

Head, adapter and blade has to pre-install as shown on pic 1.



Pic 1 Assembly unit

### Adapter assembly

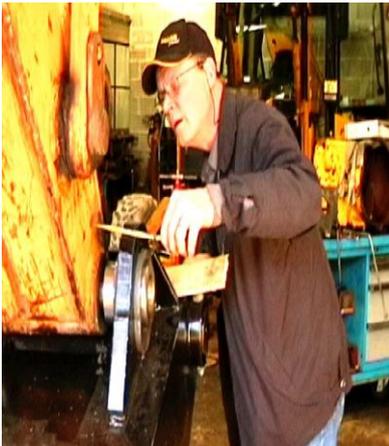
Shaft and lock-doughnuts has to installed between adapter ears.



Pic 2 Adapter and head assembly

The excavator stick will be driven between mounted adapter ears.

The lock ring and shaft have to be positioned in such a way that the stick is centered on the adapter. Make sure you have the appropriate side play between stick and adapter. The shims can be added after locking ring is welded.



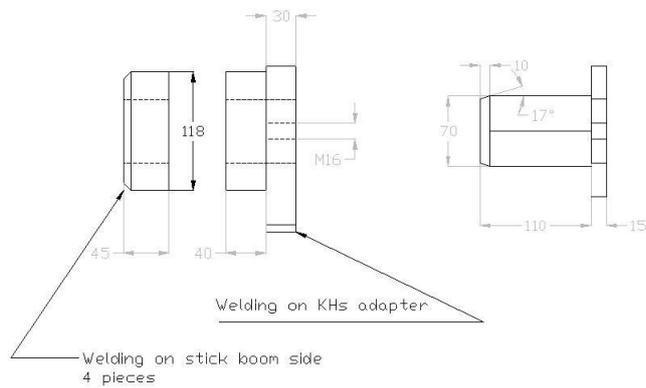
Pic 3: Measuring the mid line of adapter.

Adapter will be raised and rotated against sticks booms under plate. Care must be taken that the Adapter and Stick are properly aligned.



Pic 4 Adapter rotating / lifting

The doughnuts  $\text{Ø}118/\text{ø}70$  and conjunction pin –sleeve/plate will be positioned and tack welded on stick boom sides and adapter back plate. After all four pieces are positioned (tag welded) they have to be welded properly on stick boom sides and adapter back.



Pic 5. Support pin/bushing-set for the adapter. (Required weldings 4 sets.)

**The head assembly**

Shaft and lock-doughnuts has to installed between H-link and head ears



Pic 6. Head ear assembly.

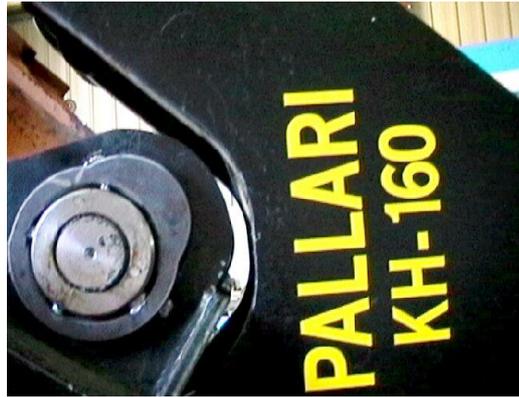
The H-link will be positioned between KH`s head ears. Ears and their counter tips should shorten so bucket piston movement reach proper positions.

The sideways movement can be prevented with lock ring and plate ( 50mm thick) positioning, The shim-plates can be used in final adjustment.

The mounting plates should be assembled so that H-link will lie in the mid line of the head. The free gap has to be justified like the Adapter.

When the bucket cylinder is fully contracted there must be a space between Head and Adapter ears. This should be no less than 10 mm. On both limit positions you have to assure the head doesn't hit the stick in either position.

The free gap between adapter ears and head should be about 10 mm.



Pic 7 Required gap between head and adapter..

The free gap can be obtained by moving the sleeves in long (oval) opening to appropriate point.

After assembly ensure proper operation and clearances. Then complete the final welding. After welding install cylinder hoses and re-paint welded parts.



After welding install cylinder hoses and re-paint welded parts.

Hydraulic connections, max pressure settings are (5000 PSI) 320 bar. Max flow setting is 170 l/min. in and out. Cylinder fitting sizes are R 3/4" inner thread.