

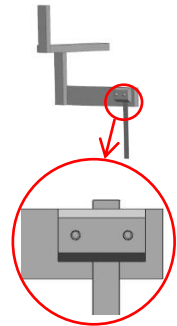



# Half Arrow Corner Wear Gauge

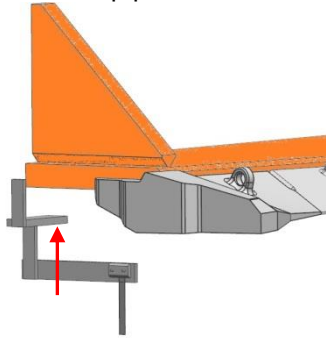
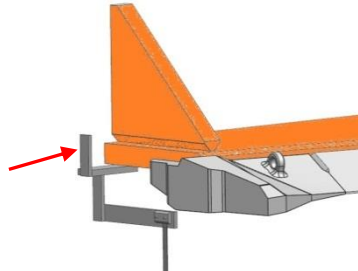
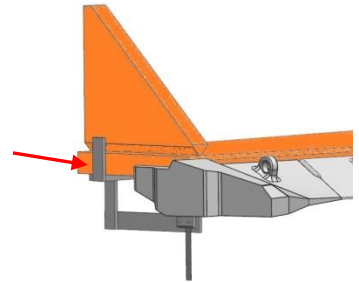
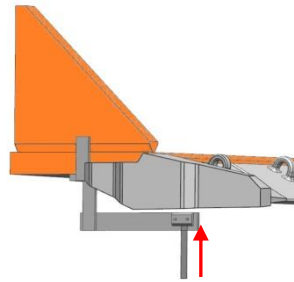
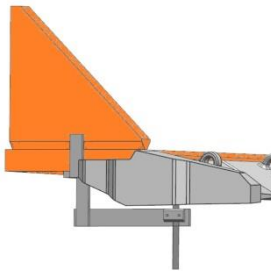
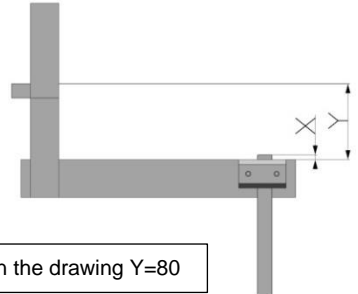
## Instruction procedure

The Half Arrow Corner Wear Gauge is designed to measure Sandvik Large and Small Half Arrow Corners Wear Pieces, parts number as present:

Half Arrow right-hand corner piece - SHA320X350-HR - SHA180X280-R	Right hand side gauge BU00016422 RH 	150mm/6" straight ruler - 15/150/0.3 	Installation of the ruler 
Half Arrow left-hand corner piece - SHA320X350- HL - SHA180X280- L	Left hand side gauge BU00016422 LH 		

**Ensure that the bucket is properly supported with the Cat stand, or similar supports before starting the measurements.**

Before measuring ensure that the bucket has a clearance of at least 50cm from the ground. Ensure that any dirt is cleaned out from the bucket.

<p><b>Step 1</b> – Push gauge up onto the bottom of the lip plate.</p> 	<p><b>Step 2</b> – Push gauge onto the side of the lip plate. Ensure the gauge is hold firm to both the side wall of the lip, and the bottom of the lip plate.</p> 	<p><b>Step 3</b> – Slide gauge forward until the gauge hits the back of the corner shroud.</p> 
<p><b>Step 4</b> – While holding the gauge securely with one hand. Slide the ruler up to the bottom of the shroud with the other hand.</p> 	<p><b>Step 5</b> – Make sure the ruler is sitting firm to the bottom of the shroud. Take the gauge away from the lip to read the wear measurement.</p> 	<p><b>Step 6</b> – Read the value X and Y from the ruler. Thickness of the remaining wear material = Y-X.</p>  <p>On the drawing Y=80</p>

First measurement has to be taken, when Half Arrow are first welded onto the lip. This procedure has to be used along with “Half Arrow Corner Wear Gauge – Measuring spreadsheet”.