

## Price List - Page 1 Effective: January 1, 2011

	0 to 150 lb	151 to 300 lb	301 to 500 lb	501 to 700 lb	701 to 1000 lb	Over 1000	Minimum Charge
<b>1045, 1141, 4140, 6150, 52100 1095, WH, Harden Only (carbed)</b>	\$1.75	\$1.70	\$1.60	\$1.50	\$1.40	\$1.30	\$32.00
<b>0-1, A-2, D-2, S-7, L-6</b>	1.90	1.85	1.75	1.65	1.55	1.45	32.00
<b>H-13, 410 to 440 SS Stainless</b>	2.00	1.95	1.85	1.75	1.65	1.60	32.00
<b>HSS, M-2, T-15, (High Temps)</b>	3.00	3.00	3.00	3.00	3.00	3.00	52.00
<b>17-4, Age Hardening (See Back Also)</b>	1.25	1.25	1.25	1.25	1.25	1.25	62.00
<b>+ Note: Case depths listed are total case, not effective; call if question</b>							
<b>Carburize &amp; Harden (Standard Run) (Depth varies from .035 to .060 max)</b>	1.90	1.85	1.75	1.65	1.50	1.35	42.00
<b>+ Carburize &amp; Harden (Long Run) (Depth varies from .060 to .080)</b>	3.05	3.00	2.95	2.85	2.75	2.55	302.00
<b>Case Depths Greater Than .080</b>	– Call for Quotation –						1500.00
<b>+ Carburize Only (Standard &lt; .060)</b>	1.90	1.85	1.75	1.65	1.50	1.35	102.00
<b>Carbo-Nitride/Light Case to .015</b>	1.50	1.45	1.40	1.35	1.30	1.25	42.00
<b>+ Gas Nitride</b>							
<b>.005 Max. (Standard)</b>	1.90	1.90	1.90	1.90	1.90	1.90	102.00
<b>.006 – .010 (24 Hrs.)</b>	2.40	2.40	2.40	2.40	2.40	2.40	202.00
<b>.011 – .020 (50 Hrs.)</b>	2.90	2.90	2.90	2.90	2.90	2.90	252.00
<b>.021 – .030 (72 Hrs.)</b>	3.40	3.40	3.40	3.40	3.40	3.40	352.00
<b>+ Note: Case depths deeper than those listed require extended furnace times, please call for quotation.</b>							
<b>Anneal-Standard Generic Temps</b>	1.40	1.30	1.25	1.20	1.15	1.15	32.00
<b>Anneal-Vac Hi-Temp, 300 Series SS</b>	1.90	1.85	1.80	1.70	1.60	1.55	202.00
<b>Normalize (No Blast)</b>	1.40	1.30	1.25	1.20	1.15	1.15	32.00
<b>Stress Relieve (No Blast)</b>	.60	.60	.60	.60	.60	.60	32.00
<b>Stress Relieve in Vacuum</b>	1.10	1.10	1.10	1.10	1.10	1.10	62.00

**Note:** Parts that need straightening will be straightened unless we are otherwise informed. Also, the pound prices listed do NOT include straightening or blasting charges, see reverse side for those. Minimums listed assume normal scheduling not requiring a custom, special run.

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<b>Certifications of Compliance</b>	\$ 50.00
<b>Special or Customized Certs</b>	\$ 100.00
<b>Furnace Charts</b>	\$ 50.00
<b>Microsections</b>	\$ 150.00
<b>Process per AMS 2759</b>	Call for quotation - Requires Special Run, \$200.00 minimum
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<b>Straightening</b>	\$ 40.00 per hour
<b>Blasting (Glass Bead Only)</b>	\$ 40.00 per hour
<b>Fixture, Rack, Wire, Mask, Package</b>	\$ 40.00 per hour, plus materials
<b>Inspection / RC Parts</b>	\$ 40.00 per hour
<b>Vapor Degreasing</b>	\$ .50 per pound, \$50.00 per hour, \$50.00 min., ht jobs only
<b>Induction Hardening</b>	\$ 70.00 per hour, \$40.00 minimum
<b>Flame Hardening</b>	\$ 62.00 per hour, \$40.00 minimum Per linear inch – 2" width swath 0 - 199"           \$.50 200 - 299"       \$.45 Over 299"         \$.40
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<b>Furnace Time (Air)</b>	\$ 30.00 per hour, \$32.00 minimum
<b>Furnace Time (Vacuum)</b>	\$ 62.00 per hour – irregular temperatures
<b>Vacuum Furnace – Special Run</b>	\$ 62.00 per hour x total time or weight of job, whichever is greater, \$ 200.00 minimum
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<b>Vacuum Temper Only (Special Draw)</b>	\$ .60 per pound, \$30.00 per hour, \$62.00 minimum
<b>Multiple Tempers (Triple Draw)</b>	Two tempers are included in pound price. 3rd temper \$ .60 per pound, \$32.00 minimum
<b>Freeze and Temper (Stabilize)</b>	\$ 1.05 per pound, \$62.00 minimum
<b>Freeze (Deep Cryogenics to -320°F)</b>	\$ 1.25 per pound, \$62.00 minimum, \$30.00 per hour
<b>Shrink Fit (Freeze-Heat-Assemble)</b>	\$ .60 per pound, plus \$30.00 per piece min., \$62.00 min.
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<b>Age Hardening</b>	\$ 30.00 per hour, \$1.25 per pound, \$62.00 minimum
<b>17-4, 17-7, 13-8, 15-5 Age Harden</b>	\$ 1.25 per pound, Air-\$62.00 minimum, Vacuum-\$200.00.
<b>17-4, 17-7, 13-8, 15-5 Solution or Condition</b>	\$ 1.90 per pound-\$200.00 minimum.
<b>Beryllium Copper (Age or Anneal)</b>	\$ 1.25 per pound, \$62.00 minimum
<b>Inconel 718, A-286, (Age)</b>	\$ 1.25 per pound, \$62.00 an hour, \$1000.00 minimum.
<b>Aluminum (Stress Relieve or Age)</b>	\$ .60 per pound, \$62.00 minimum, \$30.00 per hour
<b>Aluminum (Anneal to 0 Only)</b>	\$ 1.25 per pound, \$62.00 minimum, \$30.00 per hour Limited processing, we cannot solution to T-4 Call for quotation on extended aging cycles.
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<b>Saturday Overtime Rate</b>	\$ 60.00 per hour, one man, four hour min., plus cost of job
<b>Sunday Overtime Rate</b>	\$ 70.00 per hour, one man, four hour min., plus cost of job