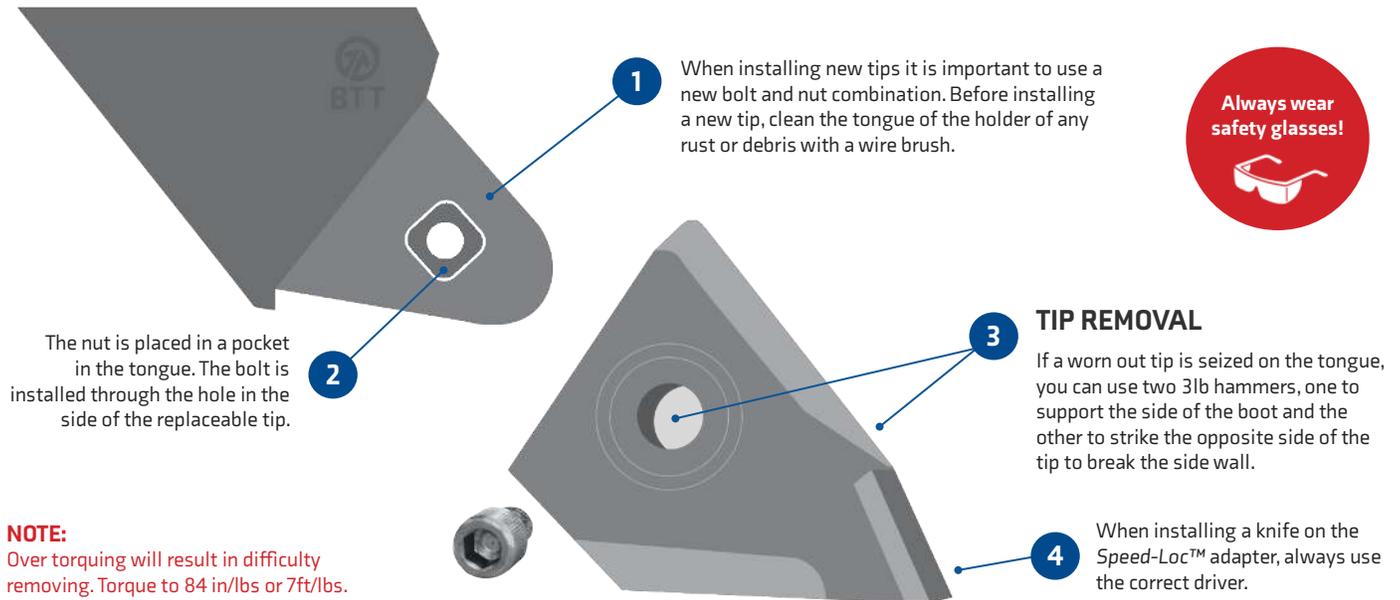


# INSTALLING & CHANGING TIPS

## REPLACEABLE TIPS

The tongue and groove configuration of replaceable tips allows customers to change them as they wear out instead of changing the entire opener. You can also change tip sizes if conditions change in your operation.

There are several things to keep in mind when changing or installing new tips:



## WELD-ON TIPS

- 1** Remove worn tip by using a torch or air arc gouger to cut the weld taking care not to cut into the holder. Grind the remainder of the weld off the knife holder.
- 2** Tack weld the new tips onto the holders. Take care to align the tips at the correct angle.
- 3** Preheat the tips to 300° – 400° F. Confirm this temperature using a heat crayon or 1/16 inch 50/50 solder which will also melt at this temperature. Set up a work flow so a couple of knives are preheating while you are welding.
- 4** Weld the tips using 7018 rod or equivalent mig wire. As soon as you are finished welding a knife place it in a steel container and cover with fiberglass insulation so it cools gradually to shop temperature.