Prior to making a connection, read and follow the full instruction sheet IPRF, the full instruction sheet shipped with CADWELD® (IPX) and special instructions below.

1. Position lug in mold bottom with .25" [6.4 mm] gap between lug end and rail lip. Reference mark lug at edge of mold for later use in checking position.

2. Lock halves of mold top together using toggle handles. Place on mold bottom. Lock top and bottom sections together using toggles.

3. Pack all openings between mold and rail (at sides of mold) with ERICO packing material to prevent leakage of molten weld metal.

4. Check lug position before initiating weld reaction.

5. After the reaction, allow 30 seconds for the weld metal and slag to solidify.

6. Remove all ERICO packing material as soon as possible (may be reused).

7. Unlatch toggle clamps and vise grips holding mold bottom to rail and remove. Unlatch "E-Z" change clamp on upper section mold and remove.

Note: Care should be exercised to prevent chipping of the graphite parts.