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Est. 1952 75 YEARS

Custom Attachments for Heavy Equipment, Welding Repairs and Alterations

Hydraulic Piping Instructions

Jan 31, 2000

Field installation of hydraulic pipes on Nye sticks and stick extensions.

Note: only the ends of the clamps need to be welded.

Nye sticks and extensions are made with QT100 Quenched & Tempered steel and must be pre-heated before welding. Please refer to the "General Welding Procedures" before starting.

- Lay the pipes on the stick in the position that provides the most suitable hose routing. (Refer to the attached photo or drawing).
- Mark the clamp locations on the stick with a felt pen.
- Remove the pipes and grind the paint off the stick in the areas to be welded.
- Grind the paint off the ends of the pipe clamps.
- Remount the pipes on the stick.
- Pre-heat the spots where the clamps are to be welded. (Lift the pipe while heating to avoid melting the plastic parts of the clamp)
- Tack-weld the ends of each clamp.
- Disassemble the clamps and remove the pipes and plastic parts.
- Finish welding the clamps. Each clamp should receive a 5 X 25mm long fillet weld on each end. (When re-heating the weld area, apply the heat to the stick, not the clamp. If the clamp is much hotter than the plate it is welded to, it will shrink and crack as it cools).
- Finally, assemble the pipes and clamps.
- Touch-up with paint as required.

For more information, contact Nye technical support at 905 897 2311