

# Product Processing Procedure

**Title:** Cast Corner Conversion  
**Applicable Parts:** Blue Pointer™II – Factory-Fitted & After-market Cast Corners  
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**Date:** 30 May, 2012  
**Revised By:** Mehrdad Javadi  
**Date:** 8 March, 2021

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## SUMMARY

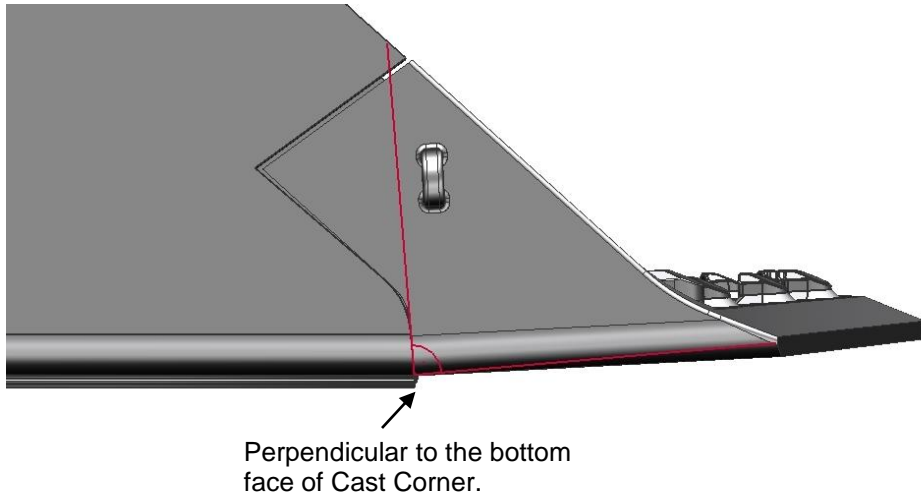
This procedure details the basic fabrication procedure required to replace factory-fitted Cast Corners (type RTM/LTM as in example SC0087) With aftermarket Cast Corners (type RS/LS or RE/LE). Sandvik Welding Procedure PWP0001 should be referenced to in conjunction with this document.

## PROCEDURE

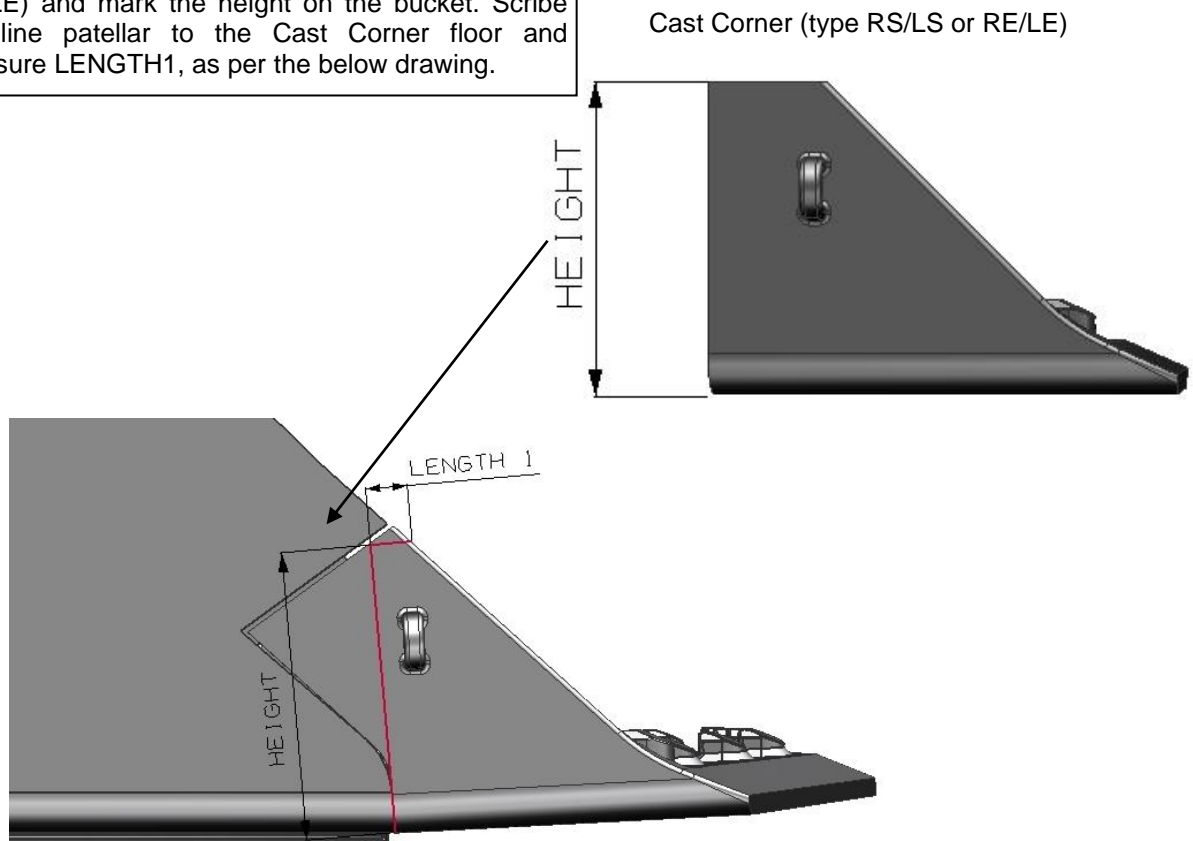
1. Take off all the shrouds from the bucket to ensure they are not exposed to preheat or HAZ of the weld.



2. To cut Cast Corner (type LTM/RTM) out of the bucket, mark CC from the bottom rear end (scribe a line up), perpendicular to the bottom face of CC.

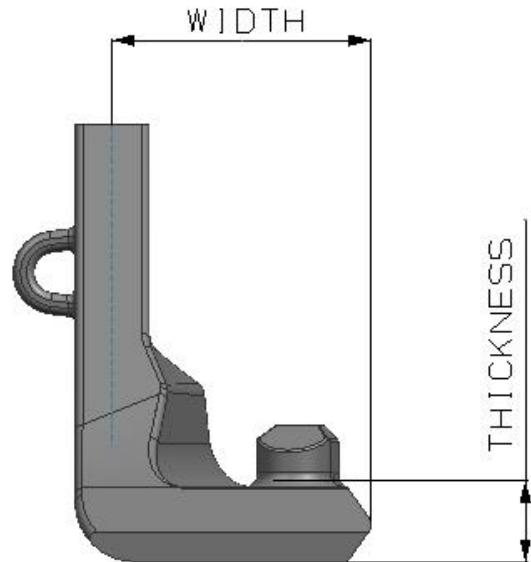


3. Measure height of Cast Corner (type RS/LS or RE/LE) and mark the height on the bucket. Scribe the line parallel to the Cast Corner floor and measure LENGTH1, as per the below drawing.



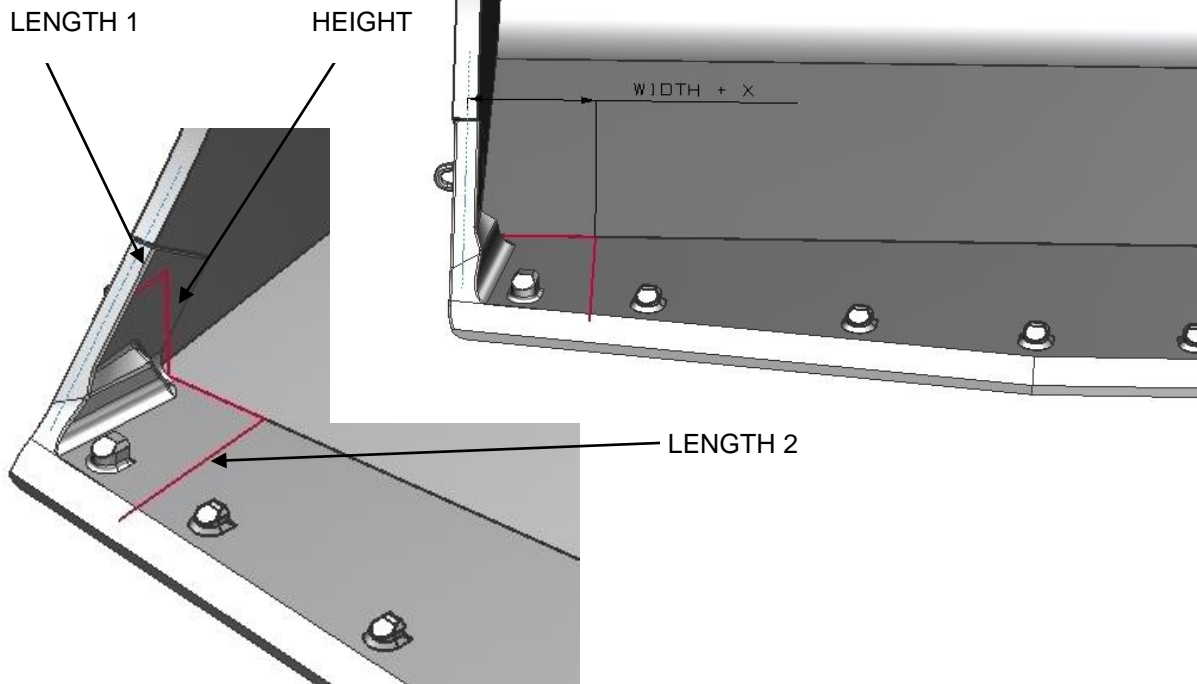
4. Measure the WIDTH on Cast Corner (type RS/LS or RE/LE). It is measure from the center section on the lip side wall to the end of the casting. Add X mm to measurement to allow from weld gap WIDTH mm + X mm.

X for 50mm thickness gap – 7.5mm  
X for 32mm thickness gap – 5mm

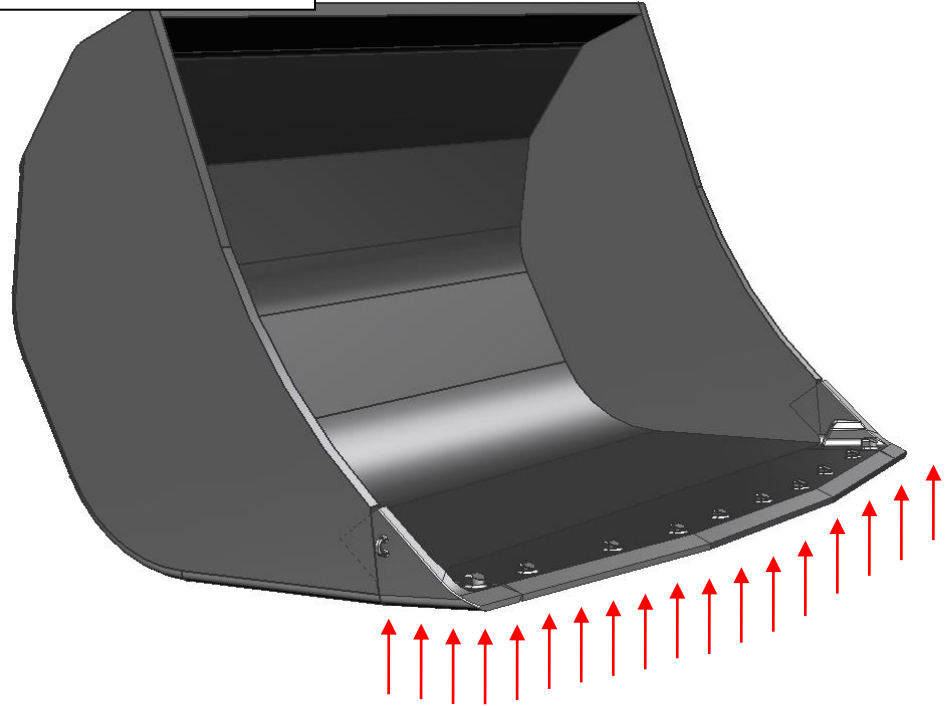


5. Scribe HEIGHT and LENGTH 1 inside of the bucket. Mark WIDTH inside of the bucket. Make sure to add X shown below.

50mm thickness lip – WIDTH mm+ 7.5mm  
32mm thickness lip – WIDTH mm+ 5mm



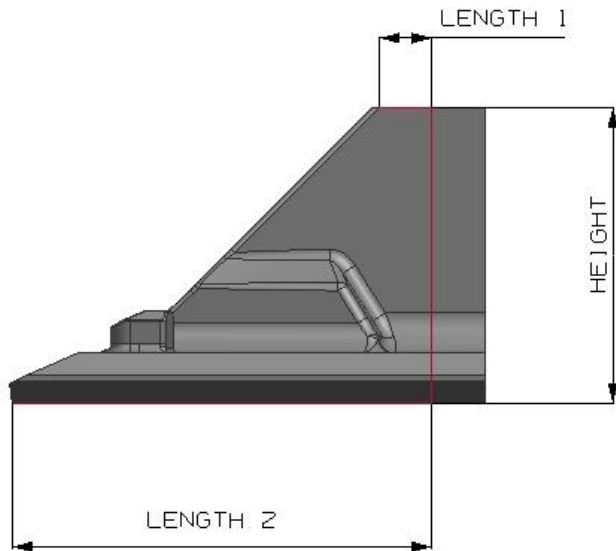
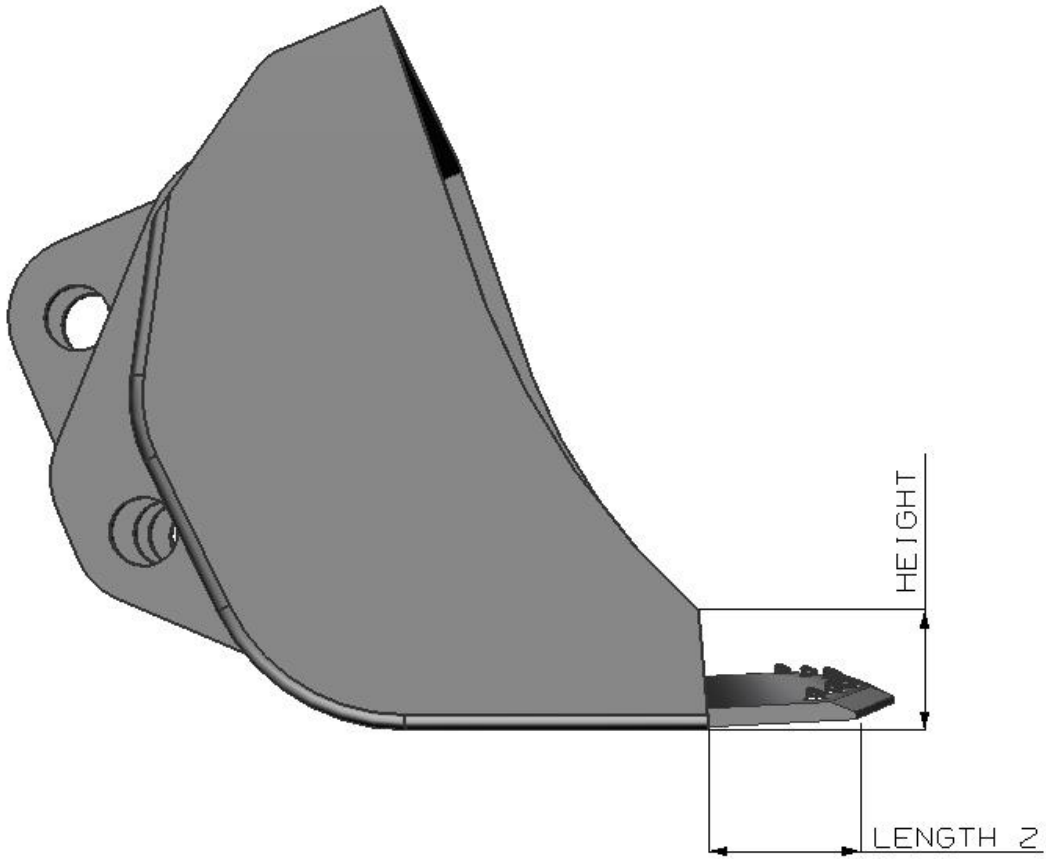
6. Make sure all shrouds are removed from the bucket, pre heat bucket and corner.



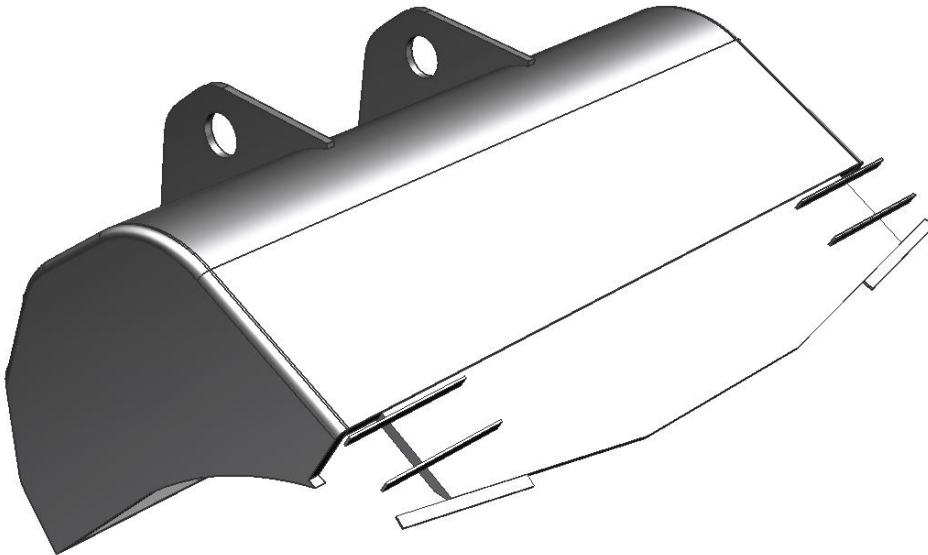
7. Cut bucket according to marks.



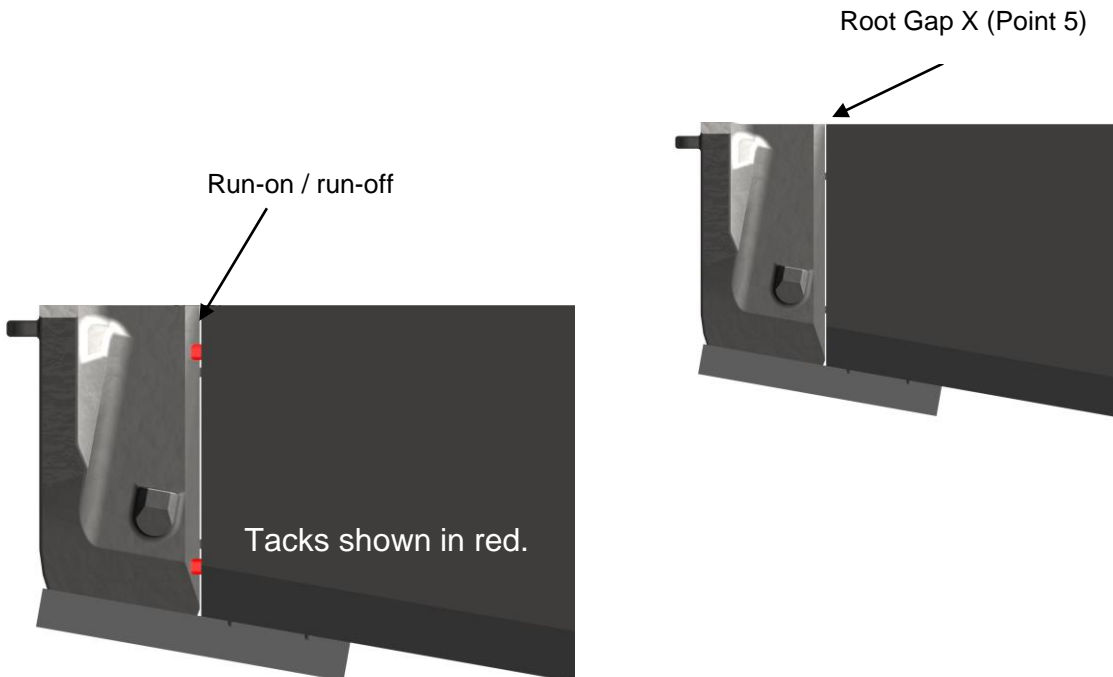
8. Measure from cut area to the end of the lip  
LENGTH 2. Mark length on the Cast Corner, pre  
heat and cut Cast Corner to suite.



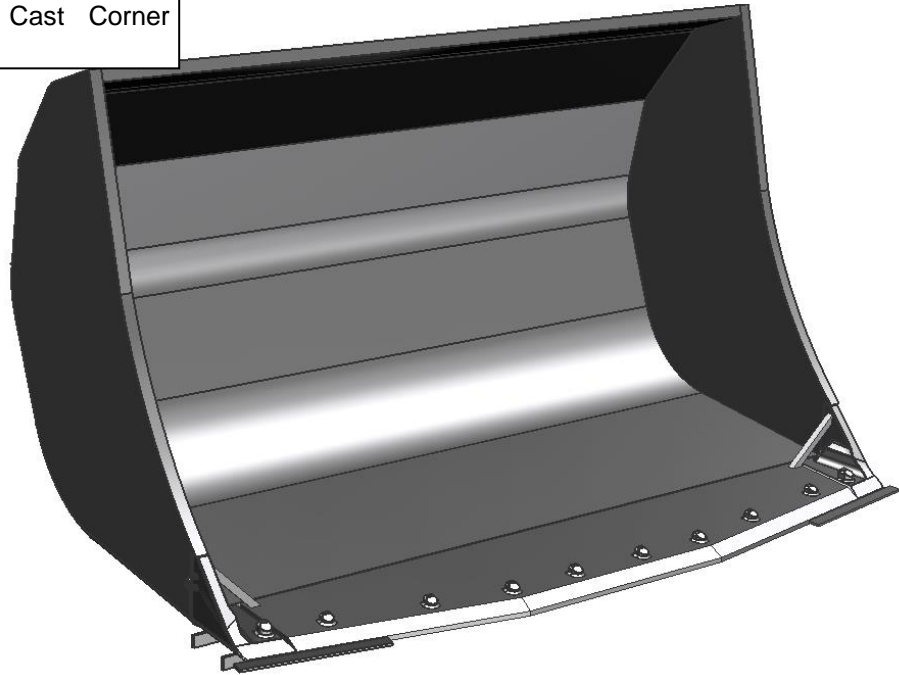
9. Attach positioning plates to the base and front of the lip as shown.



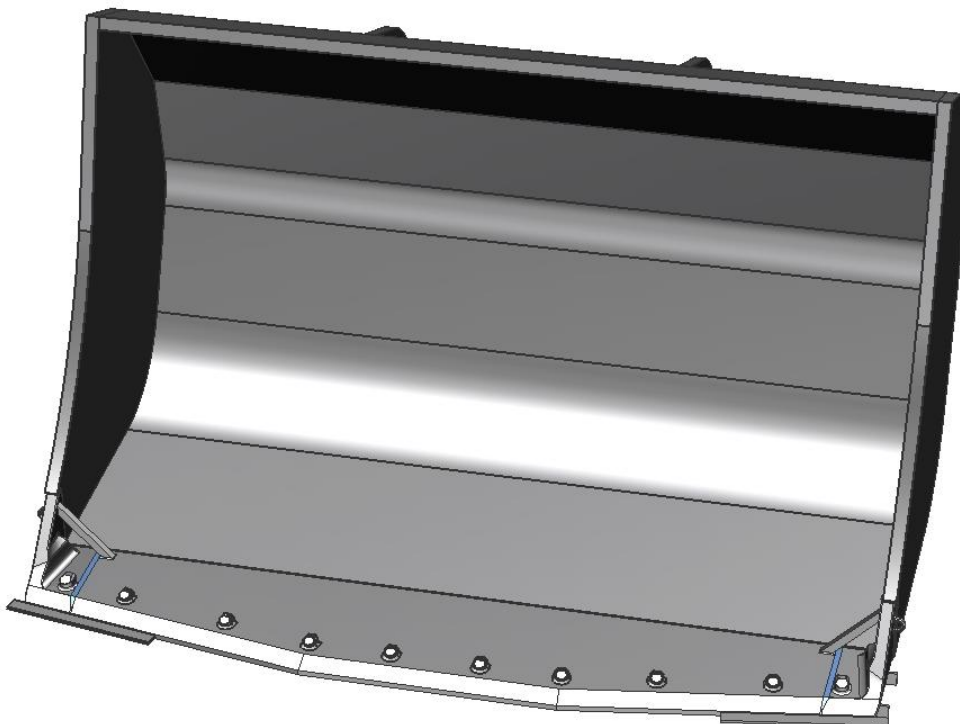
10. Position the Cast Corner on the positioning plates. Ensure to allow for the appropriate root gap as specified on the layout drawing. Attach run-on and run-off tags. Tack Cast Corner to lip plate.



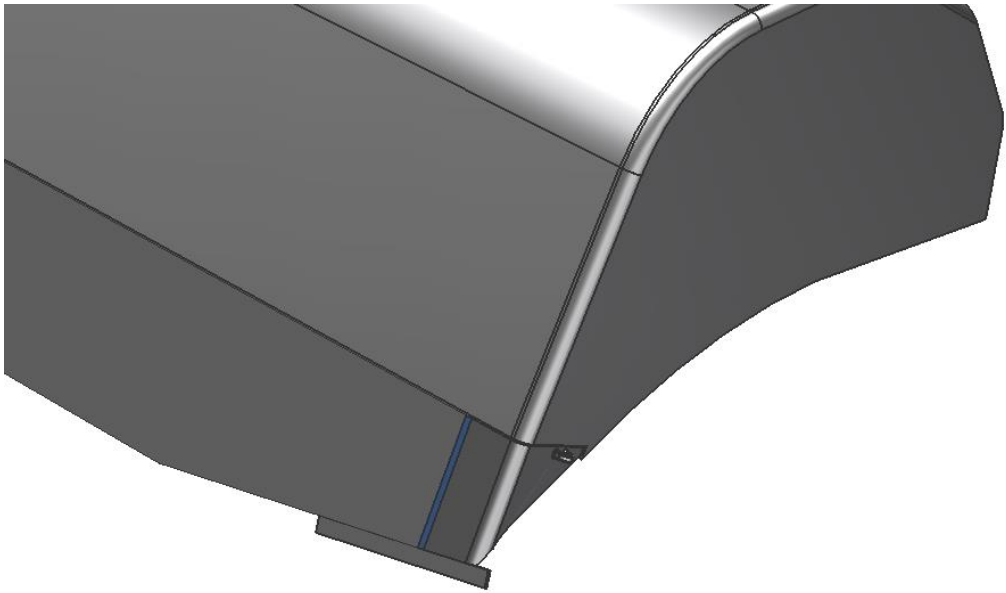
11. Attach approximately 45° brace between Cast Corner and lip plate. This is to prevent Cast Corner movement.



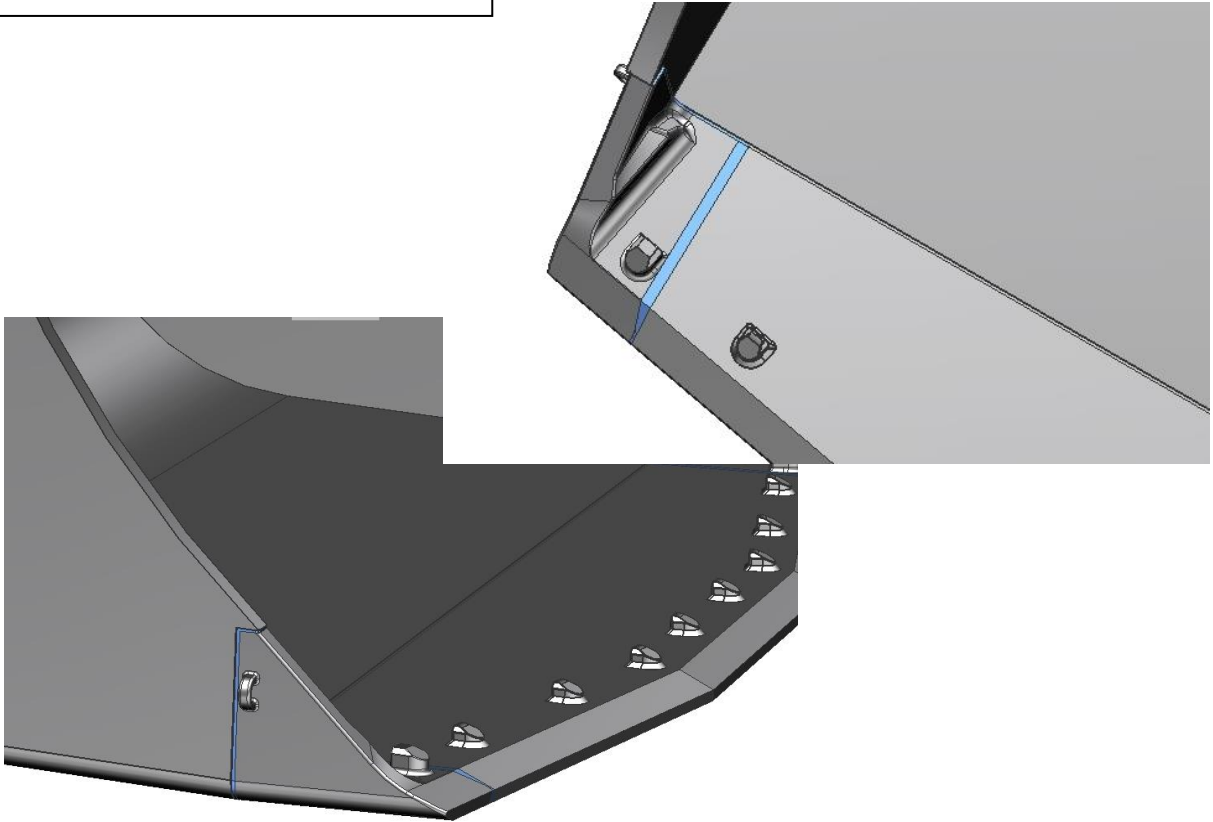
12. From the top of bucket weld Cast Corner to the lip.



13. Turn lip over and remove positioning plates as shown. Complete weld on underside of lip.



14. Remove remaining positioning plates and brace. Weld Cast Corner to the bucket.





15. Bucket complete.

