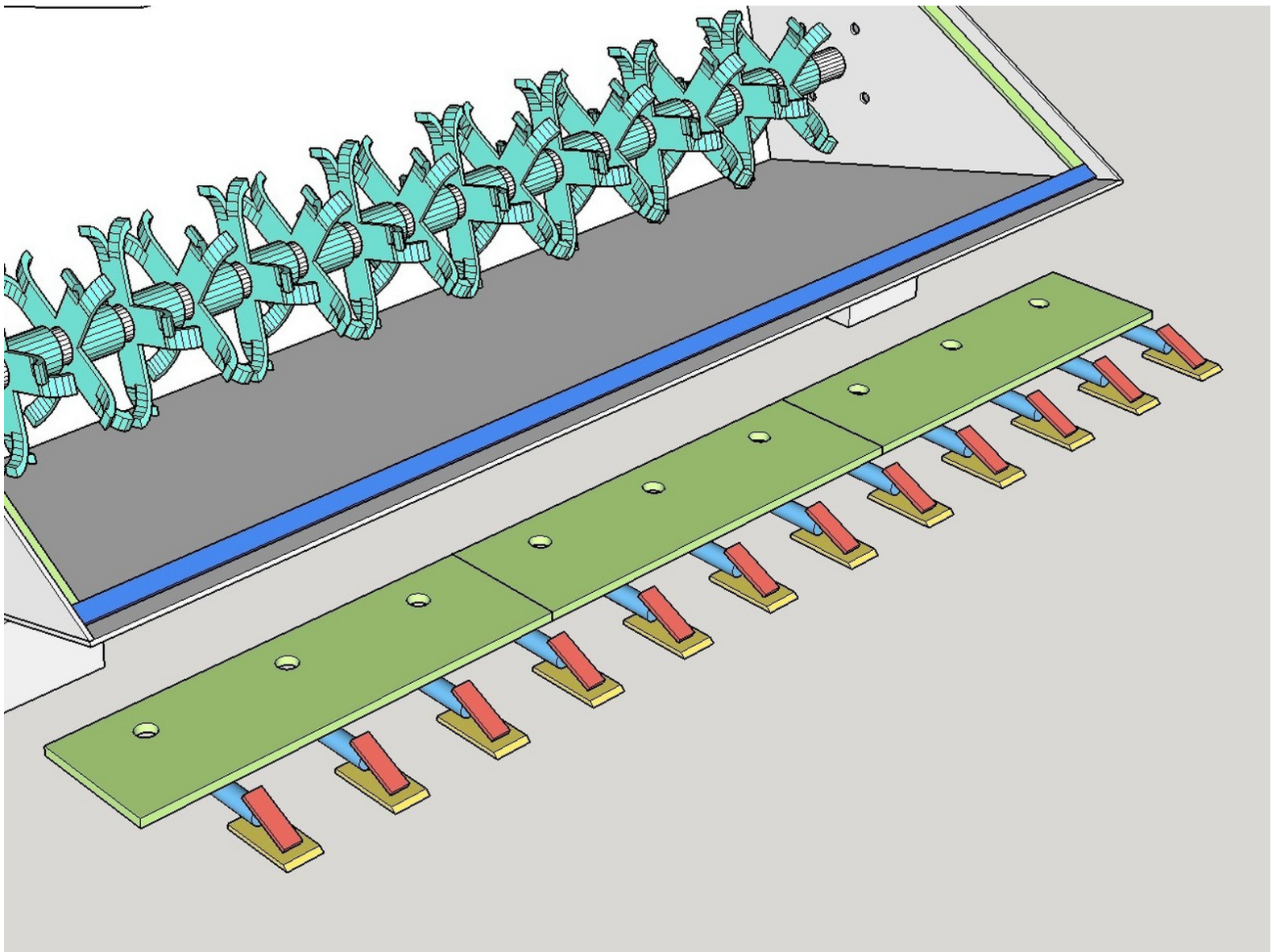




Installing Soil Mixer - Module - Toothbar Teeth

Fabrication process for teeth

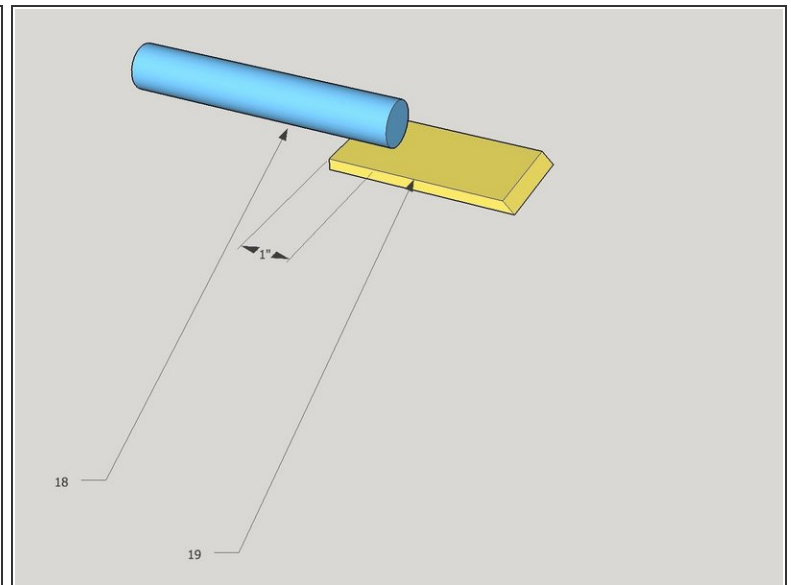
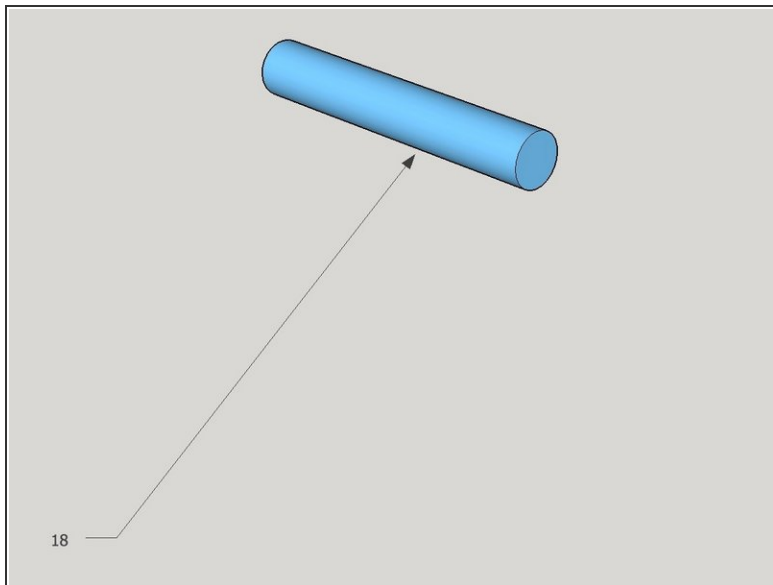
Written By: Andrew Graham



INTRODUCTION

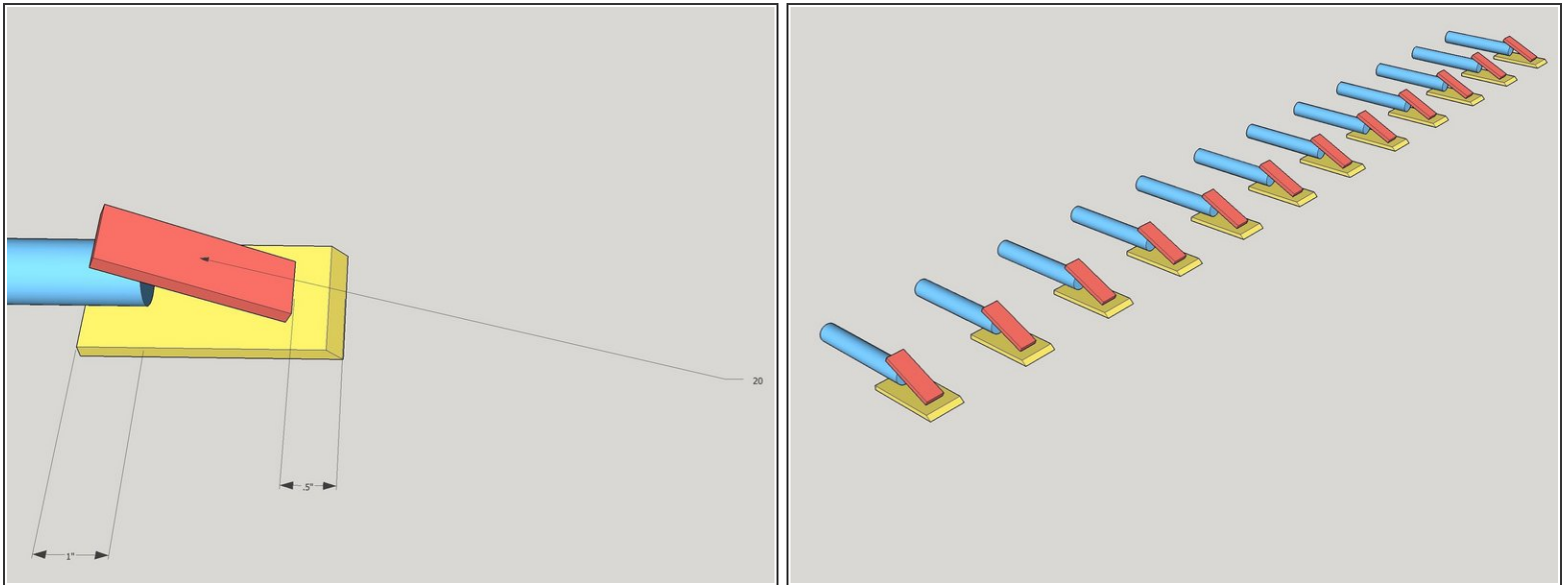
Outline what you are going to teach someone how to do.

Step 1 — Teeth



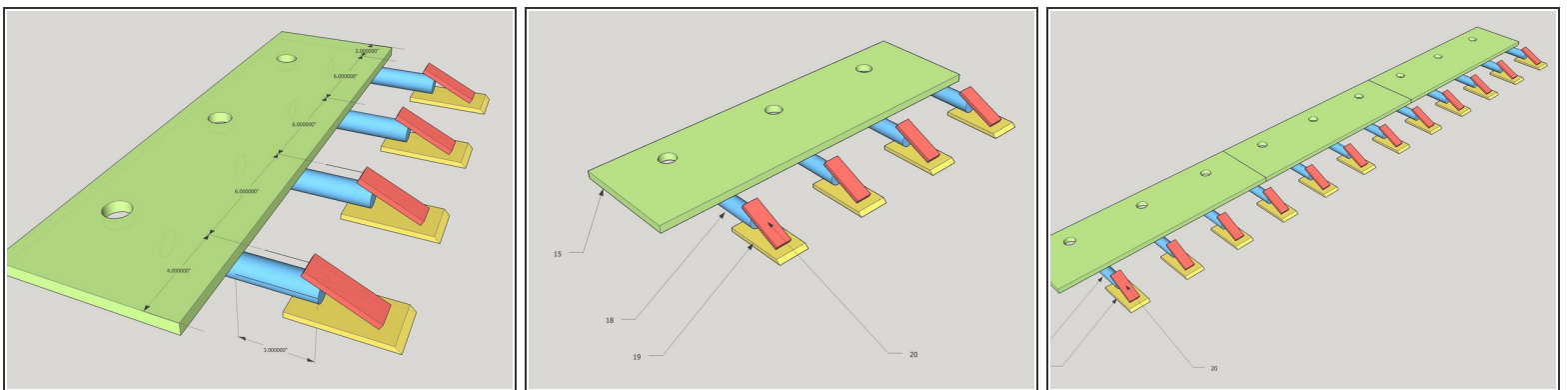
- Take P18 Rebar
- Lay P19 flat
- Weld P18 with 1" overlap onto center of P19

Step 2



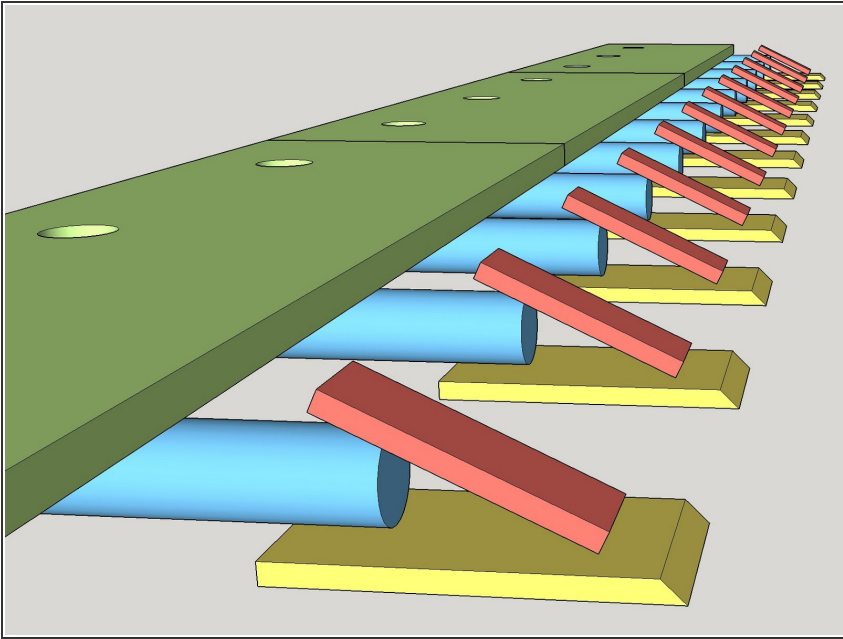
- Weld P20 to make 1/2" of P19 (cutting knife) exposed at the cutting edge
- Repeat for the total 12 teeth

Step 3



- Weld 4 teeth at the proper spacing (4" from the left to rebar centre and 2" from the right edge to rebar center) to part 15 (tooth bar bolt bar), with 3 inches overlap between P18 and P15 The teeth go on the side farthest from the bolt holes.
- Repeat for the 2 other P15 parts

Step 4



- Grind teeth at 45 degree angle with tooth bar weldment in a vice
- Water harden or air harden the teeth by heating to red hot with acetylene torch and then dunking in water

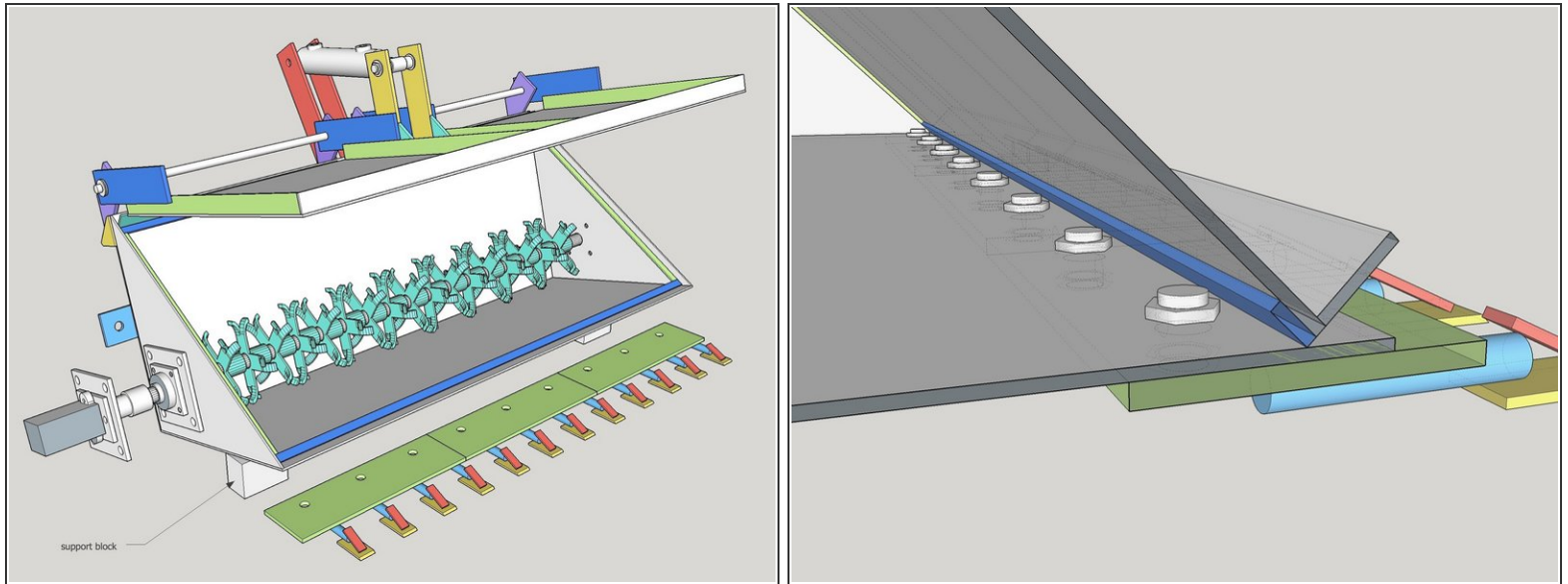
Step 5



- **Quality control Checklist**

- Make sure that P18 and P19 overlap by 1"
- Make sure that P18 and P19 are centered with respect to one another
- Make sure that at least about 1/2" of cutting knife is exposed after grinding
- Make sure that P15 is oriented with the side closest the holes on the side farthest away from the teeth
- Make sure that the angle between the long leading edge of P15 and P18 is 90 degrees i.e. those teeth are pointing straight outwards.

Step 6



- Open the lid after testing hydraulics, place a support underneath the lid for safety, and lift the bucket off the ground using the Lifetrac arms, or tilt the entire contraption and support with blocks.
- Fit the 3x P15 Digging Teeth Plates with 1" bolts to the Bucket, keeping the nuts on the topside.