

Product Processing Procedure

Title: Rebuilding 32mm Ejector Bucket Sidewall
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Date: 31 Oct 2013 **Approved By:** Marten Karlsson

SUMMARY

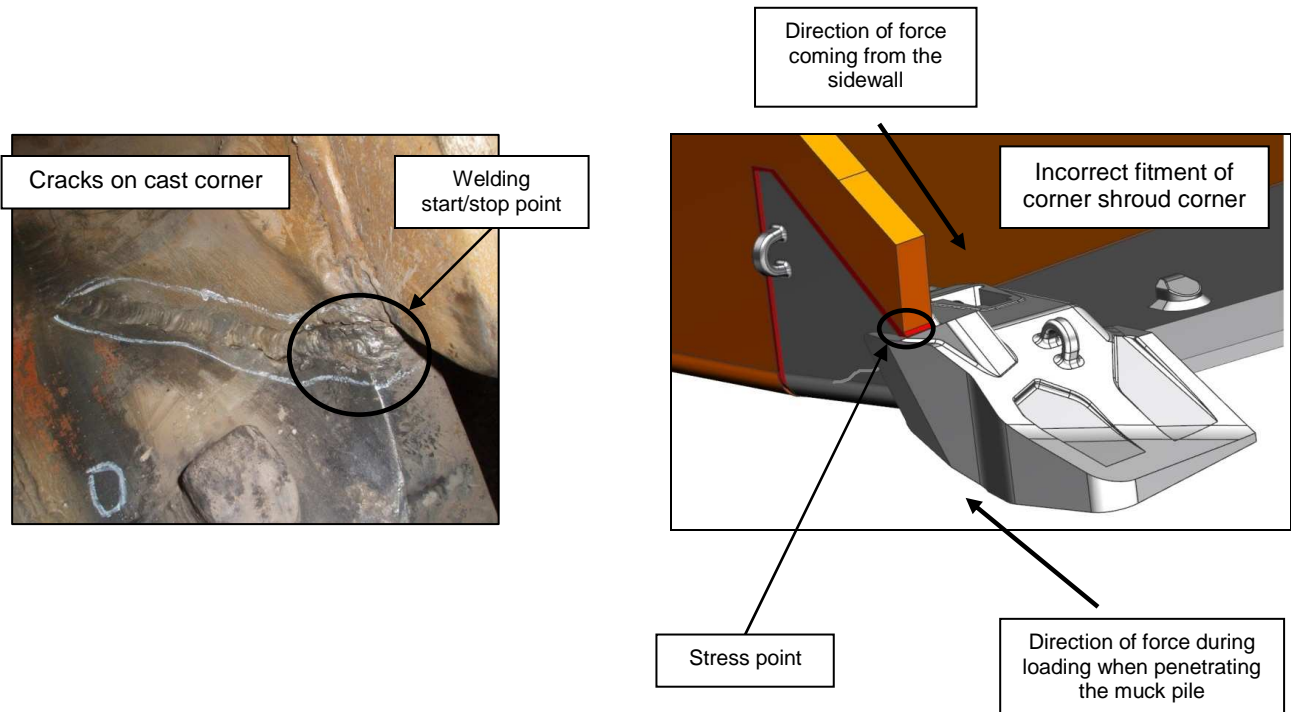
The purpose of this procedure is to present the correct method of rebuilding the weld joint between the sidewall and cast corner on the ejector bucket. This is a necessary modification due to stress points in current set-up, cracking of cast corner and incorrect fitment of corner shroud.

Aim is to improve fatigue life of cast corner and reduce the occurrence of corner shroud loosening.

Sandvik Welding Procedure PWP0001 should be referred to in conjunction with this document.

PROCEDURE

CURRENT FITMENT OF CORNER SHROUD

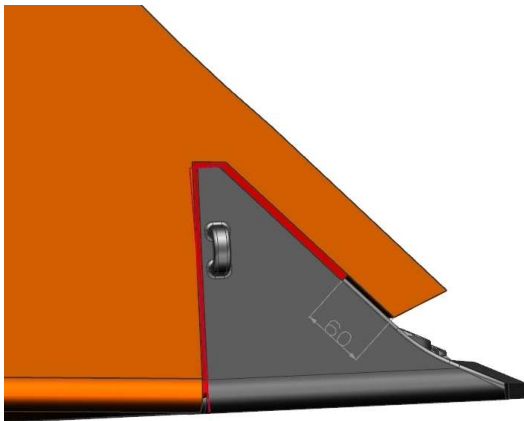


Step 1:

- Before working on the sidewall, make sure the corner shroud is removed from the cast corner.

Step 2:

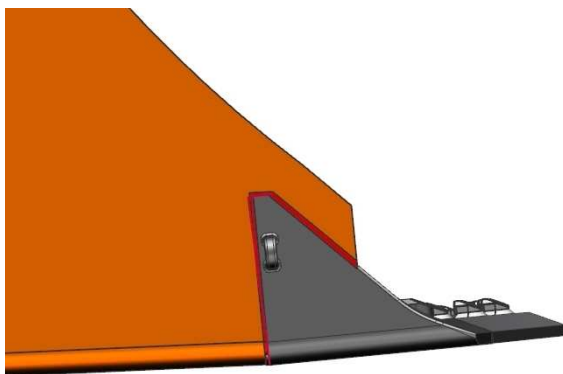
- Measure 60mm distance like image shown below and mark on a cast corner.



Make sure to preheat the sidewall before cutting from 150°C to 250°C.

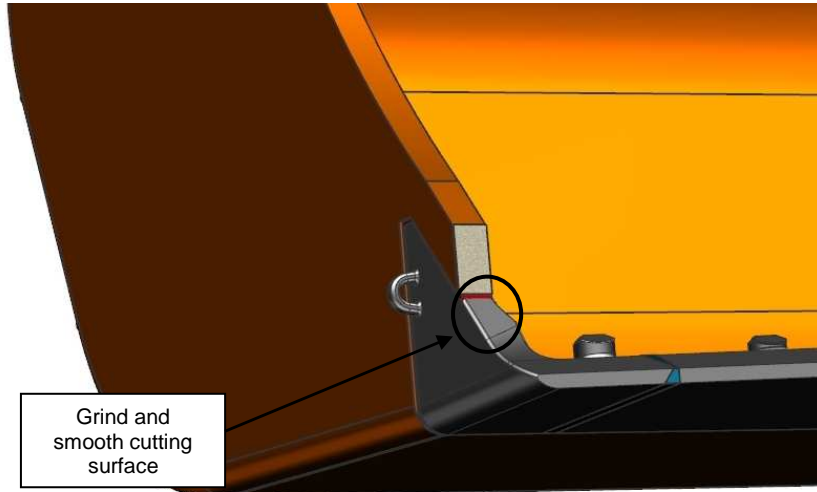
Step 3:

- Cut the sidewall like image shown below.



Step 4:

- Grind the cutting surface smooth and make sure it is free from cutting marks



Step 5:

- Grind the end of the weld to ensure it has big radius to reduce the stress in this point.

