

Engine – Repair Tv200

ONE TO ONE LESSONS IN ALLOY WELDING A CUSTOMERS TV200 ENGINE CASING

My mate 'Dave the coded welder from down the pub' wanted to see me weld a casing. Well my mate is Dave, Dave Drew brother of Barry Drew our mate and accountant of 32 years. They both did the Motorway tour with me on Race-Tour engines some years back.

We took a call from an old Dealer customer who had a knackered TV200 casing that needed repairing. When I saw photos I thought – bloody hell Ive scrapped casing for less on the rear hub bearing area. This area is unbelievably weak! The customer was adamant I was going to repair it, but didn't dare send the engine by post so asked if Barry he was coming up any time soon. Well – any excuse to do a 400 mile round trip and pay us a visit.

Now this one did make me think! You can't just cut a casing and put the new part in place and its all good. Everything needs entering and putting at the right height. Get this wrong and you've spent lots of time, effort and money to scrap a casing!

Having been forced into this job, I had to think how and why and how to do the job correctly. This is where our new jig came in play – 8 hours later!

Barry and Dave turned up, Barry sat with Ian in the hot office and Dave came down the cold workshop to see how to do a repair!

It was just a case of okay Dave this is the plan – it's a cunning plan and lets see how it goes as Ive never done one of these before, let's see if my jig and steps in my head was going to work!

Now Dave was a coded welder until he retired and became a gardener! He used to work in a lorry park repairing trailers and was a coded pipe welder so was used to working in an engineering workshop. This was an easy explanation to go through the steps of preparation, machining, cleaning, setting the jig and welding, whilst he watched and asked the odd question.

Once welded on the outside, it was cooled and stripped out to weld the inside, then cooled the welds dressed up, then bead and aqua blasted.

Job done, it worked! Oh I do like my jigs!

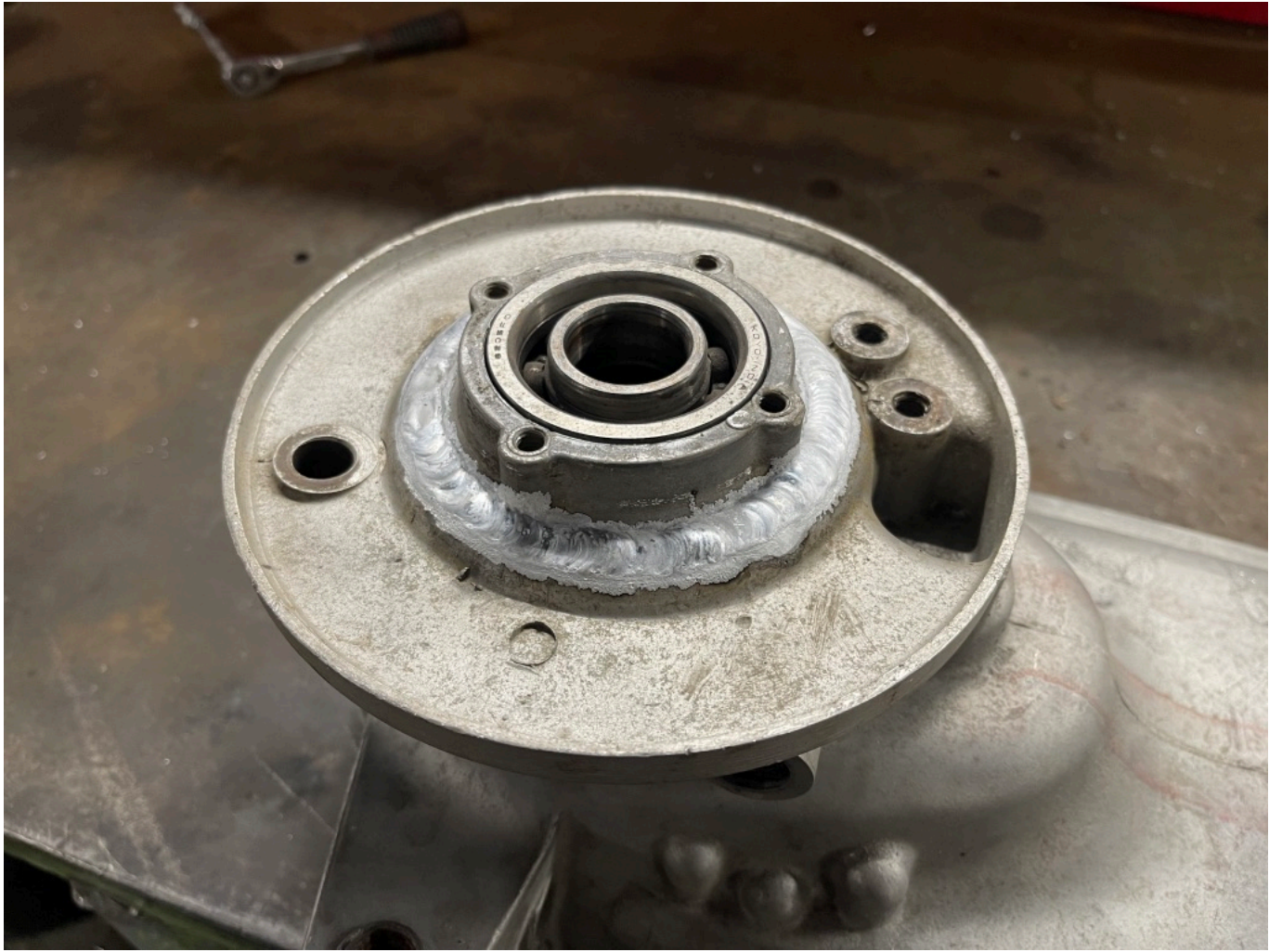
After lunch, I invited Dave to try his hand at alloy welding! We couldn't get him off the knackered casing and a bottle of gas later, he was welding again after many years.

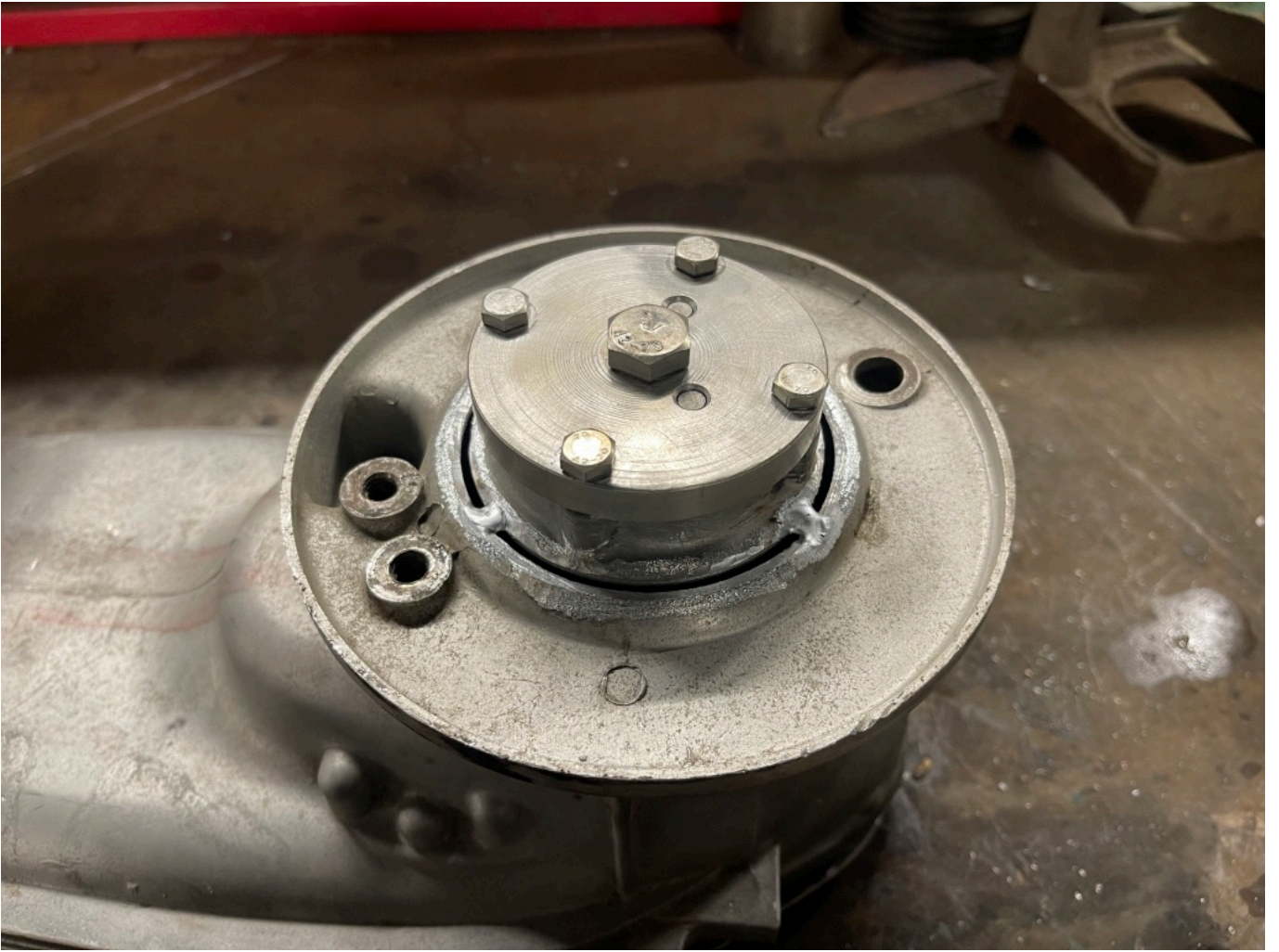
And another TV200 casing saved again!

All in a days work!





















Any comments email mark@mbscooters.co.uk