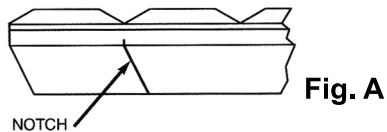


**RECOMMENDED BENDING PROCEDURES FOR
CHOCKY BARS ONLY!
READ BENDING INSTRUCTIONS COMPLETELY**

NOTE: FOR EXTREME CURVES (RADIi LESS THAN 12" [305MM]), OR INSIDE CURVES, IT IS ADVISABLE TO USE THE PRE-NOTCHED "CHOCKY BARS OR TO NOTCH THE MILD STEEL BACKING PLATE OPPOSITE THE "V" TO ASSIST BENDING (Fig. A).



1. Clean the surface to which "chocky" bar will be welded.

2a. **For outside curves:** Tack weld one end of "chocky" bar (per welding procedures) in at least 3 places using at least **15mm** of weld in each deposit (Fig.1). Hammer down unwelded end of bar so that the bar bends and follows the curve (Fig.2).

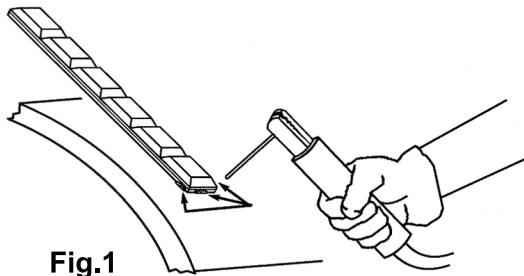


Fig.1

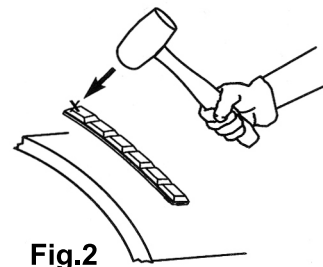


Fig.2

2b. **For inside curves:** Tack weld one end of "chocky" bar (per welding procedures) in at least 3 places using at least **15mm** of weld in each deposit (Fig.3a). Starting in the center strike bar so that the bar bends and follows the curve (Fig.3b).

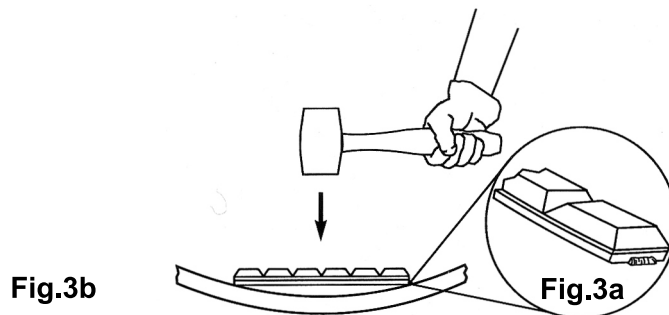


Fig.3b

Fig.3a

3. **For inside curves:** Stitch weld (per welding procedures) until bar is firmly in place.

NOTE: White iron may crack during bending. This is normal.

We recommend you always use a soft-face hammer and ANSI-approved (Z87.1) eye protection during cutting and bending procedures.