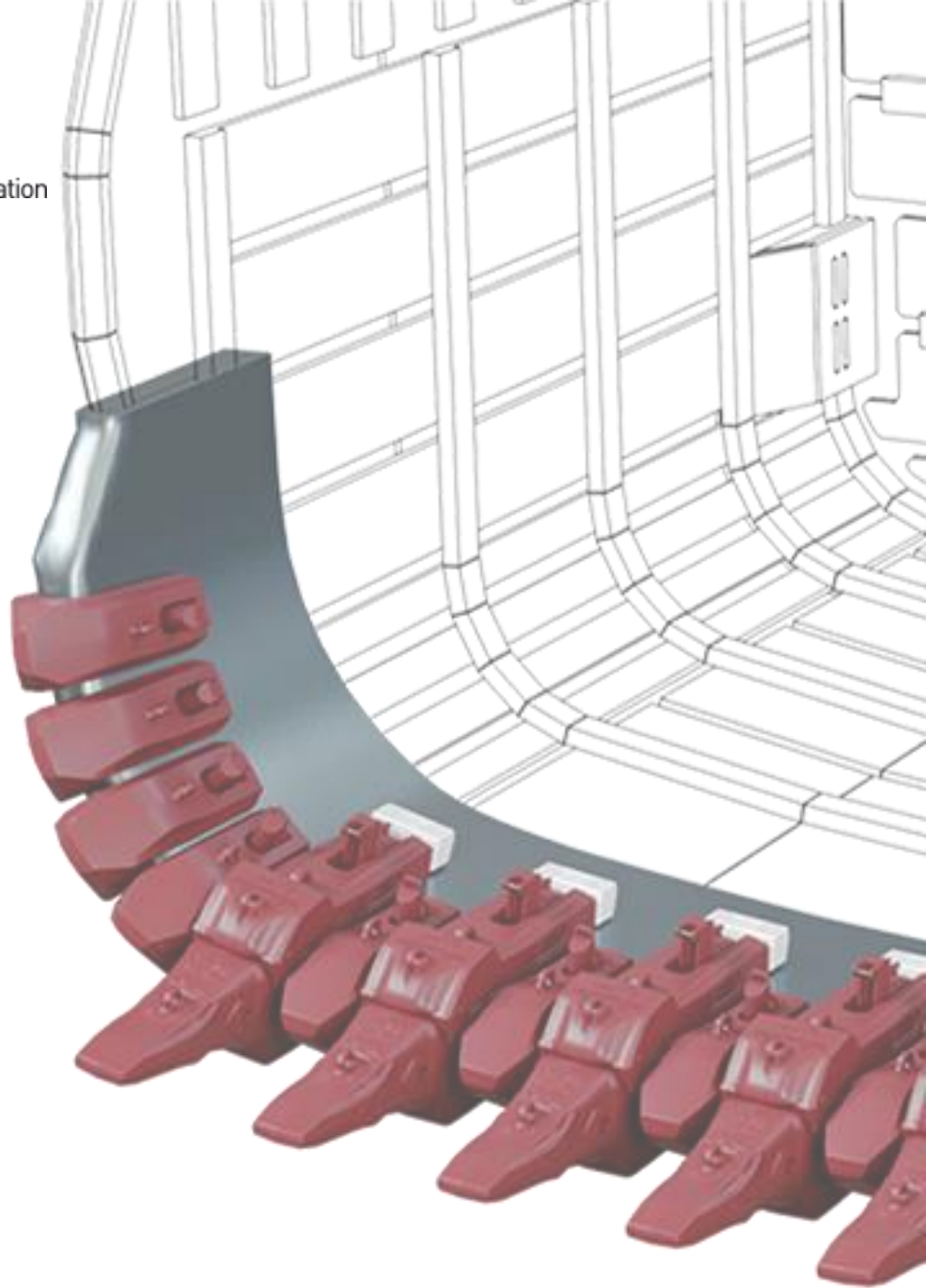




**MTG**

No limits innovation



**INS.3.6.6**

# **1.5-leg Lip Shroud + 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:



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.

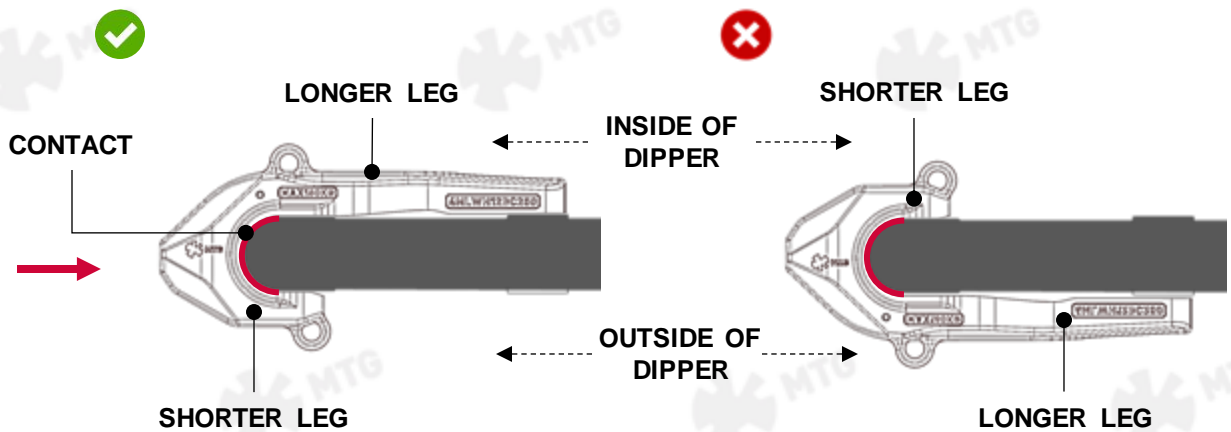
## 2. LIP SHROUD INSTALLATION

**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.

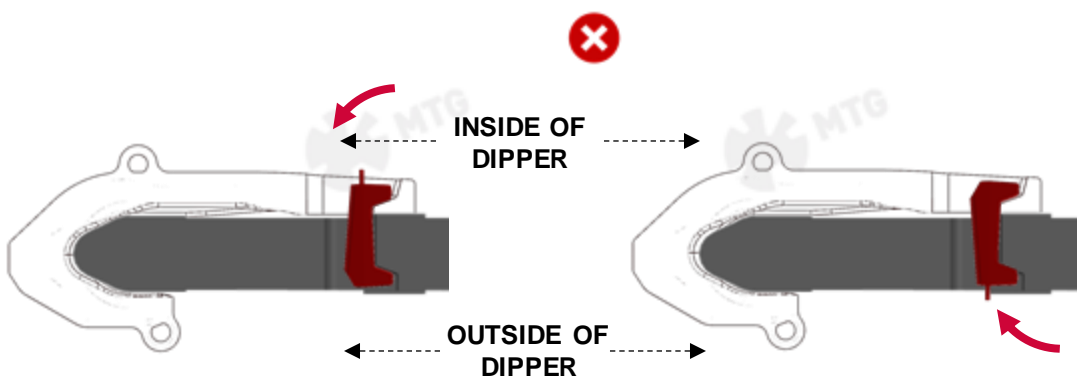


To perform the reconstruction/recalibration of lips, it is mandatory to follow the MTG reparation instructions for rope shovels which describe the proper procedures for recovering the lip geometry by using MTG gauges. Please contact [technical.services@mtg.es](mailto:technical.services@mtg.es) for further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

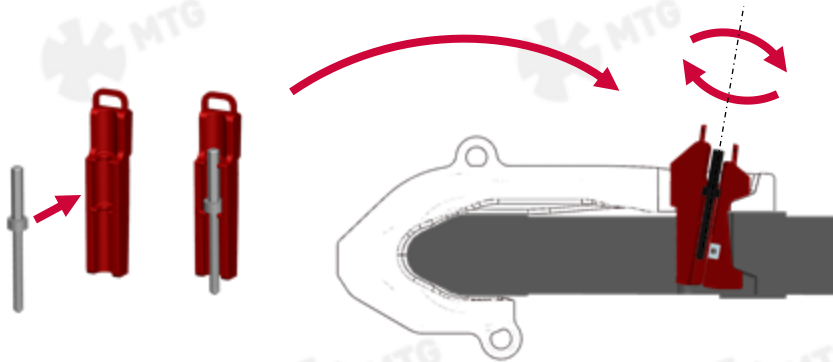
**2.1** Mount the lip shroud ensuring contact between the lip shroud and the curved edge of the lip. The thinner leg must be facing the **inside of the dipper**; the thicker leg must be facing the **outside of the dipper**.



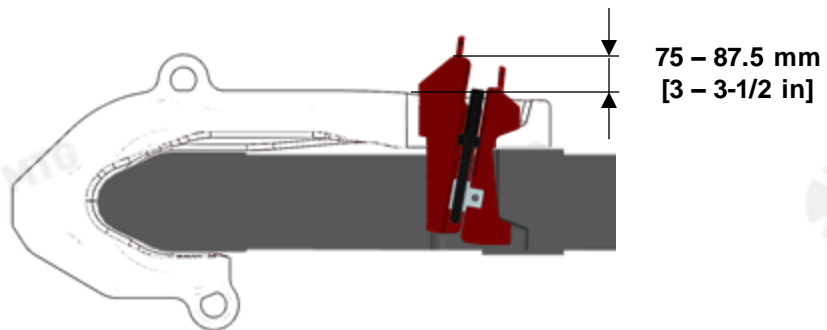
**2.2** Use the handle on the C-Clamp to install it from the **inside of the dipper**.



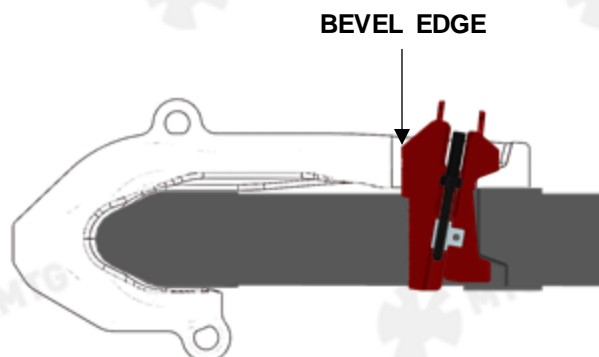
- 2.3** Insert the torque pin into the wedge and then insert the wedge and torque pin together into place between the lip and the C-Clamp as shown below. Tighten the torque pin to a torque of 540 Nm [400 lbf-ft] using an impact gun and a 19 mm [3/4"] hex socket.



- 2.4** The wedge should protrude between 75 mm and 87.5 mm [3" and 3-1/2"] above the lip shroud. If the wedge protrudes more than this, it could mean that either the lip shroud is not seated properly or that there is deformation in the lip shroud station hole which needs to be repaired.

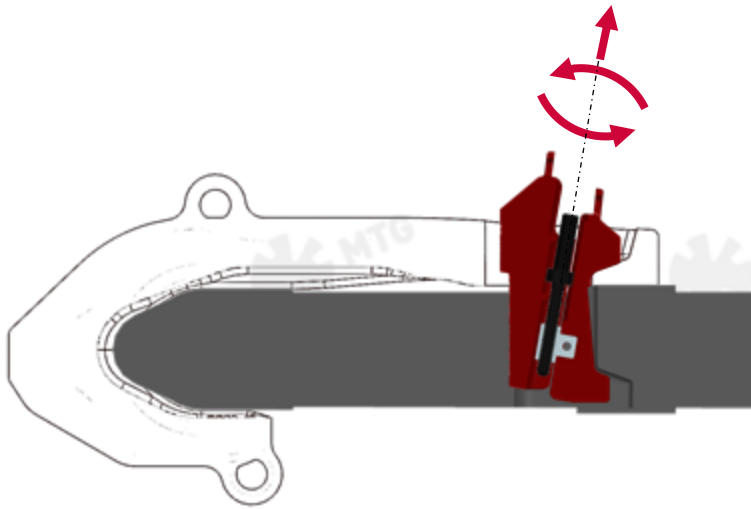


- 2.5** If after installation the bottom edge of the wedge bevel sits below the lip shroud, remove it and use an oversize wedge instead. If after installing an oversize wedge the problem persists this means that the lip needs to be rebuilt.



### 3. LIP SHROUD REMOVAL

- 3.1** Use an impact gun and a 19 mm [3/4"] hex socket to loosen the torque pin. This will cause the torque pin to pull the wedge up and thus release pressure on the locking mechanism until it is able to be removed by hand. A long socket or an extension may be required if the torque pin is sitting too low in the locking mechanism.



- 3.2** Once the wedge and torque pin are out, remove the C-Clamp by pushing it and allowing it to fall into the lip shroud station hole. The lip shroud may now be removed.



## Service Instructions

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

[www.mtgcorp.com/manuals](http://www.mtgcorp.com/manuals)

Please contact Technical Services in case of questions:

[technical.services@mtg.es](mailto:technical.services@mtg.es)



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