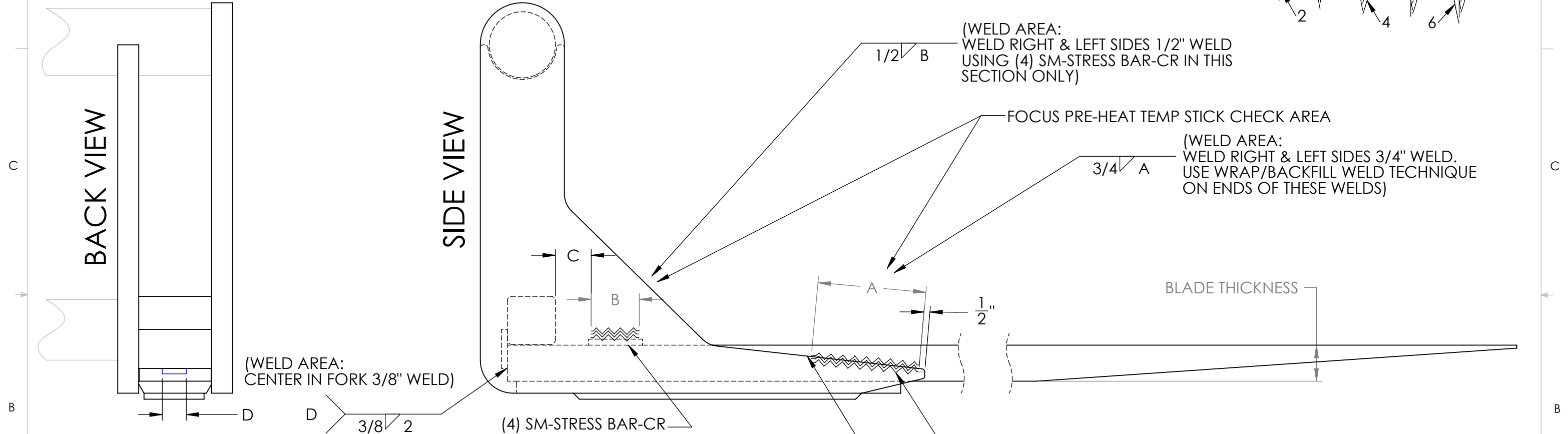
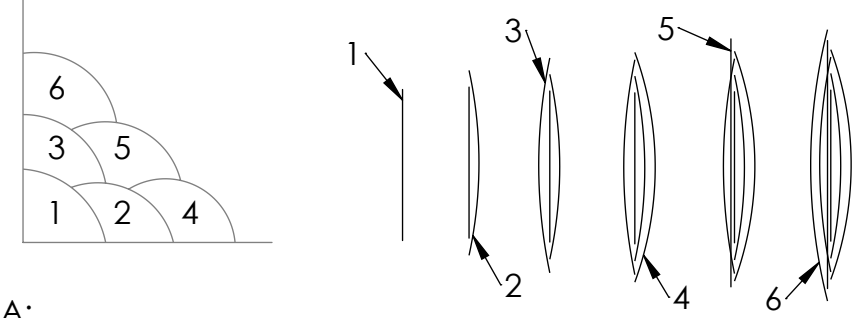


RECOMMENDED PROCEDURE:

1. CUT OUT OLD BLADES WITH GRINDING WHEEL (DO NOT USE TORCH).
2. CLEAN UP POCKET AREA BY GRINDING SMOOTH REMAINING WELDS.
3. INSTALL NEW BLADES INTO POCKET AREA AND TACK IN PLACE.
4. CENTER THE STRESS BARS IN WELD LOCATION (B), MAKING SURE THEY ARE TIGHT AGAINST THE SHOES AND BLADES AND TACK IN PLACE.
5. PRE-HEAT "A" & "B" WELD AREA'S TOGETHER.
6. WELD "A" AREA.
7. WELD "B" AREA (MAKE SURE TO USE STRESS BARS TO FILL GAP!)
8. WELD "D" AREA AT BOTTOM REAR OF SHOE AS SHOWN (NO PRE OR POST HEAT REQUIRED)-NOT A CRITICAL STRESS AREA OF THE BLADE.

WRAP/BACKFILL WELD TECHNIQUE:

- ON WELD AREA "A" ONLY!



PRE-HEAT PROCEDURE:

THE PREHEAT TEMPERATURE SHOULD BE ABOVE 600° F & NOT TO EXCEED 850° F, TO AVOID THIS:

- USE A SOFT FLAME AND DO NOT LEAVE UNATTENDED
- USE A 600° F TEMP STICK FREQUENTLY ON HEATED SURFACE UNTIL IT MELTS

WELD PROCEDURE:

- WELD WITH MET110 or MC100 IN AREA'S SHOWN (7018LH or 11018LH WELDING ROD IS PERMISSIBLE)
- INTERPASS TEMPERATURES NOT TO EXCEED 850° F
- DO NOT LET COOL UNDER 600° F

POST-HEAT PROCEDURE:

- USE SOFT FLAME ON WELDED AREA KEEPING TEMPERATURE BETWEEN 600° F & 850° F FOR 1 1/2 HOURS
- WRAP WELDED AREA WITH BLANKET & ALLOW TO COOL SLOWLY FOR 4-5 HOURS

(WELD AREA: WELD RIGHT & LEFT SIDES 1/2" WELD USING (4) SM-STRESS BAR-CR IN THIS SECTION ONLY)

FOCUS PRE-HEAT TEMP STICK CHECK AREA

(WELD AREA: WELD RIGHT & LEFT SIDES 3/4" WELD. USE WRAP/BACKFILL WELD TECHNIQUE ON ENDS OF THESE WELDS)

(WELD AREA: CENTER IN FORK 3/8" WELD)

(4) SM-STRESS BAR-CR
(1/2" X 5/8" X 4 1/2" CR 1018)

SOMETIMES A SPACER BAR IS REQUIRED TO TAKE UP THE SIDE SPACE IN THE FORK TO THE SHOE RELATIONSHIP IF GAP IS LARGER THAN A 1/8". USUALLY ONLY ONE BAR IS REQUIRED PER FORK. PLACE THE ONE BAR TO THE INSIDE OF EACH FORK (R & L) *EXAMPLE SIZE: (3/16"x1/2"x9")

KEEP WELD AT LEAST 1/2" FROM TOP OF BLADES (X4)

BLADE THICKNESS	A	B	C	D
2 1/2"	5"	4 1/2"	3"	2"
3"	9"	4"	3"	2"
3 1/2"	11"	4"	2"	2"
4"	14"	3 1/2"	2"	2"

UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONAL ± 1/16
ANGULAR: MACH ± 0.5°
BEND ± 5°
TWO PLACE DECIMAL ± 0.03
THREE PLACE DECIMAL ± 0.005

INTERPRET GEOMETRIC TOLERANCING PER: ANSI SPEC

MATERIAL: SEE BOM

FINISH:

DO NOT SCALE DRAWING

	NAME	DATE
DRAWN	STB	11/2/2012
CHECKED		
ENG APPR.		
MFG APPR.		
Q.A.		
COMMENTS:		

SAS OF LUXEMBURG, LTD

TITLE: **CRUSHING BLADE REPLACEMENT/WELDING PROCEDURE**

SIZE	DWG. NO.	REV
B	CRUSHING BLADE REPLACEMENT-WELDING PROCEDURE	
SCALE: 1:8	WEIGHT: 2339.88	SHEET 1 OF 1

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