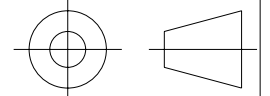


TECHNICAL INFORMATION

ALL DIMENSIONS IN INCHES	ORIGINAL SCALE 3/4
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GENERAL TOLERANCES UNLESS OTHERWISE STATED
 TO :± > :±
 > TO :± ANGLES:±
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	J. MEAGHER	06OCT05
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DI/ECR NUMBER 5039	ORIGINAL DRAWN BY: J. MEAGHER DATE: 06OCT05
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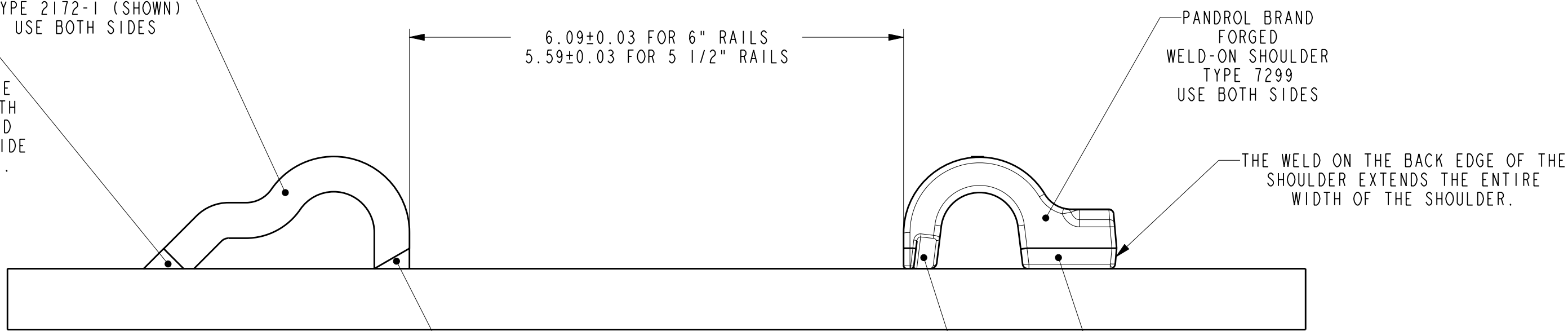
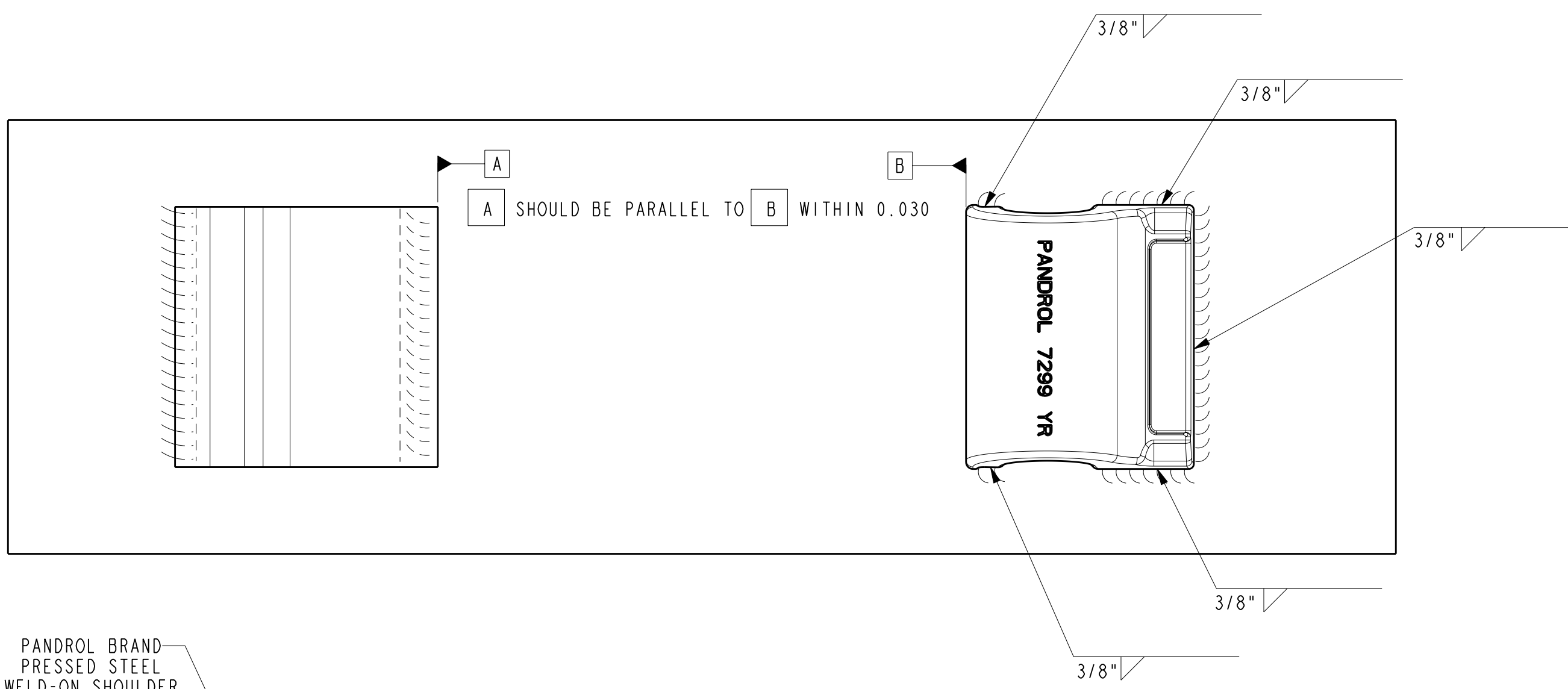


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TITLE
**DETAIL WELDMENT
 DRAWING FOR
 PRESSED STEEL / FORGED
 NON-INSULATED SHOULDERS**

DRAWING NO.
USK-1136

FILE REF. No.	SHEET
	1 OF 4 A2



THE WELD ON THE BACK EDGE OF THE SHOULDER EXTENDS THE ENTIRE WIDTH OF THE SHOULDER. THE WELD SHOULD BE 3/8" FILLET MINIMUM, AND PROVIDE ADEQUATE PENETRATION BOTH PARTS.

PANDROL BRAND PRESSED STEEL WELD-ON SHOULDER TYPE 2172-1 (SHOWN) USE BOTH SIDES

PANDROL BRAND FORGED WELD-ON SHOULDER TYPE 7299 USE BOTH SIDES

THE WELD ON THE BACK EDGE OF THE SHOULDER EXTENDS THE ENTIRE WIDTH OF THE SHOULDER.

THE WELD ON THE FRONT OF THE SHOULDER AT THE BEVEL SHOULD FILL THE GAP APPROXIMATELY 3/8", BUT NOT OVERFLOW INTO RAIL SEAT AREA. GRIND FACE OF WELD IN RAIL SEAT TO BE FLUSH WITH SURFACE OF SHOULDERS. ALSO GRIND WELD ON CORNERS OF SHOULDERS TO PERMIT FULL SURFACE BEARING FOR RAIL PAD (IF REQUIRED). CARE IN GRINDING MUST BE EXERCISED TO PREVENT ANY NOTCHING OF THE WELD OR SHOULDER.

THE WELD ALONG BOTH SIDES OF THE SHOULDER SHALL BEGIN 1/4" BEHIND THE BACK EDGE OF THE CLIP HOUSING AND CONTINUE TO THE BACK EDGE.

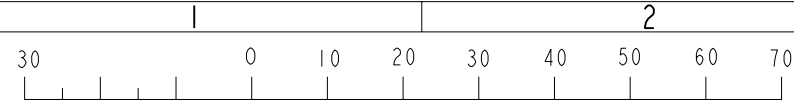
THE WELDS ON THE FRONT OF THE SHOULDER AT THE INDENTS SHOULD FILL THE INDENTS BUT NOT OVERFLOW INTO THE CLIP HOUSING.

NOTES:

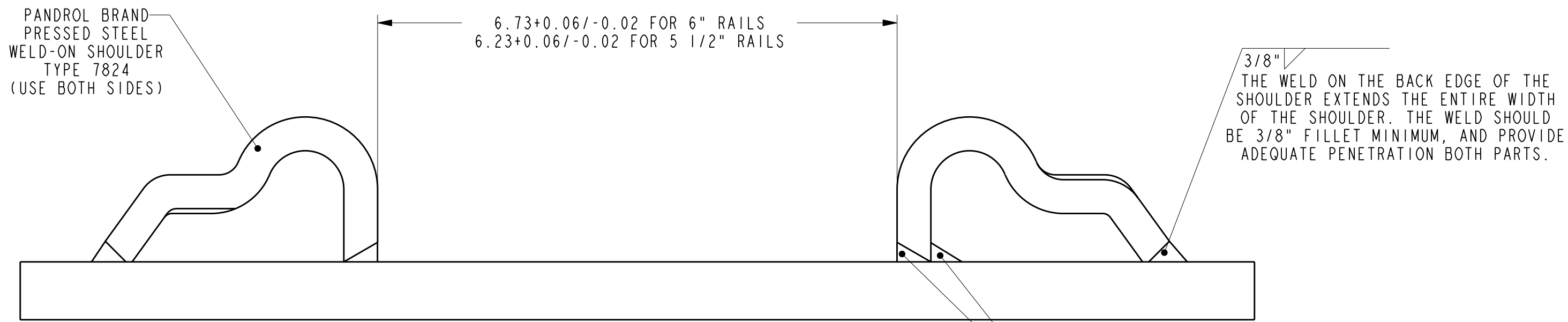
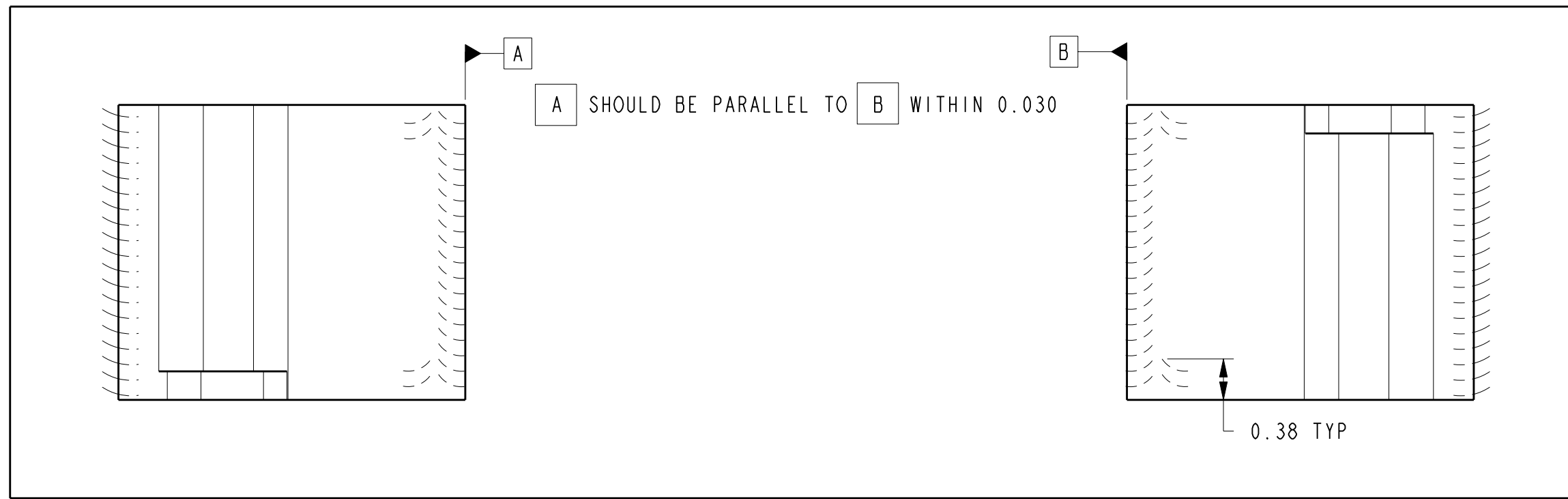
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2. ALL WELDS SHOULD BE 3/8" FILLET WELDS MINIMUM, AND PROVIDE ADEQUATE PENETRATION INTO BOTH SHOULDER AND PLATE.
3. WELD MUST NOT INTERFERE WITH EITHER RAIL OR PANDROL CLIP.
4. RAIL SEATS SHALL BE FREE OF EXCESS WELD, SLAG AND SPLATTER.
5. SHOULDERS SHALL BE TACKED (OR CLAMPED) DOWN PRIOR TO FINAL WELDING TO PREVENT THE SHOULDER FROM RISING DURING FINAL WELDING.
6. PRE-HEAT 7299 FORGED SHOULDER TO 300°F BEFORE WELDING.

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ISSUE CODE HISTORY	ISS	MOD	ISS	MOD	ISS	MOD
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SCALE 3:4

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3/8"
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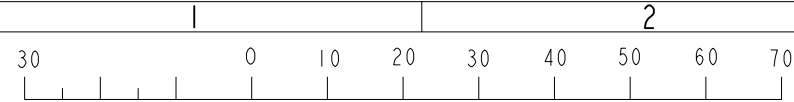
TITLE
**DETAIL WELDMENT
DRAWING FOR
PRESSED STEEL
INSULATED SHOULDERS**

DRAWING NO.
USK-1136

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FILE REF. No.	SHEET
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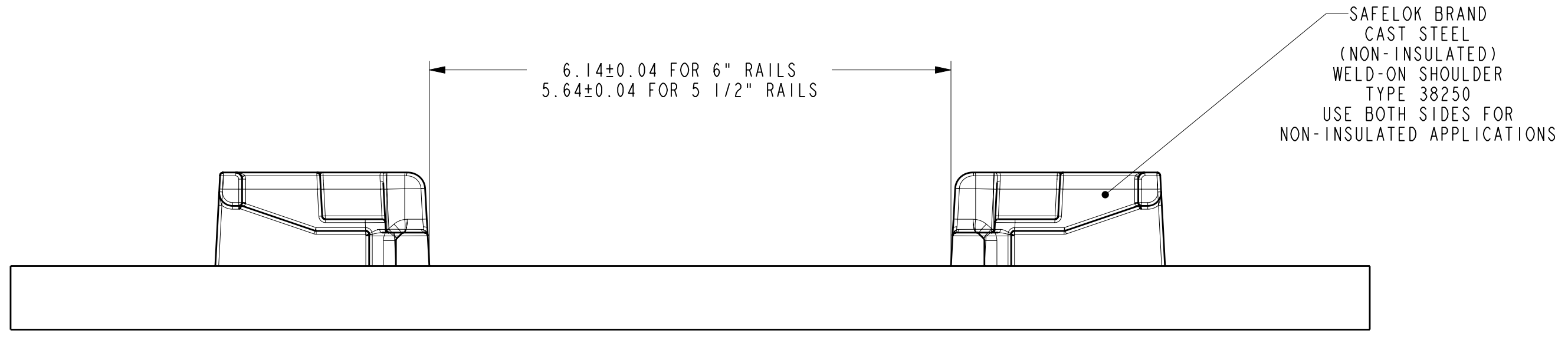
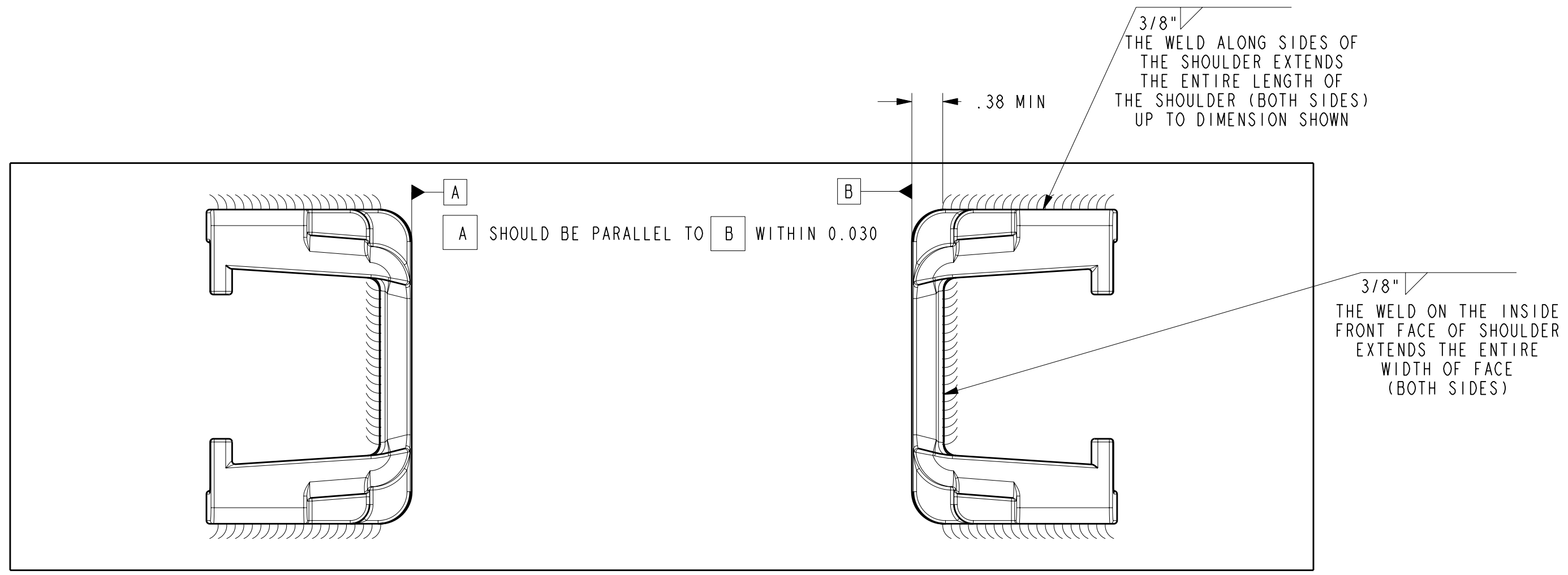
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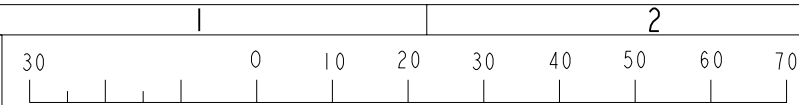
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DRAWING FOR
SAFELOK NON-INSULATED
CAST SHOULDERS**

DRAWING NO.
USK-1136

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FILE REF. No.	SHEET
	3 OF 4 A2



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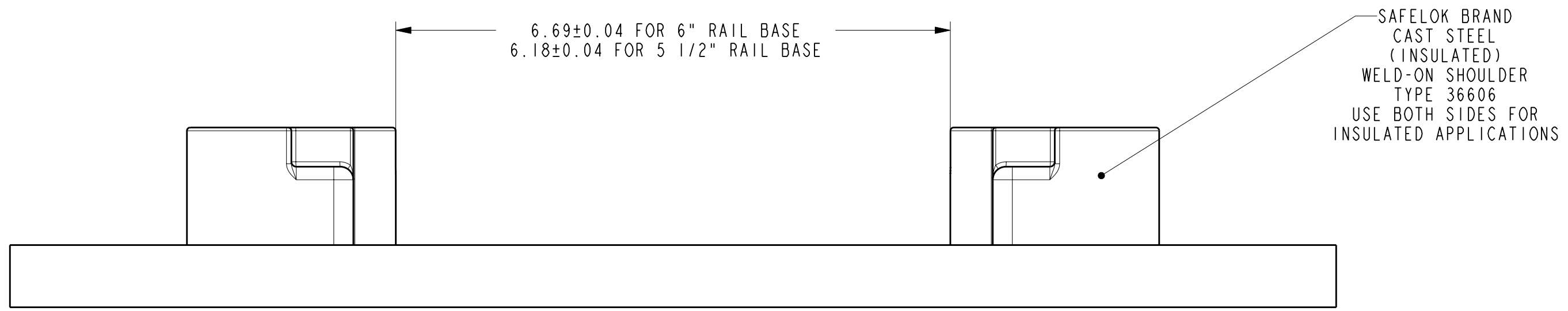
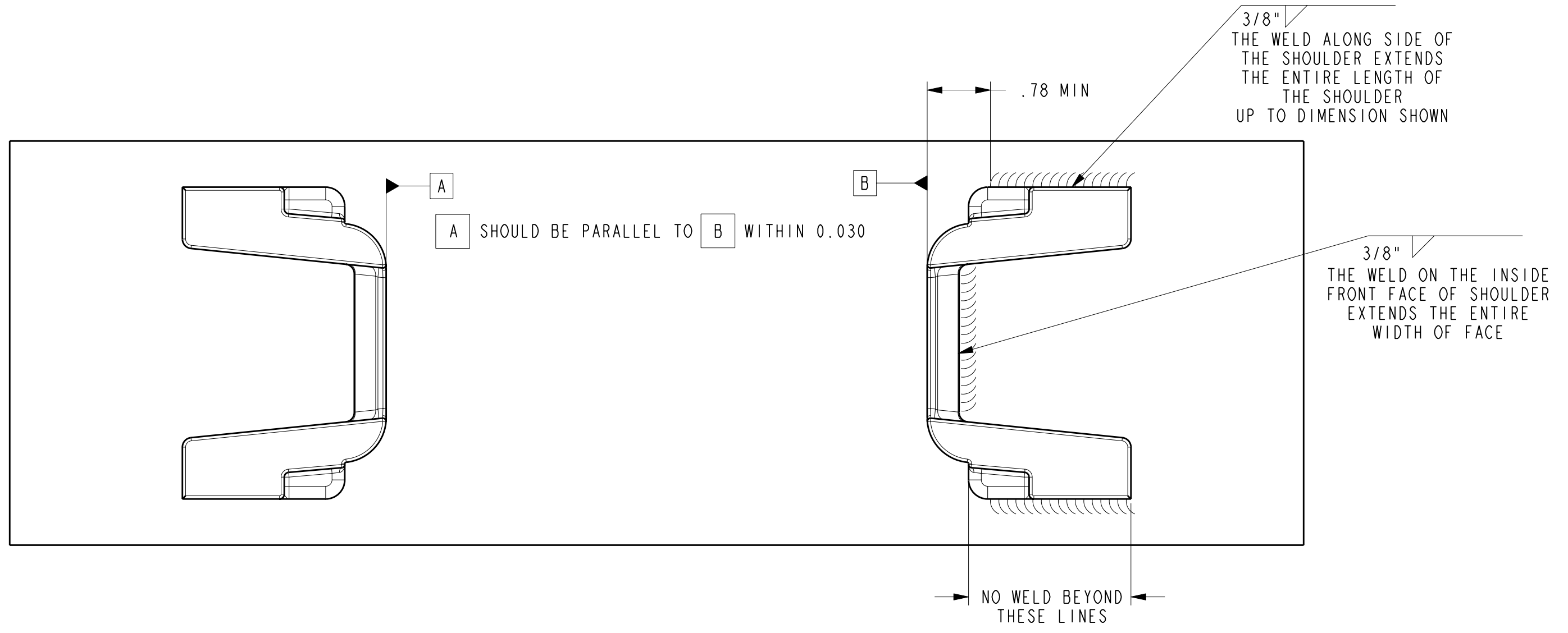
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