Stitch & sequence planner

Book 1 · Chapter 6 · a single end-to-end pass on thin sheet is a warp machine

Job ref	Assembly	Material + thickness	Joint

Sketch the assembly. Number each stitch in weld order, mark clamps (C) and strong-backs (S), and arrow the back-step direction.

BEFORE THE FIRST STITCH

- ☐ Clamped to a flat strong-back where possible
- ☐ Back-step: short segments towards previous heat
- ☐ Intermittent weld used where the design allows
- ☐ Coating ground back to clean metal in the weld zone
- ☐ Welds balanced either side of the centreline
- ☐ Dry run with the beam off so hands know the order
- ☐ Closed stainless: purge ports, or the consequence agreed in writing
- ☐ Straightening planned if the assembly needs it

Stitch	Length	Side	Cooled first?	Done	Notes
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	
			☐	☐	

Out of flat before (straightedge)	Out of flat after

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