



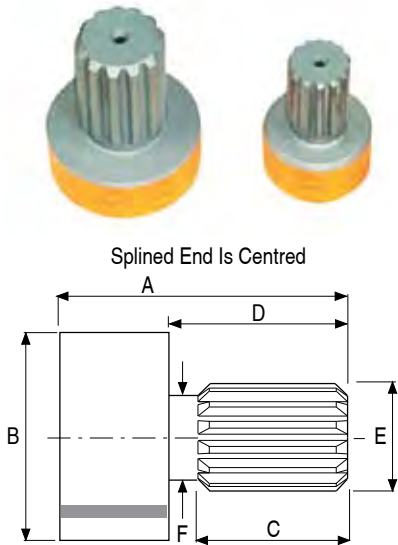
STUBWELDS, P.T.O. ADAPTORS & AGRICULTURAL STROKE CONTROL SEGMENTS

SPLINED HUBS, COUPLINGS & SHAFTS

SPLINED STUBWELDS FOR SAE HYDRAULIC APPLICATIONS

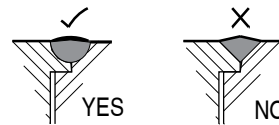
DETAILS AND APPLICATIONS

Material is EN36A or 8620 alloy steel with splined end fully hardened. Buttress end is left as soft as possible for later machining and welding. Machining is held true on all surfaces for setup. Ideal for use with precision splined hubs for manufacturing of M & F couplings. Stubwelds may also be used for replacing splined ends of worn shafts or manufacturing splined ends on new shafts.



MACHINING AND WELDING

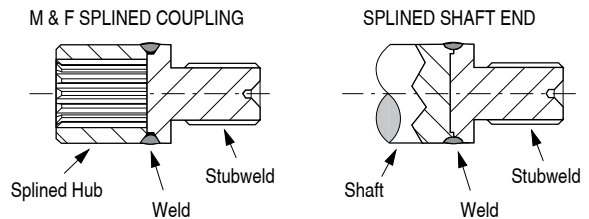
Machine mated pilot registers and fillets true on both items to be joined. See cutaway sketch and machine same as YES below. Hold firmly under press or between pressed centres. Pre-heat to electrode suppliers recommendations. Use alternate welding deposits to fully fix parts then fully weld while rotating in horizontal position. Some post heating may be necessary to insure slow cooling. Use only a special purpose electrode such as Staincraft or other comparable brand. Use a spray-pack type spatter protection coating on spline area while welding. Check clocking error after welding to test alignment.



WARNING

Above information is a guide only. Correct welding and machining operations are entirely the responsibility of the user. **Federal or State Occupational Safety Regulations relating to circumferential shaft welding should be observed where applicable.**

EXAMPLE APPLICATIONS



SAE	Spline Type	A	B	C	D	E	E Nom.	F	Part Number
A	9T 16/32 DP	58mm	34.92mm	22mm	28mm	0.608"	5/8"	12mm	76/70001
B	13T 16/32 DP	64mm	44.45mm	27mm	34mm	0.858"	7/8"	18mm	76/70003
BB	15T 16/32 DP	68mm	44.45mm	31mm	38mm	0.983"	1"	21mm	76/70004
C	14T 12/24 DP	77mm	53.97mm	40mm	47mm	1.229"	1 1/4"	27mm	76/70006
D	13T 8/16 DP	96mm	76.20mm	58mm	66mm	1.721"	1 3/4"	37mm	76/70008

P.T.O. PUMP SHAFT ADAPTORS FOR WATER PUMPS OR HYDRAULIC PUMPS

Used for driving Water pumps, Spray pumps or Hyd pumps from a Tractor PTO.

Tractor Spline	Pump Shaft Details	O.A. Length	Part Number
1 3/8" 21	1 1/4" 14 Spline SAE C	4 3/8"	56/01/01191

For Direct Tractor Hyd Pump Drive On Cotton Module Makers.



STROKE CONTROL SEGMENTS FOR HYDRAULIC CYLINDERS

FOR TILTH SETTING OF RAMS FOR BROAD ACRE PLOUGHS AND SEEDERS

Made from cast iron for durability with wide compression face to minimise wear and protect cylinder ends. Rigidly attached spring with contoured handle permits installation and removal with one hand. Fits all ram rods from 1" to 1 3/4" diameter.

Part Number 03/39/80000 (set of 5 Segments)

Set Of 5 Segments includes :- 2 off 1" Thick, 1 off 1 1/4" Thick, 1 off 1 1/2" Thick, 1 off 1 3/4" Thick. Weight Per Set 3.5 kg.

