



S.S.KHARDEKAR
INDIA PVT. LTD.

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HIGH DENSITY (HD) SLEEVES



HD SLEEVES are HIGH DENSITY HIGHLY EXOTHERMIC SLEEVES suitable for Iron & Steel Castings.

TECHNOLOGY FEATURES:-

- It contains extremely low Fluoride which helps in minimizing Fish-eye Defects especially in S. G. Iron Castings.
- It is Highly Exothermic with MEF ranging from 1.6 cm to 4.5cm.
- Due to it's nature of higher density & higher compressive, withstand heavy pressure during molding especially in high pressure line.

MECHANISM & PROPERTIES:-

- It carries a very small metal feed volume.
- Effective Feed Metal available is around 70% which results in higher % yield of the castings.
- Massive wall.
- HD Sleeves are useful on the casting where there is a limitations on the neck size & it's area.
- HD Sleeves can be located on the casting heavy sections with the special pins during molding on High Pressure Molding line.

BENEFITS:-

- It gives higher casting % yield.

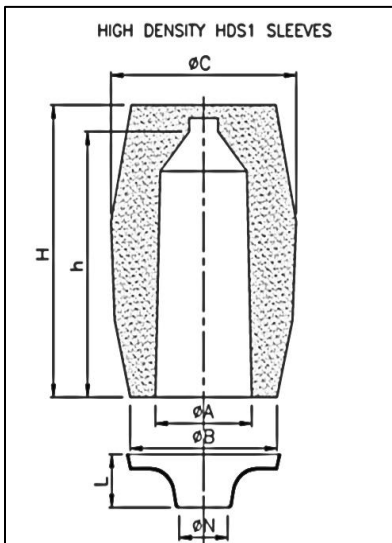
- It improves soundness of castings.

STORAGE:-

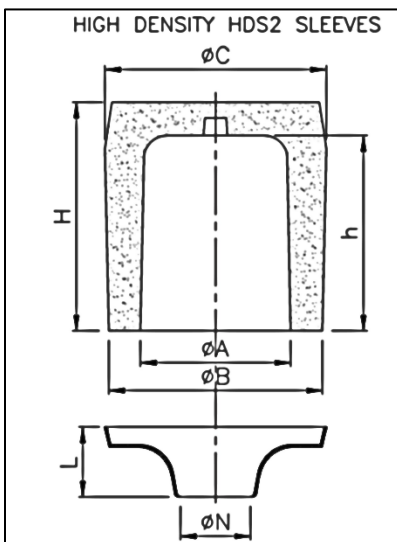
Store in a cool & dry place.

SHELF LIFE:- Shelf life is one year & recommended to use within six months.

Selection of Sleeves



DIMENSIONS OF HIGH DENSITY HDS1 SLEEVES										
HIGH DENSITY – HDS1 sleeves										
Size	Modulus Cm	Vol.cc	Dimensions(mm)							Pack size
			ØA	ØB	ØC	h	H	ØN	L	
HD 40	1.35	40	29	54	68	74	85	17.2	16	36 Nos.
HD 97	1.75	97	40	60	76	100	110	20	20	25 Nos.
HD 121	1.85	100	40	66	104	101	116	20	20	---
HD 134	2.2	134	50	82	91	96	114	23	20	16 Nos.
HD 159	2.3	133	50	82	115	95	118	23	20	9 Nos.
HD 191	2.5	179	50	90	133	116	140	23	20	9 Nos.
HD 240	2.7	240	60	98	112	114	138	25	20	9 Nos.
HD 339	3.2	299	65	98	133	121	145	25	20	----
HD 680	3.8	630	80	110	145	152	175	30	25	5 Nos.
HD 770	4.2	720	80	110	170	180	205	30	25	----



DIMENSIONS OF HIGH DENSITY – HDS2 SLEEVES										
HIGH DENSITY – HDS2 sleeves										
Size	Modulus Cm	Vol. cc	Dimensions(mm)							Pack size
			ØA	ØB	ØC	h	H	ØN	L	
HD 4/95	1.35	100	42.5	58.5	64.5	85	97.5	21	20	----
HD5/8	1.55	130	52	71	83	71	82	21	20	----
HD 6/9	1.75	180	55	81	85	80	92	23	20	----
HD 7/10	2.1	300	70	90	95	87	101	25	20	16 Nos
HD 8/11	2.3	420	77.5	101	107	96.5	112	25	20	----
HD 9/12	2.6	580	90	110	115	108	122	30	20	----