

Instructions for IMS BRODY-ring®

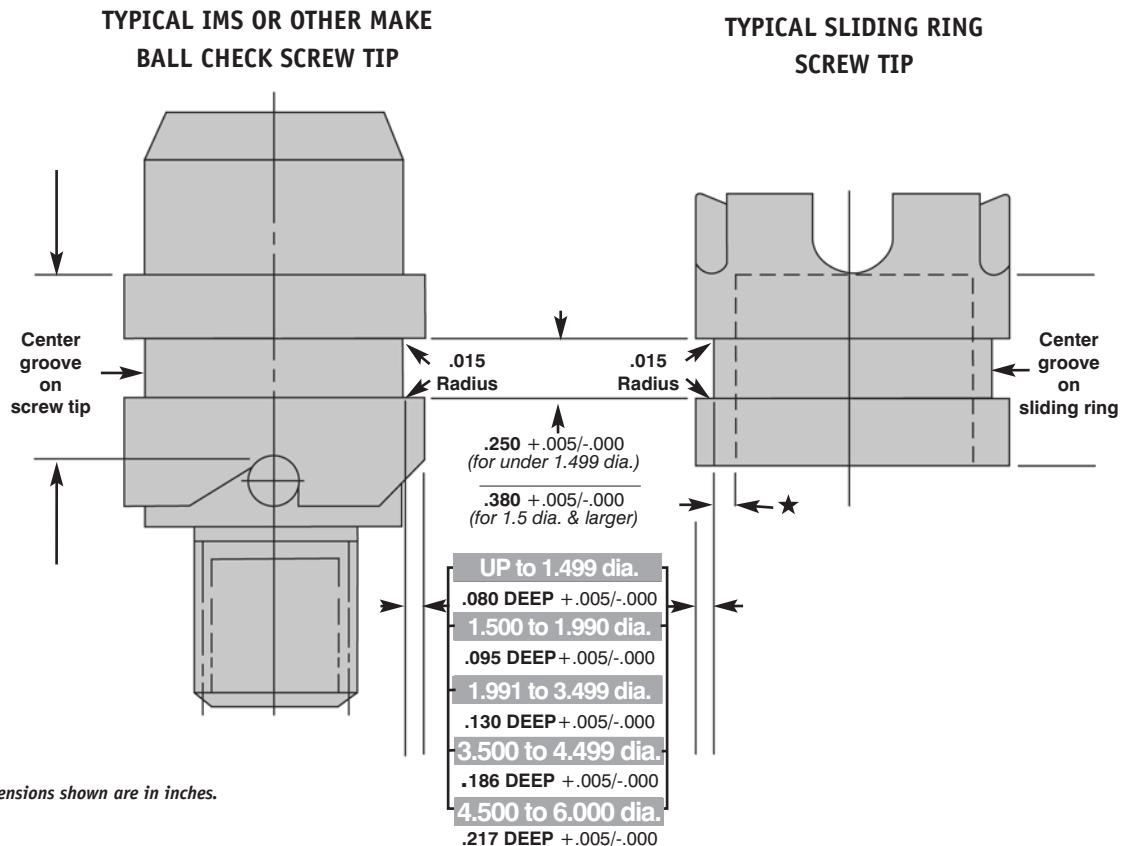
GROOVING & INSTALLATION INSTRUCTIONS

(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, phone an IMS Customer Service Representative.
- 4.) Wall thickness under groove must be equal to groove depth for adequate check ring strength. ★



BRODY-ring® is a registered trademark of IMS Company



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