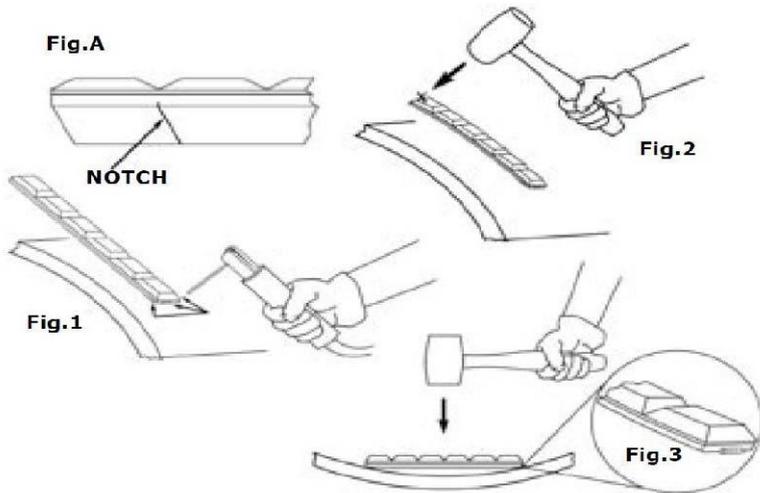


FORMING PROCEDURES



This practice is suitable for WEAR Chocky Bars and WEAR Strips only.

Note: for severe curves with radius of less than 305 mm, or inside curves, it is advisable to notch the mild steel backing plate opposite the 'V' to assist forming (Figure A).

The WEAR Chocky Bar or Strip may crack during bending. This is normal.

1. clean the surface to which the WEAR Chocky Bar or Strip will be welded;
2. tack weld one end of the WEAR Chocky Bar or Strip (as per the welding procedure) in at least 3 places by 15 mm minimum length per weld (Figure 1)

Outside curves : hammer down unwelded end with a soft faced hammer to bend bar to match mating radius (Figure 2)

Inside curves : starting in the centre strike bar with a soft face hammer to bend bar to match mating radius (Figure 3);

3. stitch weld as per the weld procedure.

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