

Roof and Cutting Help



IF THE ROOF IS SAGGING ON YOUR SHOP EQUIPMENT WELDING TRAILER OR YOU WOULD LIKE CUTTING HELP, PLEASE READ ON.

Roof

A sagging roof on the shop equipment welding (SEW) trailer can let water, snow, and ice collect, which eventually leads to leaks. A T-bracket can prevent sagging. Here's how to make the bracket:

You'll need a tape measure or square, a hacksaw or reciprocating saw, a grinder and welding equipment. These are all part of the SEW. The bracket can be welded with any process, but shielded metal arc welding (SMAW) or gas metal arc welding (GMAW)/flux core arc welding (FCAW) are the fastest.

You'll also need two feet of 1 1/2 x 1 1/2 x 1/8-in angle iron.

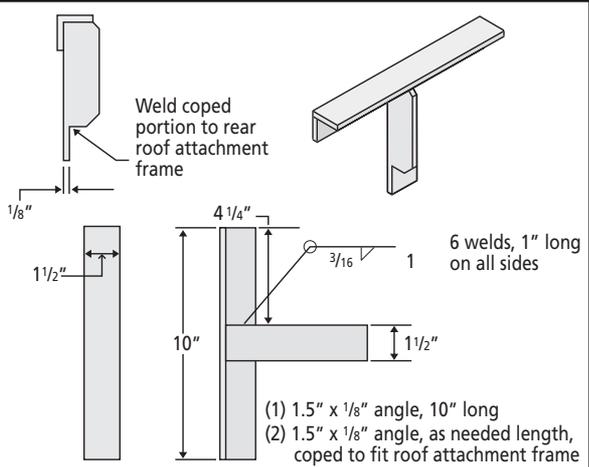
To make the bracket, first open the back doors and roof of the SEW. Make sure the rear stabilizer legs are deployed. Have someone stand underneath the rear cross-member of the square roof attachment frame and push up the roof as far as they can.

Measure the distance from the roof to the top of the square roof attachment frame. Take this measurement and add 1 1/2 inches (for example, 3 1/2 inches become 5).

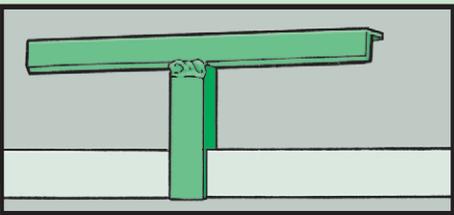
CUT A PIECE OF ANGLE IRON TO THAT LENGTH.



TAKE 1 1/2 INCHES OFF OF ONE FACE OF THE ANGLE IRON AS SHOWN IN THE DRAWING.



Trim the remaining angle iron to 12 inches long. Center and square the first piece on the second piece as shown and then weld as shown.



The bracket can be either welded or bolted into place on the SEW.

Cutters

A PLASMA CUTTER IS AUTHORIZED BY REMARKS 16 IN SC 4940-95-B33.

IT CAN BE LOCAL PURCHASED USING THESE PART NUMBERS AND CAGE CODES...



THERE IS ALSO AN EXOTHERMIC CUTTING KIT AUTHORIZED BY REMARKS 16 FOR LOCAL PURCHASE.

USE THESE PART NUMBERS AND CAGE CODES...

Item	P/N	Cage	Qty
Plasma cutter kit	67500VKT	2N560	1 kit
Kit Components:			
Plasma cutter	907404-01-1	2N560	1
Accessory kit	675PTSKT	2N560	1 kit
Airline kit	228926	40608	1 kit
Element	228928	40608	4
Retaining cup	192050	40608	2
Tip	204325	40608	20
Swirl ring	192049	40608	2
Electrode	192047	40608	20
O-rings	169232	40608	10
Silicone grease	169231	40608	2
Circle cutting guide	195981	40608	1
Accessory box	3750	2N560	1

Item	P/N	Cage	Qty
Exothermic torch kit	PCA200KVT	2N560	1 kit
Kit Components:			
Apron	4236	2N560	1
Torch body	BR24E	2N560	1
1/4 cutting rods	1418PCSPS	2N560	1 pkg
3/8 cutting rods	3818CSPPS	2N560	1 pkg
1/4 torch adapter	PCRP-305B	2N560	1
3/16 torch adapter	PCRP-305D	2N560	1
1/2 torch adapter	PCRP-305C	2N560	1
Battery	230789	2N560	1
Battery charger	413242	2N560	1

IF YOU HAVE QUESTIONS ABOUT THE SEW, CONTACT TACOM'S AT DSN 793-0633, (309) 782-0633, OR EMAIL us.army.mil

