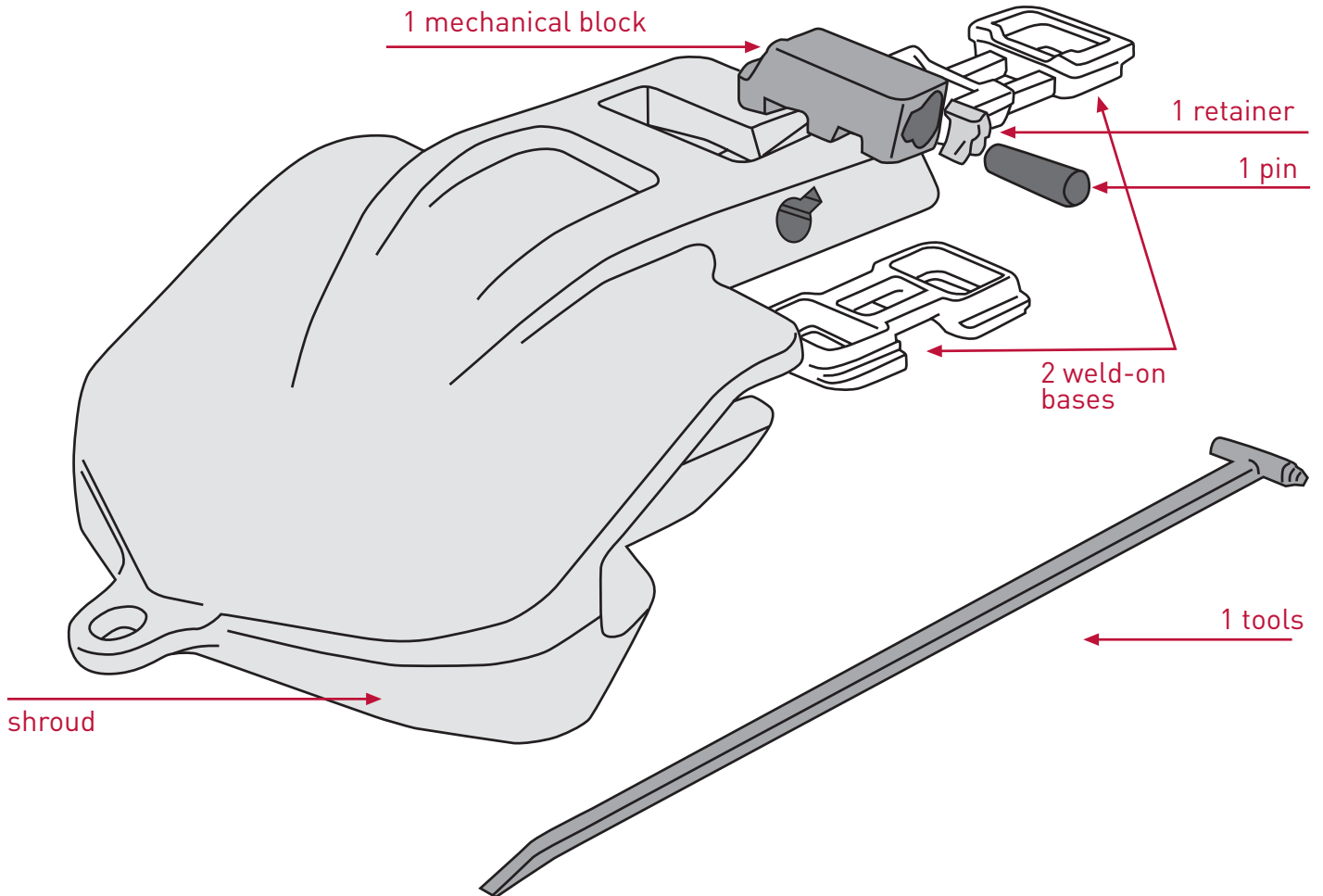
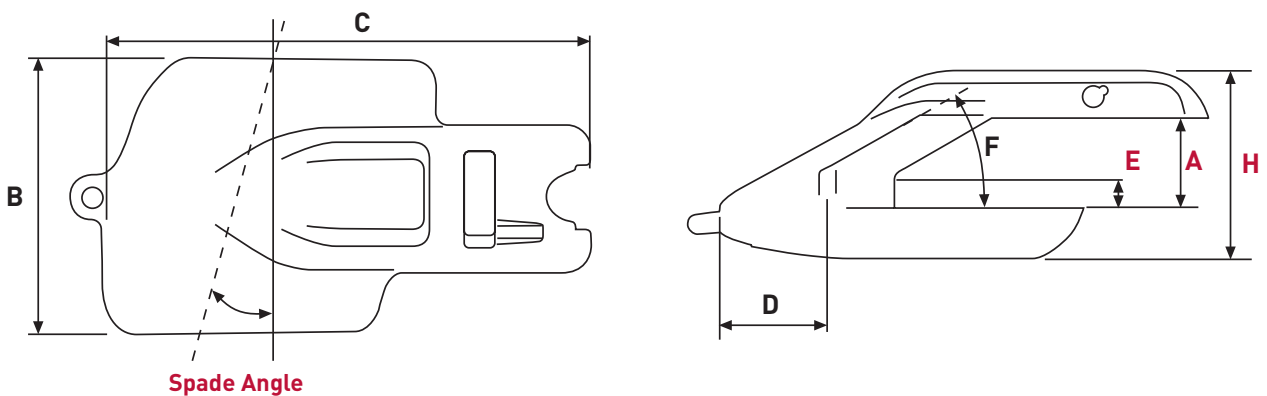


Welding Instructions

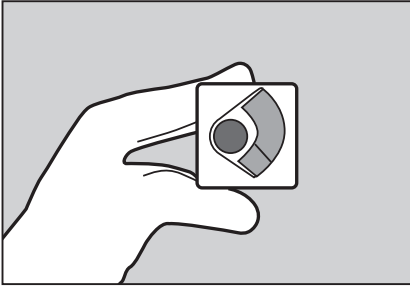
Components of the System



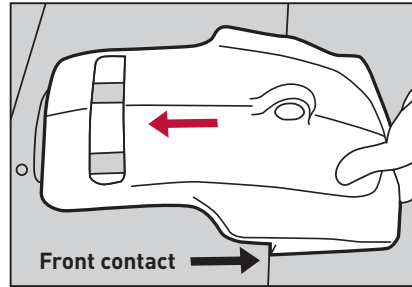
Check blade dimensions "E", "A" and Spade angle



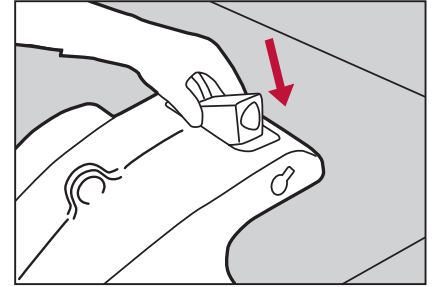
Welding Instructions



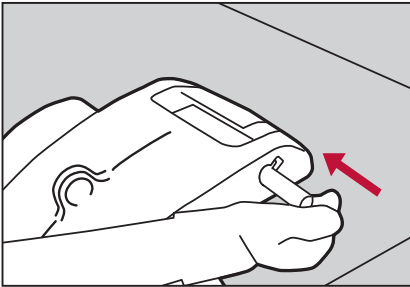
Place the retainer in the block



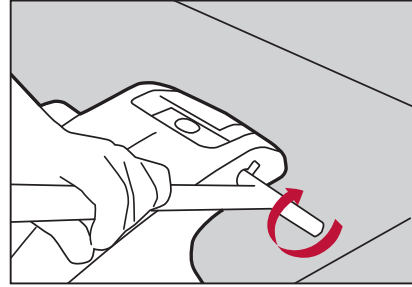
Place one base on the top of the blade
Place the shroud on the blade
(the shroud **MUST BE IN CONTACT** with the **FRONTAL PART OF THE BLADE'S LEVEL**)



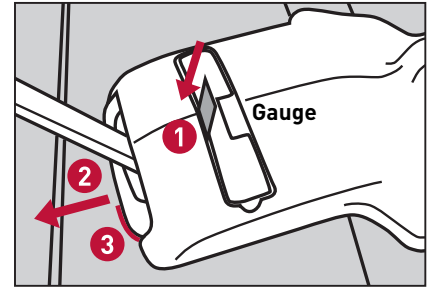
Place the block



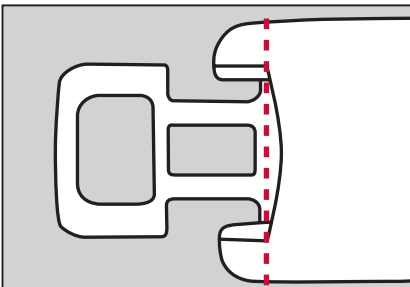
Insert the pin



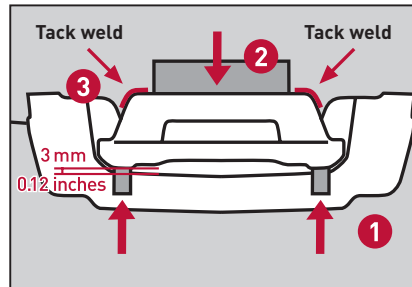
Turn the pin clockwise



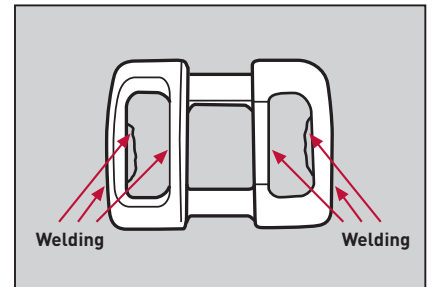
Keeping the frontal contact all the time:
1. Insert 1 mm / 0.04 inches thickness plate/
gauge at the back of the block
2. Push the base towards the back
of the bucket
3. Make several tacks welds on the back of
the base



Place the second base in the bottom leg of
the shroud up to the line shown



1. Insert two 3 mm / 0.12 inches thickness
gauges / plates (long ones) between the
shroud and the base (see drawing)
2. Insert a wedge between the blade and the
base that ensures the 3 mm / 0.12 inches
gap.
3. Keeping the frontal contact, make several
tacks welds on the back of the base



Disassemble the shroud, turning the pin
counter clockwise, complete the welding
(only in areas shown) and keep a constant
distance between the base and the blade
Follow general welding instructions

Weldable bases for mechanical shrouds

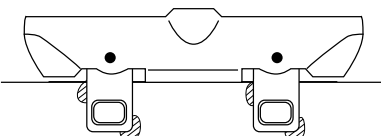
In addition to the recommendations in the general instructions...

Procedure.

- Place the assembled unit (weldable bases and shrouds) in the desired position at the side of the bucket and do some spot welds at the base so as to fix them in their correct position.
- Remove the shrouds and retainers.

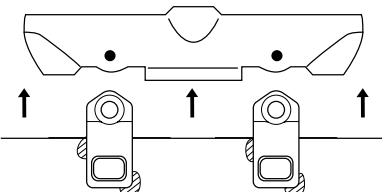
- Weld around the edge of the base and also the inside of the hole. It is very important to fully weld all the entire chamfered edge, especially inside the bucket. This weld bead on the inside of the bucket plays a vital role in ensuring that the MTGSystems ProMet functions correctly.

Attachment Instructions
To weld the bases, follow the general welding instructions.

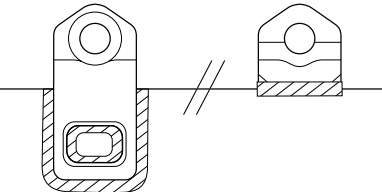


Welding Points

Place the unit in the correct position and spot weld the bases



Remove the protector and the retainers



External Bucket Welding **Internal Bucket Welding**

Weld around the base and inside the hole