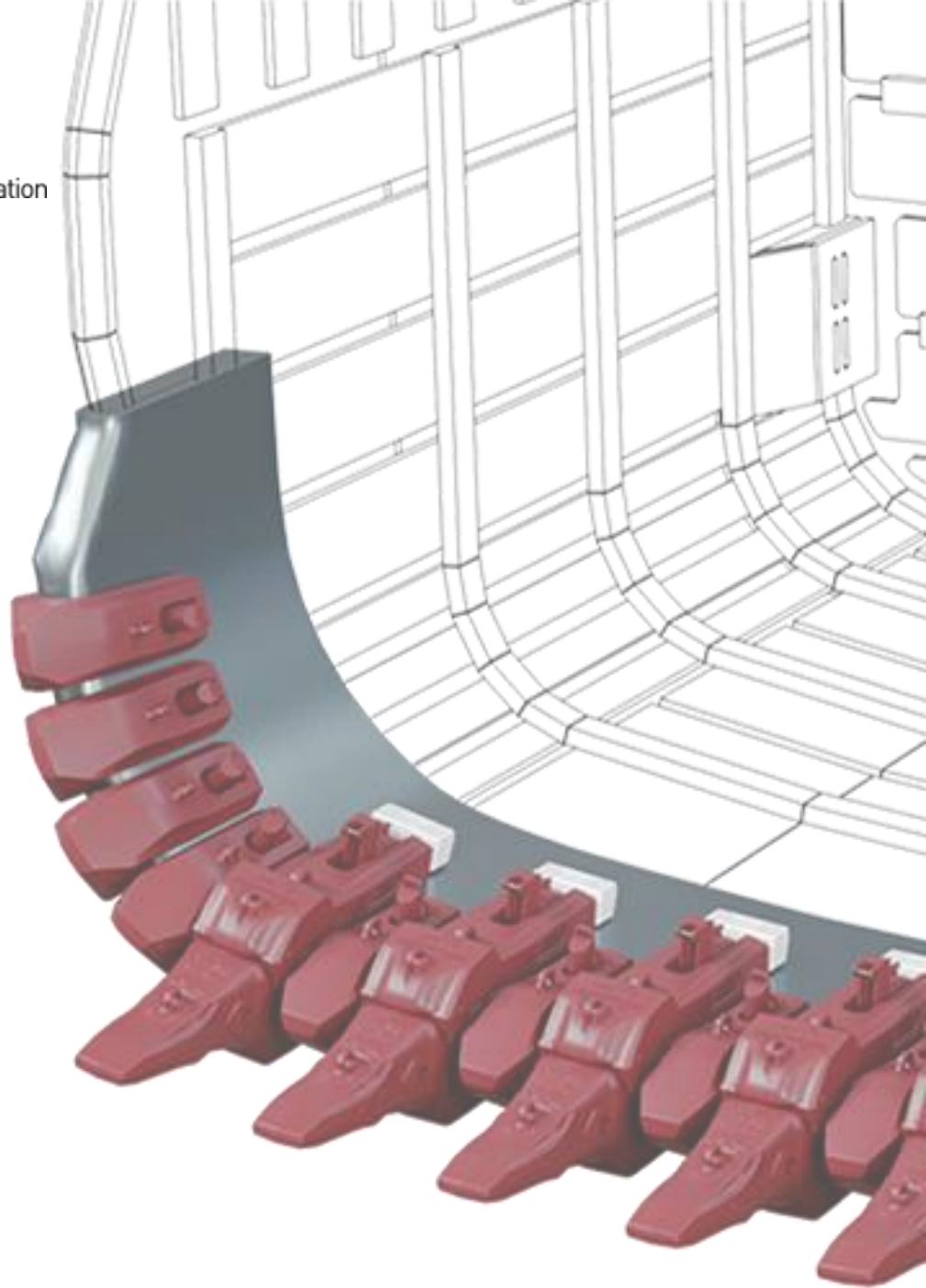




MTG

No limits innovation



INS.3.8.4

Lower Wing Shroud Bevel + Hammerless 2-part Locking H2

Installation procedure

DISCLAIMER

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1. SAFETY

The practices described in this manual can be taken as guidelines for operating safely in many conditions and in addition to the safety standards that are current and enforceable in your area or region.

Your safety and the safety of third parties is the result of putting into practice your knowledge of the correct operational procedures.

Attention, when performing the work described in these instructions, always work safely and use the personal protection elements required to minimize or avoid injury. Always wear:



**HARD
HAT**



**SAFETY
GLASSES**



**EAR
PROTECTION**



**STEEL TOED
BOOTS**



**PROTECTION
GLOVES**

To avoid eye injury, always wear safety goggles or a protective mask when using any equipment, hammer or similar tool. When equipment is under pressure or when objects are struck, chips or other debris can be thrown out. Make sure no one gets hurt by the debris that is fired before applying pressure or hitting an object. Wear eye protection that complies with ANSI Z87.1 and OSHA standards. Also wear hearing protection and gloves.

Lifting a heavy object can cause serious or fatal injury. DO NOT exceed the maximum rated capacity of lifting and positioning devices: Stay away from the area under a suspended load.



**LIFTING
LUG**

Make sure that the chain is not damaged and that the load is always balanced.

2. INSTALLATION PROCEDURE

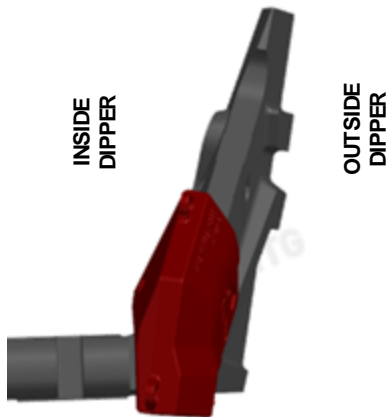
CAUTION: Installation of MTG products for rope shovels may require reconstructive work on the lip, such as welding and grinding, to return it to its original geometry and ensure proper fit and performance.



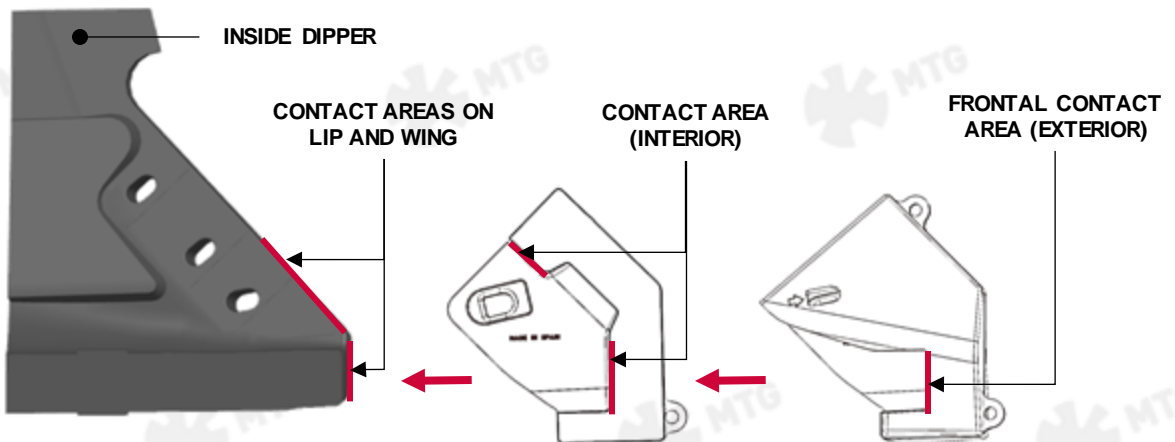
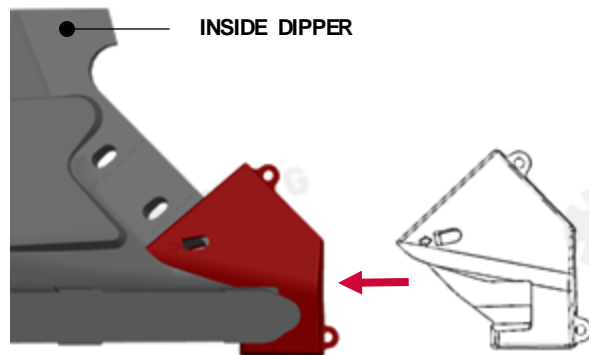
To perform the reconstruction/recalibration of lips, it is mandatory to follow the MTG reparation instructions for rope shovels which describe the proper procedures for recovering the lip geometry by using MTG gauges. Please contact technical.services@mtg.es for further information.

2.1 Place de wing shroud on its station assuring contact on the surfaces shown in the picture. Keep in mind that there are both left and right versions of the wing shrouds.

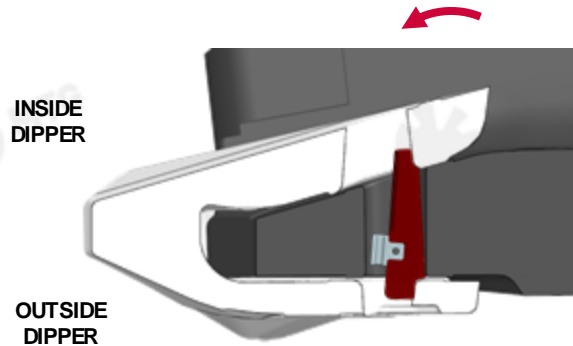
DIPPER FRONTAL VIEW



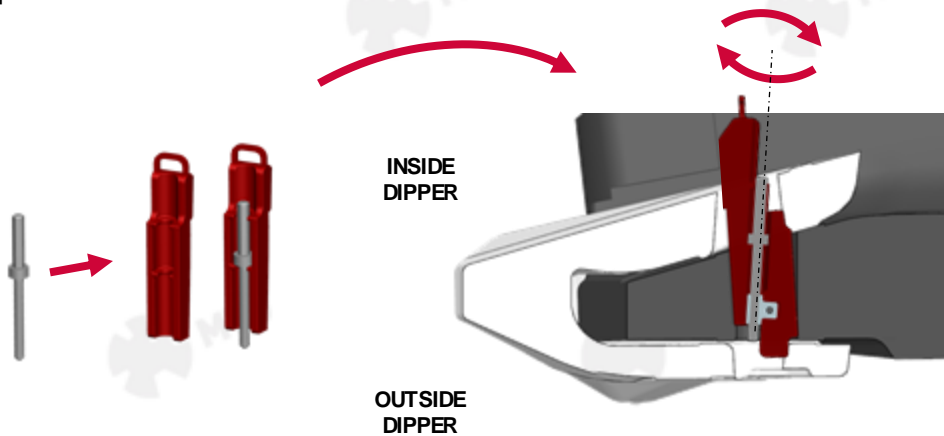
DIPPER SIDE VIEW



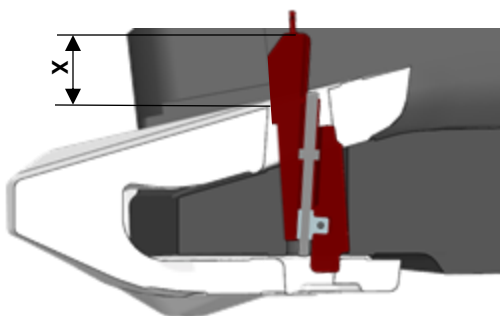
2.2 Insert the C-clamp on its position from the **inside of the dipper**.



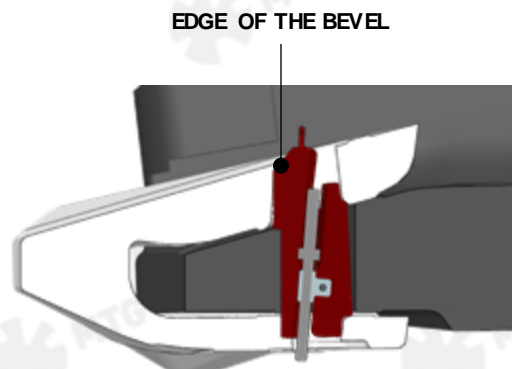
2.3 Place the torque pin into the wedge as shown in the picture, introduce the wedge on its housing from the inside of the dipper and screw with an impact gun until a torque of 200 Nm (148 lbs-ft). Impact socket size -> hex. 12mm.



2.4 The maximum length admissible that the wedge should protrude from the shroud (mark X) is 75+12,5mm (3+1/2"). If the wedge protrudes more than this dimension it could mean that either the lip shroud is not seated properly or that there is deformation in the wing shroud station hole which needs to be repaired.



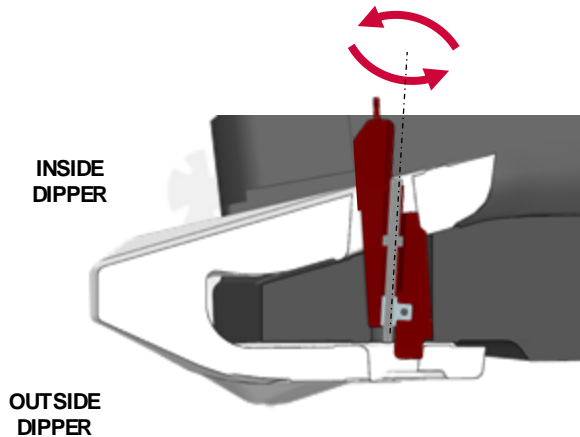
2.5 After installation, if the edge of the bevel shown in the picture below is underneath the shroud this means that the lip needs to be rebuilt.



3. REMOVAL PROCEDURE

3.1 Place the dipper in a safe position to access the wedge from the inside of the dipper.

3.2 Use the impact gun and a hexagonal impact socket of 12mm (1/2inch) to unscrew the torque pin from the inside of the dipper. The torque pin movement will pull the wedge up untightening the locking until the wedge can be removed by hand. A long impact socket or an extension may be needed.



3.3 Once the wedge is out, take the c-clamp out and remove the shroud.



Service Instructions

The latest welding recommendations and assembly / disassembly instructions can be found online:

www.mtgcorp.com/manuals

Please contact Technical Services in case of questions:

technical.services@mtg.es



MTG HEADQUARTERS

Carrer d'Àvila, 45
08005 Barcelona (Spain)
(+34) 93 741 70 00
info@mtg.es

MTG NORTH AMERICA

4740 Consulate Plaza Drive
Houston, TX 77032 (USA)
+1 (281) 872 1500
info@mtgcorp.us

MTG AUSTRALIA

16 – 18 Thorpe Close
Welshpool, WA, 6106 (AUS)
+61 8 6248 6513
Info.australia@mtg.es