

BLUE POINTER 2 LIP FABRICATION PRODUCT PROCESSING PROCEDURE

SHARK™ GROUND ENGAGING TOOLS

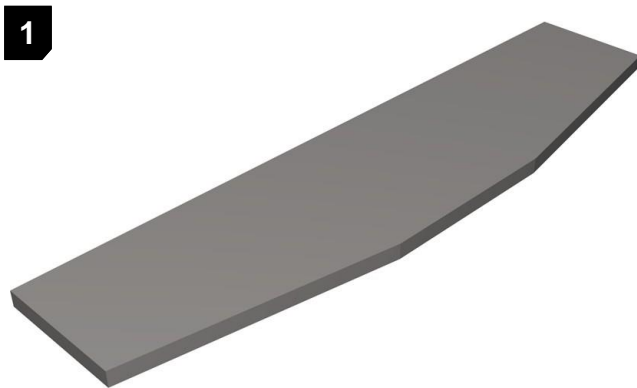
1.0. INTRODUCTION

This procedure details the basic fabrication procedure required to manufacture a Sandvik Shark Blue Pointer Lip Assembly. In conjunction with this document Sandvik Shark gauging procedure PGP0015 and Welding Procedure PWP0001 should be referenced. Each Lip Assembly must be manufactured to the dimensions specified in the Sandvik Shark Layout drawing provided when the Lip is ordered.

Applicable parts:-

- Sandvik Shark Blue Pointer 2 Products

2.0. PRODUCT PROCESSING PROCEDURE



Important!!

Preheat the cut zone to 150 deg C measured a minimum of 75mm on either side of the cut, as specified in welding procedure PWP0001.

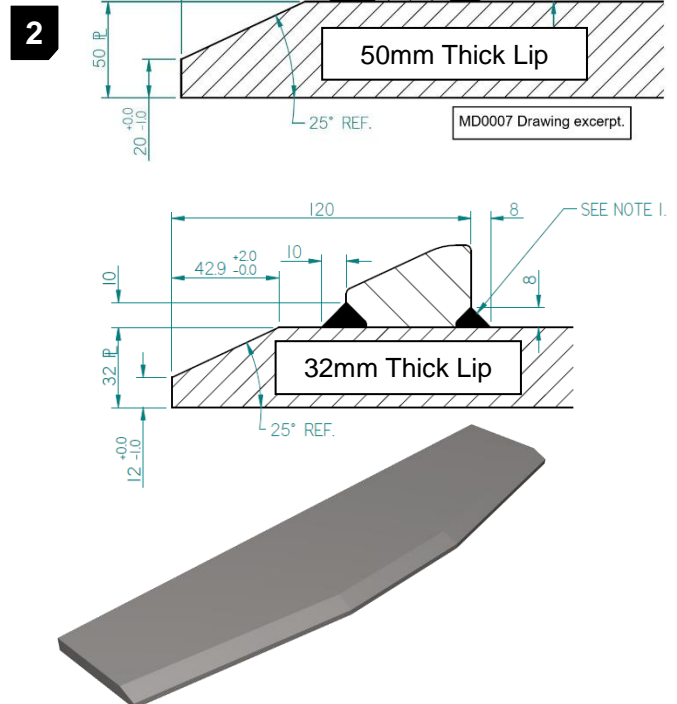
Prep Lip Plate

Profile cut lip plate from Hardox 400 or 450 Q/T Steel to dimensions specified in layout drawing.

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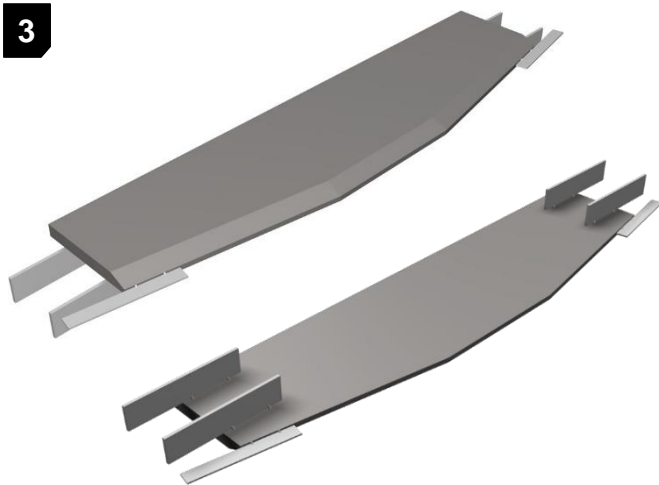


Prep Lip Plate

Bevel lip plate as detailed above.

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3 Prep Lip Plate

Attach positioning plates to the base and front of the lip as shown.

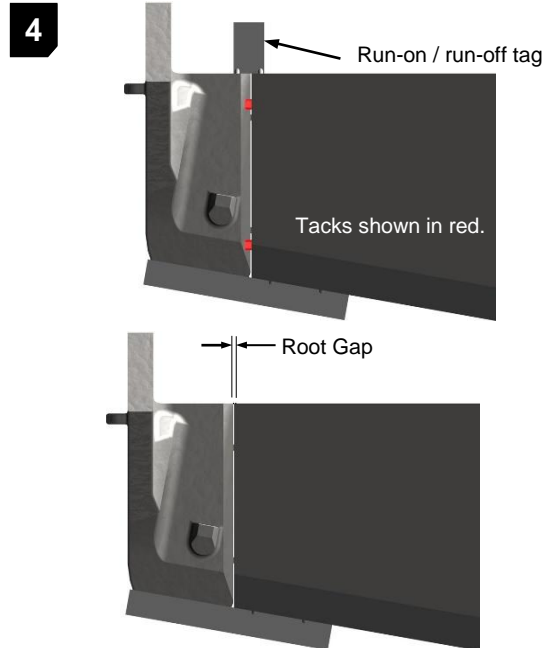


5 Cast Corner Weldment

Attach approximately 45 deg brace between Cast Corner and lip plate.

This is to prevent Cast Corner movement.

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Run-on / run-off tag

Cast Corner Weldment

Position the Cast Corner on the positioning plates. Ensure to allow for the appropriate root gap as specified on the layout drawing.

Attach run-on and run-off tags.

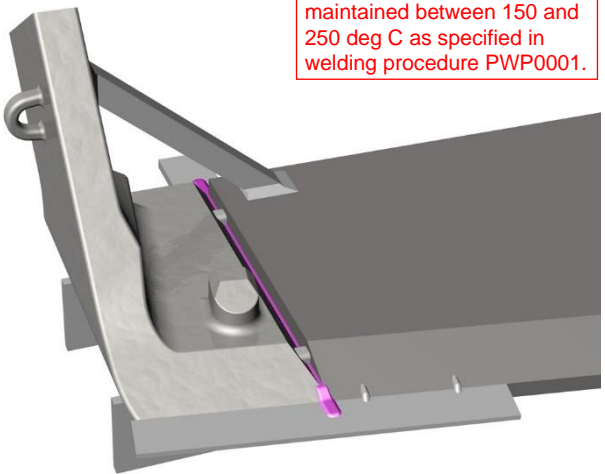
Tack Cast Corner to lip plate.

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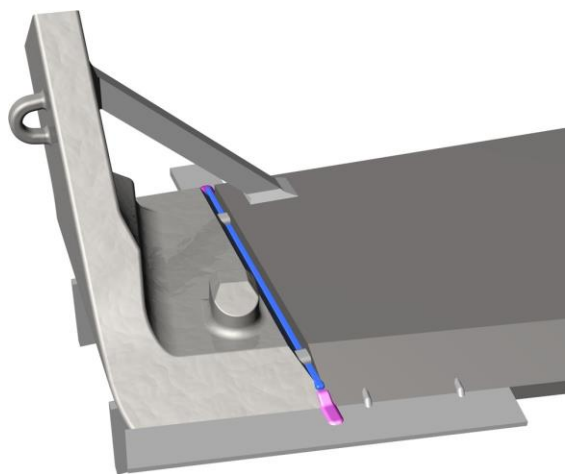
Important!!
Weld zone temperature to be maintained between 150 and 250 deg C as specified in welding procedure PWP0001.



Cast Corner Weldment

Weld root run.

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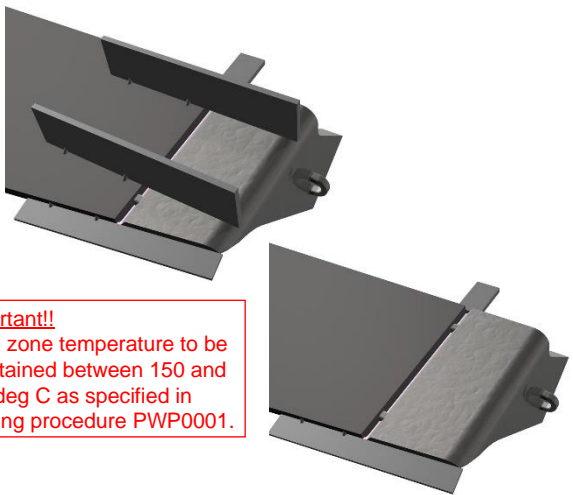


Cast Corner Weldment

Weld 1st pass to reinforce root run.

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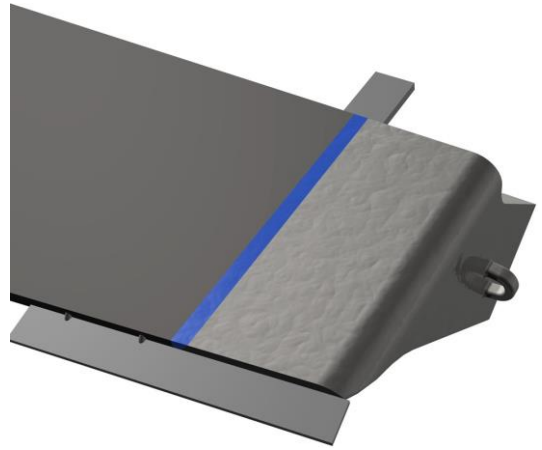
Important!!
Weld zone temperature to be maintained between 150 and 250 deg C as specified in welding procedure PWP0001.



Cast Corner Weldment

Turn lip over and remove positioning plates as shown.

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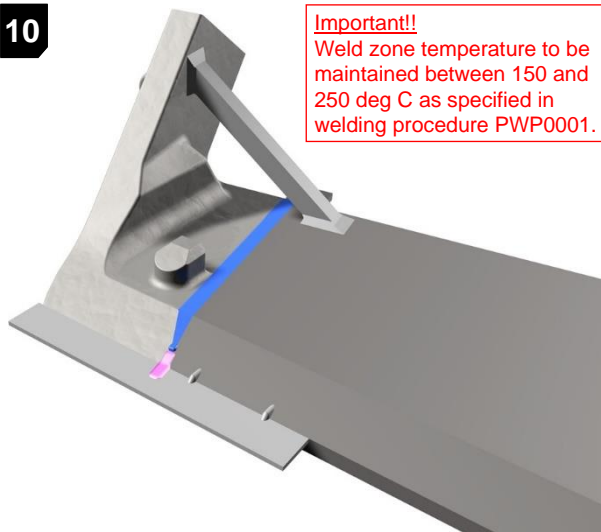


Cast Corner Weldment

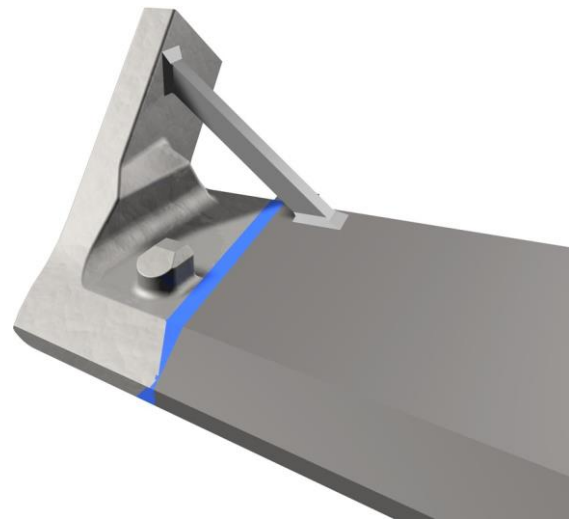
Complete weld on underside of lip.

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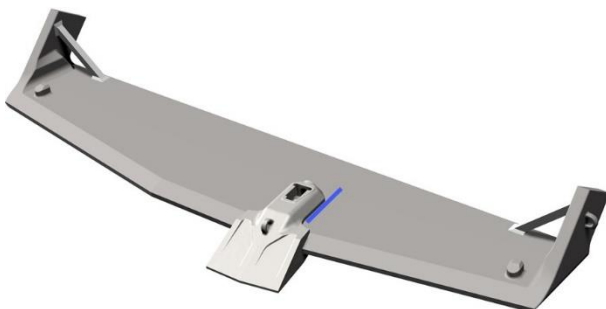
10**Cast Corner Weldment**

Turn lip over again and complete weld on topside of lip.

11**Cast Corner Weldment**

Remove remaining positioning plate and run-on run-off tags.

Clean up welds. Cast Corner welding is now complete.

12**Boss Positioning**

Fit Transition Shroud to lip and mark sides of top leg.

Fit Transition Shroud to the second position and mark sides of top leg as in the previous step.

Mark the center line between the top leg markings and tack boss onto lip.

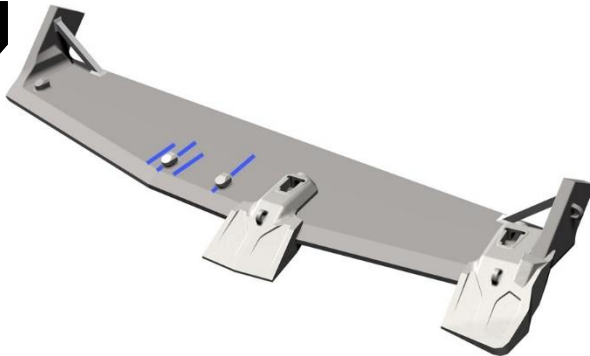
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13**Boss Positioning**

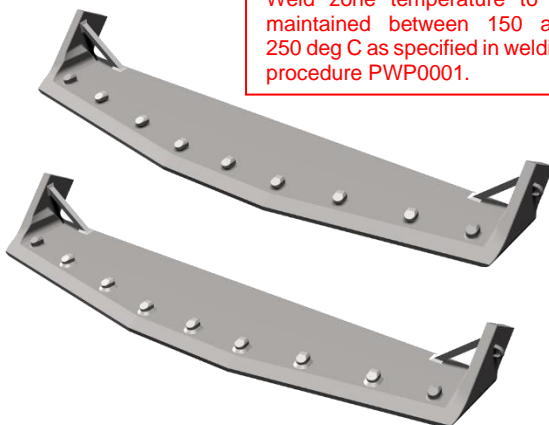
Tack second Transition Shroud boss on center line marking. Mark center of lip for center boss and tack to lip.

Move Transition Shroud to first location and fit Corner Shroud.

14**Boss Positioning**

Using the same marking out technique determine the position of the side bosses. Using the appropriate Straight Shrouds, mark the positions evenly between the Transition and Corner Shroud.

Once marking out is complete tack remaining bosses in place.

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Important!!
Weld zone temperature to be maintained between 150 and 250 deg C as specified in welding procedure PWP0001.

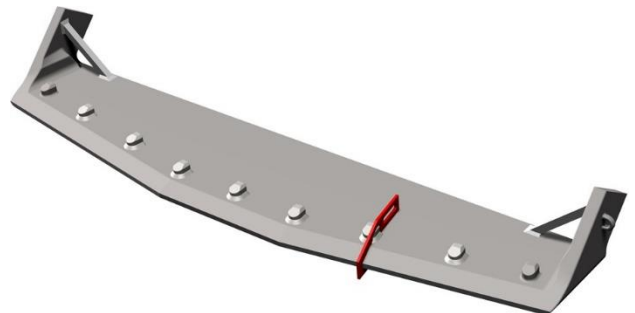
Boss Welding

Now all bosses are in place complete welding of all bosses.

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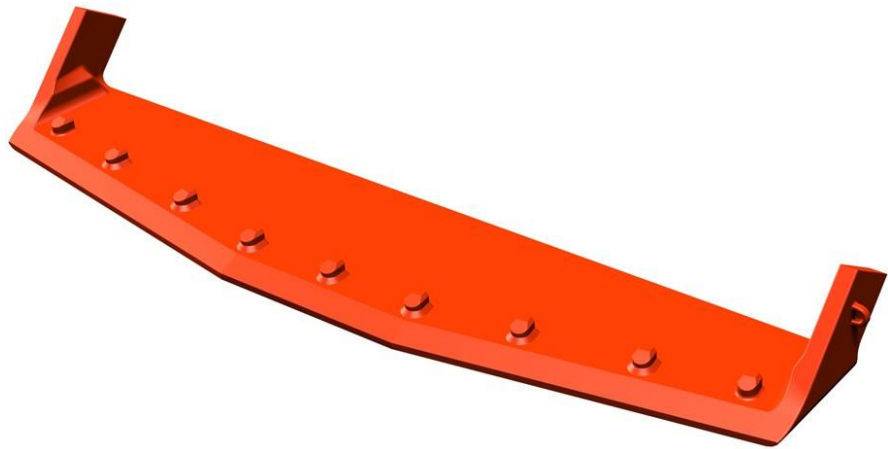
16**Inspect Lip**

Clean up welds and inspect lip as per gauging procedure PGP0015.

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Lip Complete.

Paint Lip Sandvik Orange.



3.0. DOCUMENT CHANGE REGISTER

| Rev | Date | Changes | Revised By | Approved By |
|-----|------------|---------|-----------------|-------------|
| 0 | 5/09/2008 | - | Adam Coy | - |
| 1 | 26/02/2009 | - | Marten Karlsson | - |