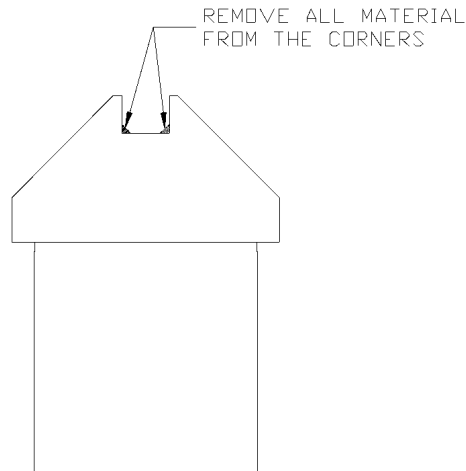


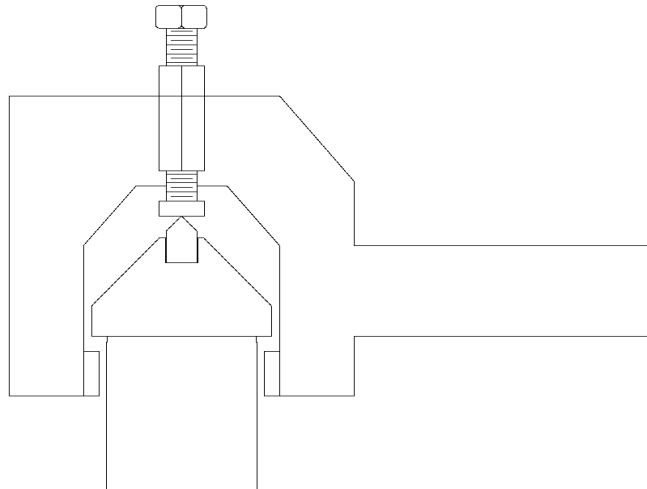
IMPORTANT NOTE: CLEANING THE TOOTH GROOVE AND CARBIDE IN STEP 4, AND TEMPERATURE IN STEP 5 ARE VERY IMPORTANT.

1. Remove any of the carbide remaining in the tooth by heating it with a torch to break the bond of the glue. Do not over heat the tooth because this will remove the temper on the tooth and cause it to develop stress cracks and break. This will only take a few minutes.



2. Remove any glue from the corners of the groove with a file, a wire brush, etc. We sand blast the groove. Any remaining material will cause a weak bond and point loading on the carbide which will either cause the carbide to fracture or fall out.
3. The bottom edge of the carbide should be rounded slightly to reduce the chance of point loading. This can be done on a grinder with a green wheel installed. (Green wheel stones are used to grind carbide.) Cee-Jay Tool Company sends out carbide pre-ground.
4. Roughen the groove with sandpaper and remove any grease and rust with Acetone. Also clean the carbide with Acetone, handling it on the ends.
5. Ensure that the temperature of the tooth and insert are not less than 55° F (they should not feel cold to touch) by first running them under hot water or leaving them in direct sun light.

- Mix the 2 part JB Weld thoroughly. Spread the epoxy on the bottom and sides of both the carbide and the tooth groove, and let it cure under medium clamping pressure for a minimum of 15 hours (24 hours is preferred) in a heated area no less than 55° F.



Clamp Part Number	
2 $\frac{1}{4}$ " tooth	: A20935
3" tooth 2" head	: A20936
3" tooth 4" head	: A20937