STOP weld MAX. 0.7" before front face

WELD on back faces if required.

0.02" CONCAVE contour for weld.
4 PLCs.

IMPORTANT WELDING NOTES:
1. TIG weld with T3AH 1/16" rod.
2. Weld should be built up to at least 2 layers plus extra layer, to be ground off after completion (speak to PAT MILLER)
3. Pre-heat the tool to 300-400°F as best as possible.
4. First two layers should be welded with same heat input.
5. Keep arc length as short as possible. Coated electrode at 90° to joint sides to avoid undercut. Hold electrode at angle 75° to 80° to direction of forward travel.
6. Any GRINDING should always be carried out before the temperature in the tool sinks too much. Not too rough as to make weld reheat.
7. Use A 46 HV wheel for grinding. Any other information is provided in attached sheets.

Knife Blade Weld Stage

<table>
<thead>
<tr>
<th>UNLESS NOTED</th>
<th>UNIT</th>
<th>QUANTITY</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. All Dimensional</td>
<td>Inches</td>
<td>1</td>
</tr>
<tr>
<td>Unless specified</td>
<td></td>
<td></td>
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</tbody>
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MATERIAL:
A2 Tool Steel

University of Illinois
Knife Blade Design

314 12-04-07  Manu Sharma