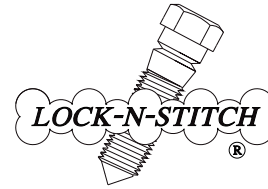


LOCK-N-STITCH Inc.
Casting Repair Specialists
1015 S. Soderquist Rd.
Turlock CA 95380



800-736-8261
209 632-2345
Fax 209-632-1740
www.locknstitch.com

Crusher Final Report

Date 12/18/2012

Part HP 300 Crusher

Inspected by Alaa Al'Robaie

1. Base metal

- cast iron
- ductile iron
- cast steel
- cast aluminum
- other _____

4. Cause of damage

- impact
- heat
- freezing
- normal operation
- other _____

2. Machinability

- no previous repairs
- arc-welded
- brazed
- heat-related cracks
- other _____

5. Length of crack/s

26"

3. Casting shape where cracked

- flat
- inside/outside corner
- radius
- other _____

6. Material thickness

1-4"

7. Operating pressure

N/A

8. Operating temperature

N/A

9. Working environment

- hot
- cold
- safety concerns
describe: _____

- other _____

10. Remachining requirements

- bolt holes
- bearing bores
- machined surfaces
- other Grinding

13. Inspection method(s)

Mag check

14. Damage found:

26" of crack

11. Customer's needs

- permanent repair
- temporary repair
- turnaround time
describe: _____

- other _____

12. Accessibility

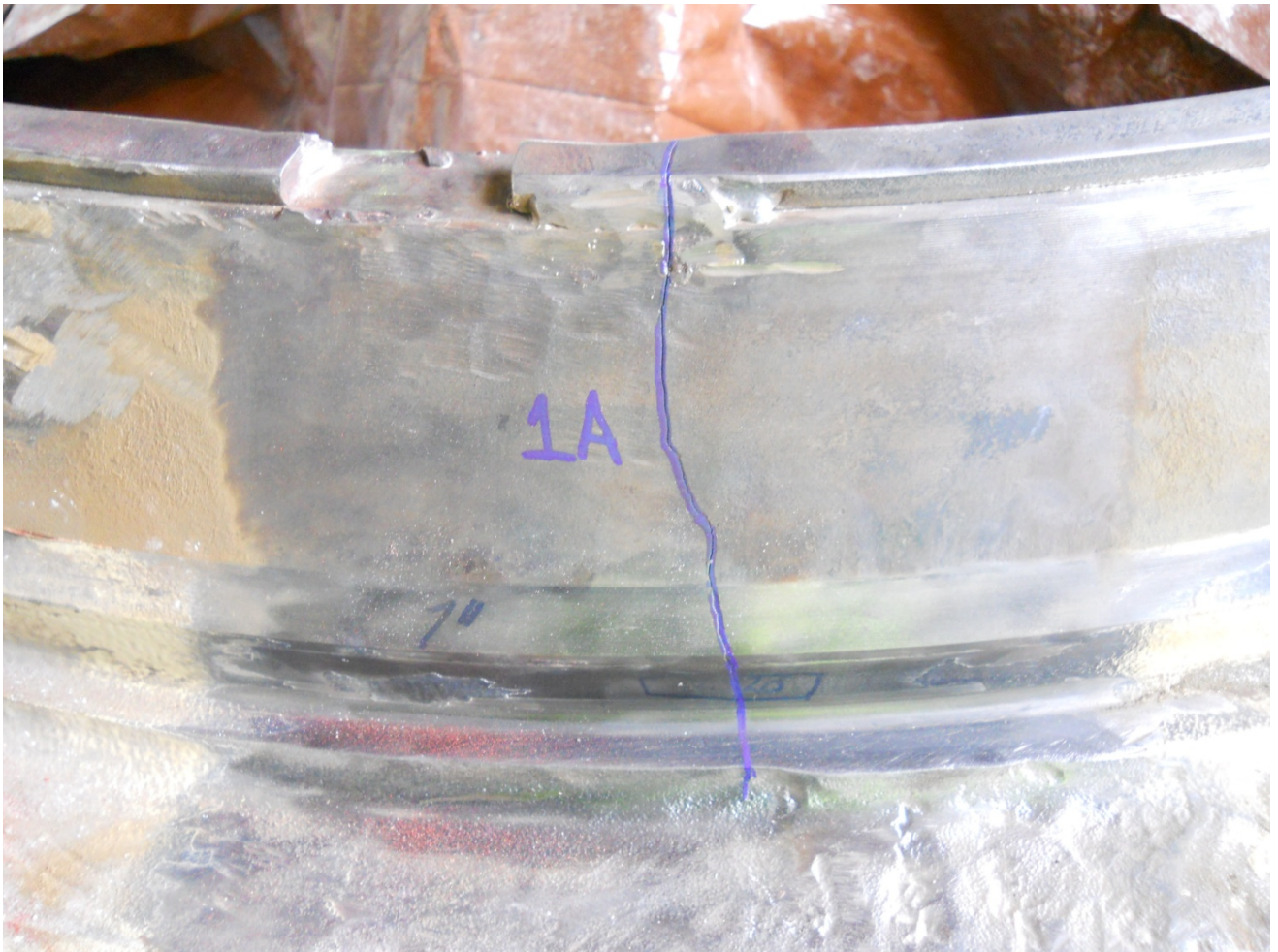
- room for the tools?
- room for the operator/s?
- need for disassembly?
describe: _____

- other _____

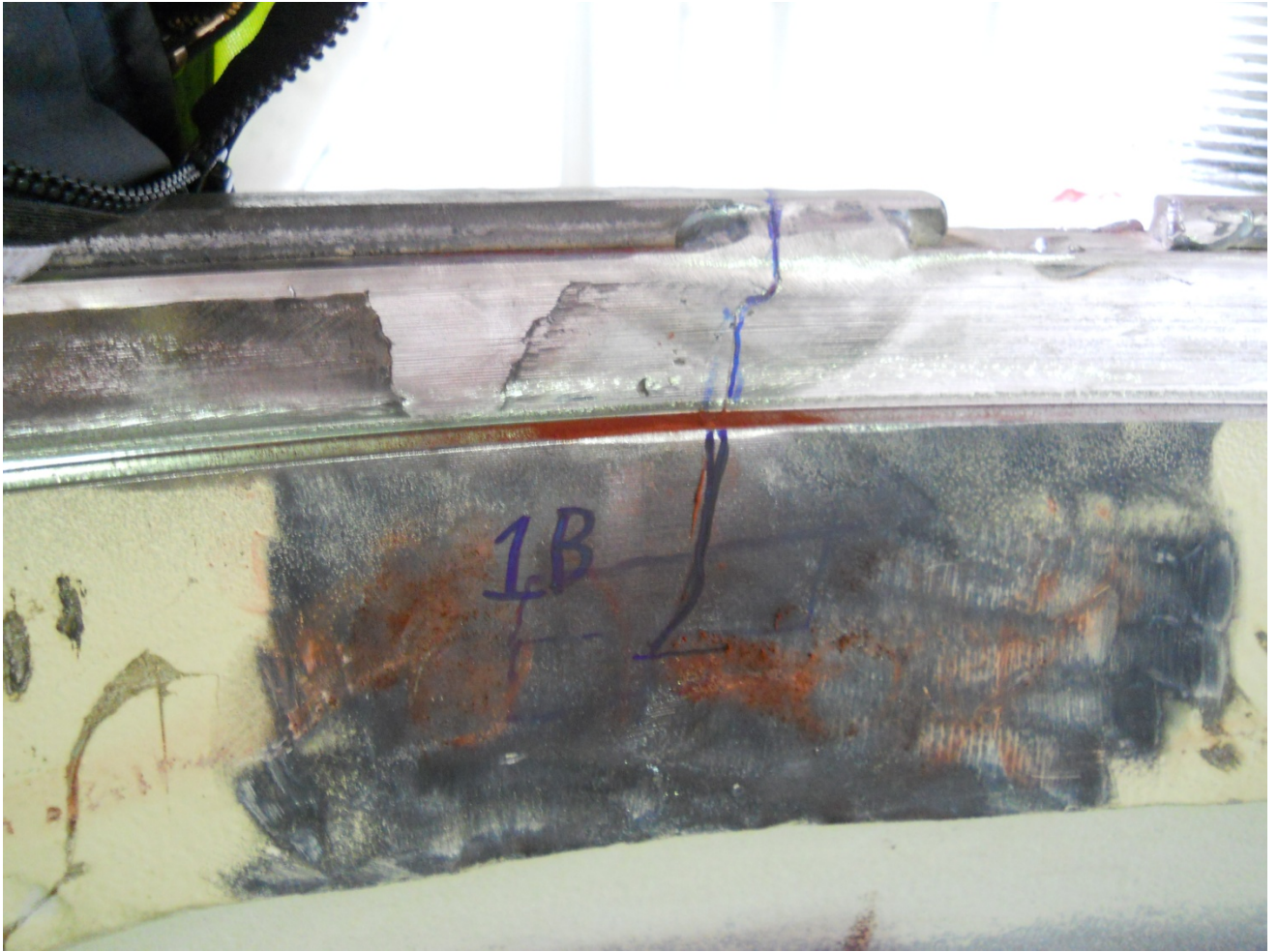
Inspection – Magnetic particle test performance on HP 300 Crusher to identify cracks and length of crack.

Found—Inspection shows 4 cracks on HP300 Crusher, totaling 26” of crack.
(interior & exterior)

Exterior:



Interior:



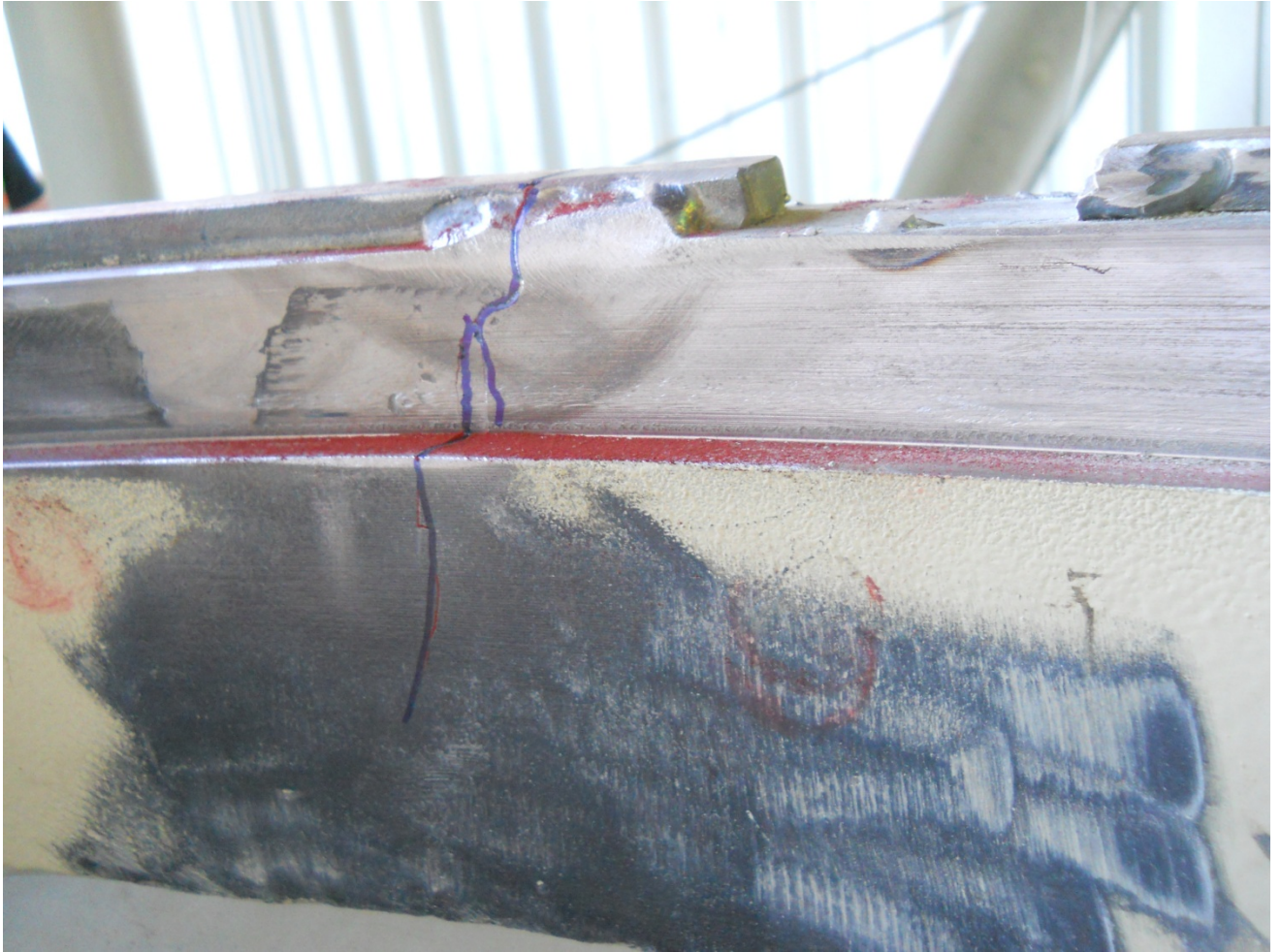
Exterior:



Exterior:



Interior:



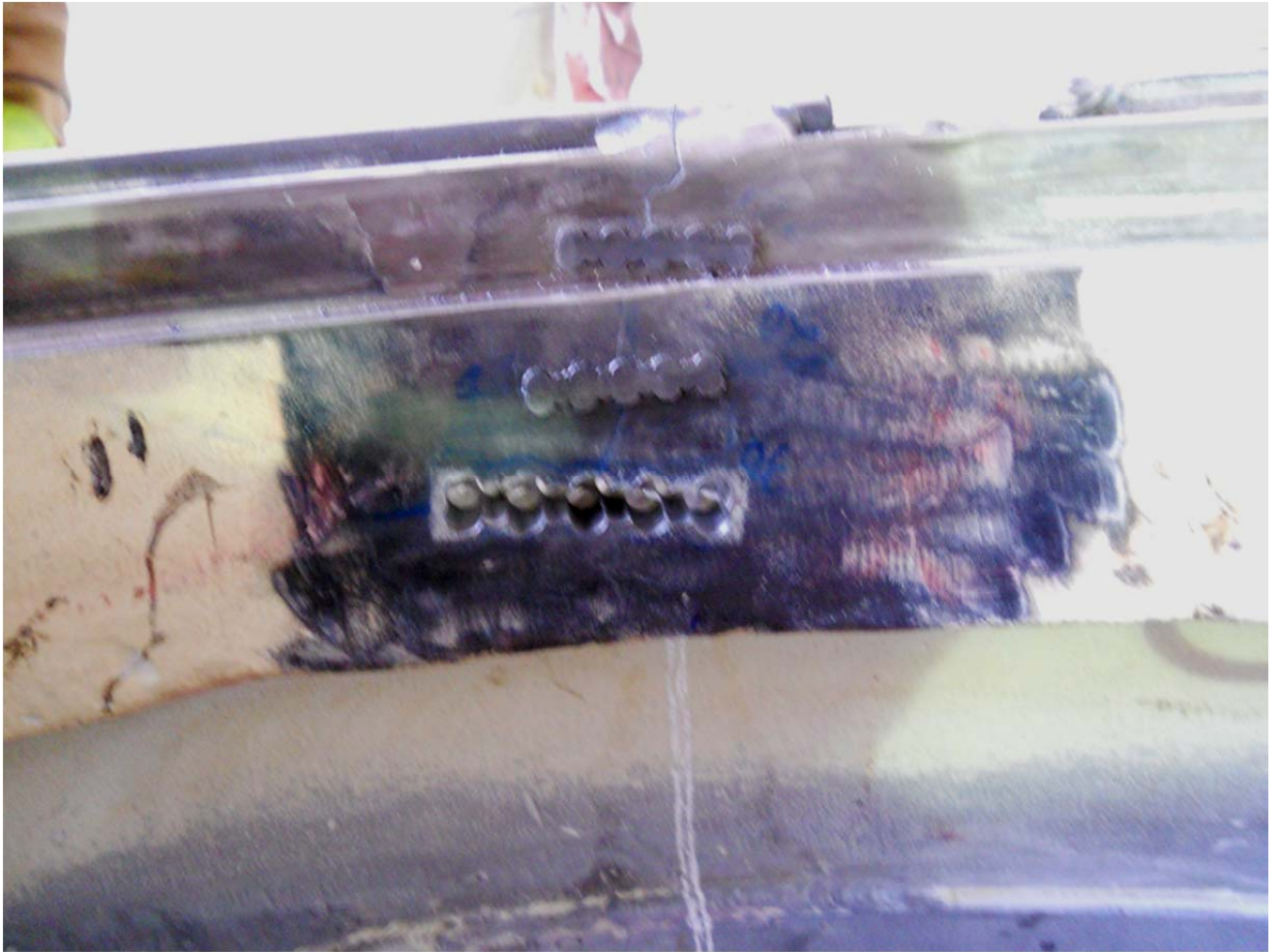
Installed locks L50, L30, and L20 locks on the exterior and interior sides of HP300 Crusher for additional strength.



Exterior:



Interior:



Metal stitch remaining cracks with C3 high-strength Castmaster pins.

Exterior:



Interior:



Hand finished on HP300 Crusher.

Exterior:



Exterior:

