

## TURNKEY® Wing Shrouds Installation and Removal, TURNKEY® Range. ®.

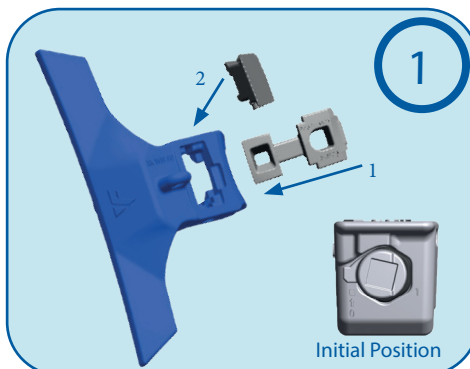
### Assembly instructions



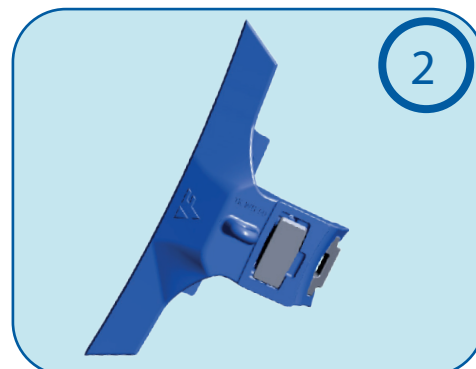
**Equipment :** Use the proper removal tool suitable for the TURNKEY® Shrouds size you will assembly .

Always work safely and wear your safety equipment (hard hat, steel-toed shoes, gloves, safety glasses).

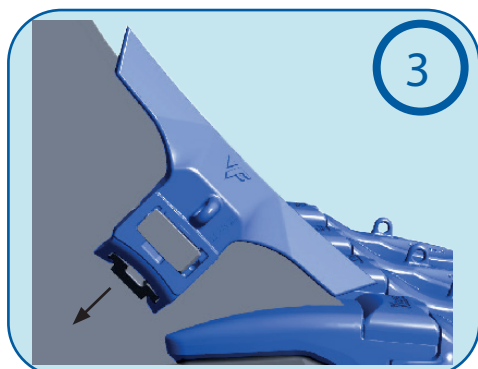
Keep bystanders out of the way.



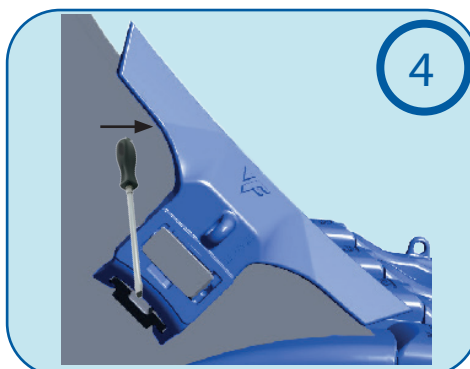
**Pre-Assembling :** Pre-assemble the 3 parts : Adapter, shroud and pin.



**Correct assembly :** Before installation on the blade, the shroud complete assembly should look like the above picture.



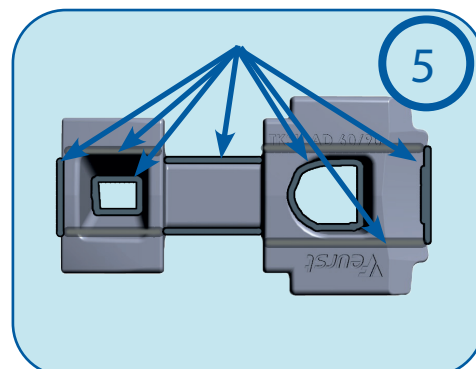
**Adapter shroud positioning:** Raise the bucket to an angle of approximately 30°. Position the shroud assembly on the Wing. Position adapter on wing, once the adapter is correctly located.



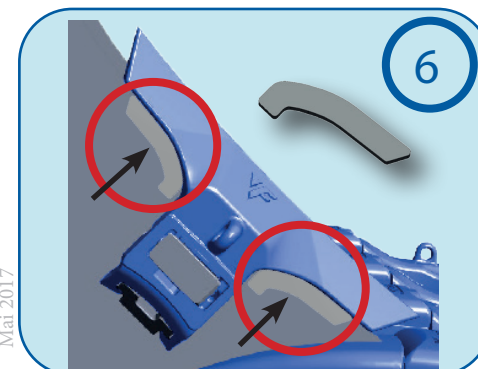
**Welding instruction (step 1) :**

After having fixed the shroud adapter, please push the base towards the back of the bucket using a screw driver and please make 1 or 2 tacks welding spots to tack weld the adapter on the blade.

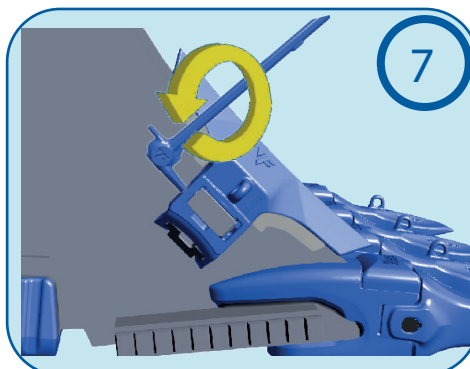
You'll complete welding after shroud removal.



**Welding instructions (step 2) :** Once shroud adapter has been properly oriented and fixed by welding spots, remove pin and shroud. Heat the adapter at 175°-200° C and weld the areas indicated above.

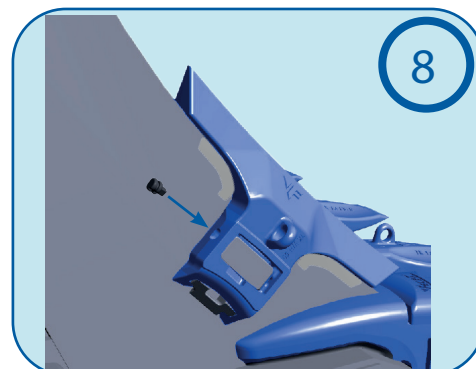


**Instruction de soudure (étape 3) :** After having installed and locked the pin, we will recommend welding shroud supports, just to absorb the forces on the wing.



**Pin clamping :** Re-assemble the shroud and pin on the adapter

Once the pin has been correctly installed, take TK OD® tool to screw the pin. Make sure to screwing and then make a 180° counterclockwise pin turn. Once the pin rotation is fully completed, the pin cannot be turned any further.



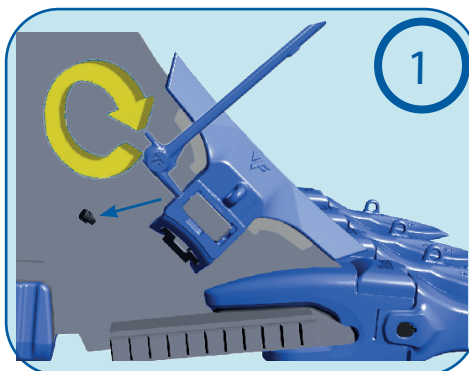
**Protective caps installation :** On both shrouds sides, insert the protective caps to avoid fines to fill up the pin hole.

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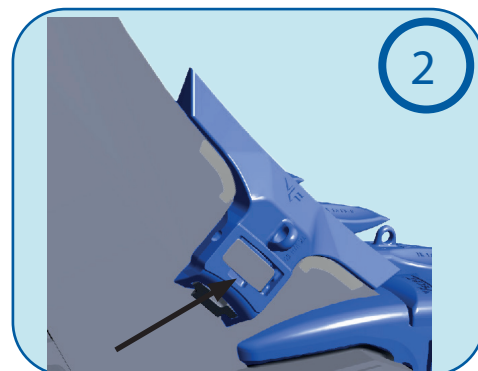
### Disassembly instructions



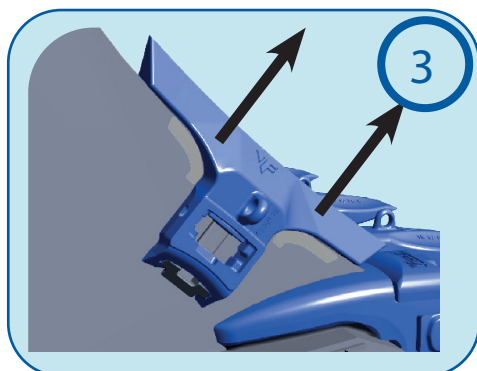
**Equipment :** A removal tool adapted to the size required to disassembly TURNKEY ® shrouds. Always work safely and wear your safety equipment (hard hat, steel-toed shoes, gloves, safety glasses).  
Keep bystanders out of the way.



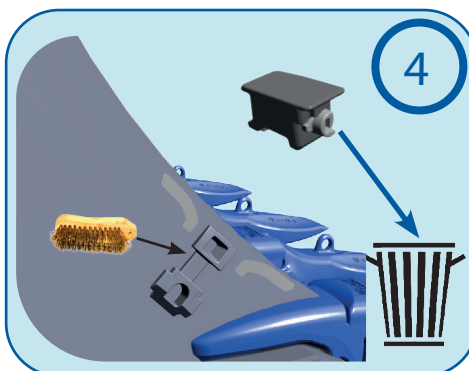
**Pin unlocking :** Remove the protective cap and insert the TK OD® tool into the pin, unlock the pin with a 180° clockwise turn.



**Pin removal :** Using TK OD® tool, remove the pin from the shroud/sleeve. You can also remove the pin manually.



**Shroud removal :** Once the pin is removed, you can easily remove the shroud



**Shroud adapter cleaning :** Clean up the shroud adapter and the pin housing.  
The adapter is ready to fitted with another new shroud.  
We advise to use a new pin for next teeth installation.

