

# HALF ARROW LIP INSPECTION PROCEDURE

## 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 or according to OEM production drawing and meets all aspects of quality requirements. If required, the following documents shall be referenced with this procedure when performing the Lip inspection. This document is produced to support in line process checks during fabrication of the lip, some steps are to be performed before proceeding to next phase of fabrication.

- Sandvik Shark Lip Layout Drawing (varies for each Lip).
- PWP0001 – Product Welding Procedure.
- PWP0003 – Half Arrow Welding Procedure.
- PWP0013 – Half Arrow Full Spade Welding Procedure.
- PWP0015 – Half Arrow Full Spade Casting Welding Procedure.
- PWP0016 – Half Arrow Semi Spade Casting Welding Procedure.

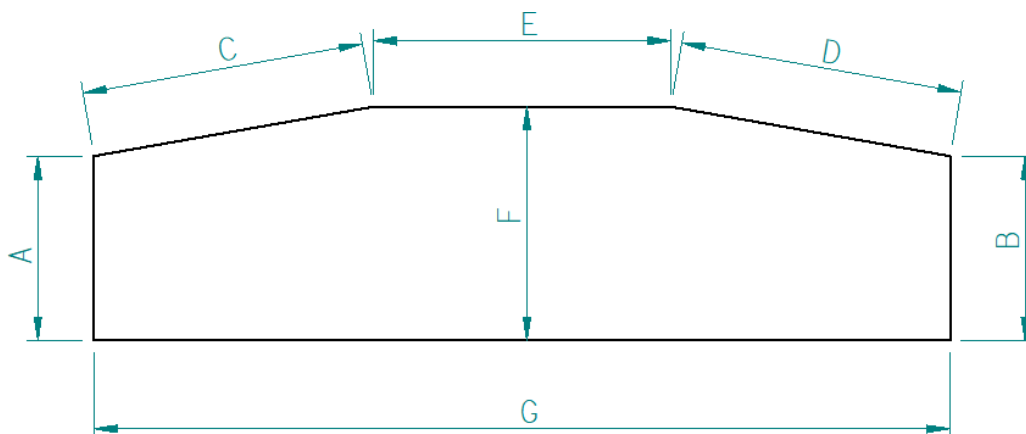
APPLICABLE PARTS :-

- Half Arrow 50mm and 32mm Lips.

### 2.0. INSPECTION PROCEDURE

#### STAGE-1: PROFILE CUTTING OF LIP PLATE

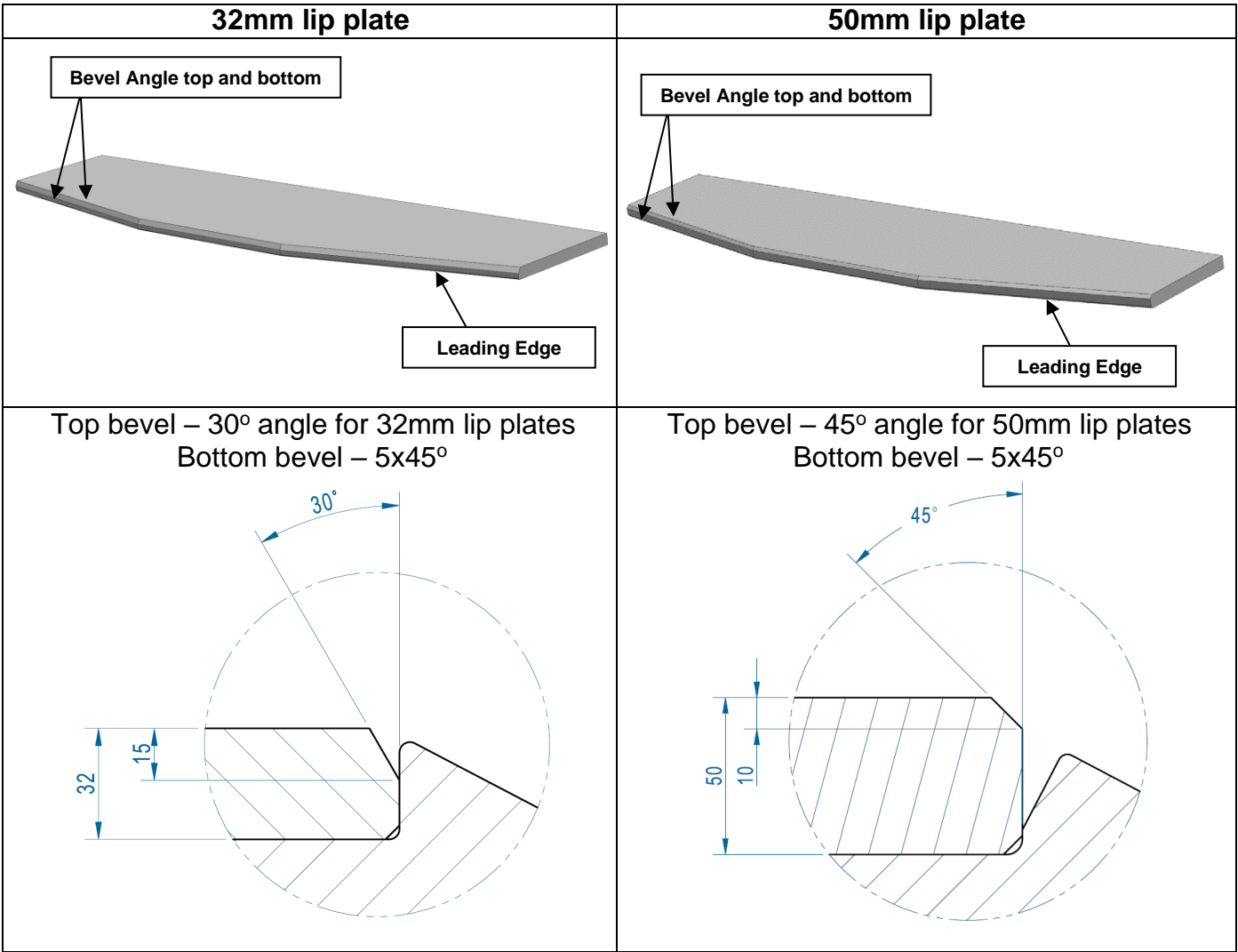
- Measure the dimensions shown below and record them



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



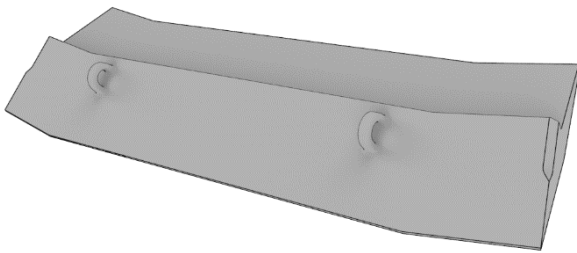


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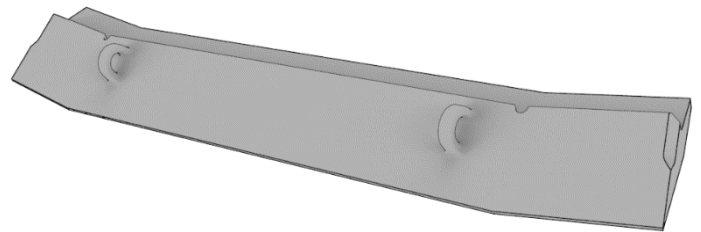
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For the application of the Half Arrow Points please follow these steps;

## Semi Spade Applications

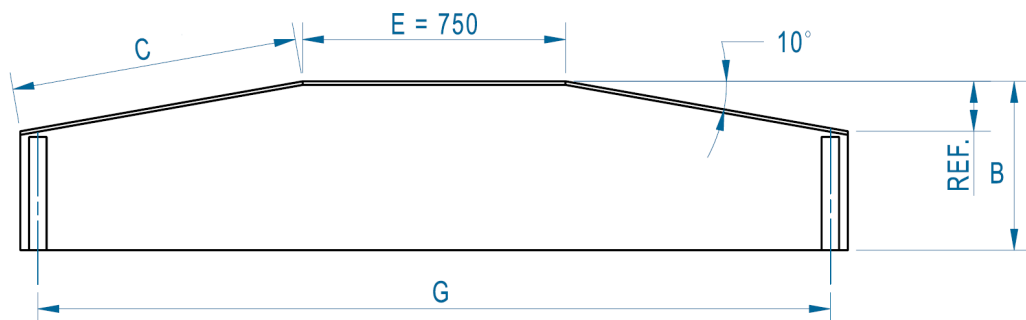


Half Arrow HD Semi Spade  
SHA320x1150-SS  
DI Part No: 69043430  
TC Part No: BC00000683  
Mass: 118 kg



Half Arrow LD Semi Spade  
SHA180x1150-SS  
DI Part No: 69043431  
TC Part No: BC00000684  
Mass: 53 kg

- The Center width 'E' is a constant size of 750mm and the Lip angle is a constant of 10°.

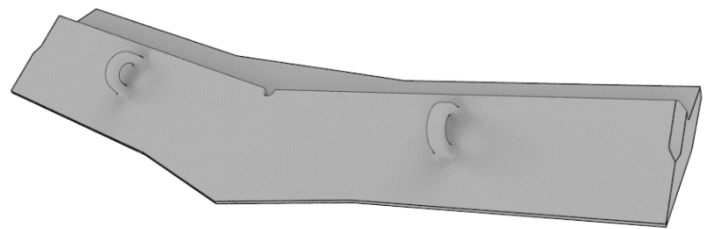
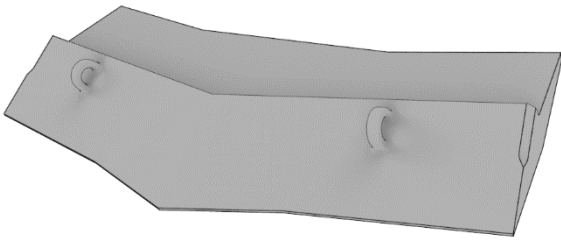




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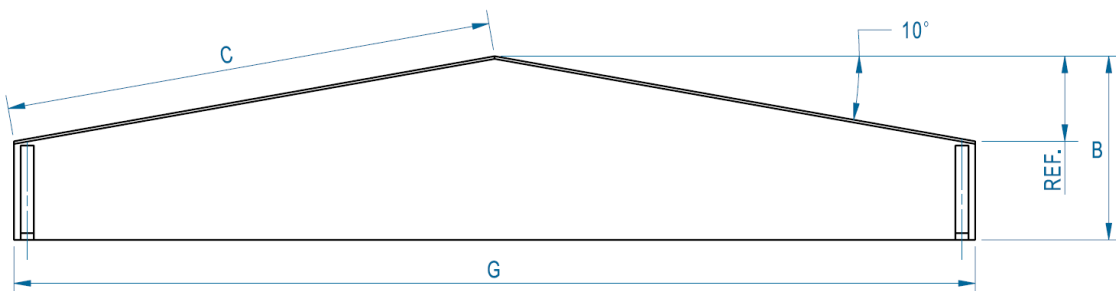
## Full Spade Applications



Half Arrow HD Full Spade  
SHA320x1044-FS  
DI Part No: 69043428  
TC Part No: BC00000679  
Mass: 117 kg

Half Arrow HD Full Spade  
SHA180x1026-FS  
DI Part No: 69043429  
TC Part No: BC00000851  
Mass: 54 kg

- The Center width 'E' is a constant size of 0mm and the Lip angle is a constant of 10°.



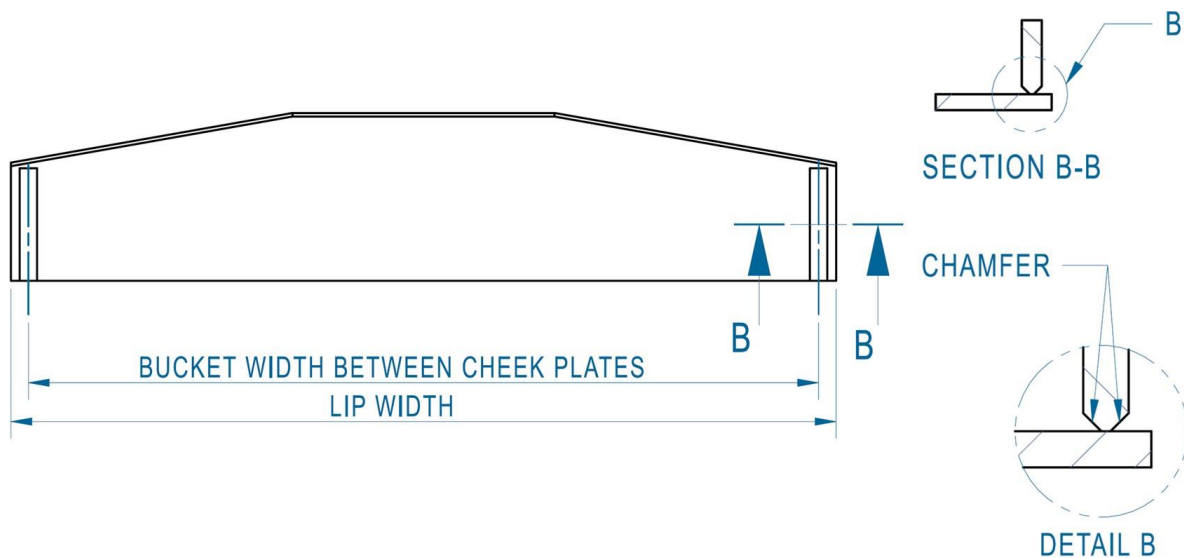
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### STAGE-3: POSITIONING OF CHEEK PLATES

- Position the Cheek Plates on the sides of the Lip Plate as per bucket dimension and as show below measure center to center width of the Lip prior to welding the Cheek Plates with the Lip plate.



### STAGE-4: BEFORE DPI OR MPI

- Before processing with DPI or MPI let assembly rest for 48 hours.

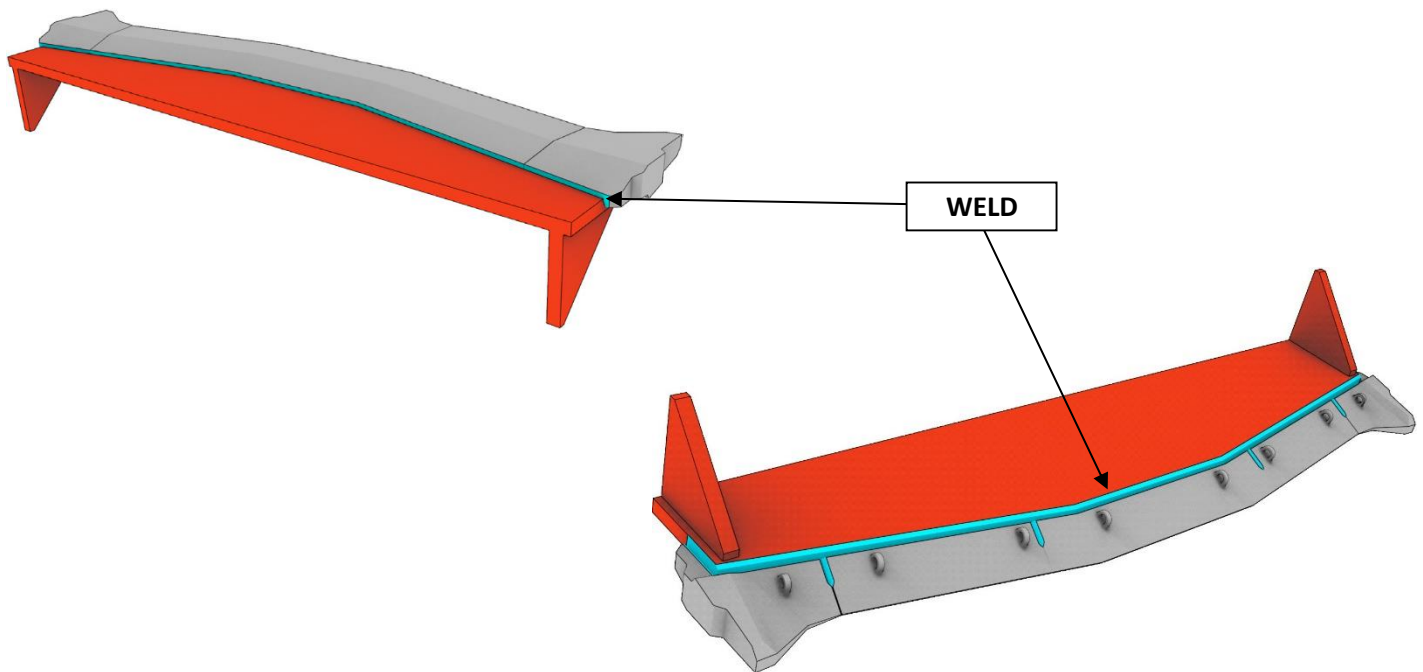


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## STAGE-5: DPI OR MPI OF WELD

- Any defects such as inclusions/cracks should be gouged out and re-welded according to PWP0001 procedure.



## STAGE-6: PAINTING

- Ensure the lip is thoroughly painted.

### 3.0. DOCUMENT CHANGE REGISTER

Rev	Date	Changes	Revised By	Approved By
0	-	-	-	-
1	9/02/2016	-	Bradley Dallard	Chye K Soon