



Pacific Alloy Castings, Inc.

Founded In 1880



Introduction

It takes years to build a reputation for superior workmanship, reliable service and integrity. Our employees are proud of the reputation they have earned in the agricultural industry, and we regard it as our biggest asset.

Our business is only as good as our employees, and we know they are among the best in the industry. Their dedication to quality and customer service will contribute heavily to our growth and success.

Our philosophy is simple, produce castings of the highest quality, engineered to your requirements, and provide them reliably.

We take pride in our reputation as a time proven source for custom castings, designed to meet your needs. If you are a customer of ours, we thank you for your business. If you are not, we welcome the opportunity to be of service to you.

History

Pacific Alloy Castings, Inc. of South Gate, California, a suburb of Los Angeles, is a foundry

specializing in the production of abrasion resistant irons and steels.

Founded in 1880 in Portland, Oregon by Francis Leach, the foundry produced gray iron sash weights and wood burning stoves. As the foundry passed on to succeeding generations in the Leach family its production methods and products became more sophisticated. In 1937 the foundry was moved to Los Angeles, CA by George and Winfield Leach. Walter Leach, Winfield's son became president in 1963 and operated the foundry until his retirement in 1973. The foundry is now managed by his son James Leach, president and general manager.

Pacific Alloy Castings evolved from a small gray iron foundry to a high alloy iron producer occupying 36,000 square feet of building on 3 acres. Our castings are sold nationwide and used in most process industries including agricultural, asphalt, cement, construction, dredging, heat-treating, industrial minerals, mining, petrochemical, paper, sand and gravel.

CONTENTS

Special Products	1-2
Planter Openers	3
Drill Points	4
Points and Spikes for Danish S-Tine Shanks	5
Fertilizer Knife Inserts	6
Fertilizer Knives.....	7
Ripper Point Castings	8-9
Complete Ripper Points	10-11
Tool Bar Clamps and Caps	12
Ripper Shank Shin Guards	13
Tufmetal II Description	14
Tufmetal II Welding Recommendations	15

Pacific Alloy Castings, Inc.

5900 E. FIRESTONE BLVD., SOUTH GATE, CA 90280-3797
(310) 928-1387 • FAX (310) 928-0547

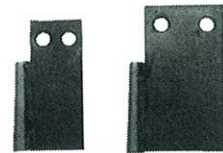
Special Products

Chisel Tip



Part No.: **CT-3**
Cross Reference: **Fits 2" Chisels**

Mulcher Blade Wear Edges



- 10 times wear life of Hardfacing
- Easy to install

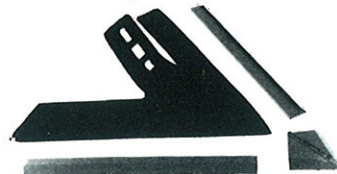
Part No.: **MRB-10** - Round Design
MBS-50 - Square Design
Cross Reference: **Fits most blades**

Alfalfa Spike



Part No.: **AT-3**
Cross Reference: **Fits 1-3/4" Spikes**

Sweep Tips and Edge Protectors



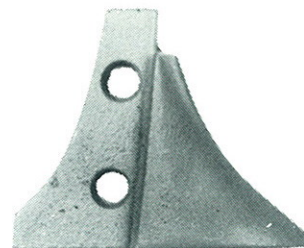
Part No.	Description
ST	Sweep Tip
SI-6	Edge Protector (1-1/8" x 6")
SI-12	Edge Protector (1-1/8" x 12")

Lister Points



Part No.: **LP-87**
Part No.: **LP-87-2** Light Duty
Cross Reference: **Fits all 14" Lister Shares**

Boot Point for Rod Weeder



Part No.: **AG-8900-00**
Cross Reference: **Acra Plant #8900-00**
Calkins #5-919-606

Special Products

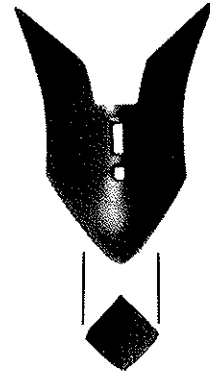
Plow Share Tips



Part No.: **PST-4000** Right
Cross Reference: **Fits all shares**

Part No.: **PST-4000** Left
Cross Reference: **Fits all shares**

Furrow Tips



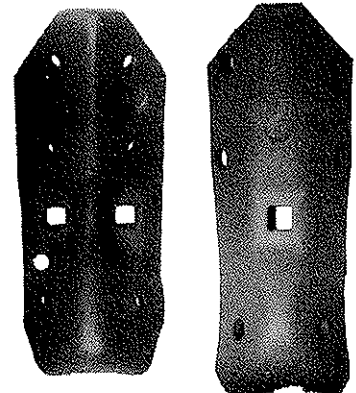
Part No.: **FT-1**
Cross Reference: **Fits 9" and 12" Snub Nose Furrow**
Other sizes available

Adjustable Foot Piece



Part No.: **FP-33-C**
Cross Reference: **78-FP-3133-C**
Other sizes available

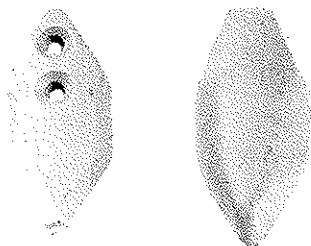
Lister Frogs



Part No.: **JD-43-LF**
Cross Reference: **JD-7958A**

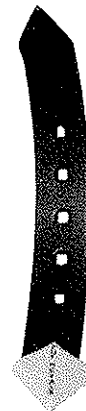
Shank Tip

Replace This With This Weld-On Style



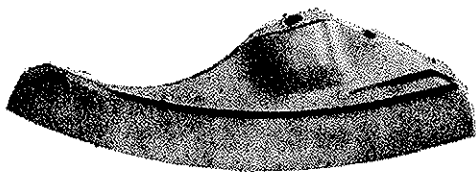
Part No.: **CCP-5**
Cross Reference: **Diamond Point Shank Tip**

Twisted Shovel Tip



Part No.: **TST-1**
Cross Reference: **Fits most shovels**
Other sizes available

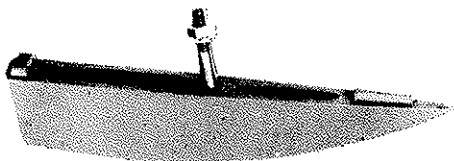
Tufmetal II Planter Openers



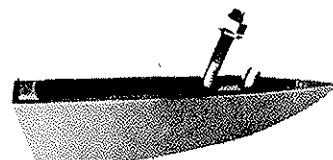
Part No.: **AG-A24371**
Cross Reference: **John Deere #A24371**



Part No.: **AG-A18004**
Cross Reference: **John Deere #A18004**

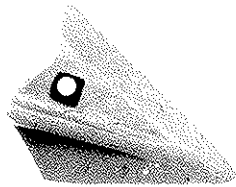


Part No.: **AG-4100-00**
Cross Reference: **Acra-Plant #4100-00**

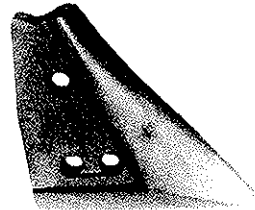


Part No.: **AG-9541-41**
Cross Reference: **Acra-Plant #9541-41**

Tufmetal II Drill Points



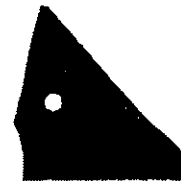
Part No.: **AG-7100-60**
Cross Reference: **Acra-Plant #7100-60**
(Z6)
Calkins #5-919-646



Part No.: **AG-7120-00**
Cross Reference: **John Deere HZ Series**
Acra-Plant #7120-00



Part No.: **AG-7100-70**
Cross Reference: **Acra-Plant #7100-70**
(Z7)
Complete with Roll Pin



Part No.: **AG-809-01**
Cross Reference: **Dyko DNC-809-"V"**

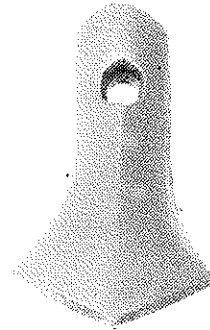


Part No.: **CCP-1**
Cross Reference: **John Deere #300170-01**

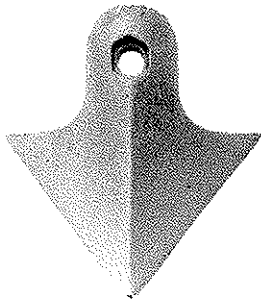
Tufmetal II Points and Spikes for Danish S-Tine Shanks



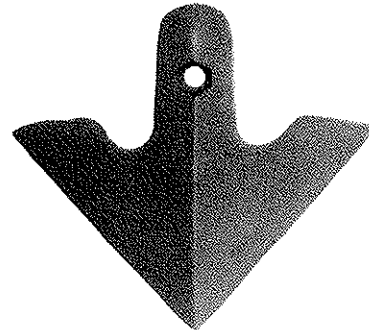
Part No.: **AG-8601-01**
 Description: **1" Spike**
 (Complete with Bolt, Nut and Neoprene Shim)
 Cross Reference: **Acra-Plant #8601-01**



Part No.: **AG-8602-01**
 Description: **2-1/2" Goosefoot**
 (Complete with Bolt, Nut and Neoprene Shim)
 Cross Reference: **Acra-Plant #8602-01**



Part No.: **AG-8603-00**
 Description: **4" Sweep**
 (Complete with Bolt, Nut and Neoprene Shim)
 Cross Reference: **Acra-Plant #8604-02**



Part No.: **AG-8607-02**
 Description: **7" Sweep**
 (Complete with Bolt, Nut and Neoprene Shim)
 Cross Reference: **Acra-Plant #8607-02**

Tufmetal II Fertilizer Knife Inserts



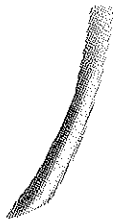
TYPICAL APPLICATIONS
TUFMETAL II INSERT
FOR USE ON FERTILIZER KNIVES



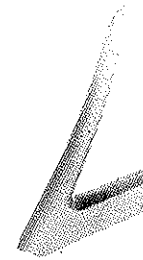
Part No.: **C-12**
Description: **7-1/2" High with
3-1/2" Long Wrap**



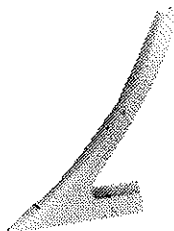
Part No.: **C-19**
Description: **8" High**



Part No.: **C-13**
Description: **7" High**



Part No.: **C-110**
Description: **8" High with
5" Long Wrap**



Part No.: **C-14**
Description: **8-1/2" High with
4-1/8" Long Wrap
with 3/4" Wide Foot**



Part No.: **STP-434**
Description: **Straight Tube Protector**



Part No.: **CTP-4**
Description: **Curved Tube Protector**

Tufmetal II Complete Fertilizer Knives

BACK SWEPT



17BSW SHOWN

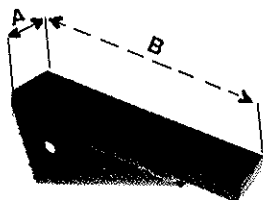
FRONT SWEPT



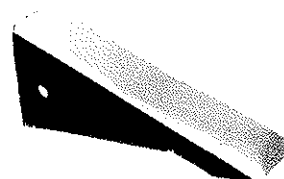
FSC14W SHOWN

PART NO.	SIZE	CHROME CARBIDE INSERT	TUBE PROTECTOR
BACK SWEPT			
13BSW	13"	C19	CTP-4
13BSWO	13"	C19	WELD BEAD
17BSW	17"	C19	CTP-4
17BSWO	17"	C19	WELD BEAD
FRONT SWEPT			
FSC12W	16"	C12	STP-434
FSC12WO	16"	C12	WELD BEAD
FSC13W	16"	C13	STP-434
FSC13WO	16"	C13	WELD BEAD
FSC14W	16"	C14	STP-434
FSC14WO	16"	C14	WELD BEAD
FSC110W	16"	C110	STP-434
FSC110WO	16"	C110	WELD BEAD

Tufmetal II Ripper Point Castings



NOTE: The casting Part No. reflects its actual size (i.e., B178-6 is 1-7/8" x 6")



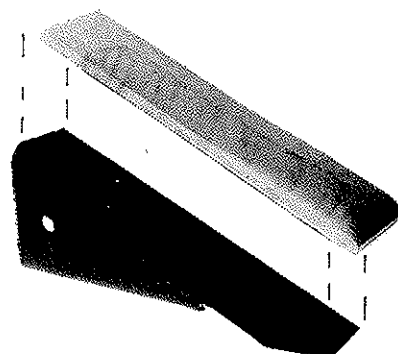
To select the correct casting, measure Dimension "A" and that portion of dimension "B" to be covered and choose the part number that fits.

Castings are made slightly oversized on width to allow fillet weld to be "hidden".

DIMENSION A	DIMENSION B	PART NO.
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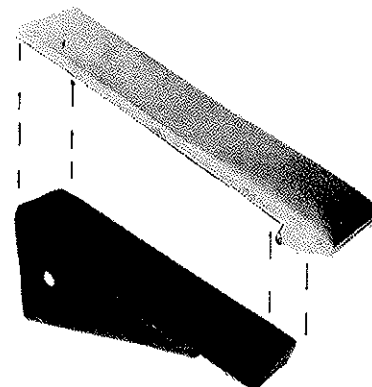
STYLE B CAP

2-1/2"	6"	B278-6
2-1/2"	8"	B278-8
1-1/2"	6"	B178-6
2"	6-1/2"	B238-612
6"	10"	B612-10
2"	12"	B238-12
2-1/2"	12"	B278-12
3"	12"	B338-12
4"	12"	B438-12
3-1/4"	14"	B312-14
6"	14"	B612-14
3"	16"	B338-16
4"	16"	B438-16
5"	16"	B538-16
5"	18"	B538-18
5"	20"	B538-20



STYLE BE

2"	7"	BE214-7
2-1/2"	8"	BE278-8
2"	10"	BE238-10
2-1/2"	10"	BE278-10
2"	12"	BE238-12
2-1/2"	12"	BE278-12
3"	12"	BE338-12
4"	12"	BE438-12



Tufmetal II Ripper Point Castings

DIMENSION A	DIMENSION B	PART NO.
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STYLE B-H, BE-H

2-1/2"	12"	B278-12H3
2"	12"	B238-12H3

STYLE BB CAP

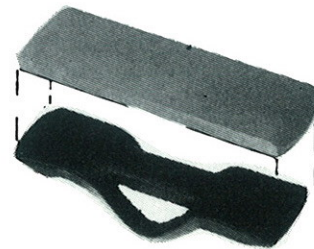
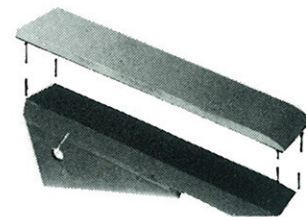
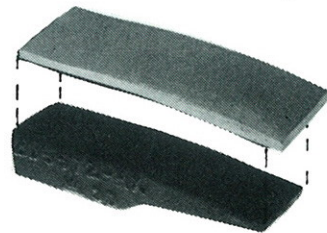
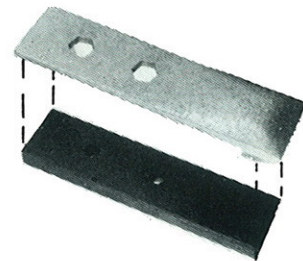
1-3/4"	7"	B178-B612-C
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STYLE F

2"	3"	F238-3
2-1/2"	3"	F278-3
1-3/4"	3-1/2"	F178-312
2-1/4"	4"	F212-4
3'	4"	F312-4
2"	12"	F238-12
2-1/2"	12"	F278-12
3"	12"	F314-12
4"	12"	F438-12

STYLE FDE

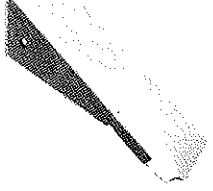
2"	8"	F238-8DE
2-1/2"	8"	F278-8DE



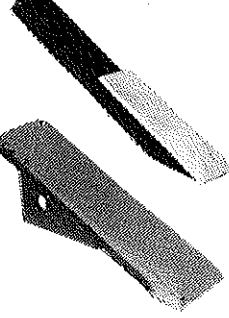
Tufmetal II Complete Ripper Points

P.A.C. PART NO.	CASTING CAP #	DIMENSIONS T x W x L	SHANK SIZE	STYLE	ORIGINAL MFG. NO.	SUBSOILER WITH TUFMETAL II CASTING WELDED ON
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ALLIS CHALMERS

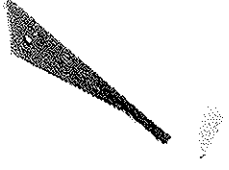
AC-342	BE-238-12	3/4 x 2 x 12	1-1/8	SLIP-ON	412050	
AC-343	BE-338-12	3/4 x 3 x 12	1-1/8	SLIP-ON	402584	
AC-125	BE-278-12	1 x 2-1/2 x 12	1-1/2	SLIP-ON	412279	
AC-133	BE-338-12	1 x 3 x 12	1-1/2	SLIP-ON	403702	
AC-144	BE-438-12	1-1/4 x 4 x 12	1-1/2	SLIP-ON	404289	

JOHN DEERE

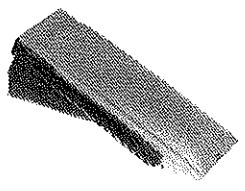
342JD	BE-278-12	1 x 2-1/2 x 12		SLIP-ON	AA-21507	
12JD	B-238-612	1 x 2 x 12		BOLT	A-17994	
12JD	BE-214-7	1 x 2 x 12		BOLT	A-17994	
12JD	BE-238-12M	1 x 2 x 12		BOLT	A-17994	
36081JD	F-278-3	1 x 2-1/2 x 12		BOLT	Q-36081	
36081JD	BE-278-8	1 x 2-1/2 x 12		BOLT	Q-36081	
36081JD	BE-278-12M	1 x 2-1/2 x 12		BOLT	Q-36081	
39096JD	F-278-2	1 x 2-1/2 x 14		BOLT	K-39096	
39096JD	BE-278-8	1 x 2-1/2 x 14		BOLT	K-39096	

NOTE: M = Modified to accept John Deere hole pattern.

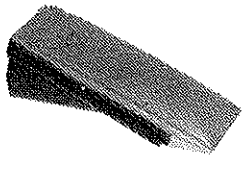
BUSH HOG

3425BH	BE-278-8	3/4 x 2-1/2 x 8-1/8	1-1/4	SLIP-ON		
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BIG ED

582E	BE-214-7	1 x 2 x 7	1	SLIP-ON	1LO	
1LOE	B-178-6	1/2 x 1-5/8 x 6	1	SLIP-ON		
3424E	BE-214-7	3/4 x 2 x 7	1-1/4	SLIP-ON		

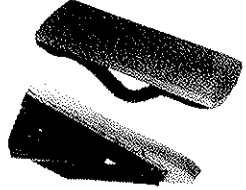
MURRAY

582M	BE-214-7	1 x 2 x 7	1	SLIP-ON	1LO	
1LOM	B-178-6	1/2 x 1-5/8 x 7	1	SLIP-ON		
3424M	BE-214-7	3/4 x 2 x 7	1-1/4	SLIP-ON		


Tufmetal II Complete Ripper Points

P.A.C. PART NO.	CASTING CAP #	DIMENSIONS T x W x L	SHANK SIZE	STYLE	ORIGINAL MFG. NO.	SUBSOILER WITH TUFMETAL II CASTING WELDED ON
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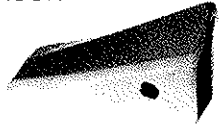
INTERNATIONAL

IH-1S	F-238-8DE	1 x 2 x 8	1	BOLT	954530R2	
IH-1	F-238-8DE	1/2 x 2 x 8	1	BOLT	1101188C1	
IH-14	BE-238-10	1 x 2-1/4 x 10	1-3/8	SLIP-ON	13163601	

BIG OX

2D5	PLAIN	1-3/4 x 7	1	SLIP-ON	2D5	
2D5B	B178-B612-C	1-3/4 x 7	1	SLIP-ON	2D5	
2D5BE	BE-214-7	1-3/4 x 7	1	SLIP-ON	2D5	

SOLID CHROME POINTS

AG-8001-01	SOLID CHROME		1	ORTHMAN, HAMBY, and JOHNSON	
AG-8002-07	SOLID CHROME		1	BIG OX	
AG-8006-01	SOLID CHROME		1-1/4	JOHN DEERE 900 P&M, BUSH HOG	

NOTES:

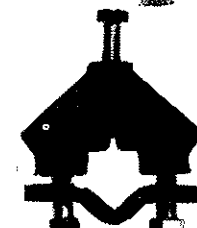
1. P.A.C. = Pacific Alloy Castings
2. Pacific Alloy Castings offers as a standard the Chrome Ripper Point Casting as noted. However, other styles may be furnished upon request.
3. Dimensions represent those of the original manufacturer prior to placement of Pacific Alloy Castings Caps being welded on. (T = Thickness, W = Width, L = Length).
4. Additional subsoiler style ripper points can be furnished upon request, such as Brillion, New Kelly, Pittsburgh, Atlas, as well as others.
5. See catalog cuts "Subsoiler or Ripper Point Castings" for details of chrome carbide caps.

Tool Bar Clamps and Caps

PART NO.	DESCRIPTION	CAP SIZE
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CLAMPS

C-1320	1" x 3" Shank	1" x 2-1/2"
C-3420	3/4" x 2" Shank	1" x 2"
C-5820	5/8" x 2" Shank	5/8" x 2"
B-1140	5/8" x 1-1/2" Shank	5/8" x 1-1/2"
C-5820-S	5/8" x 2" Square (Flat) Shank	5/8" x 2"
C-2140	1-1/4" x 1-3/8" Round Shank	5/8" x 1-1/2"



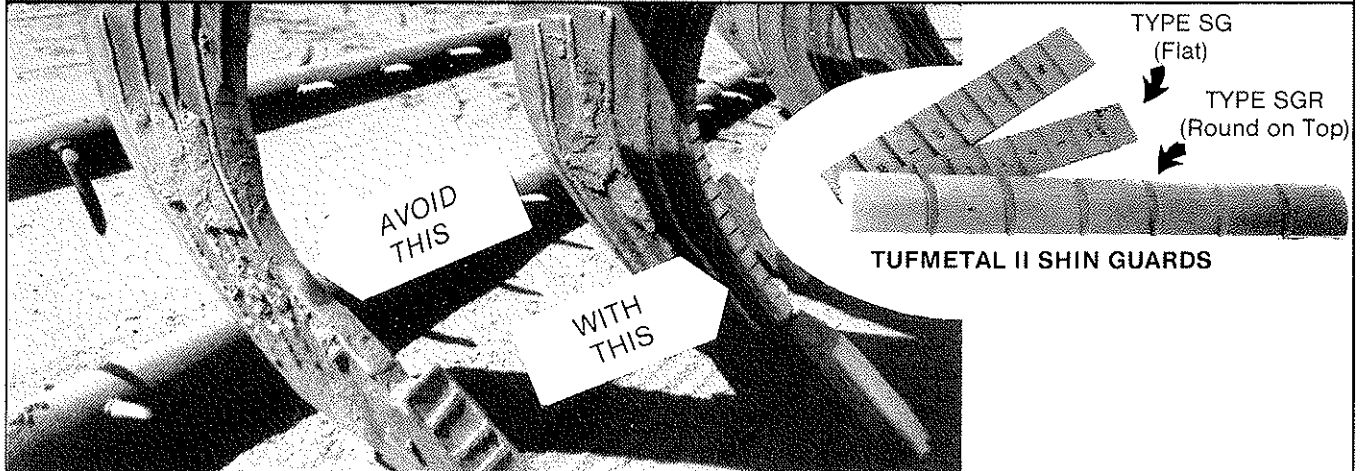
CAPS

CC-1412	Clamp Cap	5/8" x 2"
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Other Sizes Available

Tufmetal II Ripper Shank Shin Guards



SHANK WIDTH	PART NO.	SHIN GUARD
1"	SG-114-9	1-1/4" x 9"
1-1/8"	SG-112-9	1-1/2" x 9"
1-1/4"	SG-112-9	1-1/2" x 9"
1"	SGR-114-14	1-1/4" x 14"
1-1/4"	SGR-112-14	1-5/8" x 14"
1-3/8"	SGR-112-14	1-5/8" x 14"
1-1/2"	SGR-134-14	1-3/4" x 14"
2"	SGR-238-14	2-3/8" x 14"
2-1/2"	SGR-278-12	2-7/8" x 12"

- SHIN GUARDS ARE SLIGHTLY WIDER THAN THE SHANK TO ALLOW THE WELD TO BE "HIDDEN".

- SHIN GUARDS CAN BE BROKEN ON 1" INCREMENTS TO PERMIT BEING WELDED TO VIRTUALLY ANY SHAPE.

- SHIN GUARDS MAKE GREAT WEAR PATCHES FOR QUICK REPAIR TO MANY IMPLEMENTS WITH WEAR PROBLEMS.

- SHIN GUARDS WILL WEAR LONGER THAN HARDFACING AND WILL EXTEND THE LIFE OF A CONVENTIONAL STEEL PART BY UP TO 10 TIMES.

Tufmetal II Description

TUFMETAL II

Tufmetal II is a chrome carbide martensitic white iron. It is commonly referred to as 25% chrome iron, 28% chrome iron, or chrome carbide. All are the same alloy made to ASTM A532 Class III Type A.

Tufmetal II is used in applications of extreme sliding or gouging abrasion with moderate impact. It is used extensively in most process industries including mining, sand and gravel, asphalt, and cement. It has also found wide acceptance and success in the agricultural industry when used to protect ground engaging tools and equipment.

CHARACTERISTICS OF TUFMETAL II

1. Wear life of Tufmetal II is up to 15 times greater than conventional tillage steels and 5 times more the wear life of hard faced tools.
2. Tufmetal II castings can be welded in place using standard welding equipment, welding rods, and wire. See welding recommendations on page 15.
3. Tufmtal II is corrosion resistant and will not corrode like mild steel. It does not have to be protected from rain or snow by painting.

Tufmetal II tillage tools have proved to be the most economical tools a farmer can use today. The proper application of our superior products can greatly increase the wear life of engaging tools and help reduce the farmer's operating costs.

Tufmetal II Welding Recommendations

We have found the following procedure to be most successful when welding Pacific Alloy Castings Tufmetal II (ASTM A532 Class III Type A) material to a base material of T1 or Plow Steel for ripper points.

Directions:

Place chrome casting on flat non-worn base boot slab. If surface is not flat and smooth, take appropriate actions to grind/finish surfaces properly.

Wire feed (MIG): Lincoln Ready Reel
.035 to .045 diameter rod
70S series

Lincoln part number for .045 is C045L50
Other equivalents are also acceptable.

Amperage: Use as low amperage as possible (90-120 amps)

Cooling: **Avoid thermal shocks** (i.e. cold floors, drafts, water) It is recommended that welded parts be placed for slow cooling in a dry sand bed or ashes with at least 6 inch base.

Note: Minor cracks may appear along the edges of the casting after welding. These are not detrimental to the weld or the effectiveness of the casting wearability. This is not a structural weld but merely a bonding process.

PRE-HEAT AND AFTER-WELD HEAT TREATMENT

Contrary to most procedures we have found it not necessary to do any preheating or heat treatment. Should you encounter conditions which may require heating, please consult the factory for recommendations.