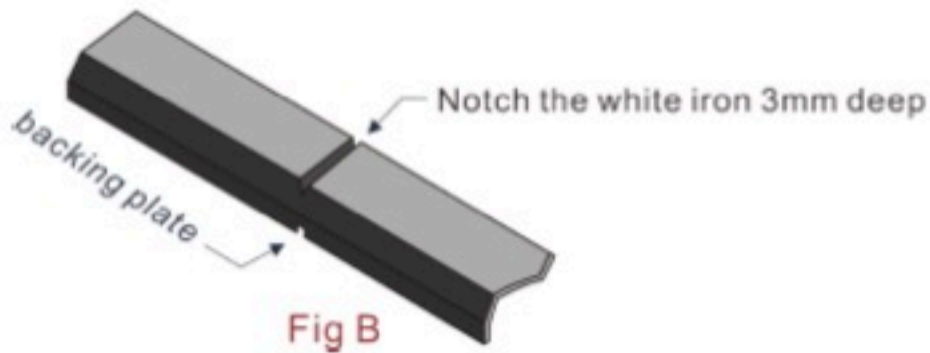


Cutting Instruction

High pressure water jet cutting is recommended. Thermal cutting using oxyacetylene torch, arc-air or plasma is not recommended. Abrasive disc cutting is accepted for blocks less than 25mm section thickness:



- Secure the block in a vice or clamp
- Notch the backing plate (FIG A) and notch the white iron a 3mm deep opposite the notch in the backing plate (FIG B)
- Wrap the block with a rag and carefully hit using a soft face hammer. The block should break cleanly at the notch.

Welding Instruction

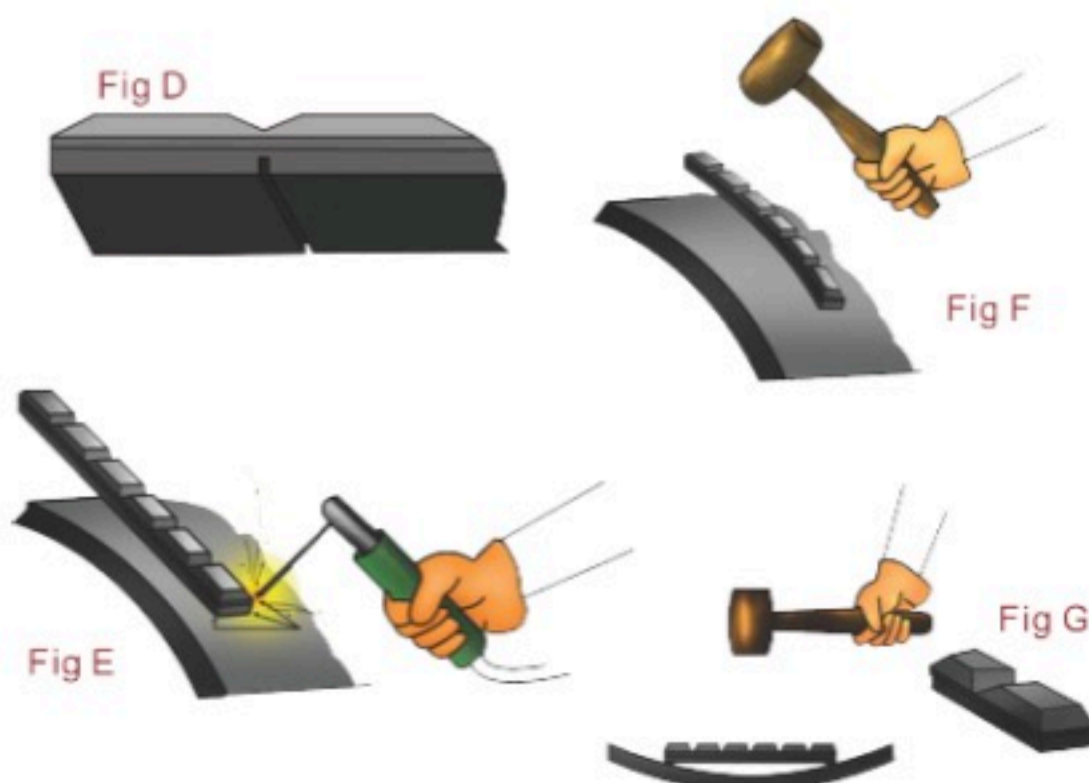
Ensure the surface which the block will be attached onto is as flat as possible and the area to be welded is clean.

- Clamp and tack weld the block into position.
- Stitch weld, laying 50mm max. length each run, alternating ends or sides to minimize heat penetration. DO NOT deposit weld within 2mm from the joint (FIG C)
- DO NOT WELD CONTINUOUSLY - Continuous welding may cause warpage, delamination and cracking. Maximum temperature allowed is 200°C.
- Using low hydrogen weld rods or gas covered cored wire.



Chocky Block Forming Instruction

For severe curves with radius less than 305mm, or inside curves, it is advisable to notch the steel backing plate opposite the "V" to assist forming (FIG D). Please note the chocky bar may crack during bending. This is normal.



- Clean the surface to which chocky bar will be welded onto.
- Tack weld one end of the bar by 15mm min. length per weld (FIG E)
- For outside curves: Hammer down the unwelded end with a soft face hammer to bend the bar to match mating radius. (FIG F)
- For inside curves: Starting in the center, strike the bar with a soft face hammer to bend the piece to match mating radius. (FIG G)
- Stitch weld as per the welding procedure.