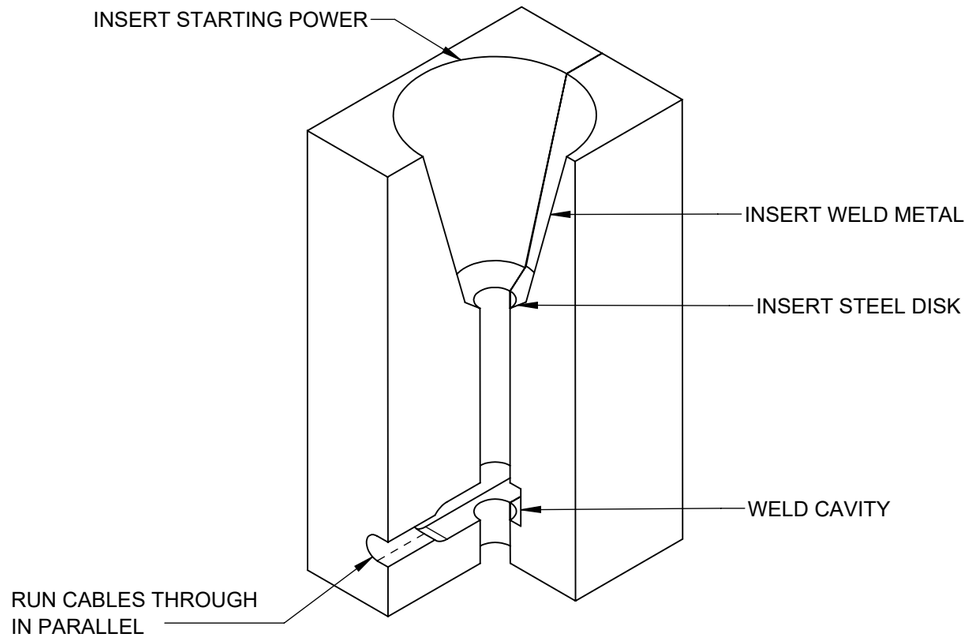
REVISIONS				
REV.	CRCO	DESCRIPTION	REV. BY	REV. DATE
A	334	PRODUCTION RELEASE	SAB	3/2/2023



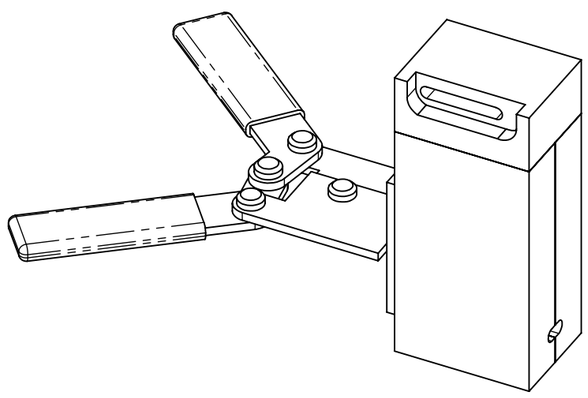
INSTRUCTIONS FOR USE:

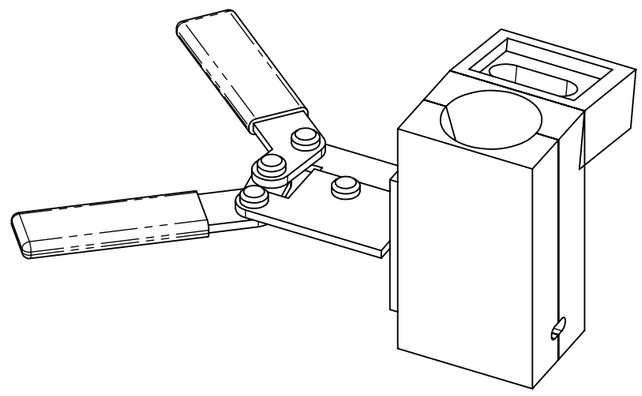
IF WELDING TWO GRADIENT CONTROL MATS TOGETHER, LINE THE MATS UP SO THE WIRES RUN PARALLEL. OPEN THE MOLD USING THE PROVIDED HANDLE CLAMPS. INSERT AN ADJACENT WIRE FROM EACH GRADIENT CONTROL MAT INTO THE WELD CAVITY OUTLINED, THEN LOCK THE CLAMPS IN PLACE. OPEN THE LID OF THE MOLD-6X AND INSERT A STEEL DISK INTO THE BOTTOM OF THE CRUCIBLE AS SHOWN. ON TOP OF THE DISK, INSERT A WELD METAL TUBE FOLLOWED BY A SMALL AMOUNT OF STARTING POWDER THROUGH THE TOP OF THE MOLD. A #25 WELD METAL CHARGE SHOULD BE USED WITH THE STANDARD MOLD-6X, WHICH WHEN IGNITIED, PRODUCES A PERMANENT, HIGH CONDUCTIVITY CONNECTION ACROSS THE GCMS.

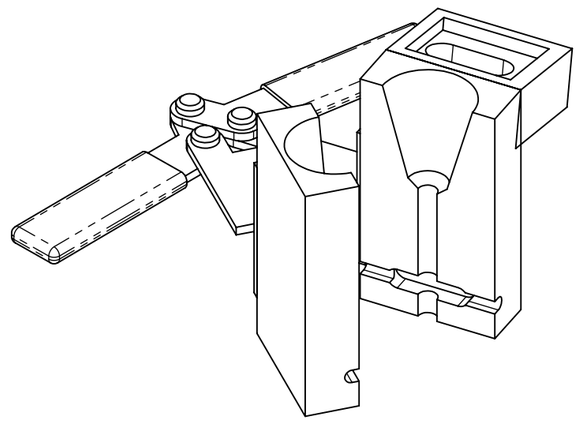
NOTE THAT A FLINT IGNITOR AND WELD METAL ARE NOT PROVIDED WITH THE MOLD-6X.

IT IS RECOMMENDED TO INCLUDE A WELD FOR EVERY 18 INCHES OF ADJOINED MAT.

THE MOLD-6X CAN ALSO BE USED TO WELD A GRADIENT CONTROL MAT TO #6 AWG WIRE LEADING TO AN ANODE OR DAIRYLAND DECOUPLER. A SMALLER CHARGE OF #15 WELD METAL SHOULD BE USED IF BONDING A SMALLER SIZE WIRE, SUCH AS #10 OR #12 AWG.





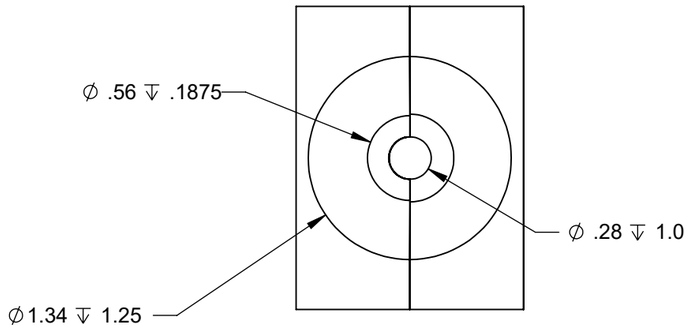


NOTE:

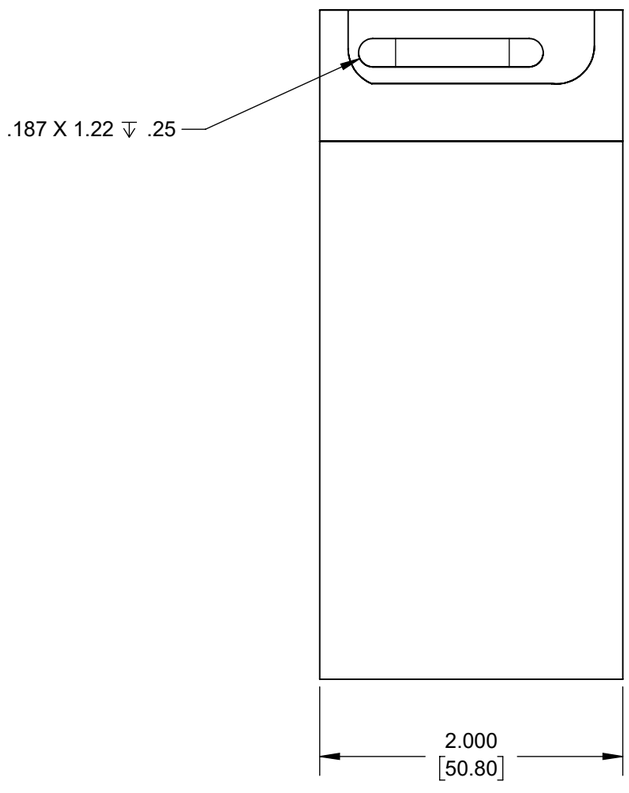
1. MOLD MATERIAL: GRAPHITE
2. SIZED FOR WELD METAL CHARGE #25 AND #15.

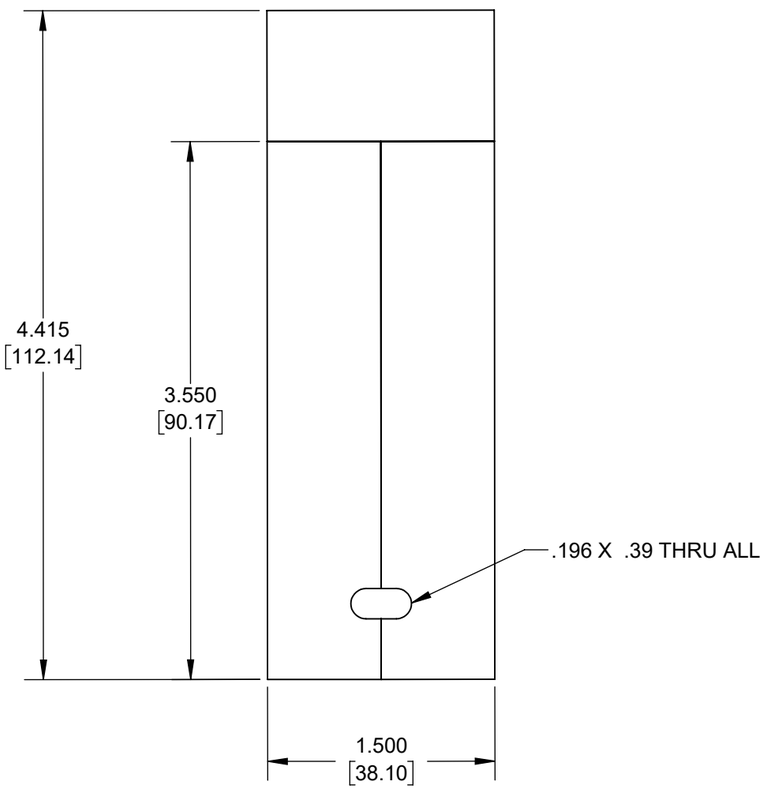
ASME Y14.5M 2018 APPLIES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. COMPUTER-GENERATED DRAWING DO NOT EDIT MANUALLY. **.XXX = ±.005"** **.XX = ±.01"** **.X = ±.03"** **ANGLES = ±1°** 63	MATERIAL: **NOTED** FINISH: **NA**	DRAWN: **SAB** DWG APPROVAL: **RJH**	DATE DRAWN: **02/24/2023** DATE APPROVAL: **03/02/2023**	**DAIRYLAND ELECTRICAL INDUSTRIES, INC.** P.O. BOX 187 STOUGHTON, WI 53589 608-877-9900 DAIRYLAND.COM
		TITLE: **MOLD-6X**		

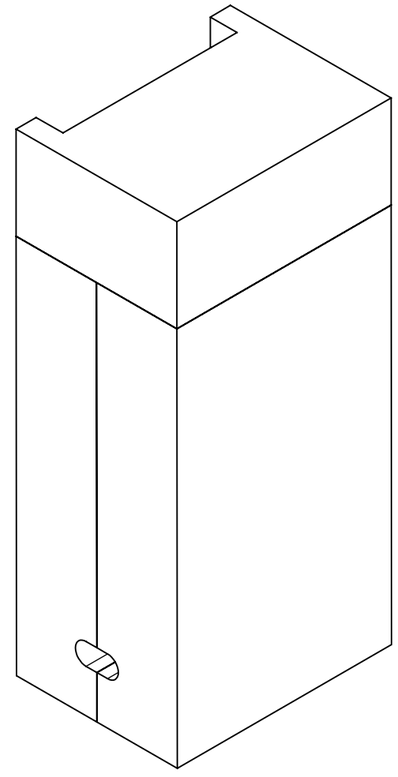
SHEET: OF	DWG SIZE:	SCALE:	REV:	PART #:
1 2	B	1:2	A	100150



TOP VIEW WITH LID REMOVED







ISOMETRIC VIEW

NOTE:

1. MOLD MATERIAL: GRAPHITE
2. WELD METAL MATERIAL: #25 OR #15

ASME Y14.5M 2018 APPLIES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. COMPUTER-GENERATED DRAWING DO NOT EDIT MANUALLY. **.XXX = ±.005"** **.XX = ±.01"** **.X = ±.03"** **ANGLES = ±1°** 63	MATERIAL: **NOTED** FINISH: **NA**	DRAWN: **SAB** DWG APPROVAL: **RJH**	DATE DRAWN: **02/24/2023** DATE APPROVAL: **03/02/2023**	**DAIRYLAND ELECTRICAL INDUSTRIES, INC.** P.O. BOX 187 STOUGHTON, WI 53589 608-877-9900 DAIRYLAND.COM
		TITLE: **MOLD-6X**		
	SHEET: OF **2 2**	DWG SIZE: **B**	SCALE: **1:2**	REV: **A**	PART #: **100150**