

CUTTING DETAILS

Figure 1

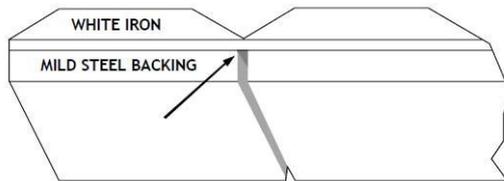
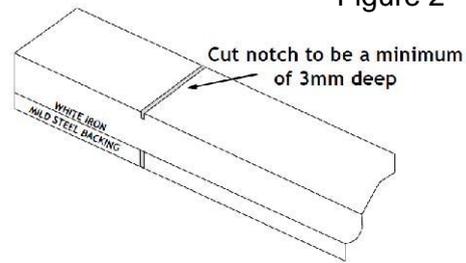


Figure 2



High pressure abrasive water jet cutting is preferred cutting method. Thermal cutting using an oxyacetylene torch, Arc-air or plasma is NOT recommended due to high localized heat input and high risk of cracking and delamination.

For WEAR parts no greater than 25 mm section thickness, cutting by Abrasive disc is an accepted practice.

CAUTION: Extreme care must be taken when cutting to minimize local pre-heating or cracks and delamination may occur.

Cutting procedure <25 mm section thickness:

1. secure the WEAR part to be cut in a vice or clamp;
2. notch the backing plate as shown in figure 1;
3. notch the White Iron a minimum of 3 mm deep opposite the notch in the backing plate as per figure 2;
4. wrap the WEAR part with a rag and carefully hit using a soft face hammer. The piece should break cleanly at the notch.

Note: the deeper the notch in the White Iron, the cleaner the break.