

Metal Surgery Milwaukee LTD

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Waukesha Engine, AT 16 Cylinder

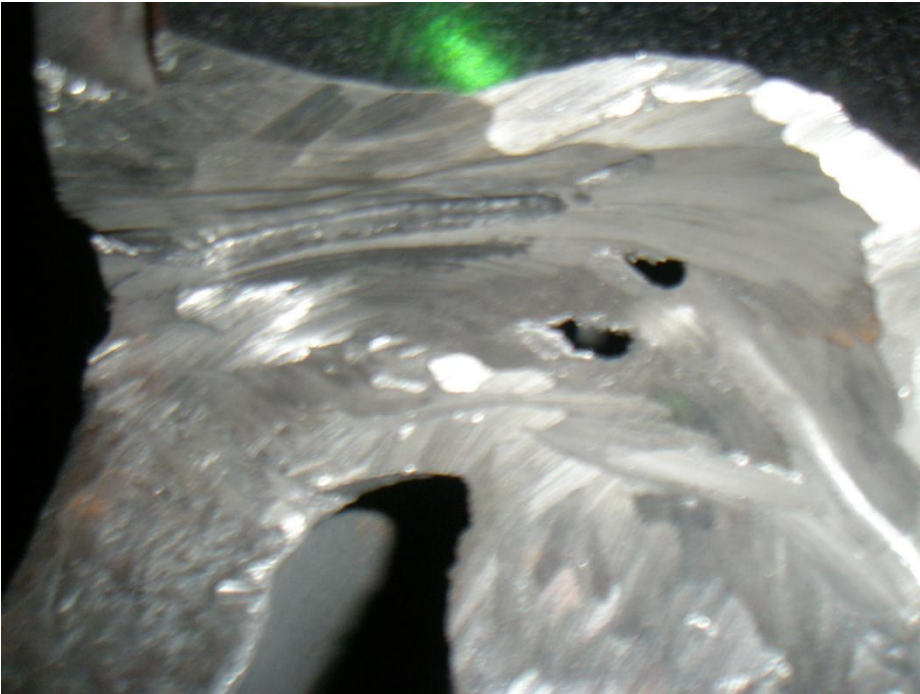
(March 2009)



This engine block was completely finished machined. The weight of this block is approximately 28,000 lbs. It had a very large sand inclusion on the fire deck. Our goal was to repair it with no distortion or as little as possible. Metal Surgery manufactured a dummy crankshaft and installed it to help in maintaining crank bore alignment. The pre-heat was done using our cooper heat equipment, electric heating ceramic pads and propane torch assist. All heating was monitored by computers.



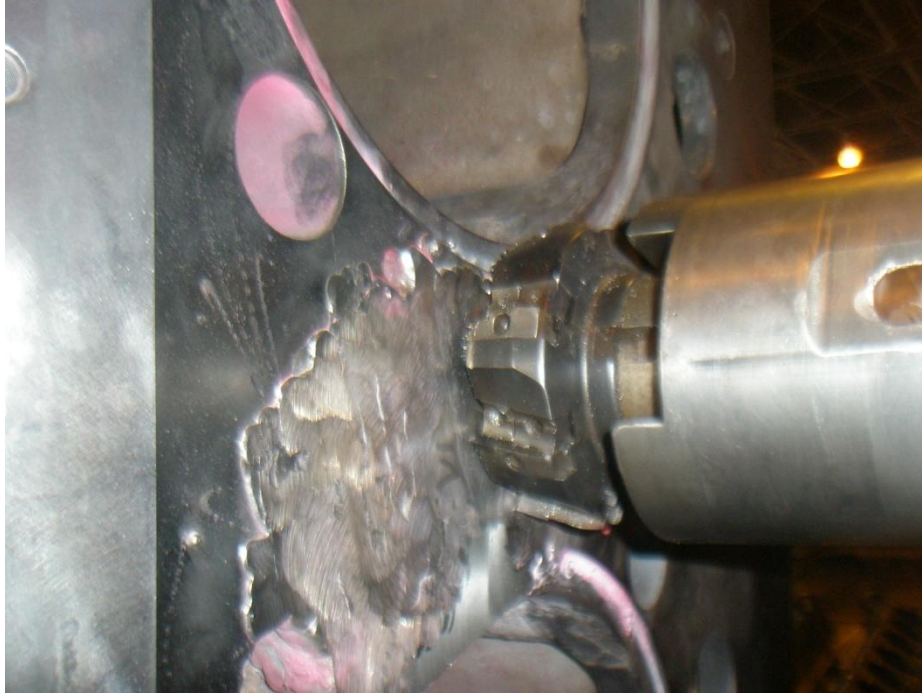
Part of the core broke out leaving a large sand inclusion approximately 8" square by 2 1/4" deep.





There was approximately 52 pounds of weld used in this deflection.





Machined and hand finished distortion .002 maximum on fire deck. All bores and bore alignment perfect. (It was another success!)

