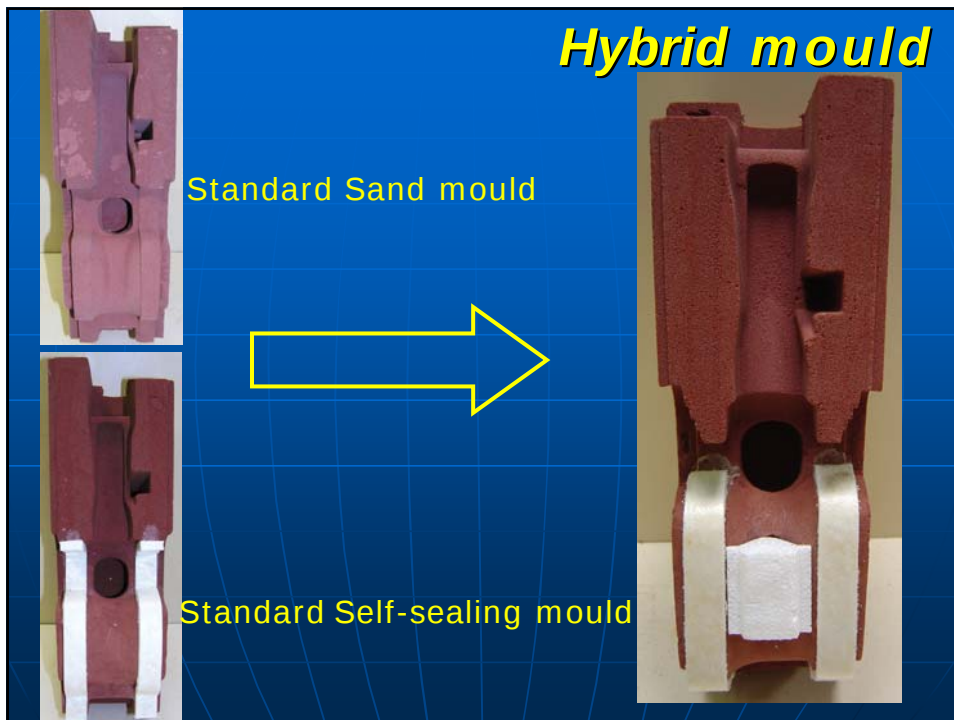


HYBRID MOULDS



PLA VG2 Type A

New rail Wear $\leq 3\text{mm}$



PLA VG2 HY Type B

$4\text{mm} \leq \text{wear} \leq 7\text{mm}$
Maximum wear 15mm



PLA VG2 HY Type C

$\Delta \text{wear} \leq 3\text{mm}$
Maximum wear 15mm



Wear measurement



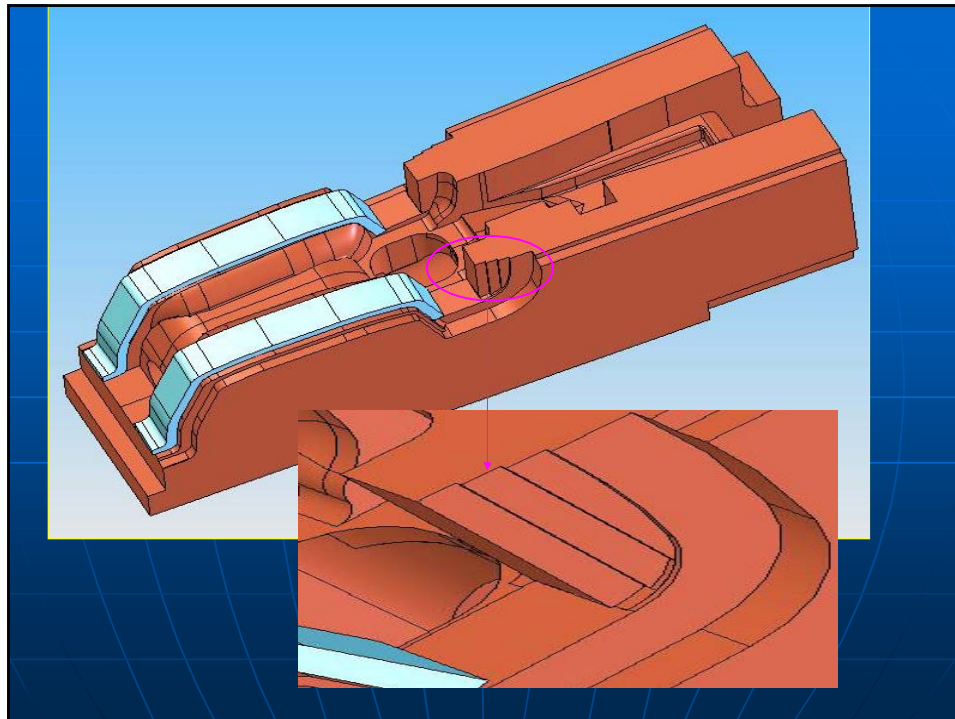
Mould Matrix

Railtech PLA Mould Selection Matrix Hybrid Felt Moulds For Maintenance															
See Note	Wear on the first rail														
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14
Wear on the second rail	0	A	A	A	A	HYB	HYB	HYB	HYB						
	1	A	A	A	A	HYC	HYB	HYB	HYB	HYB					
	2	A	A	A	A	HYC	HYC	HYB	HYB	HYB	HYB				
	3	A	A	A	A	HYC	HYC	HYC	HYB	HYB	HYB	HYB			
	4	HYB	HYC	HYC	HYC	HYC	HYC	HYC	HYB	HYB	HYB	HYB			
	5	HYB	HYB	HYC	HYC	HYC	HYC	HYC	HYC	HYB	HYB	HYB	HYB		
	6	HYB	HYB	HYB	HYC	HYC	HYC	HYC	HYC	HYC	HYB	HYB	HYB	HYB	
	7	HYB	HYC	HYC	HYC	HYC	HYC	HYC	HYC	HYC	HYB	HYB	HYB	HYB	
	8		HYB	HYB	HYB	HYB	HYC	HYC	HYC	HYC	HYC	HYC	HYB	HYB	HYB
	9			HYB	HYB	HYB	HYB	HYC	HYC	HYC	HYC	HYC	HYC	HYB	HYB
	10				HYB	HYB	HYB	HYB	HYC	HYC	HYC	HYC	HYC	HYC	HYB
	11					HYB	HYB	HYB	HYB	HYC	HYC	HYC	HYC	HYC	HYB
	12						HYB	HYB	HYB	HYC	HYC	HYC	HYC	HYC	HYC
	13							HYB	HYB	HYB	HYC	HYC	HYC	HYC	HYC
	14								HYB	HYB	HYB	HYB	HYC	HYC	HYC
	15									HYB	HYB	HYB	HYB	HYC	HYC

Example 1 Rails worn 8mm and 11mm
Step = 3mm = Mould type HYC

Example 2 Rails worn 7mm and 12mm
Step = 5mm = Mould type HYB

Note: Either Type A moulds or HYC moulds can be used for welding together rails that both have 3mm wear or less



- Mould Grinding only on the running surface according to the wear measured on the rail.
- No other grinding anywhere else (collar, top of the foot)
- Luting method identical as usual

Mould Adjustment

Mould grinding





Luting Method



Preheating



Casting



Unmouling and Shearing



Weld aspect



Benefits of the Hybrid Moulds

- Easy and Simple to use
- Grinding only on the running surface
 - Easy for the welder
 - Saves time
 - Improved collar shape (especially on top of the base)
- The felt guaranties the verticality of the moulds
- Avoid having flashing under the head, web and the base