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# SECTION H: FISHERTECH RENEWAL PARTS SALES AND SERVICE

Fishertech provides an extensive list of services available to you following the installation of your Injected Metal Assembly system.

## Renewal Parts

Fishertech maintains an extensive inventory of genuine IMA renewal parts, designed and built exclusively for your system. Reference drawings for the most common renewal parts for the system are contained in this section. For more information about renewal parts or to place an order, please contact us at:

**tel:** +1 (705) 748-9522

**fax:** +1 (705) 748-6312

**E-mail:** [renewalparts@fishertech.com](mailto:renewalparts@fishertech.com)

## Service and Training

Fishertech offers various service and training options to help you ensure that your IMA system will continue to operate at the levels of productivity and quality achieved when the system was first installed at your company.

### Troubleshooting Hotline

A no-charge, troubleshooting hotline gets you directly in contact with a Fishertech technical representative. Call:

**Hotline:** +1 (705) 748-9544, Ext. 2487

### Emergency Service Response

A staff of technical representatives are available to quickly respond to emergency service requests. In most cases, we can be on-site within 24 hours of your call. Call:

**Hotline:** +1 (705) 748-9544, Ext. 2487

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## Service and Maintenance Contracts

A Service and Maintenance Contract provides you with the confidence that your IMA system will continue to operate at the productivity and quality levels you expect. A regular tune-up by a Fishertech technical representative will improve the operation of your system and problems can often be identified before they impact your productivity. Contact us for details about a Service and Maintenance Contract structured specifically for your operation and equipment.

## Training

A training session conducted at your facility by a Fishertech technical representative, will provide your personnel with the knowledge required to operate and maintain your IMA system efficiently and safely.

For more information, contact us at:

**tel:** +1 (705) 748-9522

**Hotline:** +1 (705) 748-9544, Ext. 2487

**fax:** +1 (705) 748-6312

**E-mail:** [service@fishertech.com](mailto:service@fishertech.com)

## IMA RENEWAL PARTS

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## ORDER NUMBER CROSS-REFERENCE

On August 31, 1998, Fishertech launched a new business system called MFG/PRO. As a result, our renewal parts are now identified with new numbers. This sheet lists the most common IMA renewal parts with a cross-reference from our OLD PART numbers to our NEW PART numbers.

If the part you are looking for does not appear on this sheet, please contact us at:

tel: +1 (705) 748-9522

fax: +1 (705) 748-6312

**E-mail: [renewalparts@fishertech.com](mailto:renewalparts@fishertech.com)**

DESCRIPTION	OLD PART #	NEW PART #
<b>Adjustable Block</b>	<b>3500B8722</b>	<b>35008722</b>
<b>Air Cylinder</b>	<b>C2043M0112</b>	<b>0151570</b>
<b>Amplifier</b>	<b>C1141E9105</b>	<b>0151000</b>
<b>Cap</b>	<b>24H723</b>	<b>24723</b>
<b>Cap - split die</b>	<b>3500B2715</b>	<b>35002715</b>
<b>Cap Retainer</b>	<b>2500A1918</b>	<b>25001918</b>
<b>Clevis</b>	<b>94196</b>	<b>10704P2</b>
<b>Connector - male to female</b>	<b>C1013A0206</b>	<b>0150222</b>
<b>Contacto – 110V, 60Hz, 20A</b>	<b>C1104A3203</b>	<b>0150855</b>
<b>Crank Pin</b>	<b>95054</b>	<b>30712</b>
<b>Cylinder - 1 1/8 inch bore</b>	<b>C2061E2210</b>	<b>0151842</b>
<b>Cylinder - 4 way, 15-140 spt</b>	<b>94468</b>	<b>35007635P2</b>
<b>Cylinder – mod 4 way 1/4 NPT</b>	<b>C2043M0013</b>	<b>25011397</b>

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Cylinder Housing	95573	80634
Eccentric Pin	2501A0342	25010342
Ejector Bar	3500B7987	35007987
End Cap – CPM	95585	44058
End Cap - Oph	91015	35007973
Fixed Die	5500C6375	55006375
Flat Faced Fixed Die	97804	55004336
Front Slide	3500B9857	35009857
Gooseneck - ½ inch	94247	15002450G1
Gooseneck - ¾ inch	94412	15002450G2
Gooseneck – 1 inch	94249	15002450G3
Guide Bushing - “A” 1.812 inch	41G443P1	41443P1
Guide Bushing - “B” 2.375 inch	41G443P2	41443P2
Heater Element - large	97973	25010307
Heater Element – small	93848	11095G1
Hinge Block	26H094	26094
Hinge Pin	94801	10023
Hinge Pin - front of die	24H571	24571
Horizontal Cable Housing	81D188	81188
Key	24H726	24726
Lever - new style	94421	31235G1
Lever - old style	95071	30679

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<b>Lever Assembly</b>	<b>97982</b>	<b>55005680</b>
<b>Limit Switch</b>	<b>C1147E2128</b>	<b>0159611</b>
<b>Link</b>	<b>97986</b>	<b>25011466</b>
<b>Link Pin</b>	<b>95057</b>	<b>30685</b>
<b>Locating Pin</b>	<b>95664</b>	<b>45239</b>
<b>Lower Links - pair</b>	<b>24H565</b>	<b>24565</b>
<b>Main Slide</b>	<b>5500C4621</b>	<b>5504621</b>
<b>Manifold</b>	<b>50F850</b>	<b>50850</b>
<b>Melt Pot - medium</b>	<b>93801</b>	<b>71335</b>
<b>Melt Pot - small</b>	<b>93849</b>	<b>90296G5</b>
<b>Melt Pot Assembly - medium</b>	<b>97911</b>	<b>90939G3</b>
<b>Nozzle - CPM</b>	<b>97976</b>	<b>35009044</b>
<b>Nozzle - mounted point</b>	<b>94604</b>	<b>35007471</b>
<b>Nozzle - standard lead</b>	<b>94605</b>	<b>35007468</b>
<b>Nozzle - standard zinc</b>	<b>94600</b>	<b>35007470</b>
<b>Nozzle Lap - lead</b>	<b>97041</b>	<b>11311P1</b>
<b>Nozzle Lap - zinc</b>	<b>97042</b>	<b>11311P2</b>
<b>Pin/Sleeve</b>	<b>94115</b>	<b>30790P1</b>
<b>Plunger - ½ inch</b>	<b>94115</b>	<b>30790p1</b>
<b>Plunger - ¾ inch</b>	<b>94411</b>	<b>30827p1</b>
<b>Plunger – 1 inch</b>	<b>97640</b>	<b>35003471p1</b>
<b>Prox. Sensor - upset sensor</b>	<b>97951</b>	<b>15002509G3</b>

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<b>Prox. Sensor - upsetter</b>	<b>98041</b>	<b>15003356G1</b>
<b>Push Button – 115V miniature</b>	<b>C1143A2502</b>	<b>151046</b>
<b>Rear Element</b>	<b>93866</b>	<b>50630G2</b>
<b>Rear Links</b>	<b>97067</b>	<b>41532P1</b>
<b>Rear Slide</b>	<b>91061</b>	<b>35009856</b>
<b>Roller Arm</b>	<b>91016</b>	<b>35007972</b>
<b>Seal Plug</b>	<b>97818</b>	<b>25008745</b>
<b>Seat Lap - lead</b>	<b>97035</b>	<b>21370</b>
<b>Seat Lap - zinc</b>	<b>97037</b>	<b>21450p1</b>
<b>Spacers</b>	<b>22H454P245</b>	<b>22454P245</b>
<b>Split Carrier Housing</b>	<b>7500D3767</b>	<b>75003767</b>
<b>Sprue Lap</b>	<b>2501A2126</b>	<b>25012126</b>
<b>Thermo Leads</b>	<b>96695</b>	<b>10656P1</b>
<b>Thermocouple – J type</b>	<b>96400</b>	<b>90952G1</b>
<b>Thermocouple – K type</b>	<b>C1301B4106</b>	<b>0151388</b>
<b>Toggle Arm - main</b>	<b>62F959</b>	<b>62959</b>
<b>Toggle Arm - upper</b>	<b>94858</b>	<b>10027</b>
<b>Toggle - upper</b>	<b>26H093</b>	<b>26093</b>
<b>Twin Torch Tip</b>	<b>51F049</b>	<b>51049</b>
<b>Upper Link</b>	<b>24H566</b>	<b>24566</b>
<b>Y-bracket Assembly</b>	<b>94419</b>	<b>50828G1</b>
<b>Yoke</b>	<b>97983</b>	<b>55005681</b>

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## Properties Of Zinc Alloys

# COMPOSITION AND PROPERTIES OF ALLOYS

Injected Metal Assembly™ systems and Injected Metal Pichtr™ systems from FisherTech use only special high grade zinc alloys because they are strong, versatile, depend-

able, and cost effective. ZAMAK 3, ZAMAK 5, and ZA-8 are precisely formulated metal alloys that offer the mechanical properties of medium strength metals.

DESIGNATION	ALLOY GROUP ASTM Designation General Description	ZINC AC40A Zamak 3	ZINC AC41A Zamak 5	ZINC-ALUMINUM ZA-8 (Die Cast) ZA-8
COMPOSITION PERCENTAGE BY WEIGHT	Aluminum Cu Copper Mg Magnesium Fe Iron Pb Lead Cd Cadmium Sn Tin Zn Zinc (balance) average	3.5-4.3 0.25 Max 0.025-0.07 0.100 Max 0.005 Max 0.004 Max 0.003 Max Remainder	3.5-4.3 0.75-1.25 0.02-0.10 0.100 Max 0.005 Max 0.004 Max 0.005 Max Remainder	5.0-8.8 0.6-1.3 0.015-0.050 0.075 Max 0.005 Max 0.006 Max 0.005 Max Bal. zinc
PHYSICAL PROPERTIES	Density Rho g/cm <sup>3</sup> Melting Range T °C Coefficient of Thermal Expansion μm/m°C μm/mK Thermal Conductivity W/m°C W/mK Electrical Conductivity % IACS % ICR Pattern Shrinkage %	7.249 6.800 718-728 381-387 15.2 27.4 35.9 113 27 53.9 0.7	7.349 6.800 717-727 380-386 15.2 27.4 34.6 106 23 63.2 1.7	7.227 6.800 707-719 375-384 13.0 25.9 65.8 115 22.7 62.2 0.7

DESIGNATION	ALLOY GROUP	ZINC	ZINC	ZINC-ALUMINUM
	ASTM Designation	AC40A	AC41A	ZA-8 (Die Cast)
	General Designation	Zamak 3	Zamak 5	ZA-8
MECHANICAL PROPERTIES	Tensile Strength			
	psi	47,000	47,000	59,200
	MPa	283	278	344
	Yield Strength			
	(0.2% offset)			
	psi	31,000	33,000	42,000
	MPa	211	228	293
	Compressive			
	Yield Strength			
	(0.1% offset)			
	psi	92,000	87,000	81,000
	MPa	414	606	252
	Elongation			
	% in 2 inches (51 mm)	10	8	8
Shear Strength				
psi	31,000	28,000	40,000	
MPa	211	263	278	
Hardness				
RHV (1/16")	up to 62	up to 31	up to 103	
Charpy Impact Strength				
kJ/m <sup>2</sup>	13	48	31	
J	58	63	42	
Fatigue Strength				
psi	8,000	8,200	17,000	
MPa	47.0	56.5	103	

1. Compressive Strength

DESIGNATION	ALLOY GROUP	ZINC	ZINC	ZINC-ALUMINUM
	ASTM Designation	AC40B	AC41A	ZA-8 (Die Cast)
	General Designation	Zamak 3	Zamak 5	ZA-8
INTERNATIONAL EQUIVALENTS	France (AFNOR)	ZM65	ZM101G	ZM801
	Germany (DIN)	SD-ZnAl4 (Zn40)	GD-ZnAl10Cu (Zn40)	Zn-Al8Cu-1 (ZA-8)
	Italy (UNI)	U-ZnAl4 (Zn40)	G-ZnAl10Cu1 (ZA40Cu1)	symbol: ZnAl8Cu1
	Japan (JIS)	Class 2	Class 1	symbol: ZnAl8Cu1
	Spain (UNE)	FZnAl4 (Zn40)	FZnAl10Cu1 (Zn40Cu1)	symbol: ZnAl8Cu1
	United Kingdom (BS)	Alloy A	Alloy B	ZA-8 (Zinc-Aluminum)
	United States (SAE)	503	528	ZA-8