

Reversible Crusher Hammer Heads



ACME® Modified ASTM A 128
Titanium Killed, Solution Annealed
Austenitic Manganese Steel (AMS)
OEM Substitute Spares
ASTM A 128/ A 128 M
Grades – A, B1, B2, C, D, E1, E2,



High performance solutions
- for steel, cement, coal, power plants;
mineral mining and ore processing industry

Reversible Impact Crusher Spares & Replacement Parts

- Hammer heads, liners, wear plates
- Ring granulators
- Beater-heads & arms
- Blow bars, Section Plates
- Pins, bushes & sleeves
- Custom made fasteners (Square/Round/Hex) head bolts & nuts



Steel, Stainless Steel, High & Super Alloy-
Heat, Wear, Abrasion, Pressure & Corrosion Resistant
Castings, Spares, Replacement Parts, Custom-Made Components
Manufacturer-Supplier to OEM's, Plants, & Process Industry
Machined, Proof-Machined, CNC/VMC Precision Machined Components
Conversion to Castings from Fabrications, Forgings & Welded Assemblies
Engineering, Materials & Metallurgical Consulting

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Why Choose Us for your Crusher/Beneficiation Equipment Spares & Consumables?

Benefits of Using ACME® Modified Austenitic Manganese Steel

We strongly recommend using Austenitic Manganese Steel and ACME's advanced metallurgical variants for Hammer/Beater Heads, Blow Bars, Impact Crusher Hammers, Wear Plates, Liners. Hammer-Pin and Arm material is suggested to be En9 or En19 in Quenched and Tempered Condition.

Advantage and Benefits of ACME Modified Austenitic Mn Steel E1 and E2, Titanium-Killed, Solution Annealed

- Optimal combination of wear and abrasion resistance, hardness, impact resistance and fracture toughness. Further enhanced performance and re-use capability is experienced with hard-facing the product
- Solution Annealed ACME Modified Austenitic Mn Steels results in less than 2% breakage/spalling.
- Uniform metallurgical properties across the cross-section of product
- Uniform wear rates and wear patterns of hammer head. Lower Gram Per Tonne (GPT) wear v/s crushed output
- More than 70% of Hammer Heads Working Faces are useful in end operation before demanding replacement
- Good cast surface finish. We use high quality mould coatings to suit the alloy and solidification properties
- Superior core work finish. No need to machine the bores. Tolerances on holes and counter sunk holes possible
- Grain refined- ASTM Grain Size 4 or finer
- Micro-alloyed with Titanium, Molybdenum, Vanadium, Tungsten, Niobium
- Clean Steel- S & P can be offered from 0.025 max to 0.08 max
- As-Cast Hardness HRC 23-30 (BHN 300). Machinable and weldable using compatible weld fillers & electrodes
- Proprietary Heat Treatment-Solution Annealed Hardness HRC 50-55
- Delivered Work Hardness HRC 60-66 in conjunct with superior fracture toughness at such high hardness
- Better crushing performance in repetitive impacting condition
- Alloy is manufactured from virgin raw materials and not from low end scrap re-melting
- Non-metallic inclusions and controlled inter-metallics
- H, N, O are maintained less than 150, 300, and 150 parts per million (ppm)
- Titanium or Niobium killed melts
- Solution Strengthened-enriched microstructure consisting prominent secondary carbides
- Can withstand wear, abrasion, and erosion due to crushing heat dissipation
- Best results in dry crushing. Slightly lower results in wet crushing. Usually higher wear rates of material are encountered in wet crushing and wet grinding compared to dry condition
- Alleviation from hydrogen pin defects, a typical failure characteristic of austenitic manganese steels
- Stable high strength tempered lath-martensite with retention of martensite 70-80% range
- Demands less frequent replacements-Cost savings in reduced annual demand for hammer heads, lower energy consumption, lower plant downtime, replacement and mounting costs, freight, and procurement costs
- Offers lower life cycle cost of crushing per MT
- Uniform crushing results and product output characteristics. Lower tonnage return. in closed circuit crushing
- Reduced iron contamination in ppm (in case of white cement and blast furnace burden / fluxes)
- Safe, and reliable in operation- breakage during operation results in accidents and damage to equipment
- Controlled mass range of each hammer to facilitate quick dynamic balancing of the equipment after mounting on the rotor
- No hard-facing as such is required as complete hammer head has uniform properties. Hence, reduction in time, material, power and labour costs associated with hard-facing surface enhancement
- Less scrap generated and lower carbon foot print. Low end quality products demand frequent replacement result in more wastage and scrap generated from used hammers, eventually add to your costs rather cost effectiveness

[Try our products in your next planned replacement and compare results!](#)

Talk to us for requirements of components, spares and replacement parts of any make OEM machine. In case, drawings are not available, new replacement part could be developed from sample, old or used OEM part.