

CRUSHER WEAR PARTS

HSI Impactor Blow Bars

Bars for horizontal shaft impactors across the common rotor designs, in the full range of wear alloys.



OVERVIEW

Horizontal shaft impactors do their crushing by throwing material against the blow bar and then against the impact aprons. The bar therefore takes the initial strike, and its alloy sets both the wear life and how the machine behaves when something uncrushable arrives.

Melco casts HSI blow bars across the full alloy range: high chrome for abrasive clean rock, martensitic steel for mixed duty, austenitic manganese for high impact and recycling work. Bars are supplied in weight-matched sets so the rotor stays balanced.

We work from OEM drawings, customer drawings or a physical sample. Where a customer is unsure which alloy to run, we normally suggest trialling two grades on the same machine and comparing tonnes per set.

APPLICATIONS

- Horizontal shaft impact crushers, primary and secondary
- Aggregate, limestone and hard rock crushing
- Recycled concrete and asphalt processing
- Mobile and track-mounted impactor spreads

KEY FEATURES

- Full alloy range from one supplier - High chrome, martensitic and manganese steel bars in the same profile, so you can trial grades without changing supplier.
- Weight-matched sets - Bars weighed and paired before dispatch to keep the rotor in balance.
- Section-appropriate heat treatment - Cycle chosen for the actual section thickness, so properties hold through the bar rather than only at the surface.
- Full test documentation - Chemical analysis, hardness and dimensional report supplied per heat.

MANUFACTURING SPECIFICATION

Parameter	Specification
Moulding	No-bake resin sand and green sand
Melting	Induction furnace, spectrometer-controlled
Piece weight	5 kg - 2,000 kg
Heat treatment	In-house, computer-controlled cycles
Dimensional control	Template and CMM check against drawing
Documentation	Chemical, hardness and dimensional report per heat

MATERIAL GRADES

Grade	Typical composition	Hardness	Suited to
ASTM A532 Cl. II Type B (15Cr-3Mo)	14-18% Cr, 2.5-3.5% Mo, 2.4-3.0% C	58-64 HRC	General high-abrasion impact crushing
ASTM A532 Cl. II Type D (20Cr-Mo)	18-23% Cr, 1.5% Mo max, 2.0-3.3% C	58-63 HRC	Abrasive limestone and secondary duty
ASTM A532 Cl. III Type A (25Cr)	23-30% Cr, 1.5% Mo max, 2.0-3.3% C	56-62 HRC	Highest abrasion, corrosive or wet feed
Low-alloy martensitic steel	0.3-0.5% C, Cr-Ni-Mo alloyed	45-52 HRC	Mixed impact and abrasion
Martensitic / manganese composite	Hard martensitic face, austenitic Mn body	50 HRC face, tough core	Reinforced concrete and recycling

ENQUIRIES

Send a drawing, a sample or the machine model and we will confirm the fitment, recommend a grade and quote a firm price and delivery date.

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