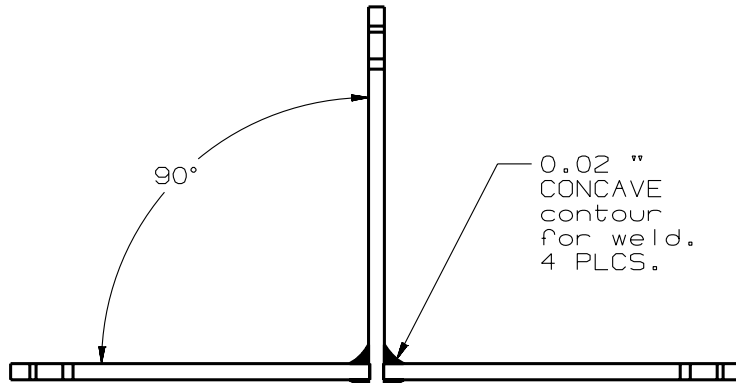
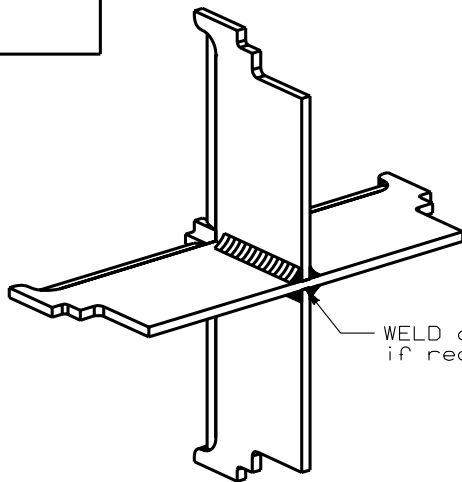


STOP weld MAX. 0.7"  
before front face



0.02 "  
CONCAVE  
contour  
for weld.  
4 PLCS.



WELD on back faces  
if required.

**IMPORTANT WELDING NOTES:**

1. TIG weld with T5AH 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)
  2. Pre-heat the tool to 390-480°F as best as possible;
  3. First two layers should be welded with same heat input;
  4. 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;
  5. Any GRINDING should always be carried out before the temperature in the tool sinks too much. Not too rough as to make weld redhot.
  6. Use A 46 HV wheel for grinding;
- Any other information is provided in attached sheets.

<b>Knife Blade Weld Stage</b>			DWG # <b>1</b>
UNLESS NOTED  1. All Dimensions: .xxx±.002  Unless specified	UNIT <b>Inches</b>	QUANTITY <b>1</b>	
	MATERIAL <b>A2 Tool Steel</b>	REV	
SIZE <b>A</b>	<b>University of Illinois Knife Blade Design</b>		
SCALE <b>3:4</b>	DATE <b>12-04-07</b>	DRAWN BY <b>Manu Sharma</b>	