

BLUE POINTER 2 LIP INSPECTION PRODUCT PROCESSING PROCEDURE

SHARK™ GROUND ENGAGING TOOLS

1.0. INTRODUCTION

The purpose of this procedure is to verify that the Lip is manufactured to the dimensions specified in Sandvik Shark layout drawing and meets all aspects of quality requirements. The following documents shall be referenced with this procedure, if required, when performing the Lip inspection:

- Sandvik Shark Lip Layout Drawing (varies for each Lip).
- MD0007 – 50mm Lip Profile and Boss set up drawing.
- MD0032 – 32mm Lip Profile and Boss set up drawing.
- PGP0015 – Lip Template and Boss Template Gauging Procedure.
- PPP0007 – Lip Fabrication Procedure.

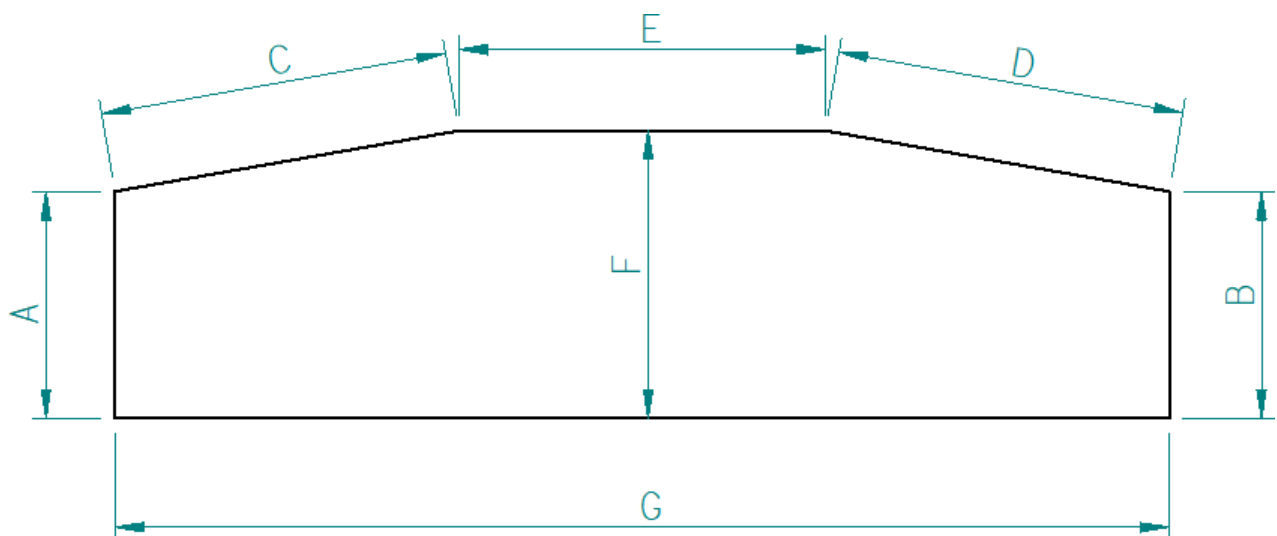
Applicable parts:-

- All Blue Pointer 2 - 50mm and 32mm Lips.

2.0. INSPECTION PROCEDURE

STAGE-1: PROFILE CUTTING OF LIP PLATE.

- Measure the dimensions shown below and record them.



BLUE POINTER 2

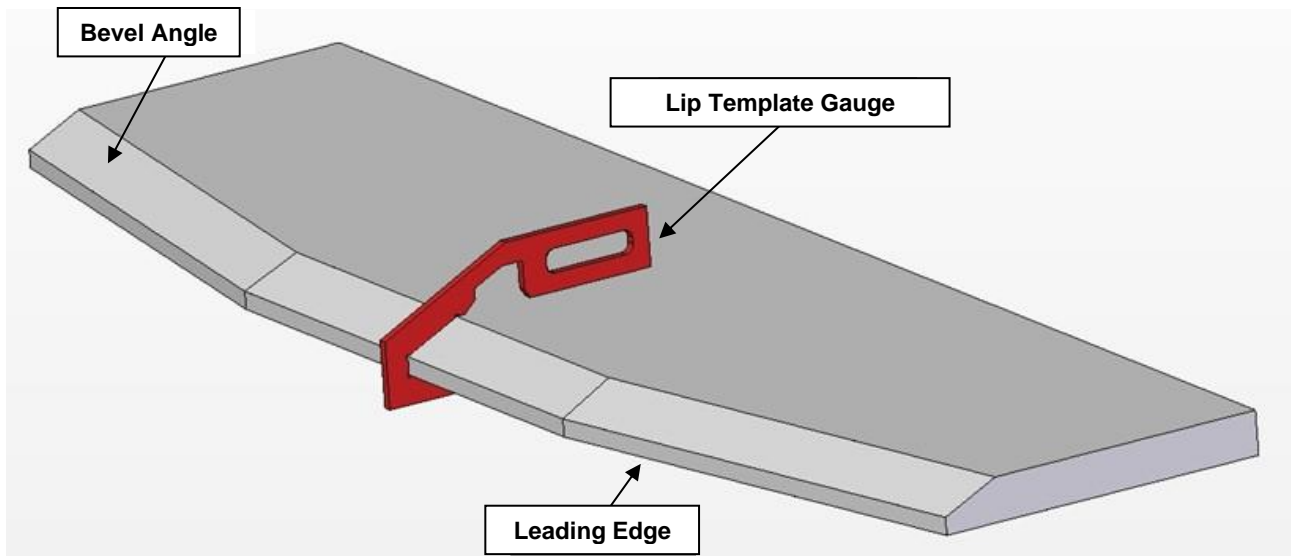
LIP INSPECTION

PRODUCT PROCESSING PROCEDURE

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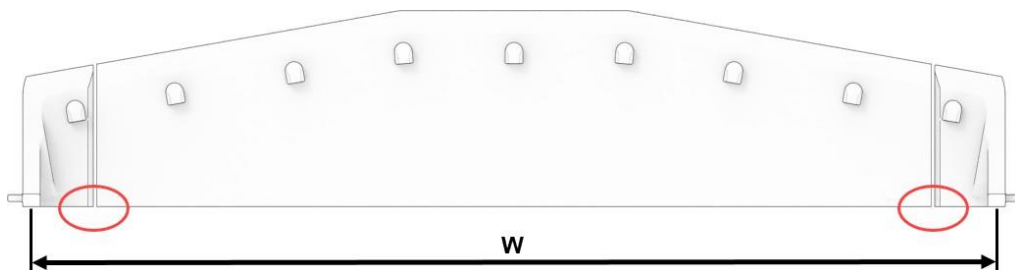
STAGE-2: BEVEL (RAMP ANGLE) CUTTING OF LIP PLATE

- Perform the Lip Template Gauge Procedure (PGP0015) to assess the bevel angel of the Lip Plate.
- The inspection should be carried out by placing the gauge at various locations along the leading edge of the Lip Plate.



STAGE-3: POSITIONING OF CAST CORNERS

- Position the Cast Corners on the sides of the Lip Plate as per the instructions given in PPP0007 procedures and measure center to center width of the Lip as shown below prior to welding the Cast Corners with the Lip plate.
- **Note:** The slight mismatch between the Cast Corner and the Lip is accepted in case of full depth Lip. The lip is called full depth lip when the Cast Corners do not need to be cut from back to suit with the depth (Dimension F) of Lip Plate.

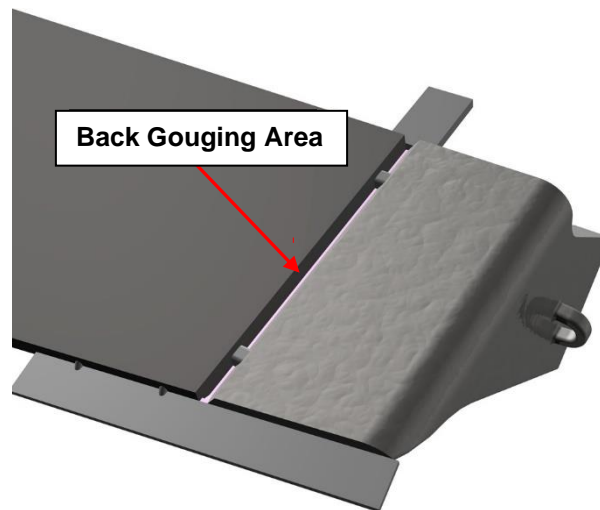


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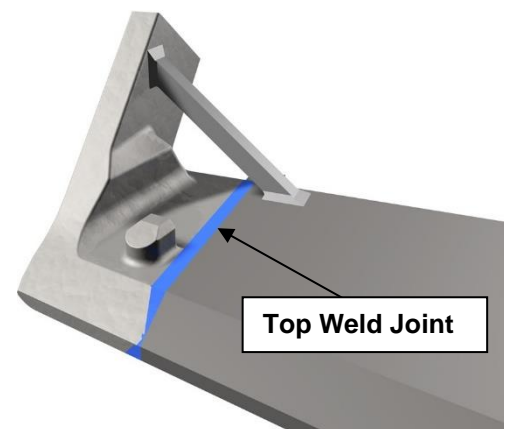
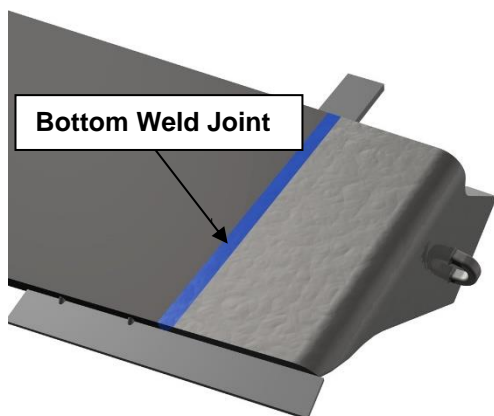
STAGE-4: INITIAL DYE PENETRANT TEST

- The Dye Penetrant Test shall be conducted after completion of back gouging of root run.



STAGE-5: FINAL DYE PENETRANT TEST

- After completion of Cast Corner welding execute the final Dye Penetrant Test on top and bottom weld joint areas of Cast Corners to confirm the structural soundness of the weld metal. The weld joint area must be dressed properly prior to commencement of Dye Penetrant Test.

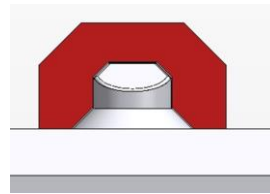
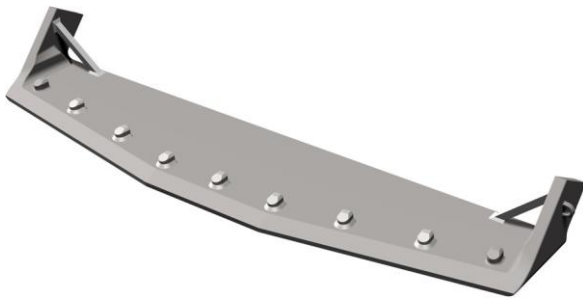


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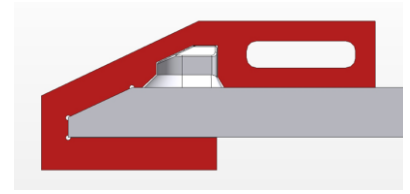
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STAGE-6: INITIAL BOSS WELDMENT INSPECTION

- Perform the Boss Weld Template and Lip Template gauge procedure (PGP0015) after completion of Boss welding to confirm the size of weld fillet and positioning of Bosses from the leading edge.



Boss Weld Template Gauge



Lip Template Gauge

STAGE-7: PAINT SPECIFICATION

- The following paint specifications are recommended for particular LHD Lip:
 - Sandvik LHD Lip : Orange
 - Elphinstone LHD Lip : Caterpillar Yellow
 - Others: as per request



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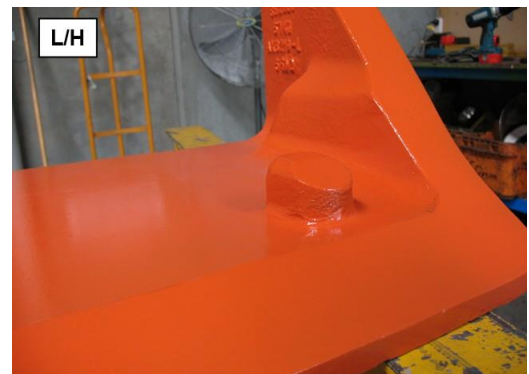
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STAGE-8: FINAL VISUAL INSPECTION

- The overall visual inspection must be carried out after painting to see the final condition of the Lip. The inspection shall be mainly focused on weld joint areas of Cast Corners and Boss weld fillets as well. All inflated weld joints and fillets areas, which may obstruct the fitment of shroud and affect the visual appearance of the Lip, must be leveled. Some examples of correct and incorrect Cast Corners weld joints and Boss weld fillets are illustrated below.

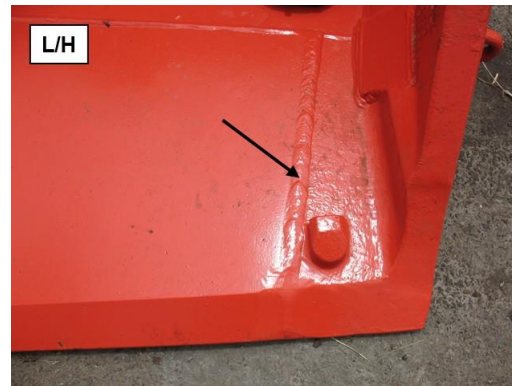
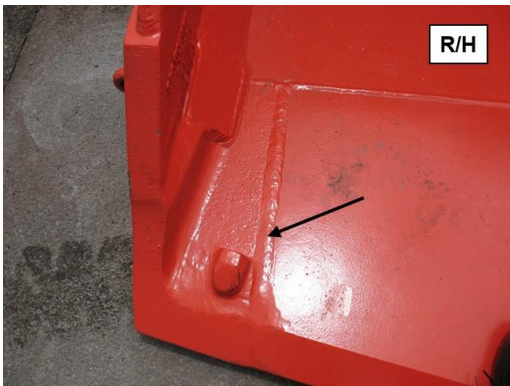
Correct Examples:



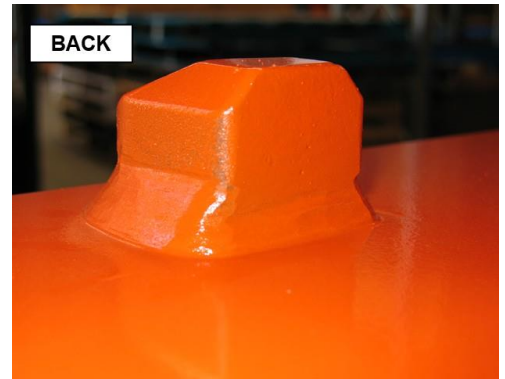
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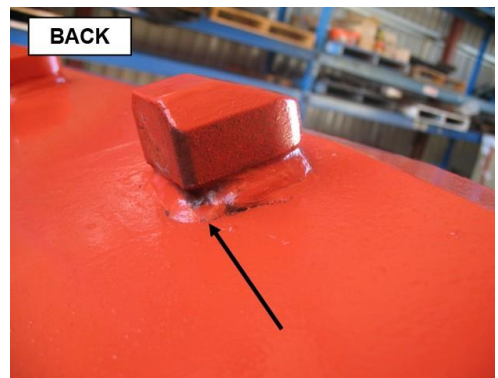
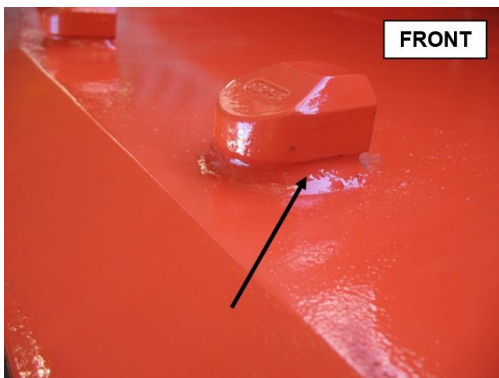
Incorrect Examples:



Correct Examples:



Incorrect Examples:



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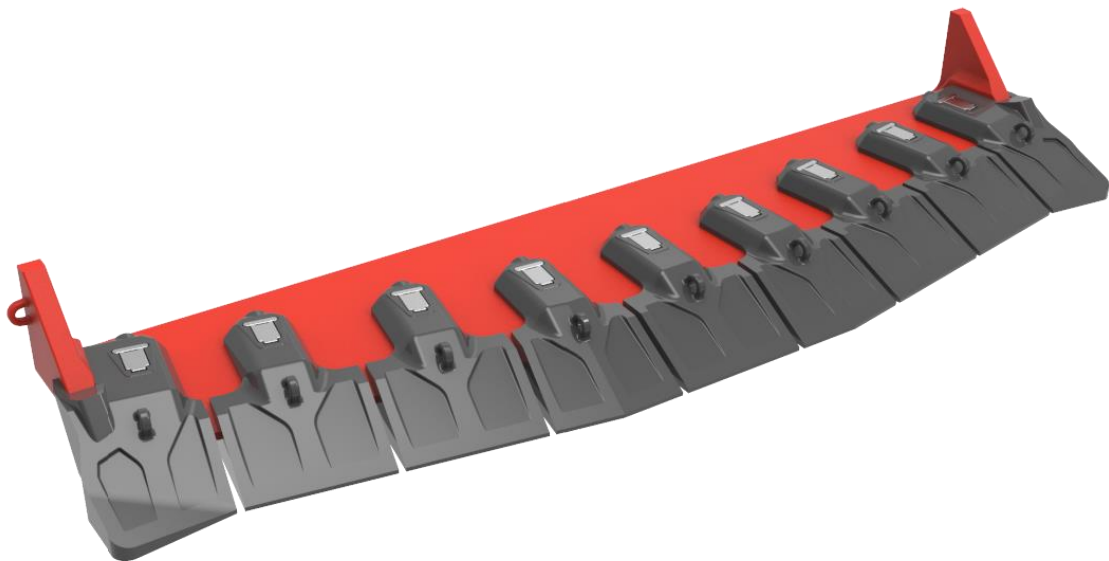
STAGE-9: FINAL GAUGE INSPECTION

- Perform the final gauge inspection as per PGP0015 gauging procedure.



STAGE-10: FINAL SHROUD FITMENT TEST

- Perform the shroud fitment test to ensure that the positions of Bosses are within specified dimensions as outlined in lay out drawing and there is no interference between the shrouds.



NOTE: Please **DO NOT** weld the profile bar to the Lip prior to attaching the Lip with the bucket.

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LIP INSPECTION

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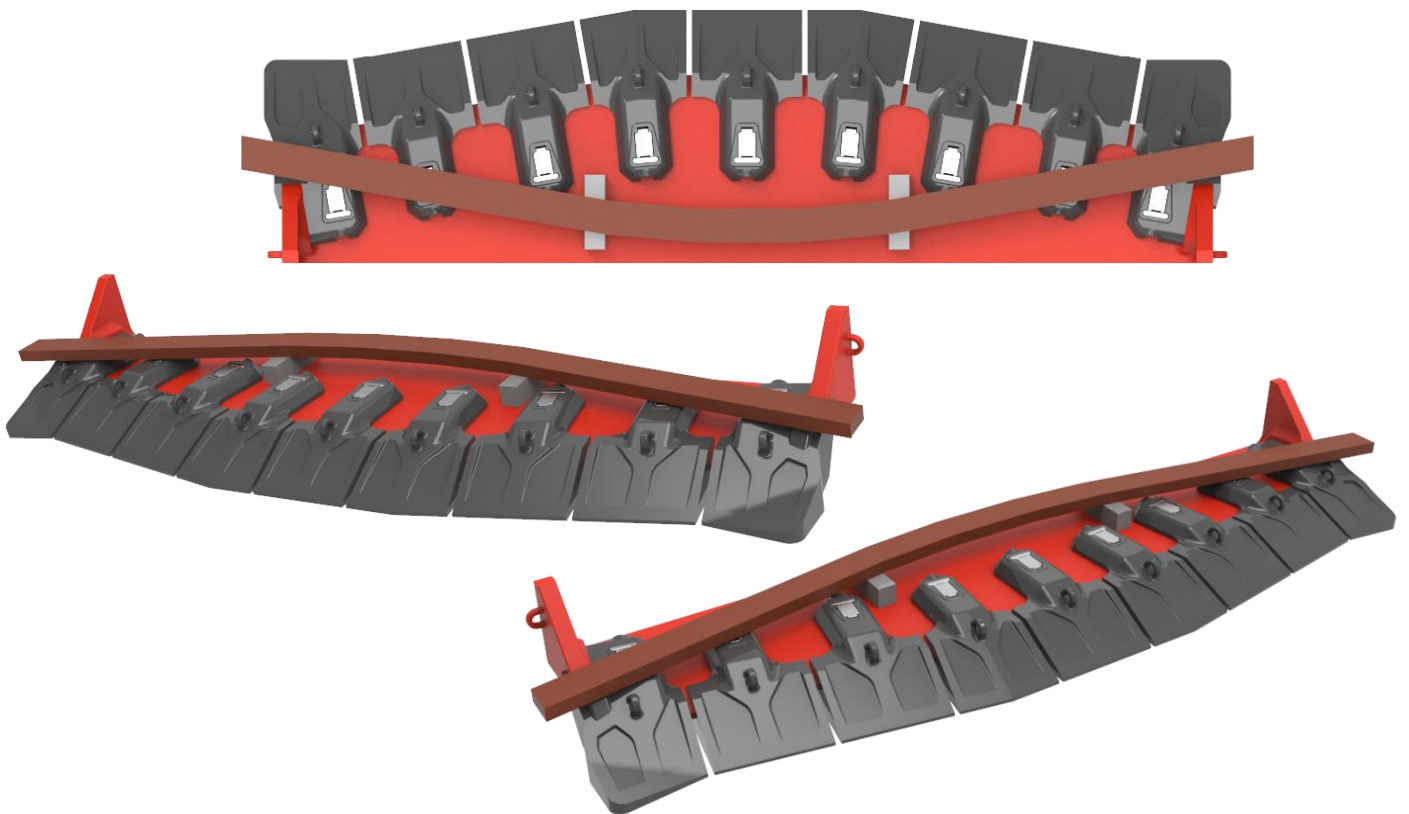
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STAGE-11: LIP DISPATCHING

The Following details should be considered prior to dispatching the lip:

- During the initial assembly of shrouds, use standard Cap-Screws instead of Nylon insert Cap-Screws (SBP50-CS2 & SBP32-CS2). Provide the Nylon insert Cap-Screw in separate box.
- The label called "Important Information" must be attached on the Lip.
- Place the wooden square blocks on the top side of the lip and then place the Profile Bar on them as shown below and strapped it.

Ensure safe working procedures are utilized while preparing the lip for dispatch, and all loose parts are securely strapped prior to dispatch.





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3.0. DOCUMENT CHANGE REGISTER

Rev	Date	Changes	Revised By	Approved By
0	-	-	-	-
1	31/03/2010	-	Rohit Bayal	Neil Dennis