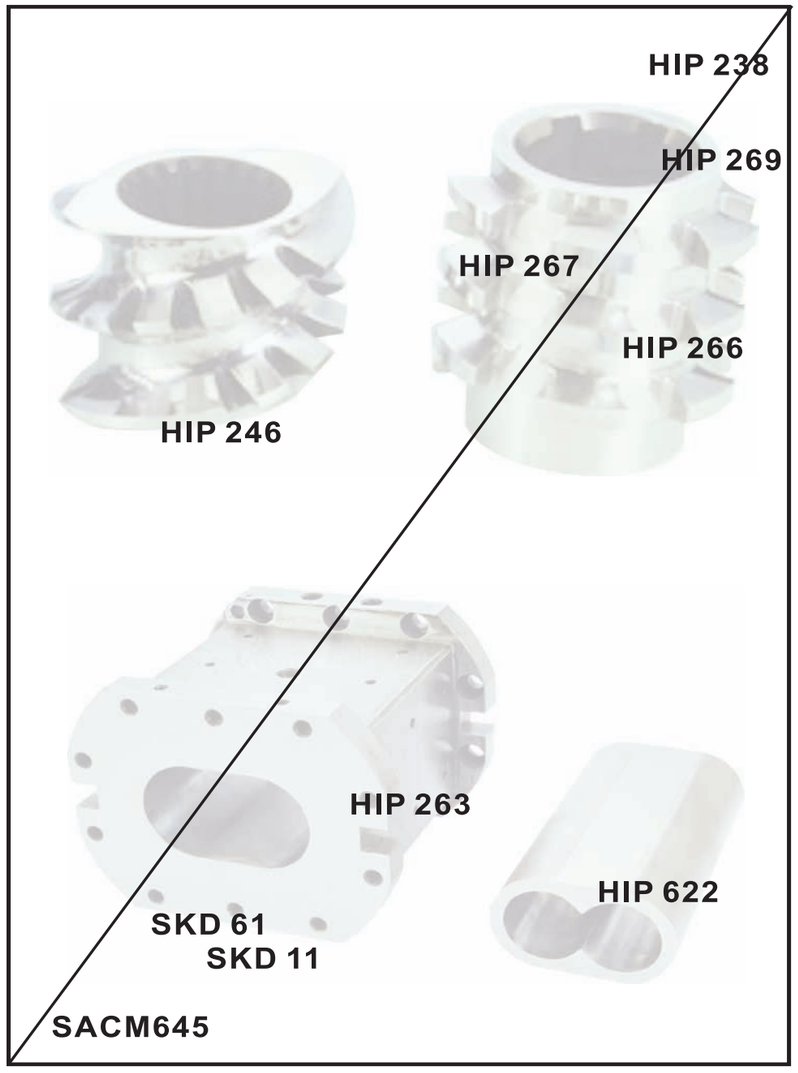
同向雙螺桿押出機專用之螺桿組塊及料管內襯熱等靜壓粉末冶金複合鋼材

HIP Compound Materials for Co-Rotating Twin Screw Extruder



KENNAMETAL HTM

耐腐蝕/耐磨耗 性能比較



耐腐蝕性

耐磨耗性

備註: SACM 645、SKD 11、SKD 61僅供比較之用，非Kennametal HTM 材料

推薦材料：

螺桿組塊 Screw element

- 披覆材料 Coating：
  -高合金工具鋼 High alloy tool steel
  (HIP 267, HIP 622, HIP 269)
- 基材 Core：
  -(低)碳鋼 (Low) Carbon steel (St. 52, Ck 45)
  -不鏽鋼 Stainless steel (1.4313 , 1.4541)

料管內襯 Barrel liner

- 披覆材料 Coating：
  -高合金工具鋼 High alloy tool steel
  -鎳(Ni)或鈷(Co)基 Ni- or Co-base hardfacing
- 基材 Body：
  -(低)碳鋼 (Low) Carbon steel

材料代碼	化學成份 (%) C	Si	Mn	Cr	W	Mo	Co	V	Ni	Cu	Nb	耐腐蝕能力	耐磨性能	硬度(HRC)	相似材質
HIP 122	0.25	1.7	<1	27	-	5	Rest	-	<4	-	-			27-34	Stellite 21
HIP 124	1.1	<1.5	< 1	29	4.5	<1.5	Rest	-	< 3	-	-			39-45	Stellite 6
HIP 125	1.9	< 2	< 2	29	-	8.5	Rest	-	< 3	-	-			46-52	Stellite 712
HIP 126	2.5	1	< 1	30	13	-	Rest	-	< 3	---	-			52-58	Stellite 1
HIP 127	1.4	< 1.5	< 0.5	31	8.5	-	Rest	---	< 3	---	---			47-50	Stellite 12
HIP 128	2.5	< 1	< 1	32.5	17	< 1	Rest	-	< 2.5	-	-			58-62	
HIP 129	2.1	-	-	33	13	4	Rest	-	-	-	-			58-62	
HIP 204	0.46	0.5	0.3	14	-	-	-	-	-	-	-	+		45-59	
HIP 236	1.6	-	-	16	4.3	1.3	-	-	-	-	-				
HIP 238	3.75	0.8	0.3	25	5	3	-	5	-	-	1			63-67	
HIP 239	2.76		-	26	10	1.12	-	2.34	-	-	-			58-67	
HIP 243	1.55	0.3	0.3	12	-	0.8	-	0.8	-	-	-	+	+	59-64	D2 (PM)
HIP 246	0.9	-	0.4	17.5	-	1.1	-	0.1	-	-	-				
HIP 260	0.9	0.35	2	0.35	-	-	-	0.1	-	-	-	--	+	56-65	
HIP 261	1.45	1.6	0.4	6.5	-	1.1		6	-	-	-	-	+	55-64	
HIP 263	2.3	0.4	0.4	12.5	-	1.1	-	4.1	-	-	-	0	+	60-63	D7 (PM) CPM 420V
HIP 266	2.75	0.8	0.7	17	0.7	1.1	-	9	-	-	-	-	+	60-62	
HIP 267	2.3	-	-	20	-	1	-	4.2	-	-	-	0	++	60-64	CPM 440V
HIP 269	2.6	0.5	0.4	26	-	1.1	-	2.4	5.8	-	1.2	++	++	60-63	
HIP 288	>0.03	0.6	1.3	22.5	-	3.1	-	-	7	0.8	-	++	--		
HIP 289	>0.03	-	-	25.5	0.7	3.6	<0.3	-	-	-	-	--	+	56-67	
HIP 341	1.27	-	-	4.2	6.4	5	-	3.1	-	-	-	--	+	54-65	
HIP 342	1.35	-	-	4.25	5.75	4.5	-	4	-	-	-	--	++	59-67	
HIP 353	1.6	-	-	4	12	1	5	5	-	-	-	--	+	51-68	
HIP 532	1.27	0.3	0.3	4.2	6.4	5	8.5	3.1	-	-	-			59-70	ASP 60
HIP 543	2.3	-	-	4.2	6.5	7	10.5	6.5	-	-	-	--	++	60-64	CPM 10V
HIP 622	2.45	0.9	0.5	5.3	-	1.3	-	9.6	Rest	-	-			40-45	(Colmonoy 42, 43)
HIP 921	0.24	3.5	-	7.5	-	-	-	-	Rest					54-58	
HIP 922	0.2	3.5	<0.1	7.5		<0.3			Rest	-	-			48-50	Colmonoy 4 (5, 52, 53)
HIP 923	0.4	4	-	9.2	-	-	-	-	Rest	-	-			56-60	Colmonoy 6, 62DJ Deloro Alloy 50
HIP 926	0.7	4.3	-	15	-	-	-	-	Rest	-	-			56-59	(Colmonoy 56, 6 PTA) Deloro Alloy 60
HIP 927	1.1	4.3	-	17	-	-	-	-	Rest	5	-			32-39	Inconel 718
HIP 928	< 0.05	-	-	19		3	-	-	53	5	5				
HIP 929	< 0.1	-	-	22	-	9	-	-	Rest	3.5	3.5			19-22	Inconel 625

推薦
++ 很好
+ 好
0 中等
- 差
-- 很差