

AJ-02: Apply/Remove Turcite

SAFETY FIRST

- Follow all Caterpillar facility safety standards when performing this task.
- Industrial cleaner may be hazardous to your health. Observe all manufacturer's warnings.

EQUIPMENT

- industrial cleaner
- scraper
- mill for scraping surface
- Turcite
- 3M Two-part Epoxy glue or an equivalent bonding agent

RESOURCES

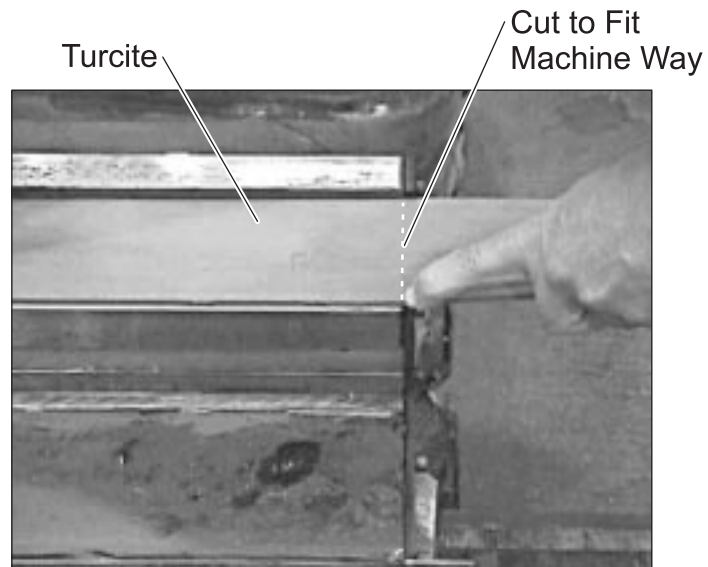
- machine manufacturer's manual
- glue directions
- cleaner directions



Apply/Remove Turcite

1. Determine Turcite requirements.

- Select the required thickness, approximately .060" thicker than the finish dimension.
- Cut the Turcite to the required length.



2. Prepare the surface.

- Remove the existing Turcite, if applicable.



Turcite Removal

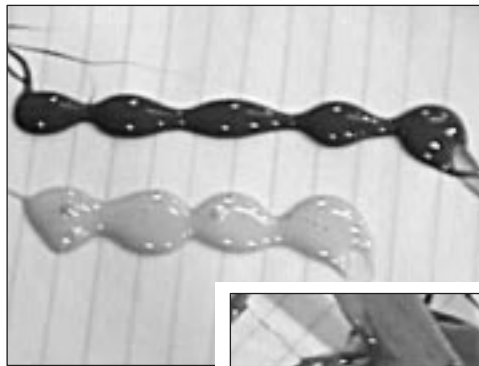
- Machine the surface, if necessary, until the surface is clean and smooth.

3. Strip the surface with an industrial stripper.

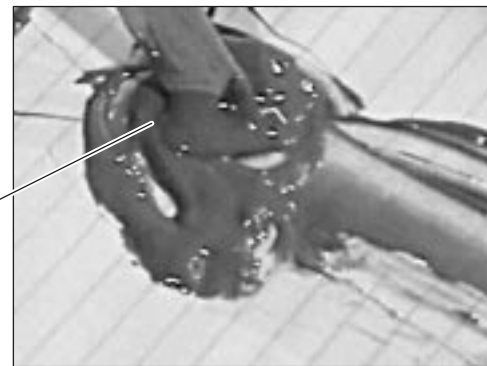
- Use Wil-Bond or equivalent stripper.

4. Prepare the bonding agent.

- Use 3M Two-part Epoxy or equivalent bonding agent.
- Mix the bonding agent according to the manufacturer's specifications.



Mix Until Color is
Consistent

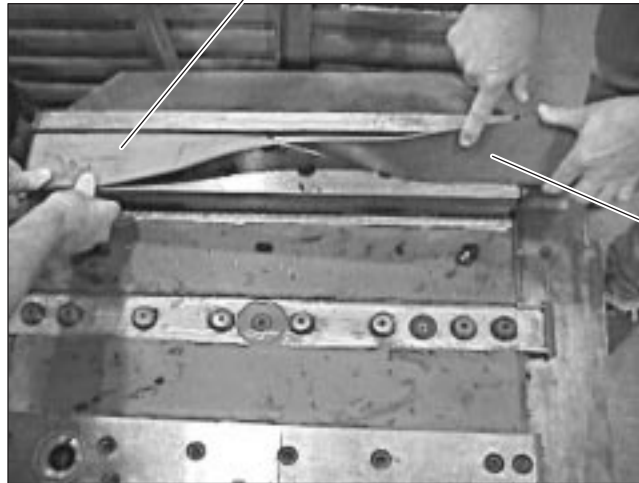


Two-Part Epoxy Glue Mix

5. Apply the bonding agent.

- Evenly apply the bonding agent to the bottom (dark side) of the Turcite and to the way surface.

Top of Turcite



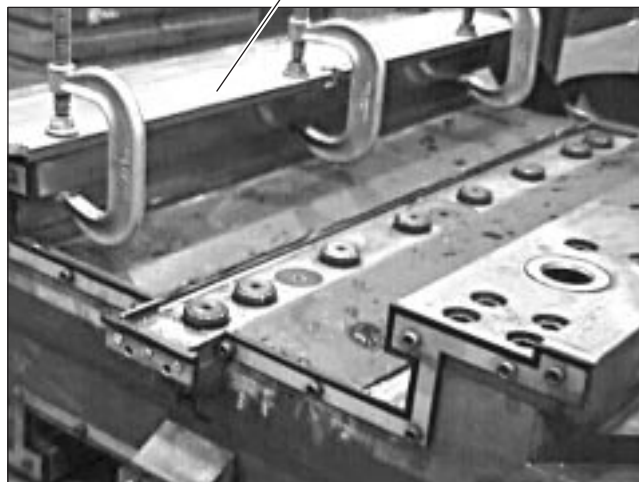
Bottom of Turcite

Turcite Orientation**6. Install the Turcite.**

- Position the Turcite squarely with the surface.

7. Apply pressure to the Turcite.

- Clamp a bar to the Turcite, as needed. See the figure below.

Metal Bar Clamping
Turcite to Machine Way

8. **Allow the bonding agent to cure according to the manufacturer's specifications.**
9. **Machine the new Turcite to the work order specifications.**

