

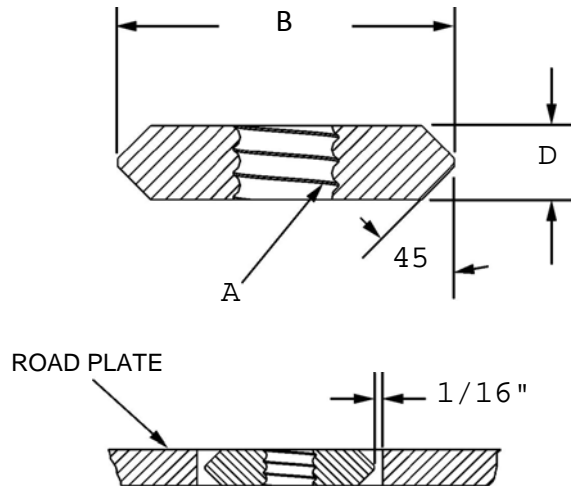


WELDING INSTRUCTIONS FOR WELD-IN THREADED INSERTS



- Material: Alloy steel.
- Minimum tensile strength of 180,000 psi.
- 100% Magnetic Particle Inspected
- Finish: Black Oxide per MIL C-13924B

Part No.	THRD TYPE	A	B	D
36980	UNC	3/4	3	1
36982	UNC	1	3	1
36984	UNC	1 1/4	3	1
36986	COIL	1 1/4	3	1
36988	ACME	1 1/4	3	1
36990	UNC	1 1/2	3-1/2	1-1/2
36992	COIL	1 1/2	3-1/2	1-1/2
36994	ACME	1 1/2	3-1/2	1-1/2
36996	UNC	2	3-1/2	1-1/2



WELDING INSTRUCTIONS:

Weld with electrodes meeting AWS class E7018 per MIL-E-22200/1

- Center threaded insert with 1/16" clearance on each side
- Align with surface of road plate
- Preheat the insert and road plate in an area with radius around the hole to 450°-950° F
- Weld insert to road plate from both sides
- Use hand grinder to grind excess weld to achieve a level even surface.

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