



SUGGESTED USE ON HOW TO REMOVE BROKEN BOLTS

USING ATS E/O-8600 BROKEN BOLT REMOVAL KIT

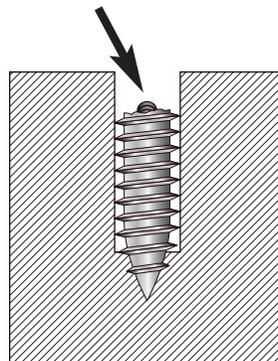
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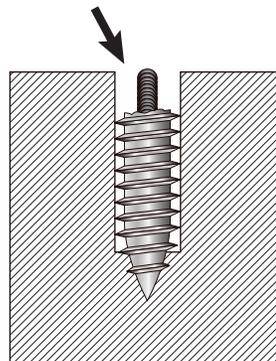
- 1) Select proper size electrode for the bolt to be removed. For the smallest bolts, use 1/16", then 3/32", & 1/8" on up for the larger ones.
- 2) Do any cleaning or preparing of the area. Also remove any fire hazards in the area to be worked on.
- 3) Strike the arc as near the center of the broken bolt as possible, just forming a small weld puddle, a few seconds of weld at a time, and do not chip the slag, as that works as protection for the threads.
- 4) Re-strike as near the top of the weld as you can, without chipping the slag, because right on the very top of the weld, there will be a bare spot to continue your build up. Once again, do not chip any of the slag, as it is protecting the side's of the threaded area.
- 5) Continue to do this until you have made a bit of a mountain, or straight up stack of weld puddles, high enough to put a washer and a nut over the top of the stack, then weld the stack of weld to the nut. You might have to now chip some slag as to get a good weld.
- 6) Now, take the enclosed wax, and hold it close enough to the just completed welded bolt, to melt the wax into the threaded area, just put the wax up close to the completed weld, and it will seek it's way down into the threads. Go have a glass of water, cup of coffee, sandwich, just let this cool, before trying to remove.
- 7) Take a wrench and gently to start with, start to work back and forth, Keep your fingers crossed. If for some reason this does not work the first time, start the process all over again.

THIS PROCESS HAS BEEN USED MANY TIMES OVER.

E/O-8600 Electrode builds up where the bolt has broken off.



E/O-8600 continues to build up until it forms a stack of weld puddles.



Once high enough to put a washer and a nut over the top of the stack, weld the stack to the nut.

