

Installation of bolt-on adapters

Work safely

All staff that carry out maintenance work should be duly protected by using the right equipment: helmet, protective goggles, gloves and boots.

General procedures

- 1.- Adapters should fit into the blade easily; they should not be forced in.
- 2.- A maximum of 3 mm play may be permitted between the adapter leg and the blade of the bucket.
- 3.- Once they have been fitted into the blade and when the bolts have been installed, the adapters should make frontal contact with the edge or with the bevel of the blade, depending on the design of the adapter (fig. 1). This ensures that when operating, the bolts are not subject to blows or shearing loads that could cause breakage, which in turn would lead to the breakage of the adapter legs.
- 4.- The bolts should be installed by fitting their heads into the corresponding housing in the adapters (fig. 2).
- 5.- Tighten the bolts alternatively, thus helping the adapter settle. Then apply the final torque, first on the rear bolt and then on the front one. Tightening in the correct sequence is important as the front bolt can become loose if it is given the final torque first.

IMPORTANT: Tighten the bolts again after approximately 4 hours of use.

- 6.- From time to time check that the bolts are tight. Incorrect tightening of the bolt to the adapters can lead to faults in hard applications.
- 7.- Check that the blade is not worn in the place where the adapters go. Use high-quality bolts that do not give.
- 8.- Check that the wear in the under part does not affect the head of the bolt to the extent that the square part of the countersink bit appears and that the lower leg of the adapter does not get too loose.
- 9.- Try to use weld adapters when the kind of work the machine needs to do involves great lateral efforts.

TORQUE APPLIED in N.m

Diameter of bolt	Without lubricating	Lubricated
5/8" (16mm)	300+/-15	225+/-10
3/4" (19mm)	535+/-25	400 +/-20
7/8" (22mm)	860 +/-40	650 +/-30
1" (25mm)	1295 +/-60	1935 +/-90
1 1/4" (32 mm)	2590 +/-125	1935 +/-90

