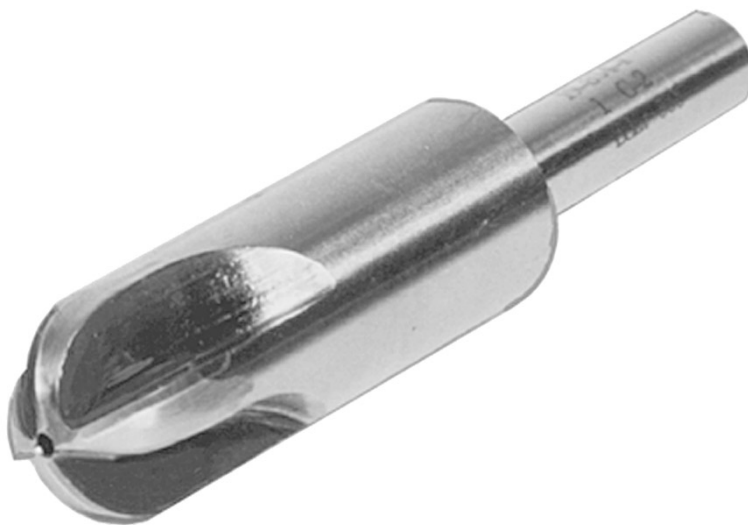




# SPRUE BUSHING REFACING TOOL

**IMS #121731, 121729, 121726  
127399, 127488**  
(NZXX-BSH500, NZXX-BSH750, NZXX-BSHM100,  
NZXX-BSHM150, NZXX-BSHM155)



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REVISIONS				
ECN#	REV	DESCRIPTION	DATE	APPROVED
	001	Deleted Obsolete Parts #105080 and 105014. Added New Parts #127399, 127488. Added graphic for new part numbers.	5/04	TEG, TMB, GDH

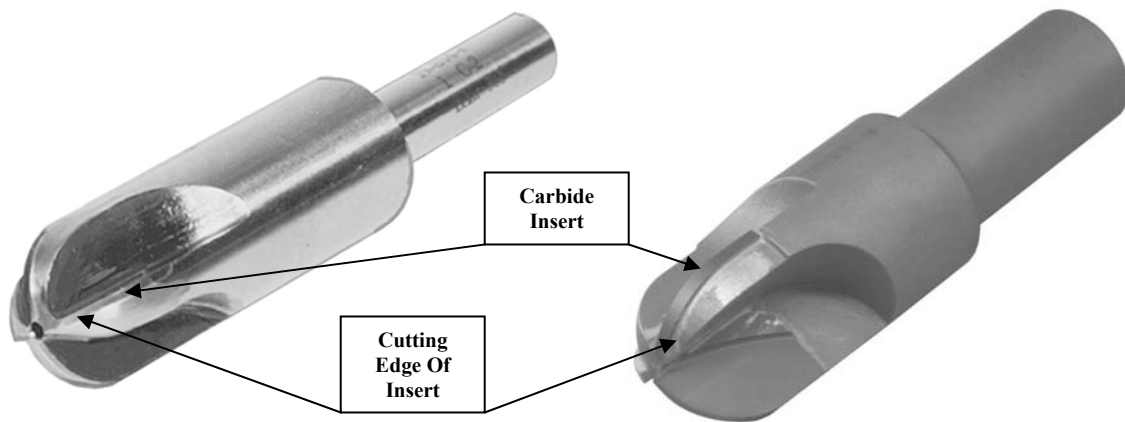
## DESCRIPTION

The IMS Sprue Bushing Refacing Tool is a carbide-tipped rotary tool to dress the existing radius on a sprue bushing. It leaves a smooth, machined surface, ready for polishing.

The smooth, well-shaped surface is needed for a good seal between the sprue bushing and the nozzle. IMS also stocks similar tools for refacing the nozzle radius.

## INSTRUCTIONS

1. Tool and sprue bushing must be well aligned and rigidly held. If they are not, the carbide tips on the tool can chip. An engine lathe is the best machine for the job, but you can use a drill press if you rigidly fixture the sprue bushing in proper alignment with the tool.
2. The best cutting speed is 56 rpm.
3. The tool is not meant to remove large amounts of material. Do not use on blank steel.
4. Coat sprue bushing radius with oil to make cutting easier and to make tool last longer.
5. Lightly apply tool to sprue bushing. Shave off just a small amount of material at a time.
6. After refacing, polish sprue bushing as required.



Part #121731, 121729, 121726

Part #127399, 127488

