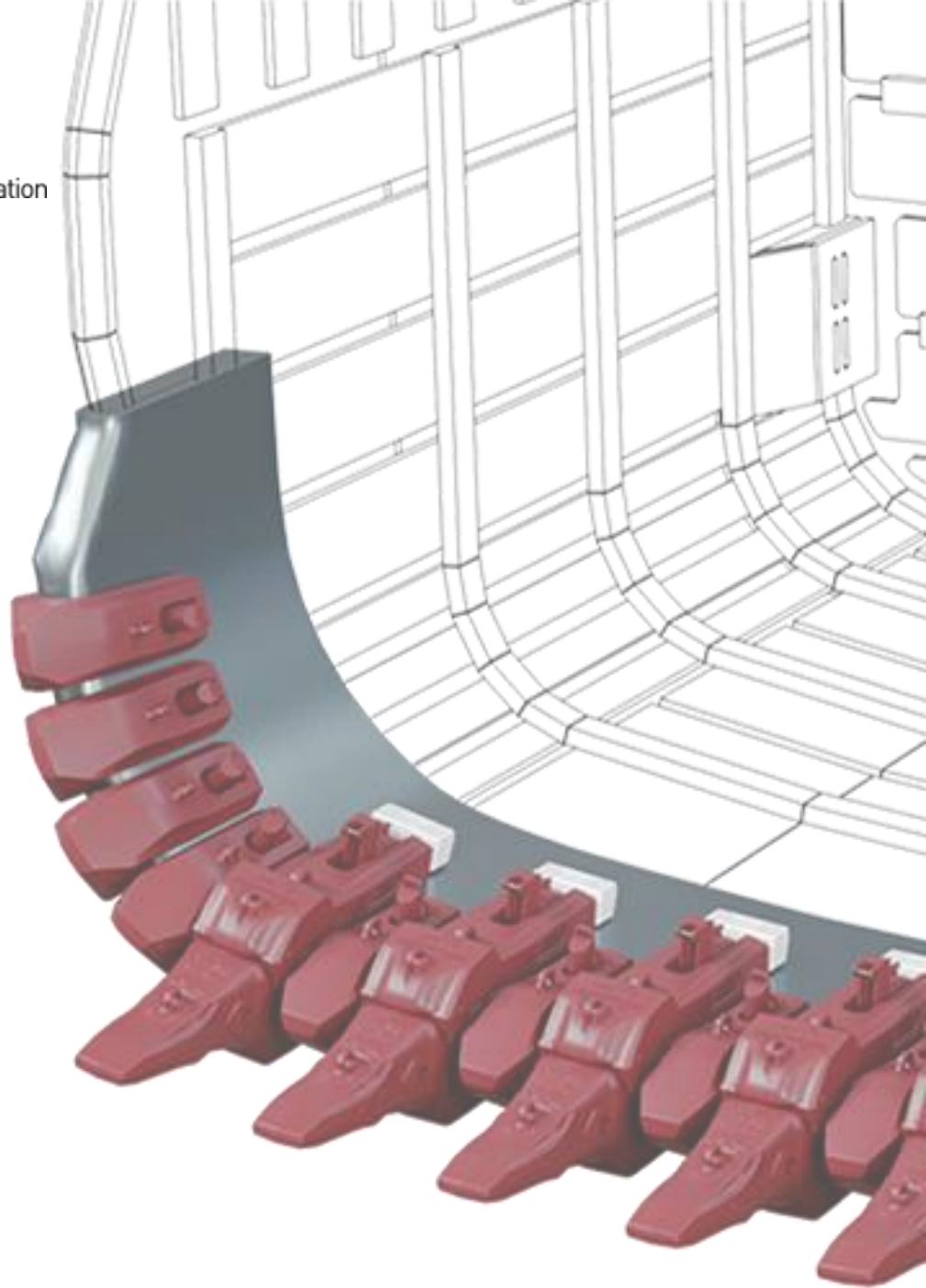




MTG

No limits innovation



INS.3.6.5

1.5-leg Lip Shroud + Conventional 2-part Locking C2

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.

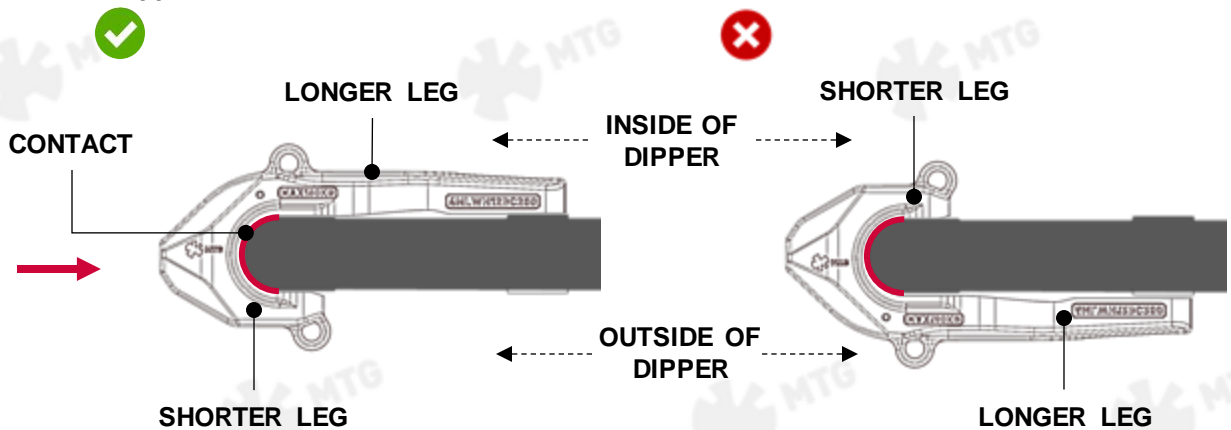
2. LIP SHROUD INSTALLATION

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.

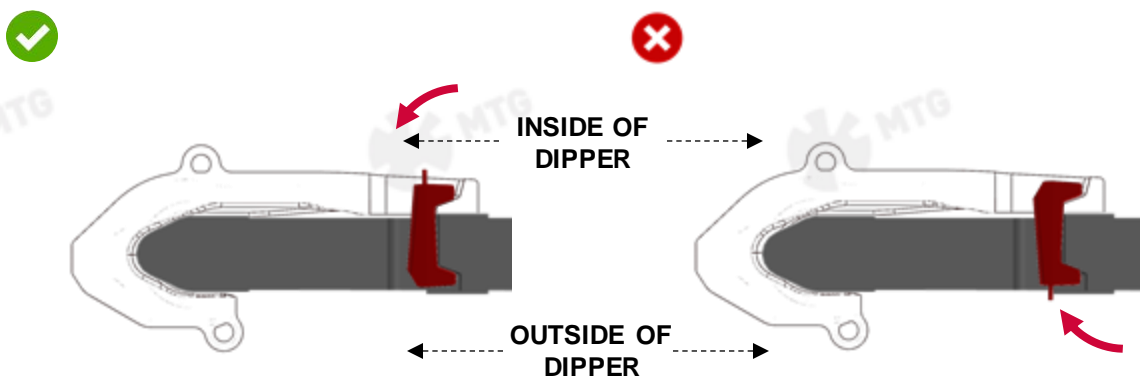


To perform the reconstruction/recalibration of lips, it is mandatory to follow the MTG reparation instructions for rope shovels which describe the proper procedures for recovering the lip geometry by using MTG gauges. Please contact technical.services@mtg.es for further information.

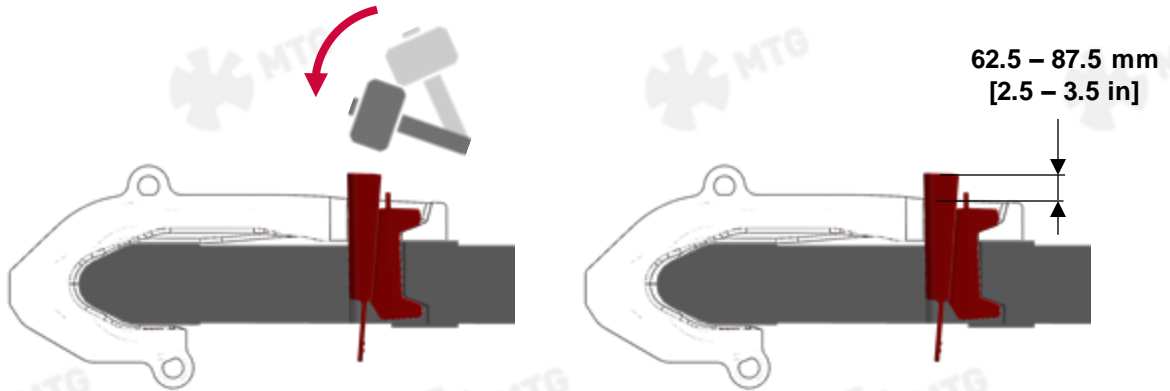
2.1 Mount the lip shroud ensuring contact between the lip shroud and the curved edge of the lip. The longer leg must be facing the **inside of the dipper**; the shorter leg must be facing the **outside of the dipper**.



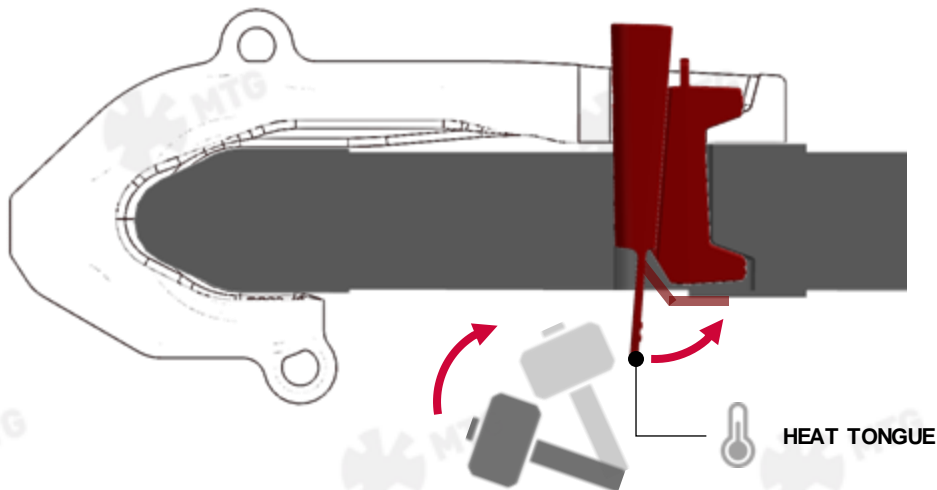
2.2 Use the handle on the C-Clamp to install it from the **inside of the dipper**.



- 2.3** Align and insert the wedge from the inside of the dipper. Strike the wedge down with a heavy hammer (>10 kg [>25 lb]) until the wedge can no longer enter. The wedge should protrude above the lip shroud between 62.5 and 87.5 mm [2.5 and 3.5 inches].

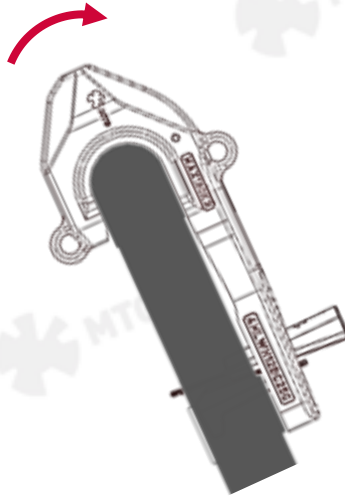


- 2.4** Once installed, heat the tongue at the end of the wedge with a torch and hammer it back towards the C-Clamp so that it is hidden within the housing.

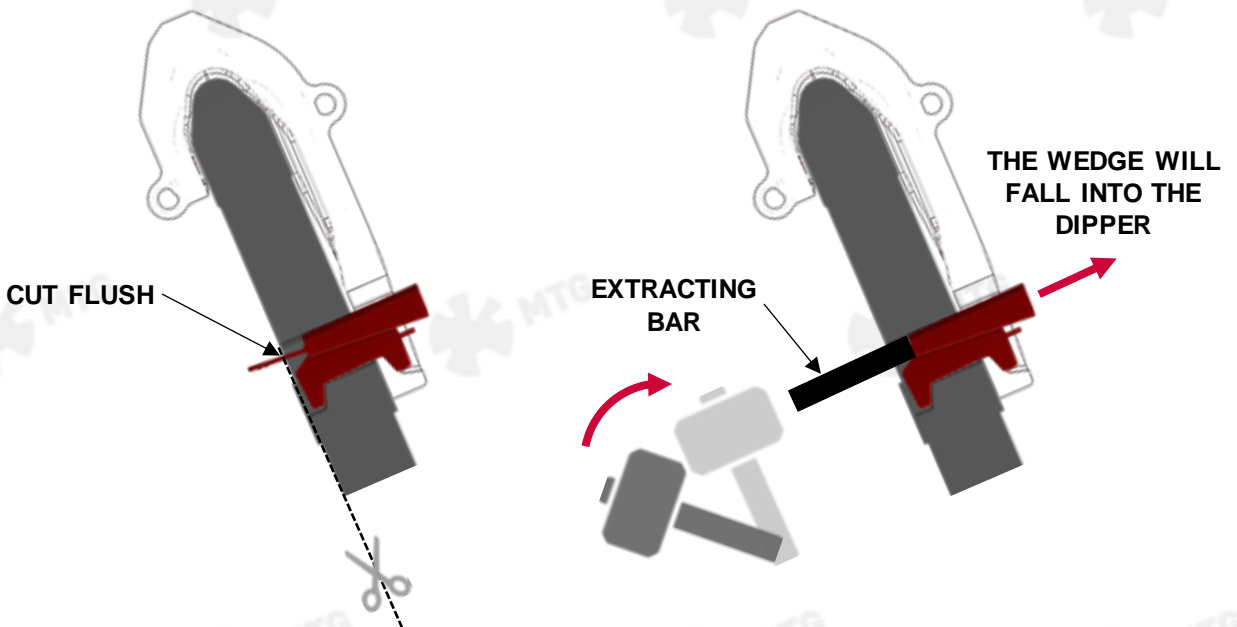


3. LIP SHROUD REMOVAL

- 3.1** Safely position the dipper in a near-vertical position in order to access the wedge from the bottom of the dipper.



- 3.2** If it is still in place, cut the tongue at the end of the wedge flush with the lip using a torch. Place an extractor bar on the bottom surface of the wedge and strike it out with a heavy hammer (>10 kg [>25 lb]). The wedge will fall into the dipper and the lip shroud will no longer be in locked.



- 3.3** Extract the C-Clamp and remove the lip 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



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