

Fig A

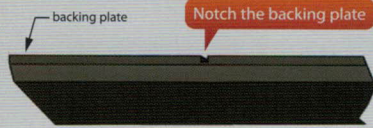


Fig B

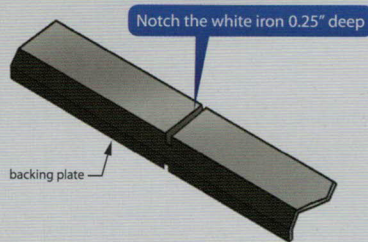


Fig C



Fig D

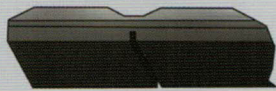


Fig E

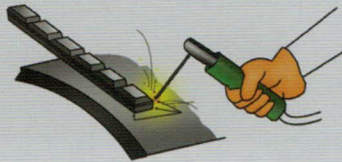
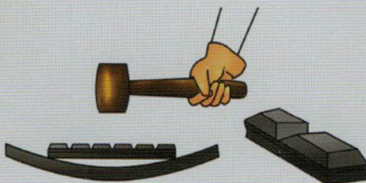


Fig F



Fig G



## CUTTING INSTRUCTIONS

**Recommended:** high-pressure water-jet cutting.  
**Not recommended:** thermal cutting with an oxyacetylene torch, arc-air, or plasma. Abrasive disc cutting is acceptable for blocks with less than 1" section thickness.

- Secure the block in vise or clamp.
- Notch the backing plate (Fig A) and the white iron a 1.25" depth opposite the plate (Fig B).
- Wrap the block in a rag, then carefully hit it with a soft-face hammer. Block should easily break at the notch.

## WELDING INSTRUCTIONS

Make sure that the surface to which you'll attach the block is clean and flat.

- Clamp and tack-weld the block into position.
- Stitch-weld, laying no more than 2" lengths per run, alternating ends or sides to minimize heat penetration. Do NOT deposit-weld within 0.25" from the joint (Fig C).
- Do NOT weld continuously. Such activity could cause warpage, delamination, or cracking. Do not exceed 400° F (200° C) temperatures.
- Use low-hydrogen welding rods or gas-covered cored wire.

## FORMING PROCEDURE

For curves with a radius less than 12" or for inside curves, notch the steel backing plate opposite the "V." This assists with forming (Fig D). (NOTE: JADCO HARDCHOC may crack during bending...this is normal.)

- Thoroughly clean the surface to which you'll weld HARDCHOC.
- Tack-weld one end of the bar by a minimum of 0.75" in length per weld (Fig E).
- For outside curves, softly hammer the unwelded end to bend the bar to match the mating radius (Fig F).
- For inside curves, softly hammer the bar (starting at the center) to bend the piece to match the mating radius (Fig G).
- Stitch-weld as noted in the Welding Instructions.