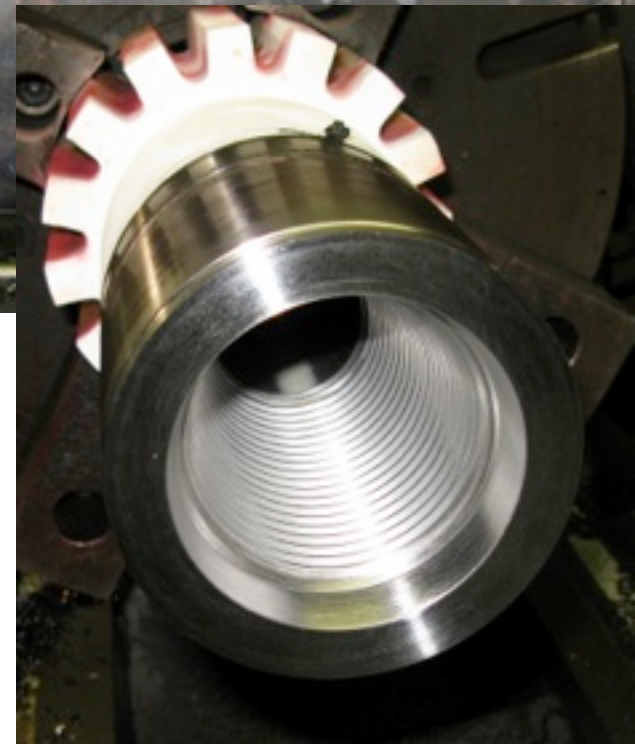


Binder/Soft Powder Mild Steel Blank HT Tool Joint

Sleeve Stabilizer/Box Thread Conversion ~ 124964 ~ 6 1/2" Impreg



4130 HT Blank Mandrel is shrink-fit and MIG welded to the mild steel blank (pre-heat 600F/post heat 1000F)
Slow Cooled in furnace heated to 1000F and turned off and let cool overnight.

Mandrel is turned and dye checked and then the box is machined.
Magnaflux inspection is done after this step.

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Plug Welds are made to join the 8620 sleeve with brazed-in inserts to the mandrel at the bit blank/weld area, at two places on the 4130 mandrel, and 360 degrees around the top sleeve/mandrel interface.

The finished sleeve assembly is diamond ground to correct size with hand grinding to blend the edges where the sleeve and bit gage meet.

The majority of this sleeve has 9/16" TCI with 12 Diamond-Impreg Inserts at top and bottom.

At right is a typical used sleeve with TCI and Diamond-Impreg inserts after a 100 hour run.

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