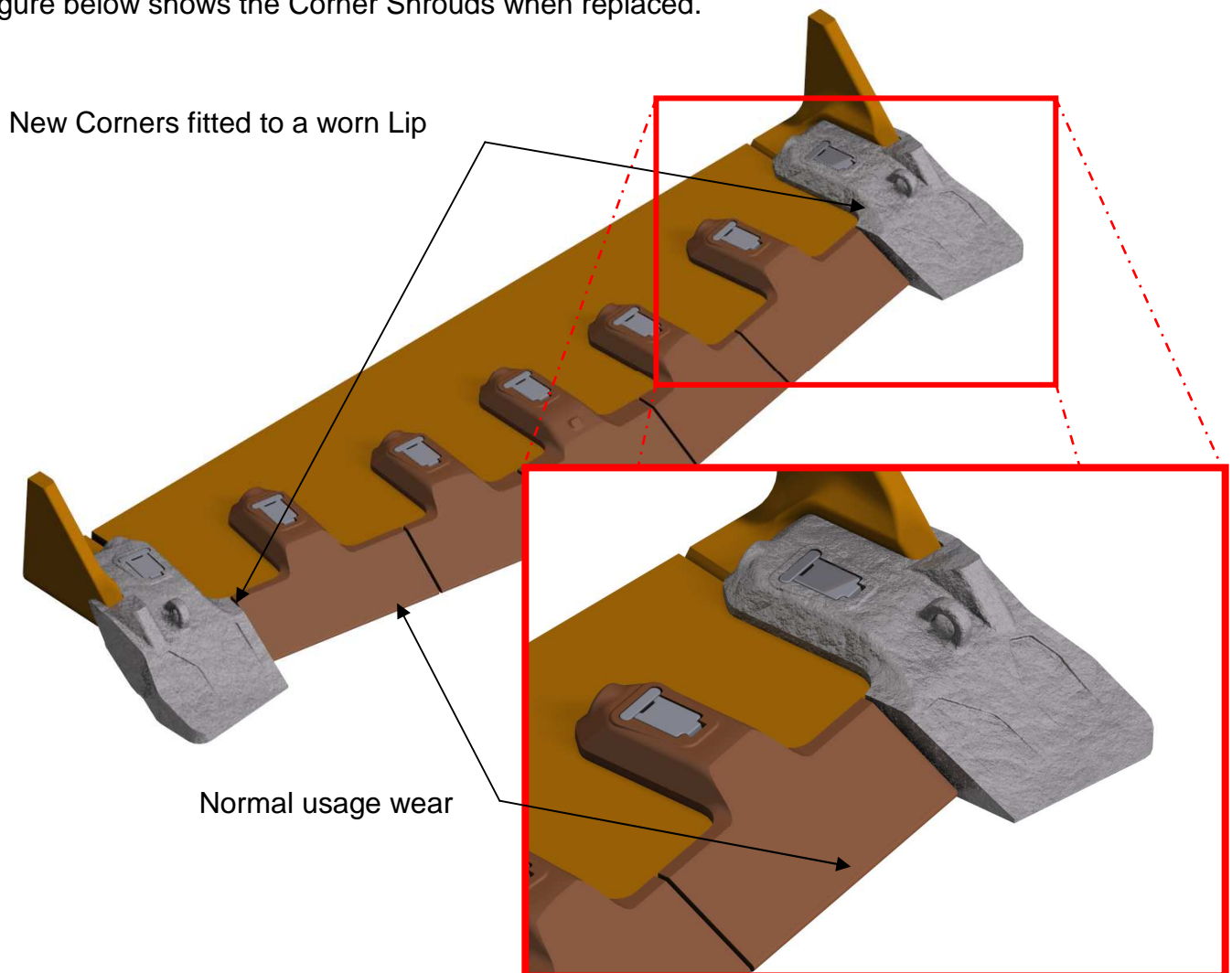


Product Processing Procedure

Title:	Cutting procedure for the 32mm ½ Corner Shroud		
Applicable Parts:	SBP32x210-CR2, SBP32x210-CL2		
Prepared By:	Brad Dallard	Revised By:	N/A
Date:	16 December, 2008	Date:	N/A

This procedure is to show the correct method of cutting the 32mm Corner Shroud when 2 new corner shrouds have been fixed to a ½ worn BP2 lip.
 This is necessary due to normal wear on G.E.T. (on a correctly used bucket); the corner shrouds wear out quicker than that of the other shrouds on the bucket. The replacement of the corner shrouds will give longevity to the lip.

Figure below shows the Corner Shrouds when replaced.

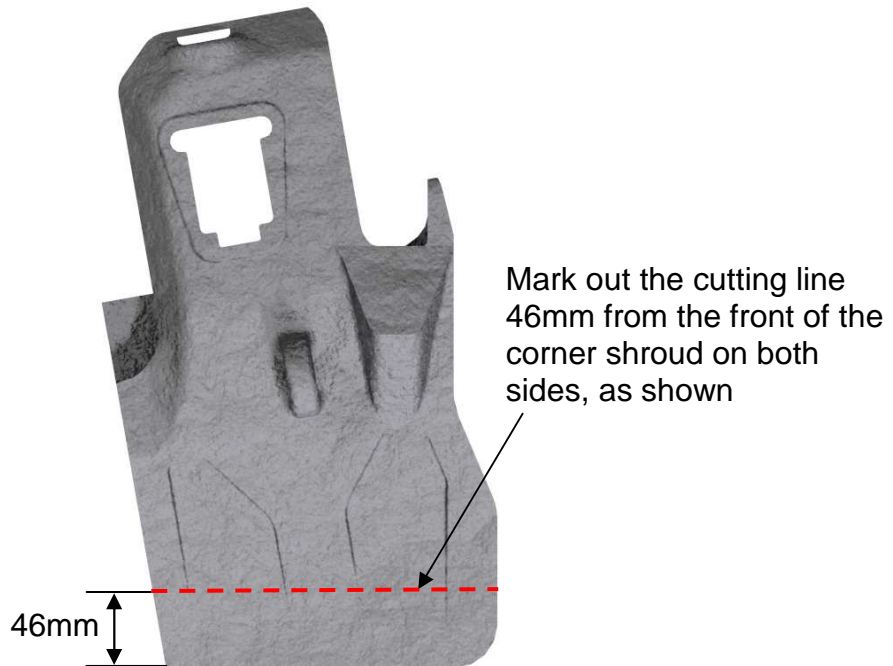


Due to the castings over hang as shown in the previous figure the castings requires manual cutting. This is so that the bucket is not to 'dig in' and possibly crack the Corner Shrouds during normal usage when replaced.

Following information is the process procedure required to complete this safely.

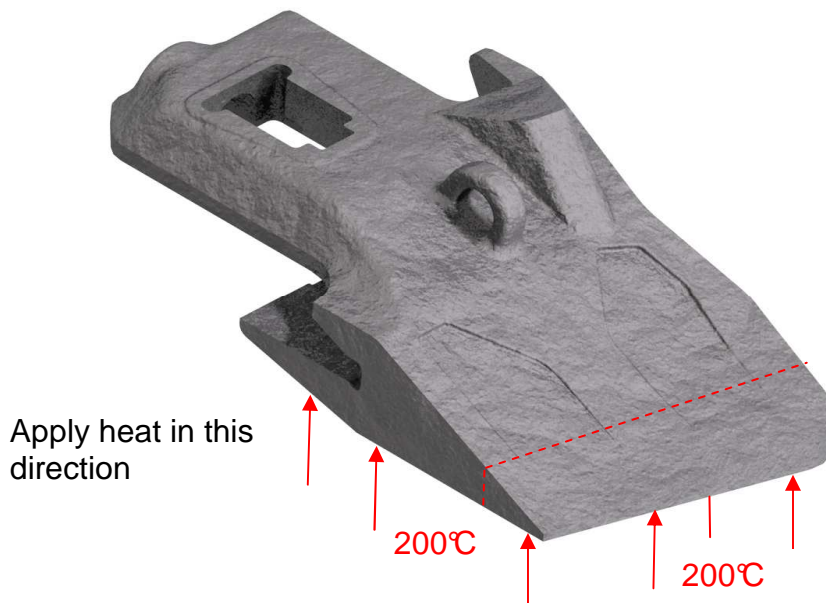
MARKING OUT

Mark out the corner shroud a distance from the front face of 46mm is required.



PRE CUTTING

Preheat the casting before oxyacetaline cutting. Ensure that the part is heated from the opposite side of the casting. The casting requires to be heated to a minimum of 200°C



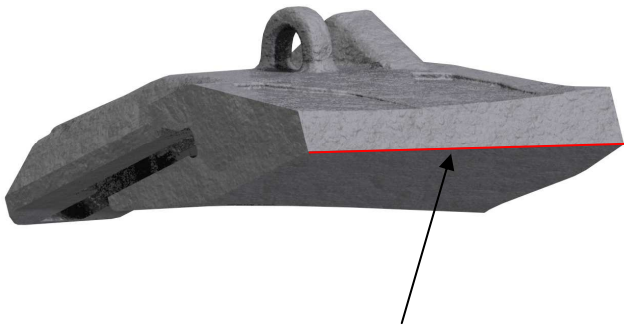
CUTTING THE CASTING

Cut the casting with an oxyacetaline cutter; ensure that the casting is at min 200°C.

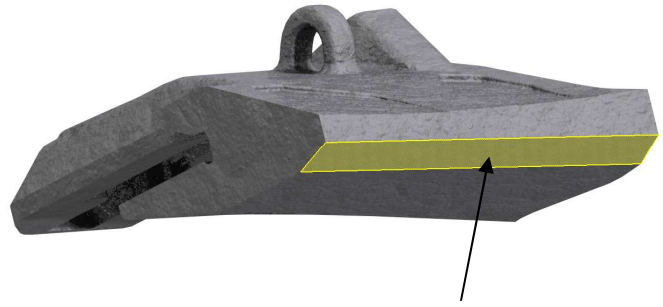


CHAMFER

Add a 30x10mm Chamfer to the bottom of the casting.



Add chamfer to this corner



Chamfer added



30mm off the length of the casting

10mm off the height of the front of the casting

POST CUTTING (AIR COOL)

Ensure that the altered parts are cooled slowly
Only Air cooled to ambient temperature ~20°C, **NO QUENCHING!**



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