

Document Version Control		
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WP0006	0	08/02/2016

PRODUCT WELDING PROCEDURE – LOCKJAW LOCK CAVITY REPAIR

OUTLINE

In the event that the Lockjaw System becomes excessively damaged resulting in newly fitted shrouds reaching the full lock rotation limit of the product (240 Degrees). The lock cavity can be rebuilt to restore the tightening capacity of the system. This procedure details the recommended process to rebuild Talon Lockjaw lock cavities. The process is demonstrated using a weld-on Boss but may be applied to any Lockjaw Adaptor, Cast Corner or weld-on Boss.

WELDING SAFETY

Welding, cutting and any allied process are a significant safety risk. Before undertaking any of these processes ensure that all precautions have been considered or implemented as per welding safety standards AS1674: 2007 or ANSI Z49.1: 2005 or equivalent globally recognized standard.

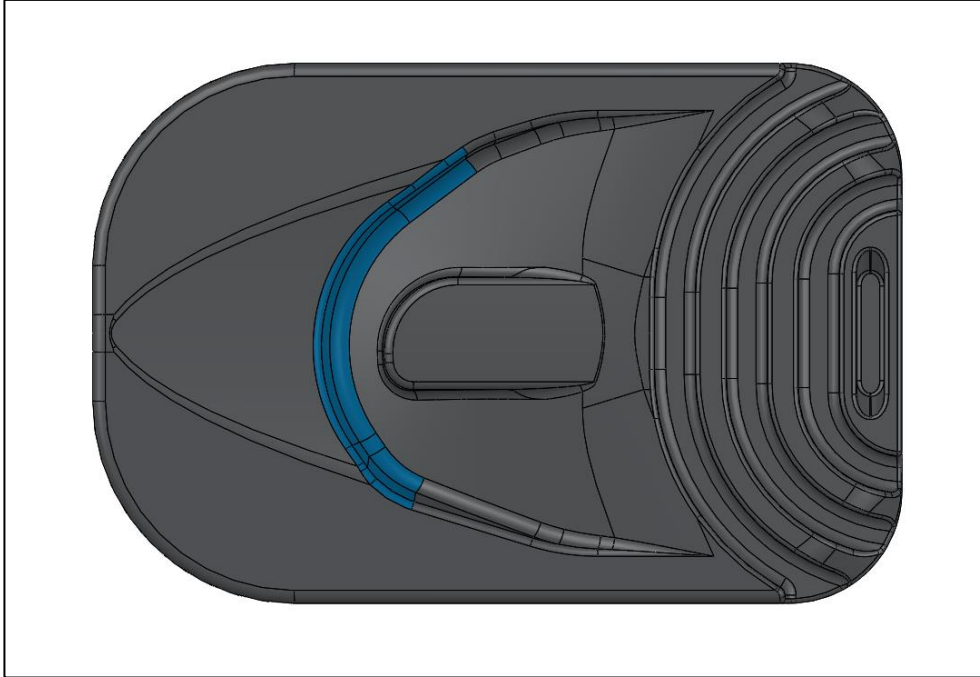
Of particular note please ensure the following is adhered to:

- Wear correct PPE including
 - Full sleeve non-flammable work wear. (No gaps)
 - Non-flammable welding gloves
 - Steel capped work boots
 - Safety glasses
 - Hearing protection
 - Full face welding shield
- Suitable ventilation is available for the person completing the operation.
- Welding is an electrical risk ensure the area where welding is to be conducted is not damp or wet.
- Welding is a fire risk ensure the area where welding is to be conducted is free of any thing flammable and that suitable fire extinguishers are easily available.
- If welding is to be conducted in an area where other people are working ensure welding flash shields are utilized.
- Good general housekeeping to ensure the work area is safe and free of clutter.
- Ensure appropriate tags for your work place and work environment are used.

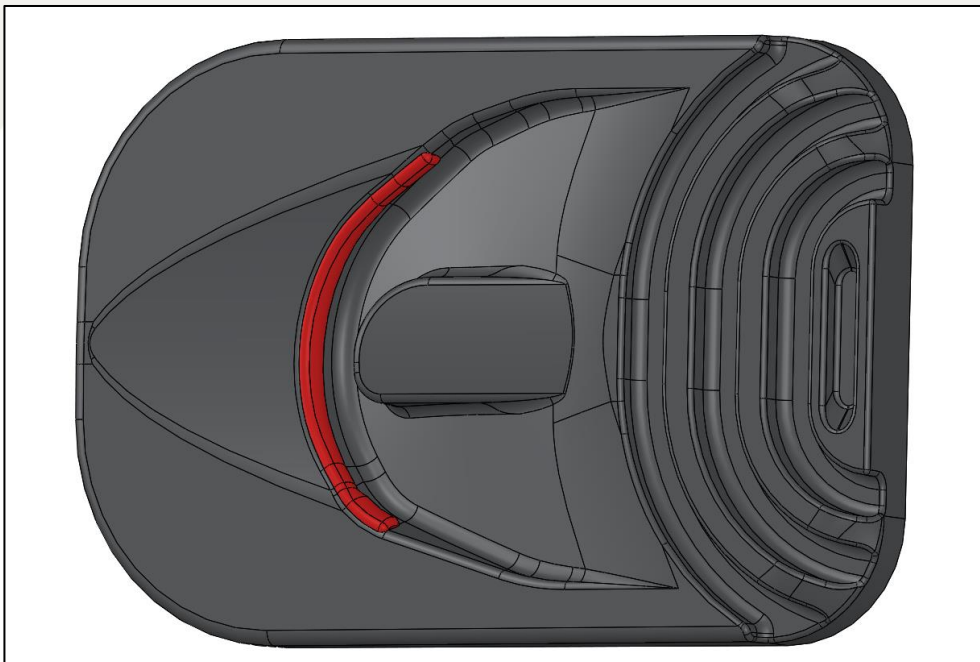
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RECOMMENDED REBUILD PROCESS

1. Remove Shroud or Point and clean the lock cavity area (Shown in Blue)

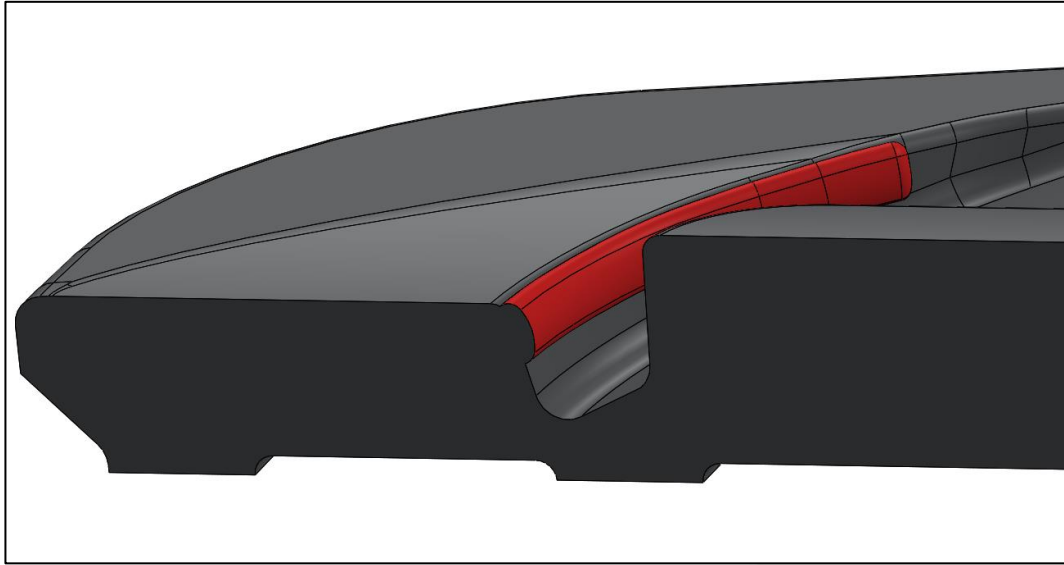


2. Using a die grinder removed any excessively damaged, burred or corroded portions of the lock cavity until sound base metal is exposed.
3. Preheat the lock area to 150 Degrees
4. Using a high tensile welding electrode (70000 Psi minimum). Rebuild the lock cavity area by applying a shallow weld approximately as shown in the following image.

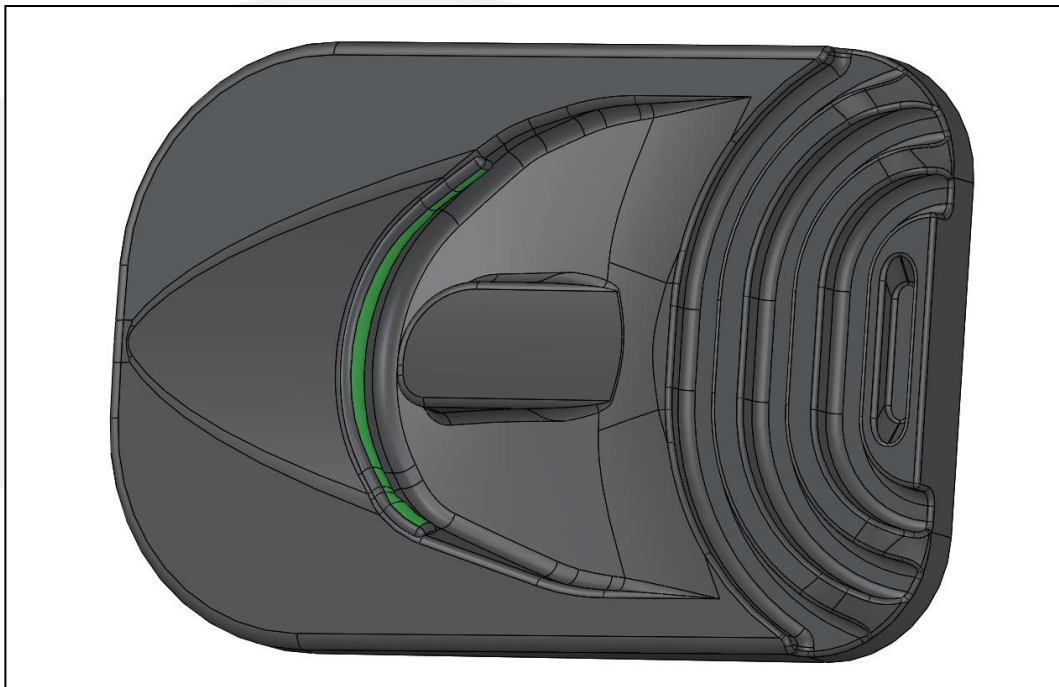


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5. The lock surface should be built up approximately 2-3 mm

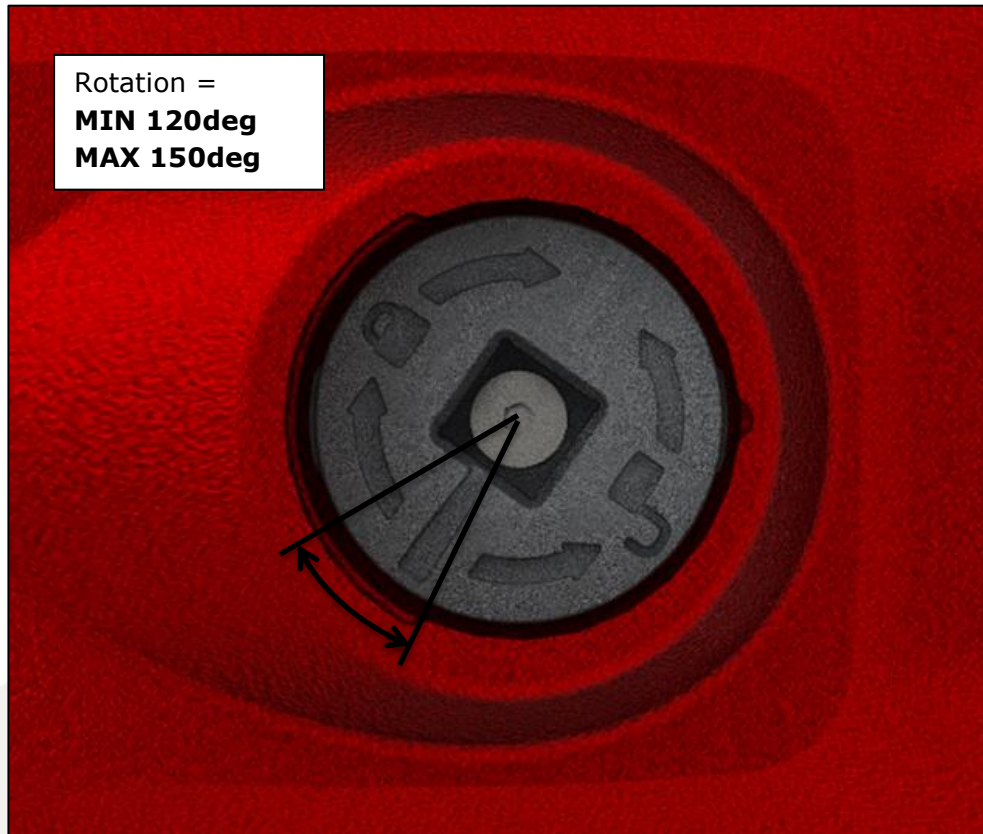


6. Following the welding process using a die grinder smooth and reshape the weld to approximately match the original bearing surface (Shown in Green)



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7. Fit and tighten a test Shroud or Point
8. Check the lock rotation when at full tension is greater than 120 degrees but less than 150 degrees.



9. Should the lock rotation be outside the range as specified above. Repeat steps 4 through to 6 as required for the lock to tighten to the specified range.