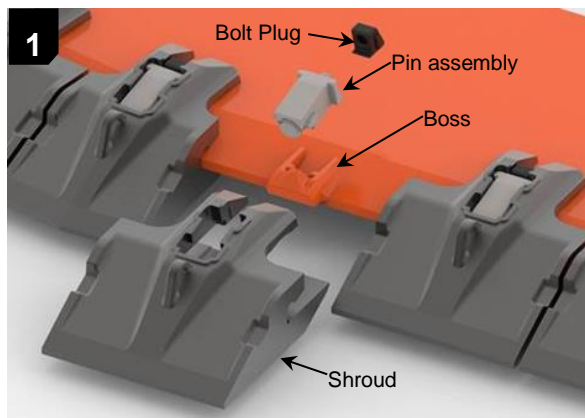


# MAKO™ 50 mm SHROUDS INSTALLATION & MAINTENANCE

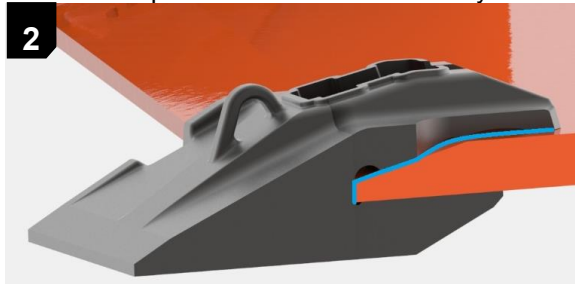
SHARK™ GROUND ENGAGING TOOLS

## 1.0. INSTALLATION



The 50 mm MAKO™ Series Shroud assembly consists of four components, labelled above.

Before installing or replacing Shrouds, ensure the bucket lip is clean and free from any debris.



With the use of a mechanical aid, raise the shroud into a position to slide the rear of the shroud up and over the Boss and push home, ensuring the highlighted surfaces are in contact with the corresponding faces on the lip. Ensure the front edge of the tooth are inline.

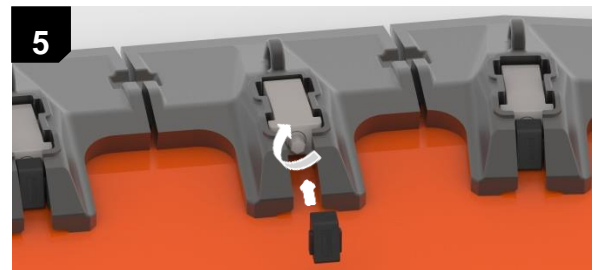


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Ensure the Piston bearing surface is positioned 5 mm forward of the front surface of the housing as shown in Image-3. Otherwise, adjust the piston by rotating the Bolt head.



Insert the Pin assembly downward into the cavity on top leg of Shroud. Ensure the Locking assembly is securely located in the boss recess.



Access the hexagonal Bolt head at the rear of shroud. Turn clockwise to tighten, using a torque wrench with a 19 mm (or ¾") socket to achieve 700 Nm (516 ft.lb). During tightening, tap the shrouds at the front-top edge using a well-dressed copper hammer to assist parts to align correctly.

Insert Bolt Plug onto the external hex head of the Bolt.

## 2.0. MAINTENANCE

To aid in the bedding in process of the casting on the lip after initial installation, the system requires re-tensioning after each shift for a cycle of three shifts.

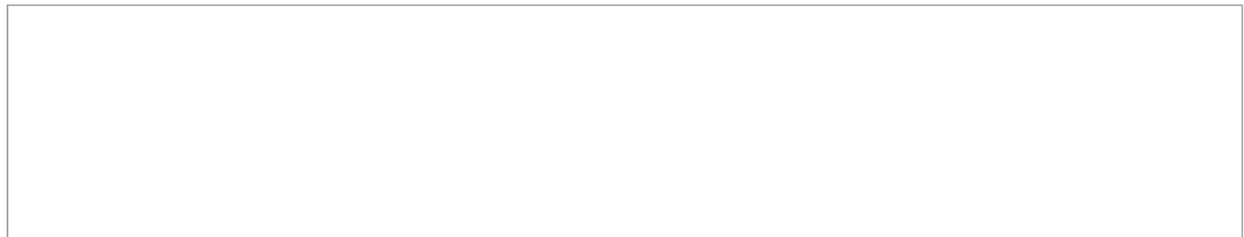
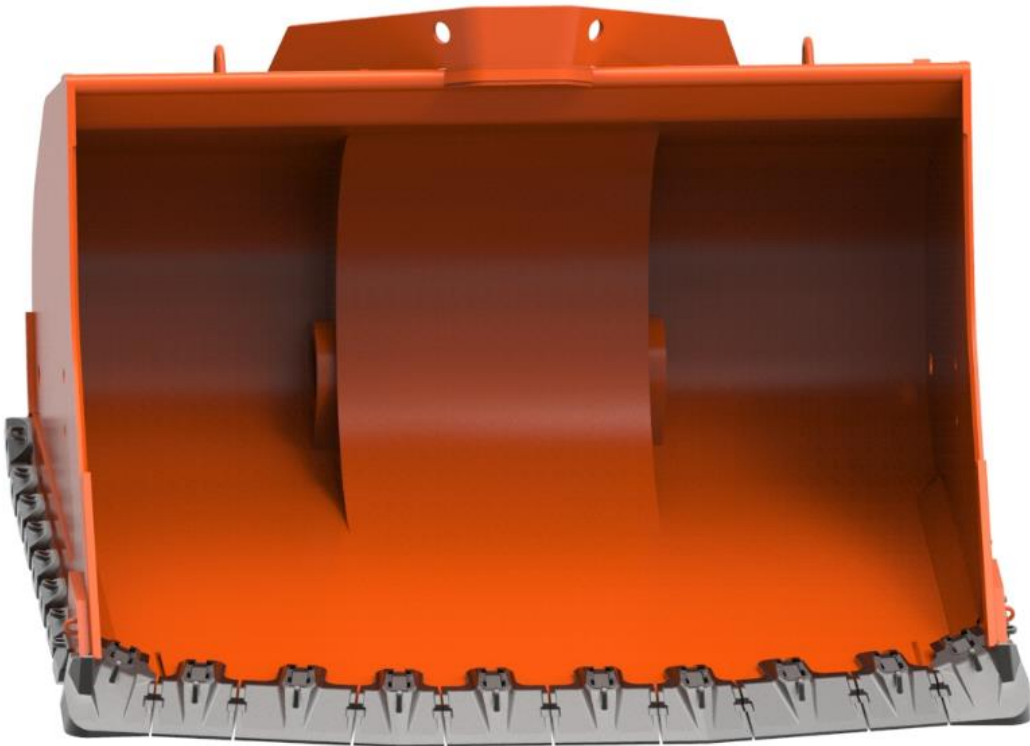
For re-tensioning, remove the Bolt Plug and re-tension the Bolt to 700 Nm (516 ft.lb).

After initial re-tightening period, through observation, check shrouds are not loose and re-tension periodically.

**Ensure to wear appropriate workshop and mine site specific Personal Protective Equipment at all times when working with the MAKO™ product.**

**Under NO circumstances should hardened hammers be used on MAKO™ Shrouds.**

**If required, a well-dressed Copper Hammer may be used.**



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