

Metal Surgery Milwaukee LTD.

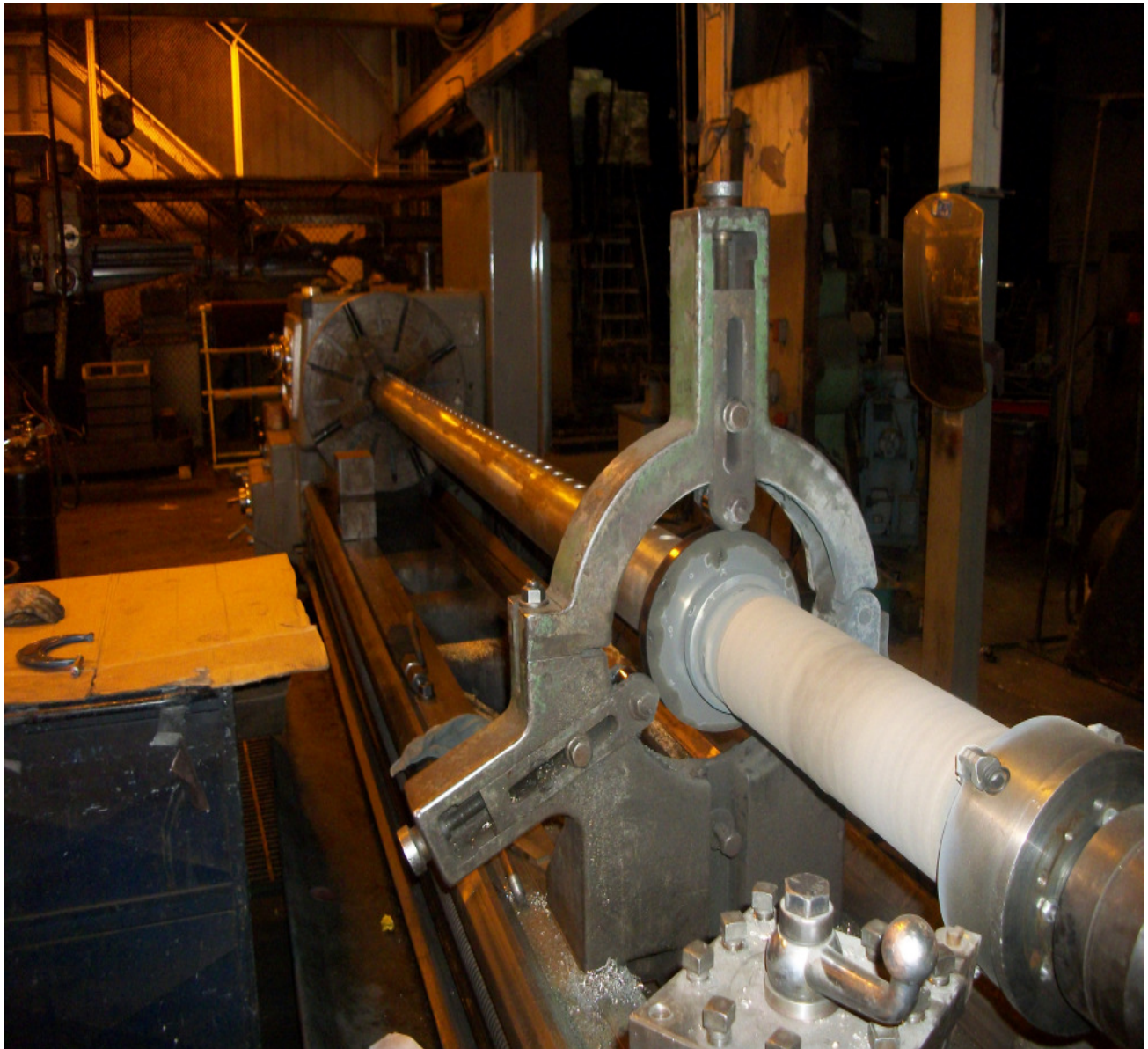
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Emergency Metalizing Of Shaft



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Metal Surgery was called on an emergency basis for the repair of this shaft which was extremely worn and had keyways that did not belong.

Metal Surgery cleaned the shaft's keyways to weld up complete upon arrival. Upon the shaft being cleaned, M/S then proceeded with the repair of the keyways. Due to a heavy deposit of metal spray being on the shaft already there was extra grinding to remove any deposits for welding of the keyways.



On the right illustrates all the old metal spray removed. The piece was then prepped for metal spray by blasting

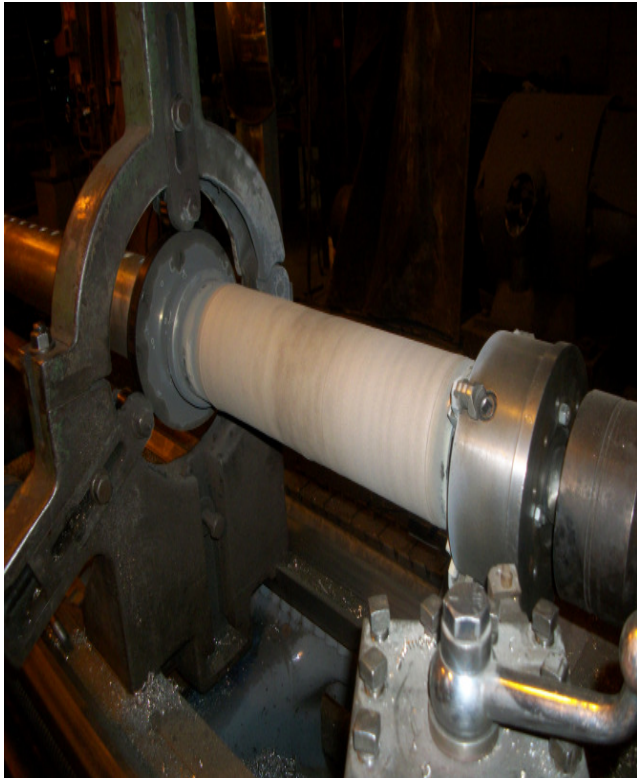


After the keyways were welded complete, the shaft was put on the machine and M/S proceeded to machine the old metal spray off the shaft. This was no easy task being that the shaft wall thickness was only .200" thick. The metal spray was .095" thick. This being said it was a very delicate process. Metal Surgery took extra precautions by ordering and machining a spare piece to be machined and welded on in case the piece was not salvageable.



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After this area was prepped the part was then metal sprayed by procedure. Stopping was required throughout the process due to preventing over heating the material. Spraying alone took over 16 hours.



To the right illustrates the shaft complete and being removed from the machine for cleaning and delivery back to the customer. Metal Surgery was allotted 2 days to complete the repair. M/S completed the repair on time.



Spraying completed Metal Surgery then moved to machine the shaft back to the required size.

