



MTG

No limits innovation



INS.3.5.4

RIPMET Shroud

Installation procedure

DISCLAIMER

© MTG, all rights reserved

The brands identified with an asterisk do not belong to METALOGENIA S.A. and this organization refers to them only to identify the destination of its products, without there being any relationship between METALOGENIA S.A. and the legitimate owners of any such brands.

Copy right: It is strictly forbidden for any person not belonging to MTG to distribute all or any part of the material set out in this document unless they are authorized to do so.

Liability: To ensure the correct use and handling of the MTG products without risk, please carefully read the corresponding service instructions set out on the MTG website. MTG will not be held liable for damages, loss, injury, or death arising from incorrect use or failure to heed the provisions of this guide. Similarly, MTG will not be held liable for damages caused due to the faulty installation or handling of its products. MTG likewise declines all liability for recommendations related to the use or handling of MTG products set out in documents not expressly authorized by MTG.

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. WELDING

Following is a quick reference on consumables that can be used to weld MTG products. For a complete reference on welding procedures, refer to the document entitled "General welding recommendations".

WELDING UNALLOYED FILLER CONSUMABLES

PROCESS	EN CLASS	AWS CLASS
SMAW	EN ISO 2560-S E42X	E70X ACCORDING TO A5.1 OR EQUIVALENT UNDER A5.5
	EN ISO 14341-A G42X	E70C-X ACCORDING TO A5.18 OR EQUIVALENT UNDER A5.28
GMAW	EN ISO 14341-A G46X	E70S-X ACCORDING TO A5.18 OR EQUIVALENT UNDER A5.28
	EN ISO 16834-A T42X	E7XT-X ACCORDING TO A5.20 OR EQUIVALENT UNDER A5.29

WELDING AUSTENITIC STAINLESS FILLER CONSUMABLES

PROCESS	AWS CLASS
SMAW	E307-X ACCORDING TO A5.4
	ER307T-X ACCORDING TO A5.22
GMAW	ER307 ACCORDING TO A5.9
	307-X ACCORDING TO A5.22

NOTE: "X" MAY STAND FOR ONE OR SEVERAL CHARACTERS

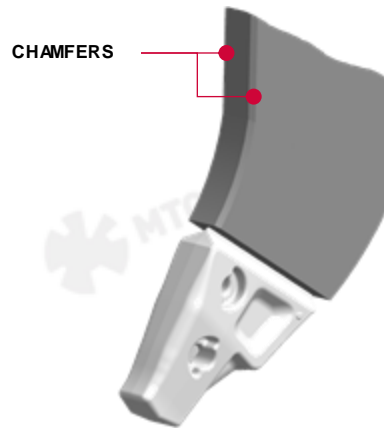
3. IMPORTANT

Please read the entire document before starting any operation as there may be some steps that may require previous checks/operations.

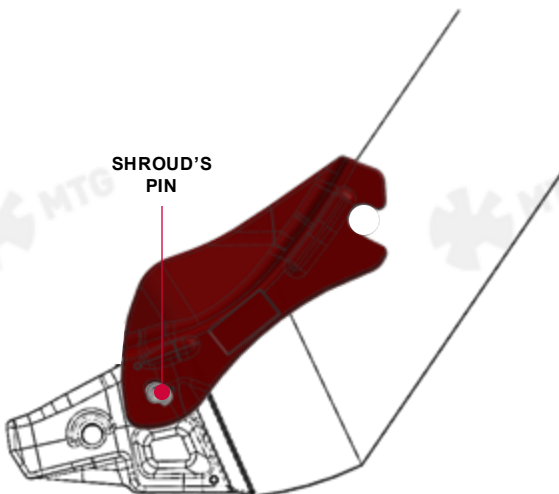


4. WELD-ON BASES INSTALLATION PROCEDURE

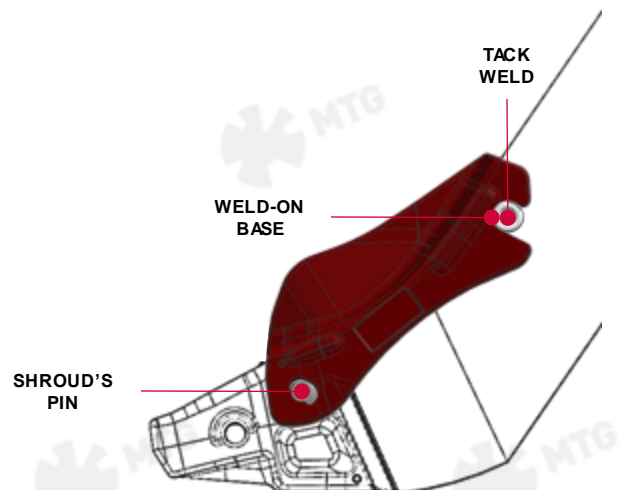
- 4.1** Prior to the installation of the shroud, two chamfers shall be performed on the edges of the shank by means of grinding. The dimensions of those chamfers must be 10x10mm (3/8" x 3/8") and its length shall be enough to cover the entire shroud length.



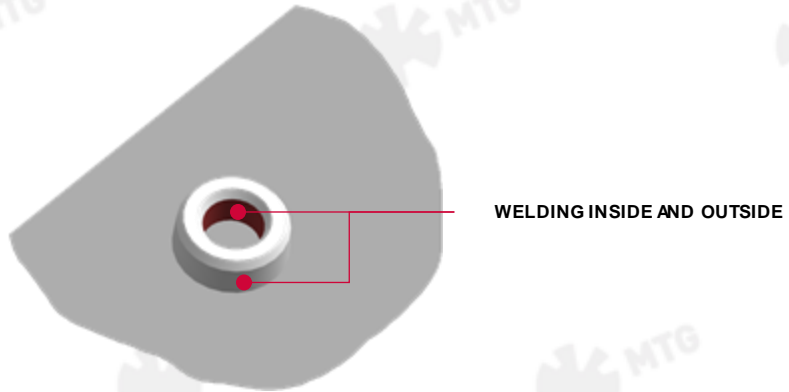
- 4.2** Insert the retainer into the nose cavity. Place the shroud, and then insert the pin. Lock the shroud by turning the pin 90° clockwise.



- 4.3** Make sure that the protector is in full contact with the shank frontal surface, then position the weld-on bases (both sides) as the picture shows. Then preheat the bases and shank to a temperature between 175°C and 200°C (347°F and 392°F) and tack weld each base to the shank.



- 4.4** Remove the protector and finish the welding, both inside and outside the base. The welding grooves of the weld-on bases must be filled, not exceeding 3.2mm above them. The welding of the outside of the base must be flush to the base to avoid mounting problems with the shroud.

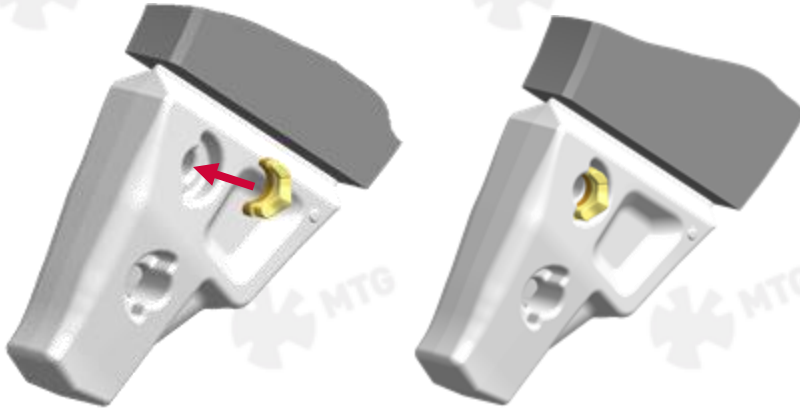


- 4.5** Once the welding of bases (both sides) has been completed, install the protector again to check that there is nothing in the welding that impedes its mounting.

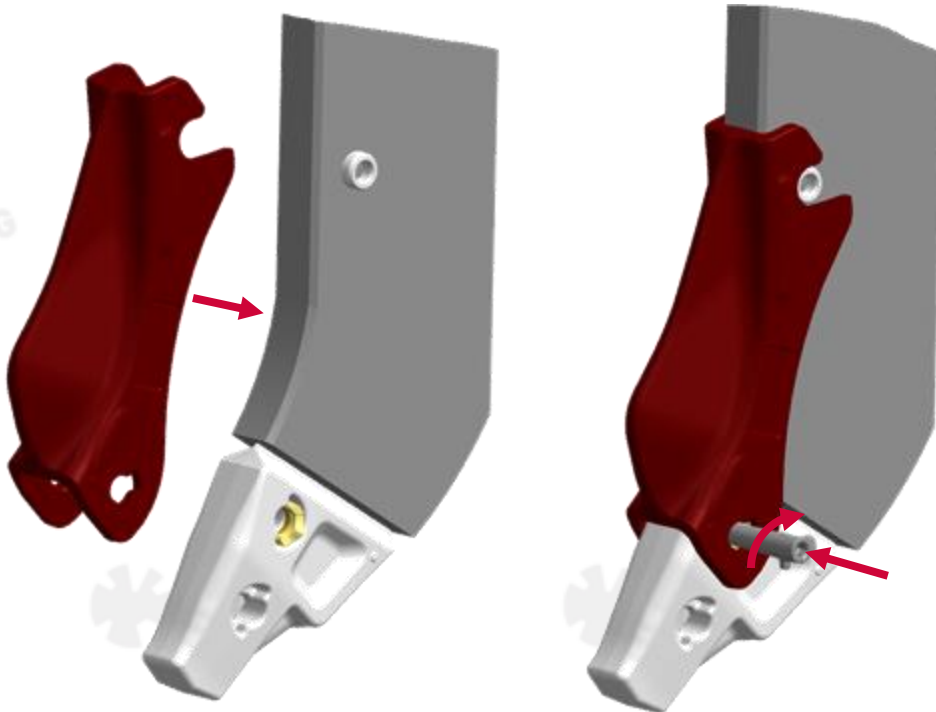
Remove the shroud and proceed with a visual and dye penetrant or magnetic particles inspection of the welds in search of cracks.

5. SHROUD INSTALLATION PROCEDURE

- 5.1** Insert the retainer into the shroud nose housing.



- 4.2** Using the weld-on bases as a rotation point, support the shroud on the bases and rotate it through the nose with the help of a crane. Once the shroud has reached the nose, insert the pin and rotate it 90° clockwise to fix the shroud position.

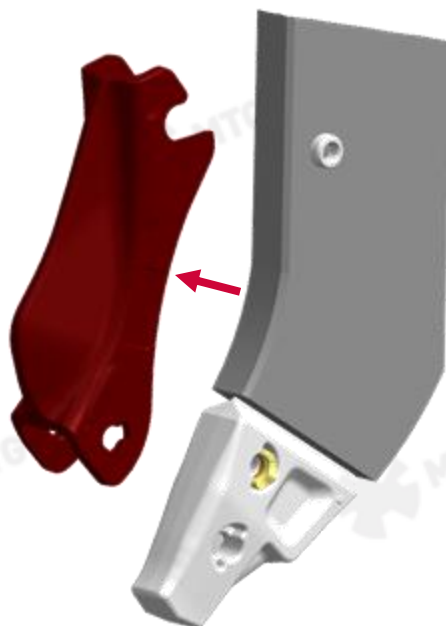


6. SHROUD REMOVAL PROCEDURE

- 6.1** Clean out all the fines stuck on the pin's keyhole and turn it counterclockwise using the removal tool. When the pin is unlocked, extract it by slightly hitting the opposite side of the keyhole.



- 6.2** Remove the shroud.





Service Instructions

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

www.mtgcorp.com/manuals

Please contact Technical Services in case of questions:

technical.services@mtg.es



MTG HEADQUARTERS

Carrer d'Àvila, 45
08005 Barcelona (Spain)
(+34) 93 741 70 00
info@mtg.es

MTG NORTH AMERICA

4740 Consulate Plaza Drive
Houston, TX 77032 (USA)
+1 (281) 872 1500
info@mtgcorp.us

MTG AUSTRALIA

16 – 18 Thorpe Close
Welshpool, WA, 6106 (AUS)
+61 8 6248 6513
Info.australia@mtg.es