

[54] METHOD FOR MAKING ROCK BITS

[52] U.S. Cl. 219/121 EM; 175/375; 76/108 A

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[57] ABSTRACT

[73] Assignee: Smith International, Inc., Irvine, Calif.

A method of making a rock bit which is a welded assembly of legs each carrying a rotatable cutter. Electrochemical grinding is used for finish machining of mating surfaces of heat-treated bit legs, and the legs are secured together by electron-beam welding along the mating surfaces.

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Related U.S. Application Data

8 Claims, 4 Sheets Drawing, 15 Pages Specification

[63] Continuation of Ser. No. 706,632, Jul. 19, 1976, abandoned.

[51] Int. Cl.² B23K 15/00

The file of this unexamined application may be inspected and copies thereof may be purchased (849 O.G. 1221, Apr. 9, 1968).

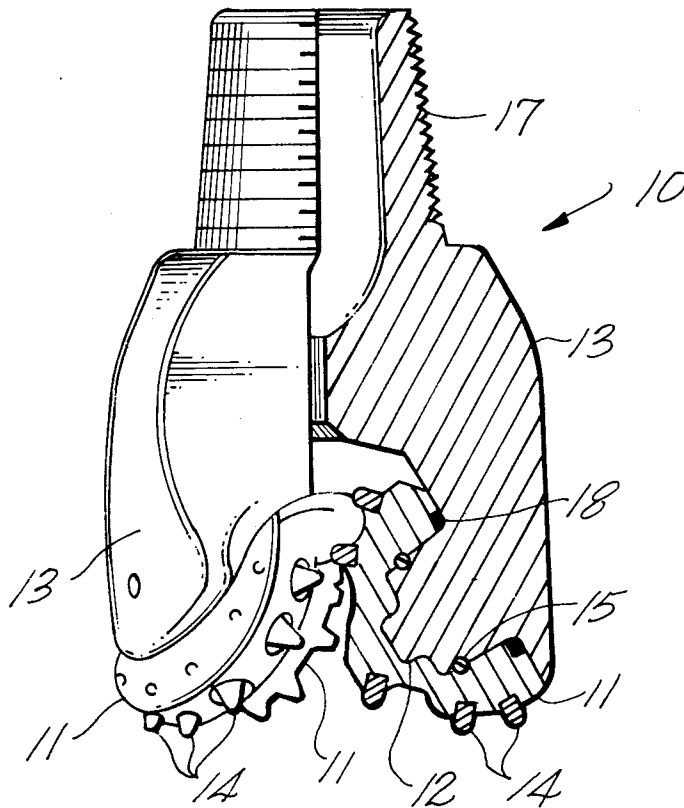


Fig. 1

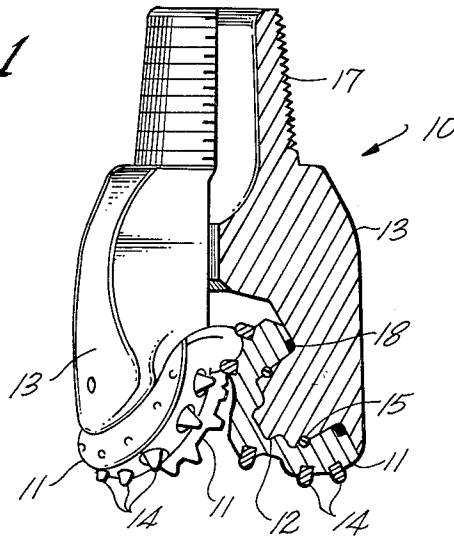
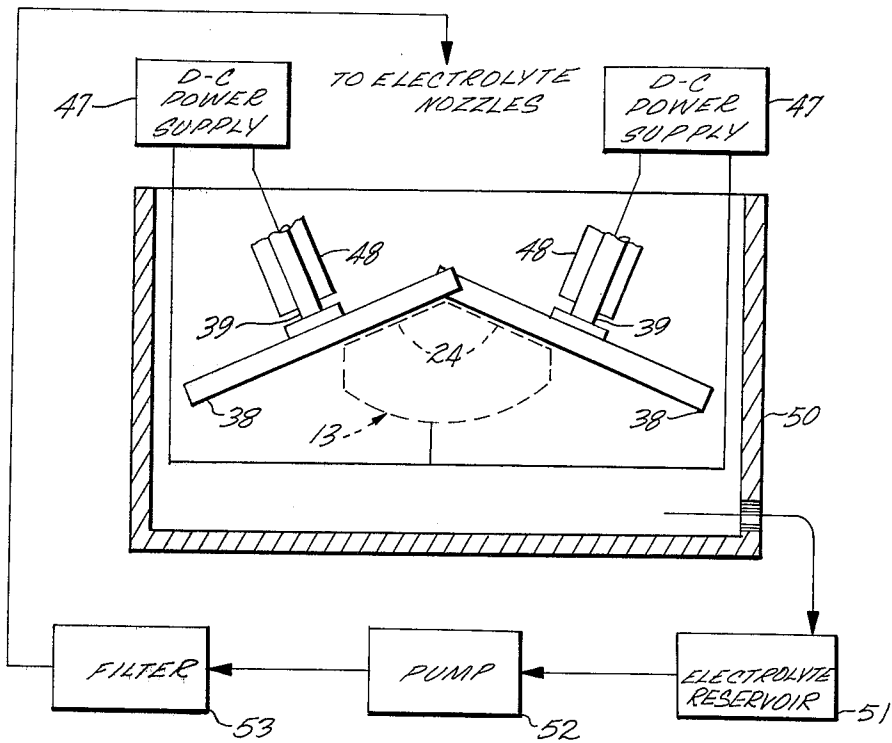
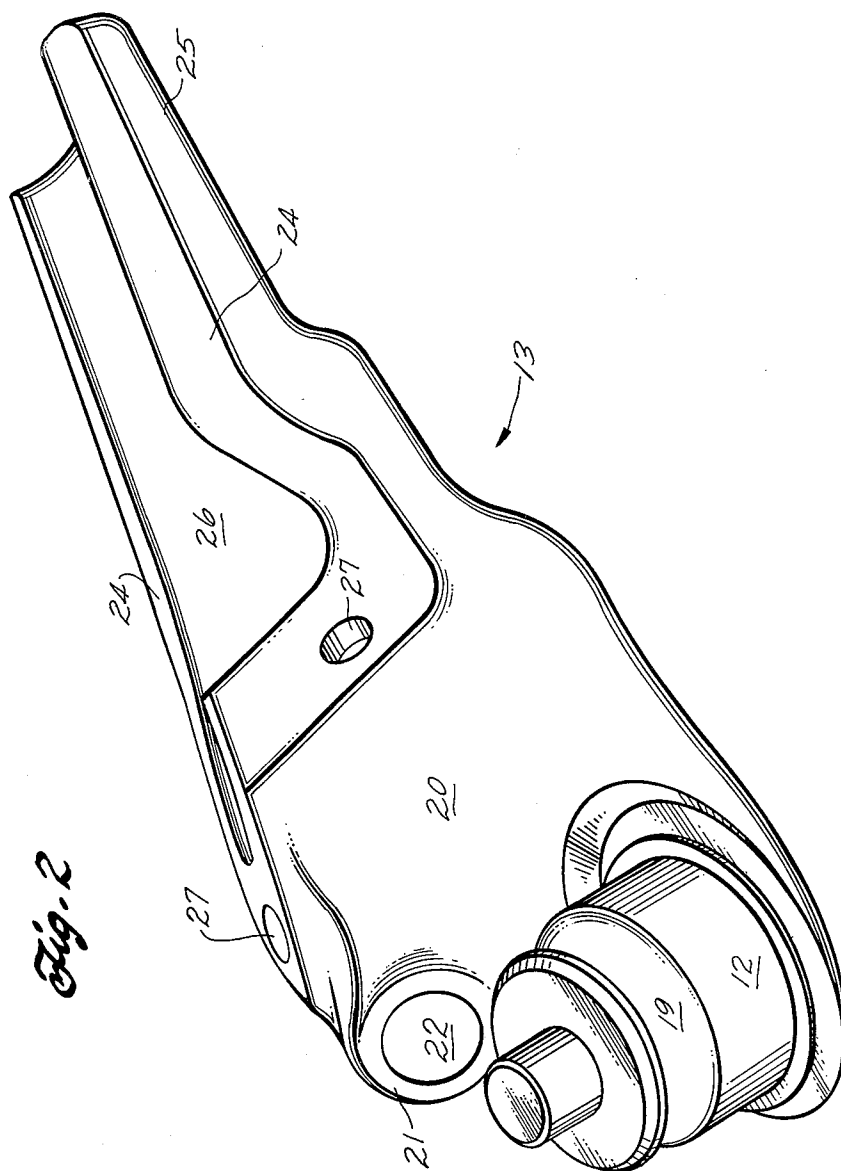


Fig. 5





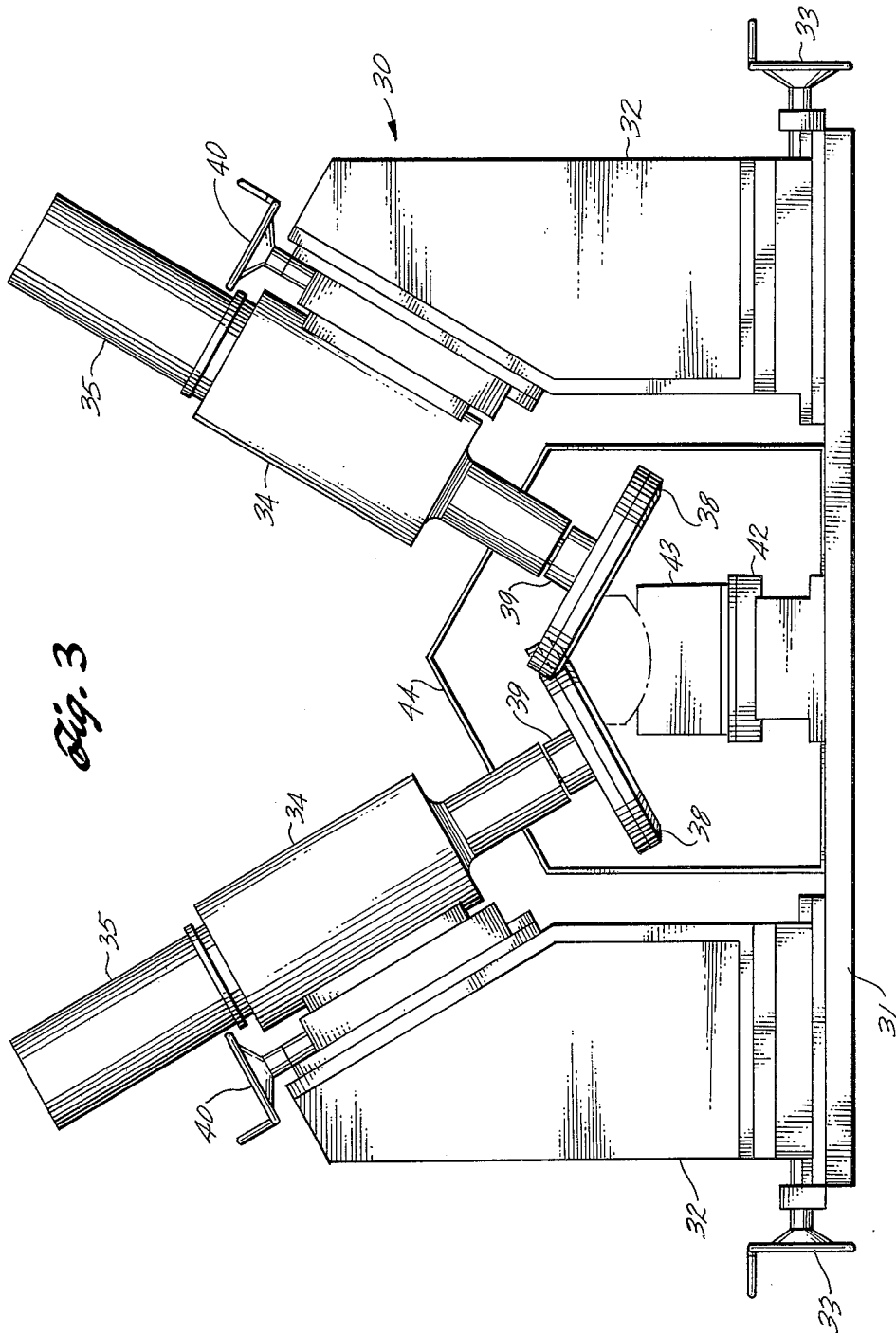


Fig. 4

