

TRACK REBUILDING SERVICE BULLETIN

WELDING OR BUILDING UP THE GROUSER DUCTILE METAL TRACK PAD IS A SIMPLE AND EASY PROCESS IF YOU FOLLOW THE PROPER PROCEDURES

COMPONENTS NEEDED

1. STOOY BUILDUP 1/8" ROD OR SUPER MISSILE ROD (THIS ACTS AS A BASE MATERIAL BETWEEN THE DUCTILE AND THE HARD SURFACE WELD),
2. STOOY 35 HARD SURFACE ROD 1/8"

REBUILDING TRACTION BARS ON THE SOFT AND METAL TRACK

1. PADS SHOULD BE AT LEAST ROOM TEMPERATURE (THE WARMER THE BETTER).
2. CLEAN ANY FOREIGN MATERIAL FROM TRACTION BAR. SET WELDER AT 90-100 AMPS.
3. WELD ONE PASS OVER AREA TO BE REBUILT USING EITHER STOOY BUILDUP OR SUPER MISSILE ROD.
4. AFTER PAD HAS COOLED A FEW MINUTES, TAKE THE STOOY 35 ROD AND PLACE A SECOND WELD ON TOP OF THE FIRST WELD.
5. LET THE WELD COOL AND TAP WELDED AREA OCCASIONALLY TO RELIEVE ANY STRESS.
6. THE WELDS SHOULD BE NO LONGER THAN 2-3 INCHES.
7. BE CAREFUL NOT TO GET ANY WELD IN THE BOLT HOLES ON THE SOFT PAD.

THIS COMBINATION SHOULD RAISE THE WORK AREA 1/4" TO 3/8" AND ALSO PROVIDE A LONG-LASTING TRACTION AREA.

REBUILDING THE CROSS BARS ON METAL TRACK

1. IF YOUR GOAL IS TO EXTEND THE LIFE OF THE PAD BY BUILDING UP THE CROSS BARS, IT IS RECOMMENDED YOU DO SO BEFORE THE BARS HAVE WORN NO MORE THAN 3/8".

Rev7100

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2. IF THE BAR HAS WORN TO 1/2" OR LESS, IT IS NOT RECOMMENDED TO TRY REBUILDING THE BARS AS THE WELDING PROCESS CAN MAKE THE BARS BRITTLE.
3. USE STOOODY BUILDUP ROD OR SUPER MISSILE ROD. START WELDING FROM EITHER THE LEFT OR RIGHT SIDE OF THE BAR. WELD 2"-3" AND SKIP 2"-3". WELD 2"-3" AND SKIP 2"-3" OR UNTIL YOU HAVE COVERED THE STEEL BAR FROM ONE SIDE TO THE OTHER. LET PAD COOL A FEW MINUTES AND WELD THE AREAS THAT WERE SKIPPED THE FIRST TIME. WHEN DONE, YOU CAN WELD THE OTHER BAR USING THE SAME METHOD. WHEN BOTH BARS HAVE BEEN COVERED BY THE BUILDUP PROCESS, LET PAD COOL DOWN. AFTER COOLING, YOU CAN APPLY THE HARD SURFACE WELD USING THE SAME METHOD. THIS METHOD WILL BUILD UP THE CROSS BARS AND GIVE THEM A VERY HARD SURFACE AREA.

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