

Platen Replacement Tip Installation

INSTALLATION INSTRUCTIONS

- 1) To determine where to cut off platen tips, measure from the face of the fully-retracted push plate as shown in Figure 1-3. Burn off old tips perpendicular to platen centerline at original usable length of platen, as measured from push plate, less length of replacement tips. Refer to attachment model number for the platen's original usable length, as shown in Figure 1-1.
- 2) Burn or grind 0.18 x 45° weld prep on top and bottom of platens to match repair tips as shown in Figure 1-2.
- 3) Locate new tips to existing platens using ¼" x 2" x 12" flat bar pieces as fixtures to keep top surface of repair tips level with platens.
- 4) Pre-heat 100°- 200° F and weld with E11018 low hydrogen rod or E91T1- NI2 wire using alternate passes, alternating from top to bottom.
- 5) Remove flat bar fixture pieces and complete welding.
- 6) Grind and polish top surface of platens using consecutively finer grain discs until desired surface quality is achieved.

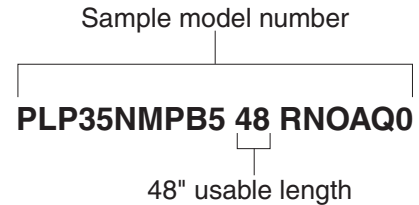


Figure 1-1

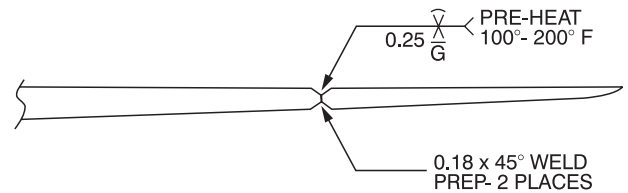


Figure 1-2

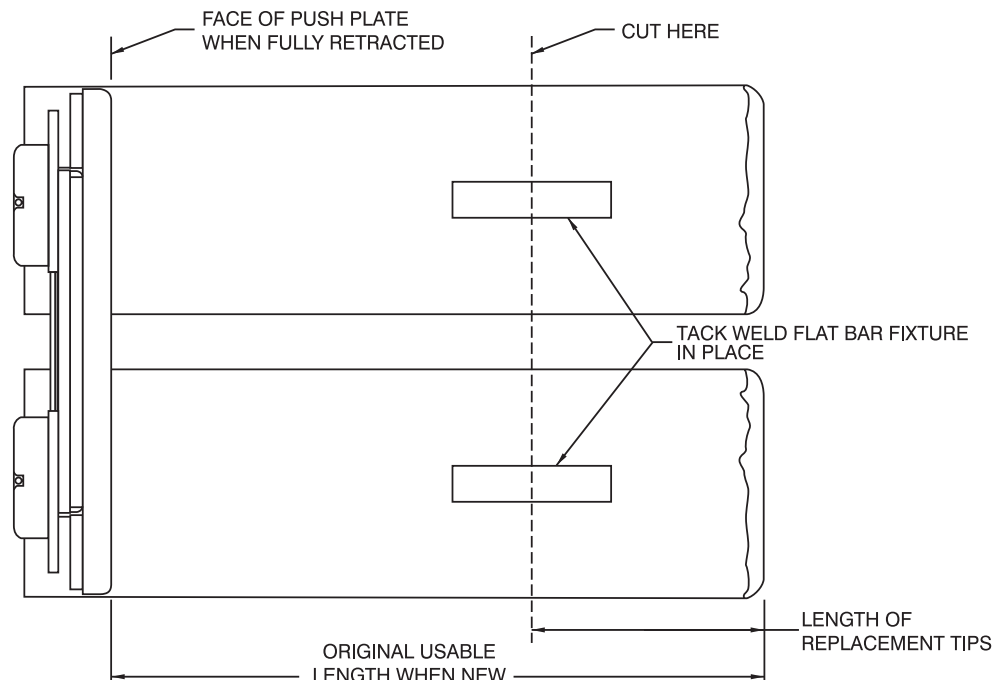


Figure 1-3