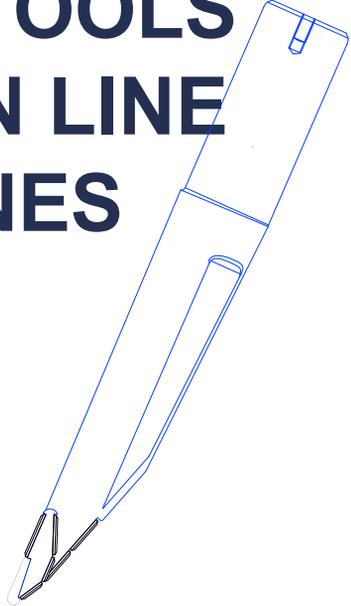




# A GUIDE FOR TAMPING TOOLS FOR PLAIN LINE MACHINES

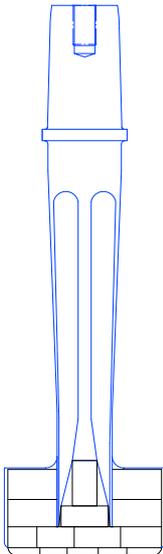


## I. Why should I use MK Tools ?

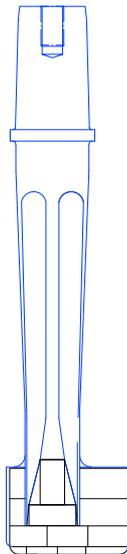
The original tamping tool is being phased out to make way for new longer lasting tools supplied by MKTOOL. These tools are forged in one piece of metal and fully hardened on both side with very high quality tungsten carbide.

## 2. What do the tools look like?

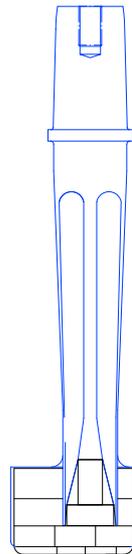
Tamping tools are referered with 3 references. The last number of the reference indicates the type of the tool, center (1) cut on left (2) and cut on right (3)\*



MK221R  
**CENTER  
TOOL**



MK222R  
**CUT ON  
LEFT**

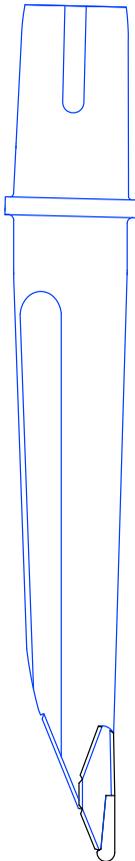


MK223R  
**CUT ON  
RIGHT**

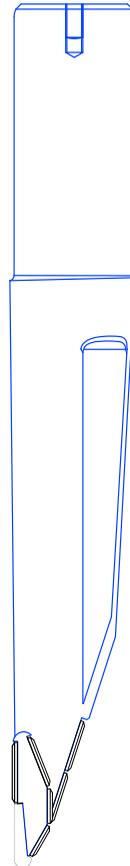
## BACK VIEW

Tamping Tools come in lengths, 420mm, 480mm and for unimat and 4S machines.

2a. Below is an example of the two types of tools.



**MK221R/MK222R/MK223R  
TOOLS**



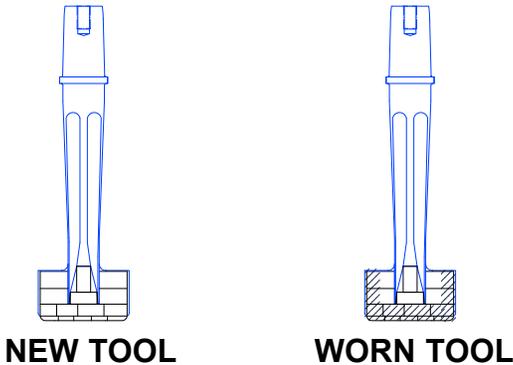
**MK241R/245R  
TOOLS**

**SIDE VIEW**

### 3. When do I replace the tools ?

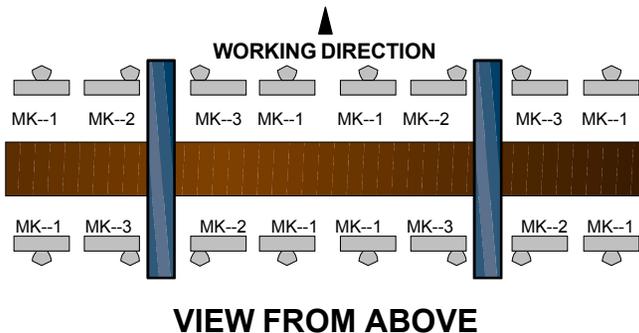
The tools are made of steel, hardfaced with solid tungsten carbid tips.

The tools have a very long life span. However, should the tip become damaged, the underlying steel rapidly wears away, reducing efficiency. The tool or tools should be changed when they reache approximately 2/3 of their original sizes.



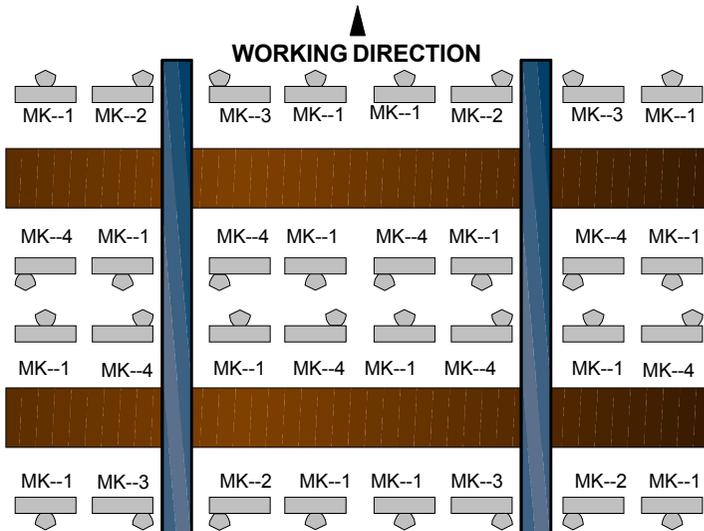
### 4. Where do I fit the tools?

The following examples show the location and number for 07 and 08 midrange 16 tool Tampers\*.



Such setting instruction sheet, showing the full references of tools, is contained in every delivery. Lets have one of these sheet always in the machine and should you lose or break a tool, simply look at the tool layout, state tool number required. Further more every tool is stamped with its reference to simplify the recognition.

5. Below is an example of a MK tool layout for 07-32 and 09-32 Tampers. MKTools are supplied all straight leg tools for the 09-32.



**Note :** If a tool becomes broken or lost, give the location number to the supervisor who will then order a new tool.

**6. Where do I get the new tools from?**

**There is MK agent almost every where MK tools are sold. You just have to contact him, at least give the length of the tools, the type of the machine and the position of the tools (center, cut on left or cut on right).**

**You would also be able to order the correct number of tools just with matching catalogue numbers.**

**Example: for ordering a set of MKTools for an 08-16**

**8 x MK 221R  
4 x MK 222R  
4 x MK 223R**

**6a. Example below shows tool and catalogue numbers for a set of MK Tools for an 08-32**

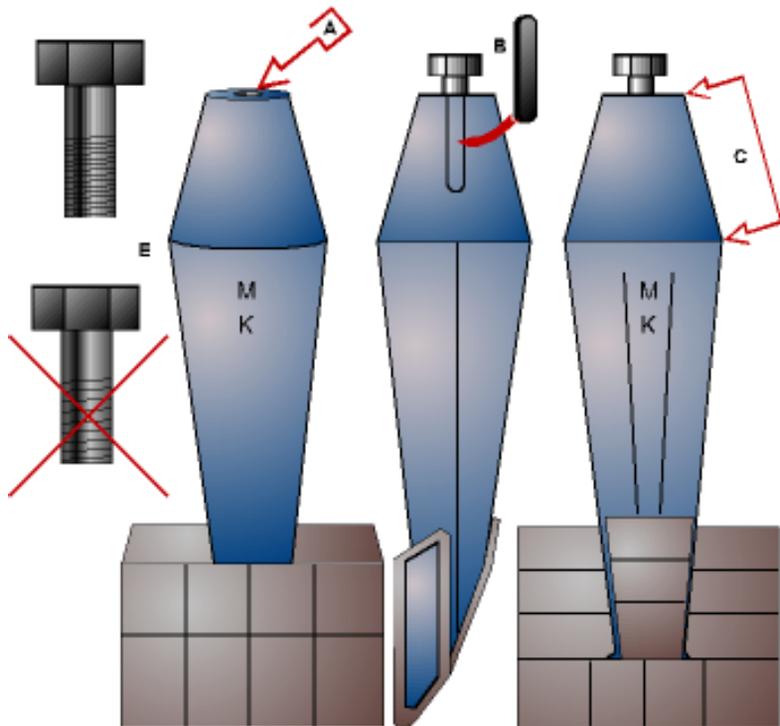
**16 x MK 221R  
12 x MK 222R  
4 x MK 223R**

**7. What must I check before fitting the new tools?**

**It is very important to check the condition of the tool before fitting it.**

- A. Ensure thread in top of tool is OK.**
- B. Ensure key and keyway is clear and not damaged.**

- C. Ensure taper on top of tool is clear and not damaged.
- D. Ensure the cone holder of the machine is clear and not damaged
- E. Make sure the correct bolt is used (the MK bolt has a fine thread).
- F. Don ' t forget caps and washers !!



## 11. How do I fit the new tools?

The following procedure must be followed to ensure correct fitting of new tools.

- (i) Insert tools into their correct sockets.
- (ii) Tighten bolts.
- (iii) Drop banks into full bed of ballast with vibrators running and press squeeze pedal four times.
- (iv) Tighten bolts again.
- (v) Repeat this process four times
- (vi) After every 10 days of working check the tightness of the bolt.

During the first four working shifts, the retaining bolts must be tightened after every 10 chains and this entered in log book.

Note : It is absolutely essential that each tool is fitted in its correct socket

**CAUTION ! : NEVER HIT CARBIDE TIPS WITH HAMMER OR ANY HARD CHOC TOOLS !**

If you have any doubt..... ASK YOUR SUPERVISOR

**KEEP IN MIND**

**Tamping tools are expensive spare parts**

**TAKE CARE OF THEM !**