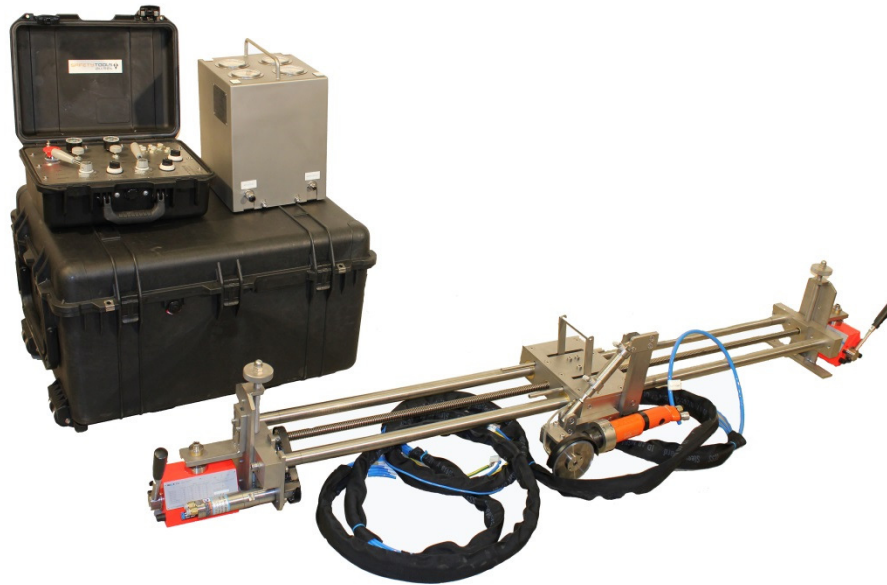


Guide for Weld Removal with Cutting guide Jr

Documentation created by STA Solutions AS for SafetyTools Allmet AS.



Picture1.

1. Setup

This is a guide on how to setup the cutting guide Jr to remove fillet welds and doubling plates. We use an A-0503, Weld removal disc, which is a thick (10mm) cutting disc.

There are a few things to remember when using a weld removal disc on the cutting guide jr. It is important to make sure that the disk is aligning with the weld on the entire track. Manually take the cutting wagon from one side to the other and make sure it is aligned. This is very important. Follow the cutting guide Jr manual for setting up the cutting guide Jr.

When completely removing doubling plates you can also remove a part (1-2mm) of the steel plate as well as the weld to get a good clean removal.

2. Notes

- Safety Tools equipment and tools should only be operated by trained and qualified personnel.
- Read the operations manual and maintenance manual before operating the tool.
- Make sure that there is no dirt, particles or other items in the system.

3. Use of weld removal disc on Cutting guide Jr



Picture2. (Easy)



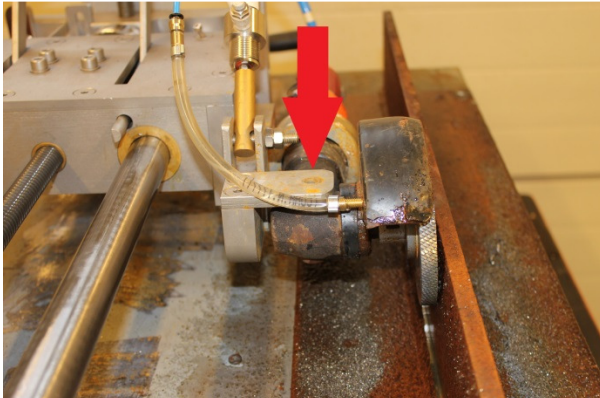
Picture3. (Complete)

Easy setup with a small leftover edge

If the job allows for a small leftover edge (picture 2) you can setup the guide as normal and start the job by doing a few rounds with almost zero pressure down. The disc will then cut less than normal, but instead of sliding down the weld it will create a good starting edge/track. After a few rounds and when you see that there is a good “edge to start” you can apply the recommended pressure for the rest of the cut. This method will leave an approx. 0,5mm leftover edge because the design of the disc (the small space between the ruler and the steel on picture2). The result depends on the angle of the weld.

Complete removal of weld

If it is needed to completely remove the weld (see picture3) there is an option to open the locking screw (red arrow picture 4) and loosen the clamp that holds the machine and tilt (picture 5) it a bit. Then lock the clamp tight with the machine in a tilted position. By not using the “head screw” you weaken the locking/tightening on the machine and it might twist after some use. Pay attention to it and adjust if needed. It might also be helpful to use a lower pressure than normal when not using the full locking mechanism (result in picture 6 and 7).

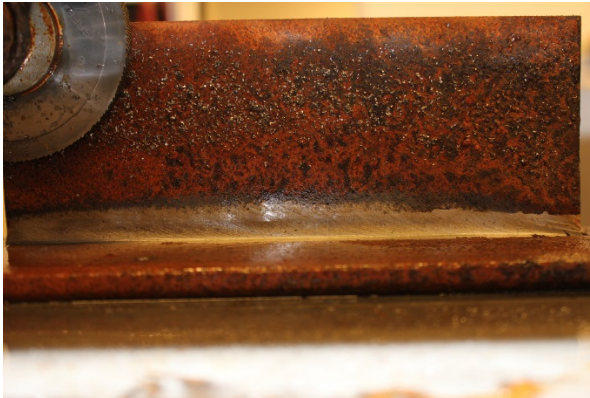


Picture4.

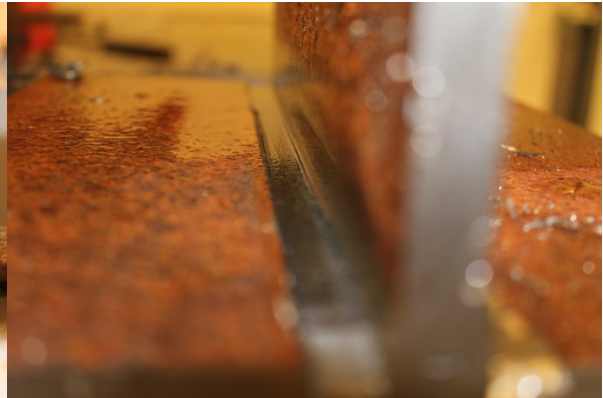


Picture5.

Result from using a tilted weld removal disc:



Picture6.



Picture7.

4. Removal of a doublings plate with a weld removal disc

Setup of the cutting guide jr with a weld removal disc with a small part of the disc onto the plate (picture8) to remove the weld and also the "burn inn". Picture 9 is after the job is done. No extra grinding is done on these pictures. This is done with a normal 90deg setup on the cutting guide jr.



Picture8.



Picture9.

You get a clean surface when the job is done.

Minimal extra cleanup!

Find more information and videos of the cutting guidejr on our web pages.

<http://www.safetytools.no/a-0320-cutting-guide-jr-solution/>