

# Induction Shrink fitting carbide ring

United Induction Heating Machine Limited

We are experienced in Induction Heating, induction heating machine, Induction Heating equipment. They are widely used in induction heating service, induction heat treatment, induction brazing, induction hardening, induction welding, induction forging, induction quenching, induction soldering induction melting and induction surface treatment applications  
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**Shrink fitting carbide ring Objective** Shrink fitting a carbide ring into a steel valve seat

**Material** Steel valve seat 6" (152.4mm) OD with 3" (76.2mm) ID hole & .75" (19mm) thick, carbide ring

**Temperature** 500 °F ( 260 °C)

**Frequency** 55 kHz

**Equipment** • Power of 25kW induction heating system, equipped with a remote workhead containing two 0.50 µF capacitors for a total of 0.25 µF

• An induction heating coil designed and developed specifically for this application.

**Process** A three turn helical coil is used to heat the steel valve seat. The steel valve seat is placed in the coil and heated for 30 seconds to enlarge the center hole & drop the carbide ring in for the shrink fitting process.

**Results/Benefits** Induction heating provides:

- Accurate and repeatable results
- Ease of integration into existing production lines
- Energy efficient, only heats the part, not the atmosphere around it
- Hands-free heating that involves no operator skill for manufacturing
- Even distribution of heating shrink fitting carbide ring

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