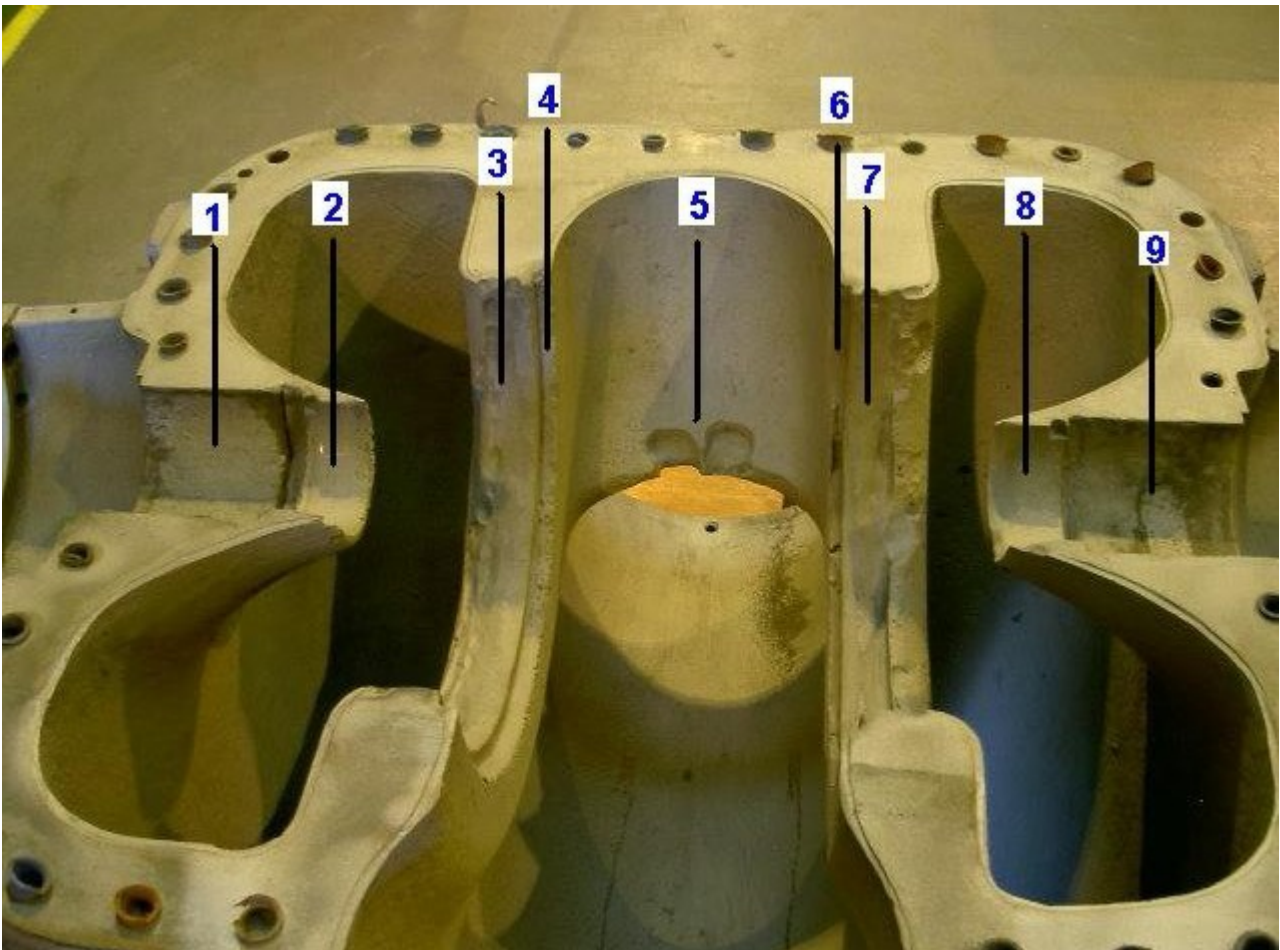


# SHILTON CAST IRON & WELDING LTD

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## Damaged locating Diameters



## Pump Casing Bottom Half

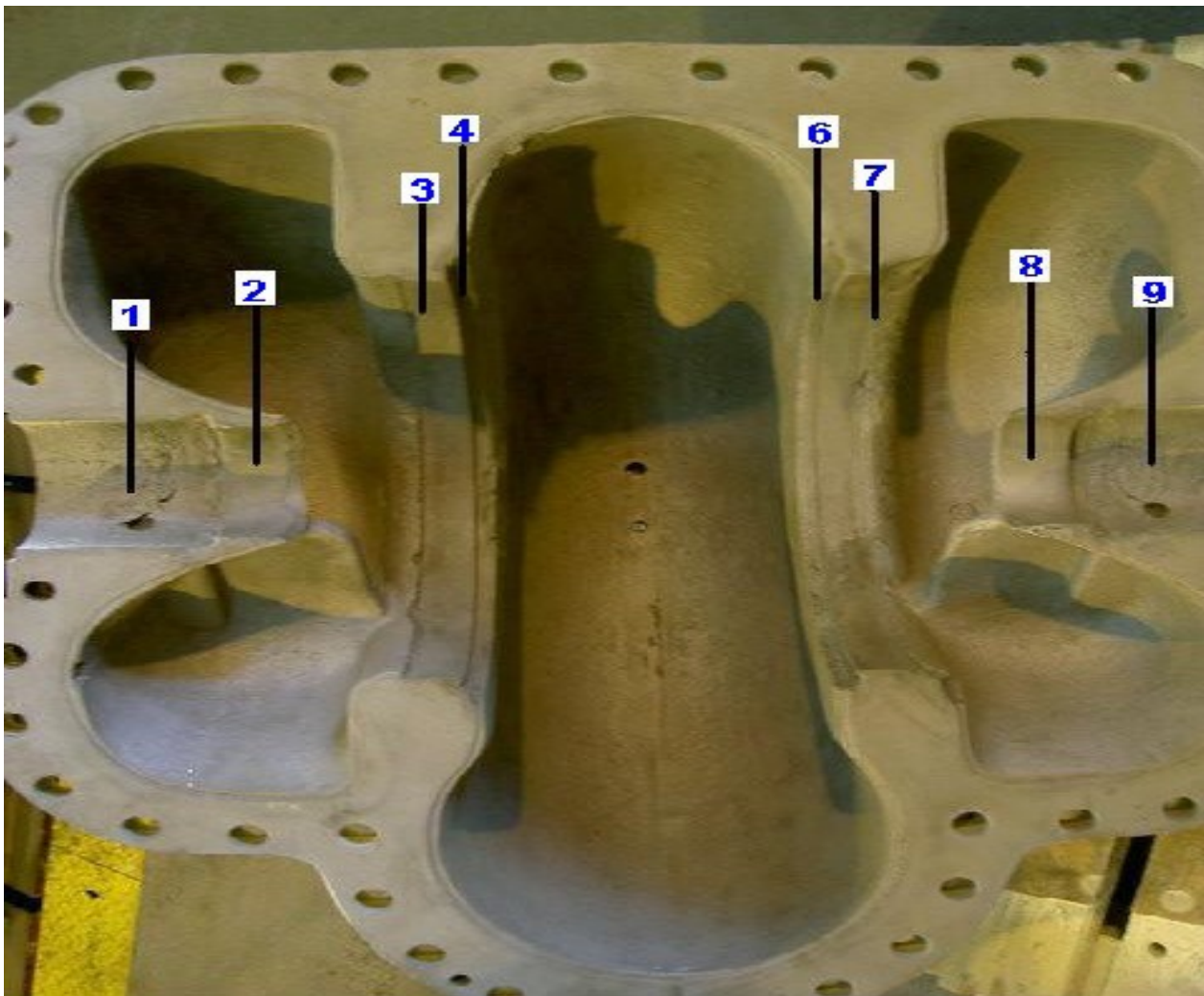
Reg. 5486928  
Director N. P. Shilton  
Company Secretary H. J. Shilton

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## Damaged locating Diameters



**Pump Casing Top Half**



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**Area 1** – Stuffing Box Bore (Deep pitting / Corrosion in and around previous weld repairs), Excavate previous weld repairs and build up in preparation for machining processes to reinstate design specifications.

**Area 2** – Throat Bush Location (Dimensionally out of tolerance, Excessive clearance between new item and bore, seat damaged / Washed away) Excavate back to parent material and build up in preparation for machining processes to reinstate design Specifications

**Area 3** – Main Wear ring locating diameter (Dimensionally out of tolerance, Excessive clearance between new item and seat, approx 10mm gap underneath, seat damaged, heavy erosion to shoulder) Excavate back to parent material and build up in preparation for machining processes to reinstate design specifications.

**Area 4** – Wear ring Shoulder locating diameter and face (Dimensionally out of tolerance, Excessive clearance between new item and seat, approx 9mm gap underneath, seat damaged, heavy erosion to shoulder and face) Excavate back to parent material and build up Square in preparation for machining processes to reinstate design specifications.

**Area 5** – Cut Water Leading edge (Eroded on leading edge, areas of material, thinning of leading edge)

**Area 6** – Wear ring Shoulder locating diameter and face (Dimensionally out of tolerance, Excessive clearance between new item and seat, approx 8mm gap underneath, seat damaged, heavy erosion to shoulder and face) Excavate back to parent material and build up Square in preparation for machining processes to reinstate design specifications.

**Area 7** – Main Wear ring locating diameter (Dimensionally out of tolerance, Excessive clearance between new item and seat, approx 10mm gap underneath, seat damaged, heavy erosion to shoulder) Excavate back to parent material and build up in preparation for machining processes to reinstate design specifications.

**Area 8** – Throat Bush Location (Dimensionally out of tolerance, Excessive clearance between new item and bore, seat damaged / Washed away) Excavate back to parent material and build up in preparation for machining processes to reinstate design Specifications

**Area 9** – Stuffing Box Bore (Deep pitting / Corrosion in and around previous weld repairs), Excavate previous weld repairs and build up in preparation for machining processes to reinstate design specifications.

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## Pump Casing finished machined

