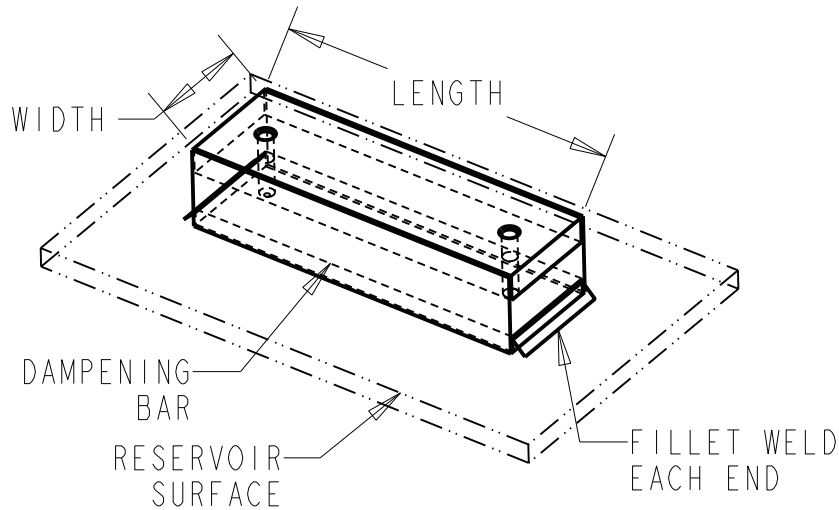


# APPENDIX RA-4

## WELD INSTRUCTIONS FOR DAMPENING BAR



To minimize localized separation of the rubber from the steel bar, welding must be limited to each end along the width of the dampening bar using welding parameters at the upper limits of the manufacturer's recommendations for the filler metal with increased travel speed to reduce overall bead size.

The chart below provides the recommended fillet weld size for our most common dampening bars.

If staining caused by trapped condensation from beneath dampening bars is a concern after painting, caulk the edges not welded with a paintable caulk.

Recommended Fillet Weld Sizes		
Part Number	Description	Weld Fillet Size (inch)
VSM-56-W	Bar Dampening .312-18 4.75	.19
VSM-143-W	Bar Dampening .312-18 5.50	.19
VSM-145-W	Bar Dampening .312-18 6.50	.19
VSM-182-W	Bar Dampening .375-16 6.00	.19
VSM-184-W	Bar Dampening .375-16 7.00	.19
VSM-213-W	Bar Dampening .375-16 7.75	.19
VSM-215-W	Bar Dampening .375-16 9.00	.19
VSM-254-W	Bar Dampening .500-13 10.50	.19
VSM-256-W	Bar Dampening .500-13 12.25	.19
VSM-284-W	Bar Dampening .500-13 12.00	.31
VSM-286-W	Bar Dampening .500-13 13.25	.31
VSM-324-W	Bar Dampening .625-11 12.50	.31
VSM-326-W	Bar Dampening .625-11 14.00	.31
VSM-364-W	Bar Dampening .625-11 13.50	.31
VSM-365-W	Bar Dampening .625-11 14.50	.31
VSM-404-W	Bar Dampening .750-10 15.50	.31
VSM-405-W	Bar Dampening .750-10 17.00	.31
VSM-444-W	Bar Dampening .750-10 19.50	.31
VSM-445-W	Bar Dampening .750-10 21.00	.31

Dimensions and specifications are subject to change without notice. Not all items are Made-To-Stock, contact us for availability.

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