

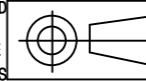
NOTES:

1. ALL WELD TOES TO TRANSITION SMOOTHLY TO LIP AND BOSS BY BLENDING.
2. IN 2F POSITION, COMMENCE FIRST FILLET PASS AT POINT 'A' AND END AT POINT 'C'. RE-COMMENCE FIRST PASS AT POINT 'D' AND END AT POINT 'G'. TWO SUBSEQUENT FILLET PASSES SHALL COMMENCE AT POINT 'E' AND END AT POINT 'G'. BLEND A SMOOTH TRANSITION BETWEEN FIRST FILLET PASSES AND SUBSEQUENT FILLET PASSES AT POINT 'E'.
3. 8.0 mm FILLETS SHALL BE WELDED FROM POINT 'A' TO 'C'. WELD FILLET GAINING IN THICKNESS FROM 6.0 mm TO 12.0 mm FROM POINT 'D' TO POINT 'F'. 12.0 mm FILLETS SHALL BE WELDED FROM POINT F TO G.
4. PARTIAL PENETRATION BUTT WELD SHALL BE WELDED USING A MINIMUM OF 2 PASSES IN THE 1G POSITION.
5. INTERFACE AT PARTIAL PENETRATION BUTT WELD AND FILLET WELDS AT EACH CORNER SHALL BE BLENDED SMOOTH.
6. EXTENSION WELD SHALL FOLLOW BOSS PROFILE.
7. GRIND OFF EXTENSION WELD TOP TO LIP TOP SURFACE AS SHOWN.
8. GRIND OFF EXCESS WELD AT POINT E AS SHOWN IN THE ISOMETRIC VIEW.
9. REFER TO WELD PASS INFORMATION DOCUMENT WPS SS-012 FOR MORE DETAILS.

DRAFTING STANDARD
AS1100 - 1992

DO NOT SCALE

ALL DIMENSIONS IN MILLIMETRES



TITLE

**MAKO 50MM BOSS SETUP
& LIP PLATE PROFILING
INFORMATION**

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DRAWN
J. JOSE

DATE 02/03/17 SCALE 1:3

DRAWING No.
BU00037748

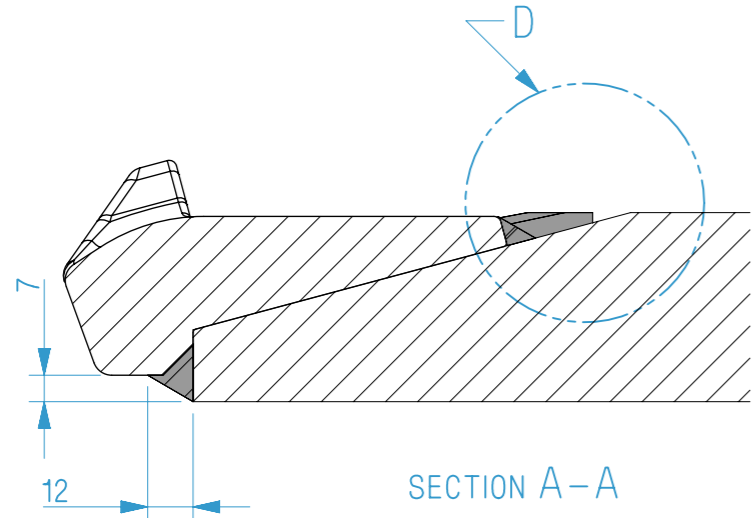
SHEET No.
1 OF 2

DWG SIZE
A3

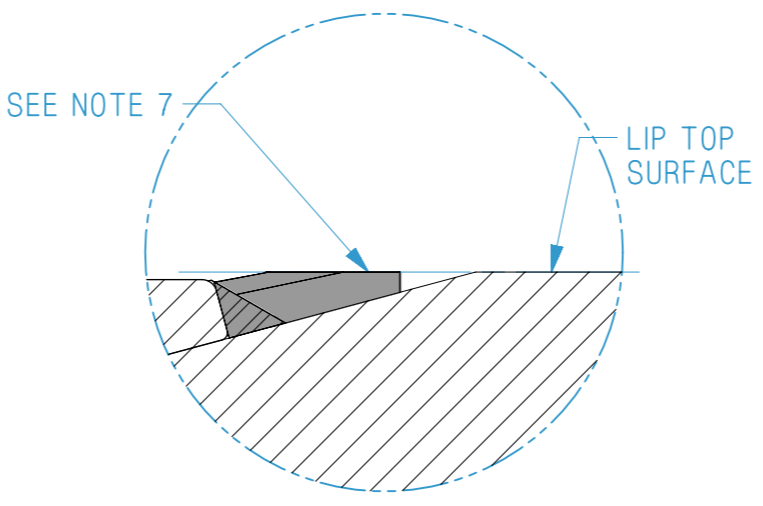
REVISION.
C

REV.	DESCRIPTION	BY	DATE	APP'D	REF. DRAWINGS
A	ORIGINAL ISSUE	J.J	02/03/17	B.J.D	
B	(1)POINT C POSITION CHANGED, (2) POINT D ADDED.,(3) NOTE 2 RE-WORDED. (4)VARIABLE FILLET THICKNESS ADDED IN NOTE 3., (5)19 REF; WAS 19+0/-1.5. (6)116 REF; WAS 115.7+1.5/-0, (7)50+1.5/-0.9; WAS 50+0/-1.5,(8&9)12 ± 1; WAS 12.	J.J	15/09/17	R.F.S	
C	(10)ADDITIONAL WELDS ADDED AND WELD POINTS REDEFINED.	J.J	18/09/18	B.J.D	

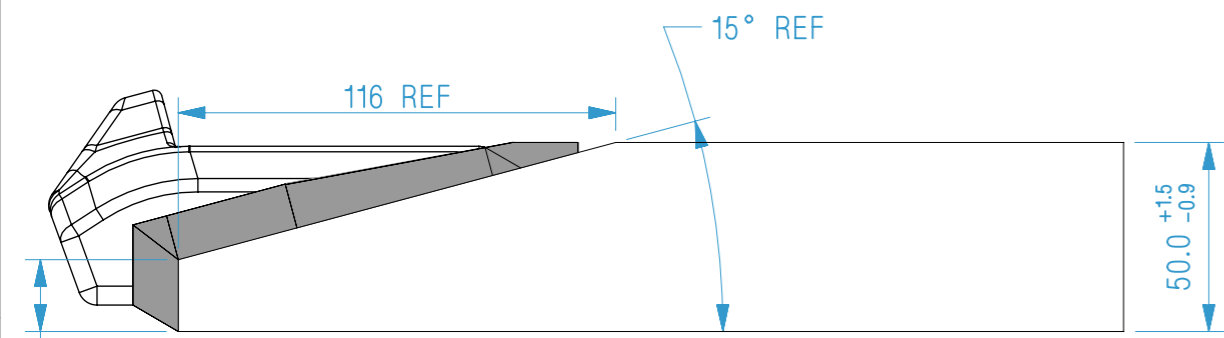
PRODUCTION METHOD	FROM - INC.	GENERAL TOLERANCES					ANGULAR DIMS. (±)	FLATNESS (mm)
		LINEAR & CYLINDRICAL DIMENSIONS (± mm)						
SAND CAST	WHOLE No.	≤50	51 - 250	251 - 500	501 - 1000	>1000	2.0°	3 PER 1000
	DECIMAL	2.0	2.5	3.0	3.5	4.0	1.0°	
FABRICATED OR INVESTMENT CAST	WHOLE No.	1.0	1.5	2.0	2.5	3.0	1.0°	2 PER 1000
	DECIMAL	0.5	1.0	1.5	2.0	2.5	0.5°	
MACHINED	WHOLE No.	0.5	1.0	1.5	2.0	2.5	0.5°	0.5 PER 1000
	1ST DEC.	0.1	0.2	0.4	0.6	1.0	0.1°	
	2ND DEC.	0.05	0.15	0.2	0.3	0.5	0.05°	



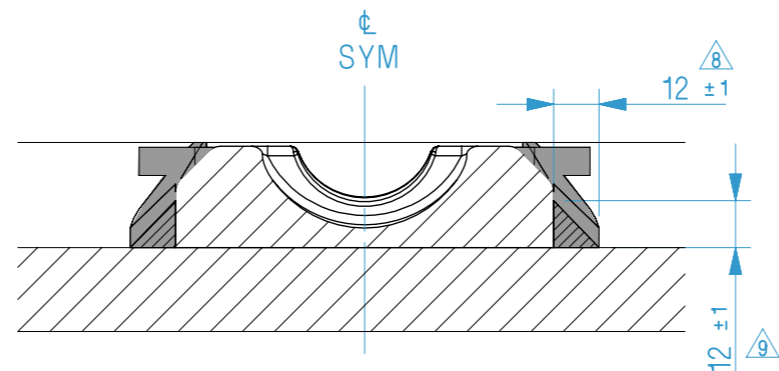
SECTION A-A



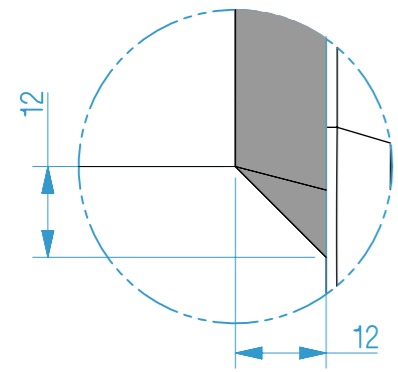
DETAIL D SCALE 1:1



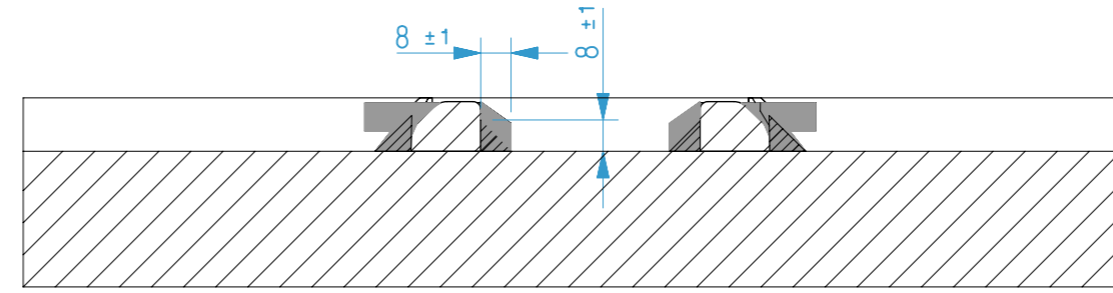
LIP PROFILE
50mm HARDOX PLATE



SECTION B-B



DETAIL C
SCALE 1:1



SECTION E-E

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AS1100 - 1992
DO NOT SCALE
ALL DIMENSIONS IN MILLIMETRES



TITLE
**MAKO 50MM BOSS SETUP
& LIP PLATE PROFILING
INFORMATION**

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C	(10)ADDITIONAL WELDS ADDED AND WELD POINTS REDEFINED.	J.J	18/09/18	B.J.D	

PRODUCTION METHOD	FROM - INC.	GENERAL TOLERANCES					ANGULAR DIMS. (±)	FLATNESS (mm)
		LINEAR & CYLINDRICAL DIMENSIONS (± mm)						
SAND CAST	WHOLE No.	2.0	2.5	3.0	3.5	4.0	2.0°	3 PER 1000
	DECIMAL	1.0	1.5	2.0	2.5	3.0	1.0°	
FABRICATED OR INVESTMENT CAST	WHOLE No.	1.0	1.5	2.0	2.5	3.0	1.0°	2 PER 1000
	DECIMAL	0.5	1.0	1.5	2.0	2.5	0.5°	
MACHINED	WHOLE No.	0.5	1.0	1.5	2.0	2.5	0.5°	0.5 PER 1000
	1ST DEC.	0.1	0.2	0.4	0.6	1.0	0.1°	
	2ND DEC.	0.05	0.15	0.2	0.3	0.5	0.05°	

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J.JOSE

DATE 02/03/17 SCALE 1:3

DRAWING No. BU00037748 SHEET No. 2 OF 2 DWG SIZE A3 REVISION. C