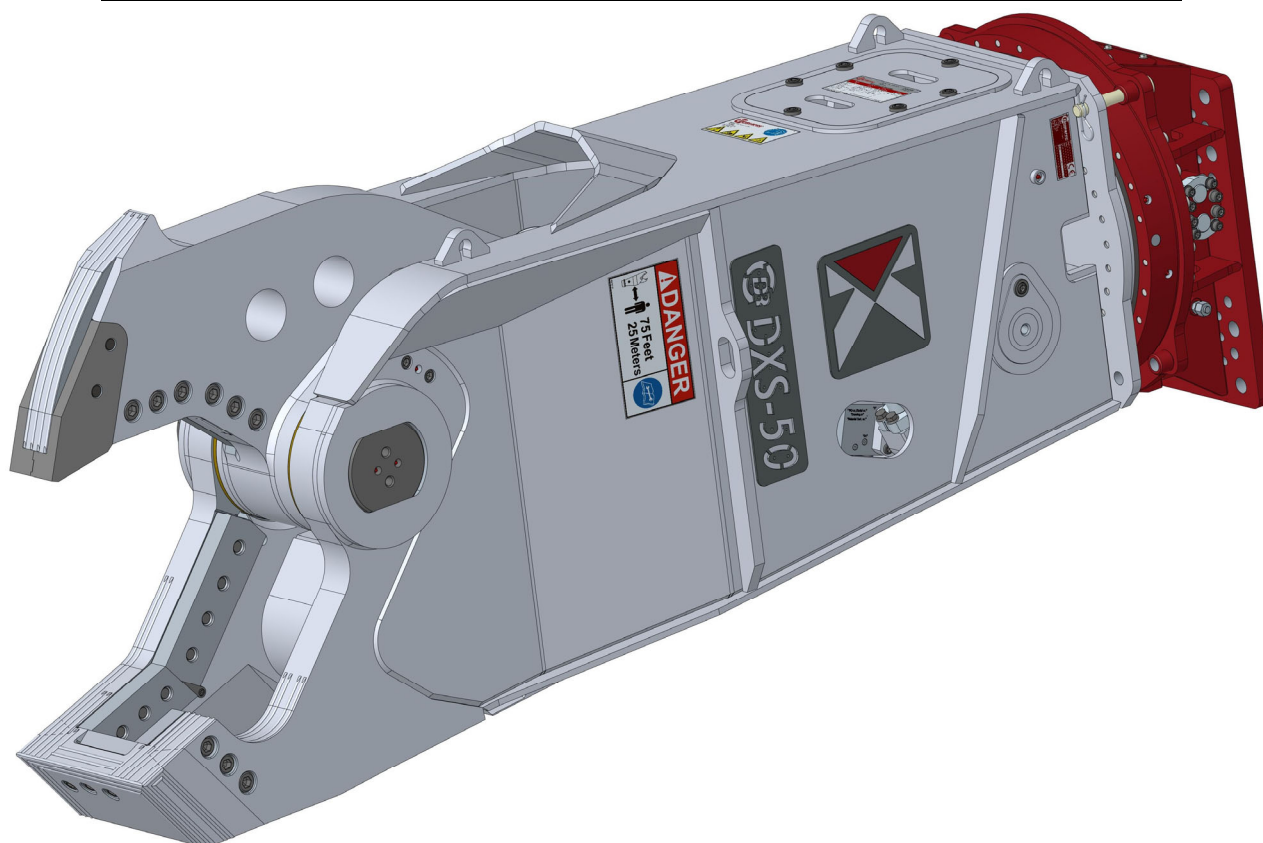




Partsbook
for
Rotatable shear
DXS-50-A

Product	Part Number	Ref.
DXS-50-A Serie 5	DXS050E546BAB6	



Partsbook_dxs050e546bab6-c_2022-06-01.docx

June 2022

Demarec Demolition and Recycling Equipment BV

De Hork 32, 5431 NS Cuijk Netherlands

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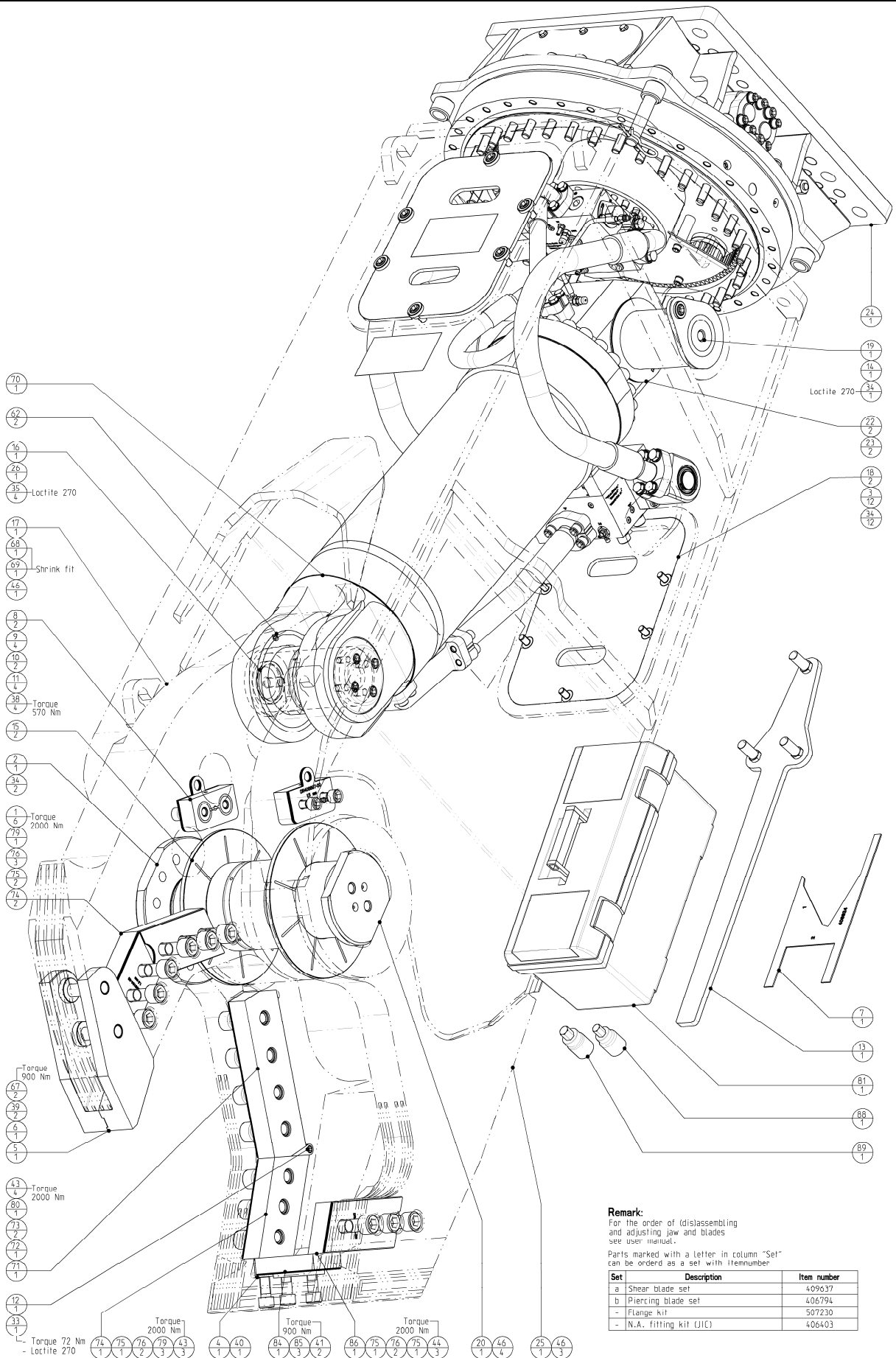
INTERNET
E-MAIL

www.demarec.com
info@demarec.com

Rotatable Shear

Page	1	of	38
Date	June 2022		
Product type	DXS-50-A		
Number	DXS050E546BAB6-C		

Housing GP



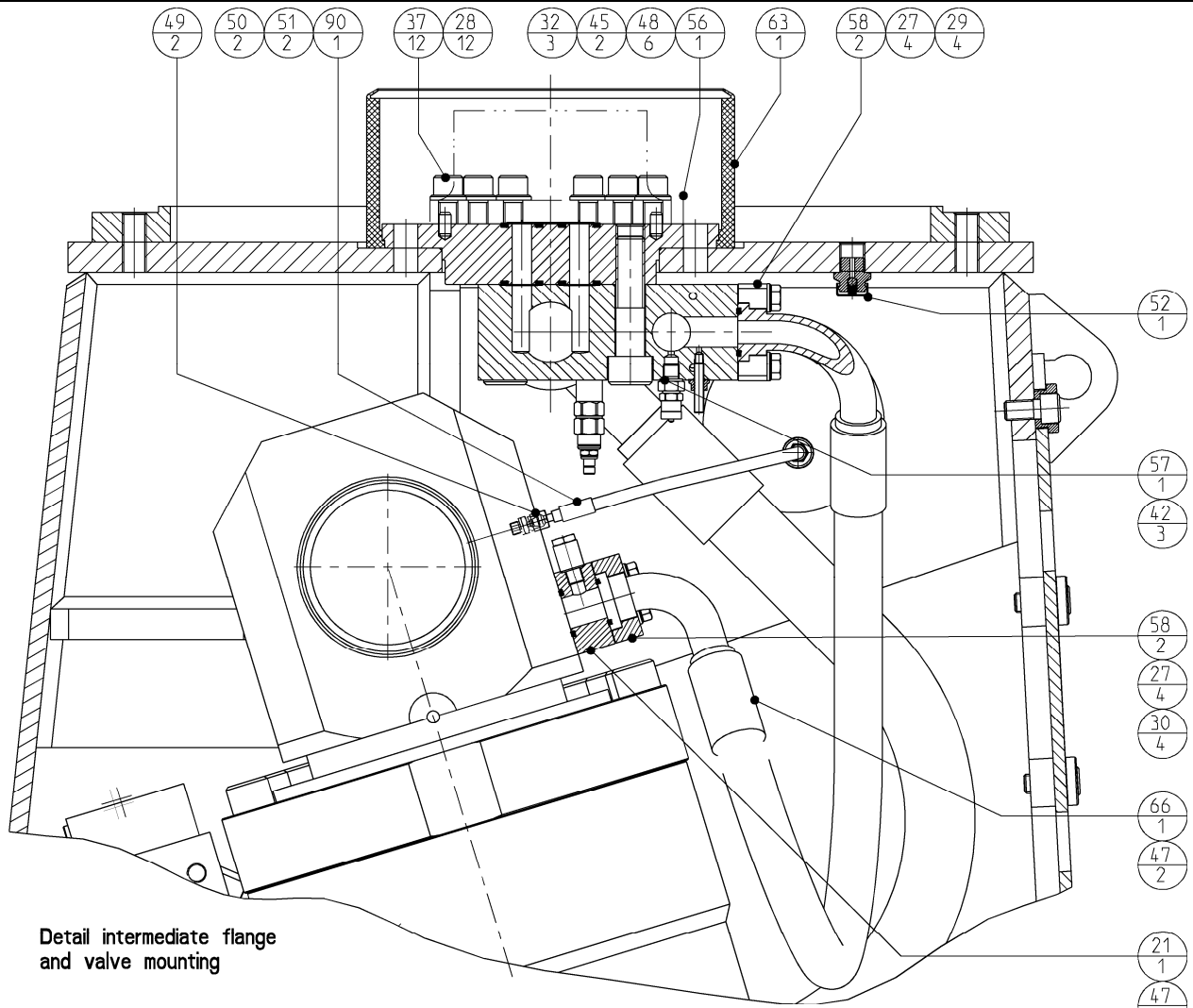
Remark:
For the order of (dis)assembling and adjusting jaw and blades see user manual.
Parts marked with a letter in column "Set" can be ordered as a set with item number

Set	Description	Item number
a	Shear blade set	409637
b	Piercing blade set	406794
-	Flange kit	507230
-	N.A. fitting kit (UIC)	406403

Rotatable Shear

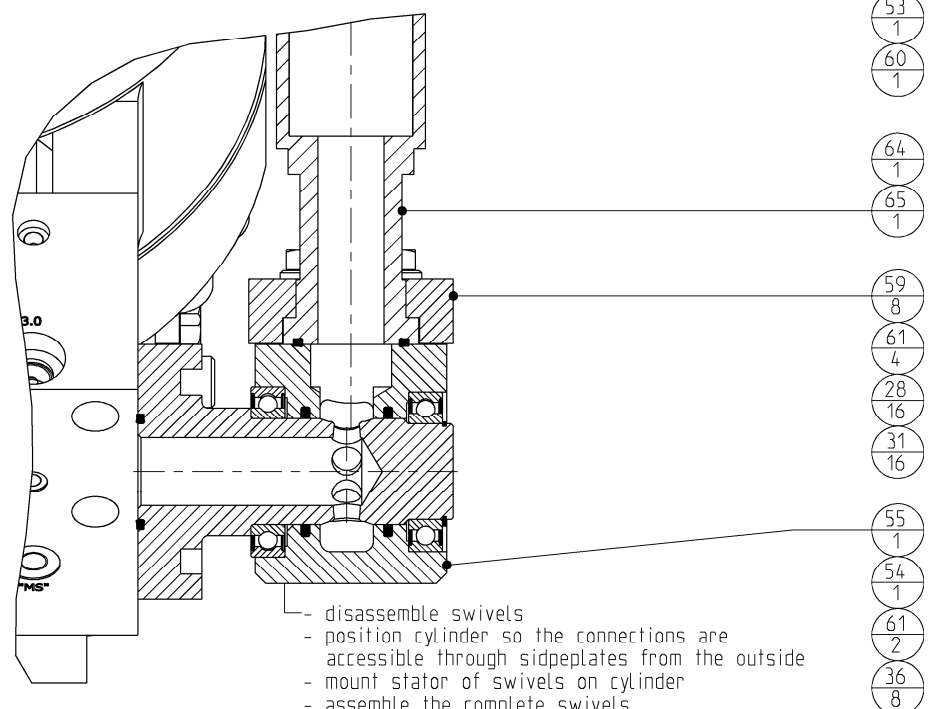
Page	2	of	38
Date	June 2022		
Product type	DXS-50-A		
Number	DXS050E546BAB6-C		

Housing GP



Detail intermediate flange and valve mounting

Detail swivels on cylinder



- disassemble swivels
- position cylinder so the connections are accessible through sideplates from the outside
- mount stator of swivels on cylinder
- assemble the complete swivels

Rotatable Shear

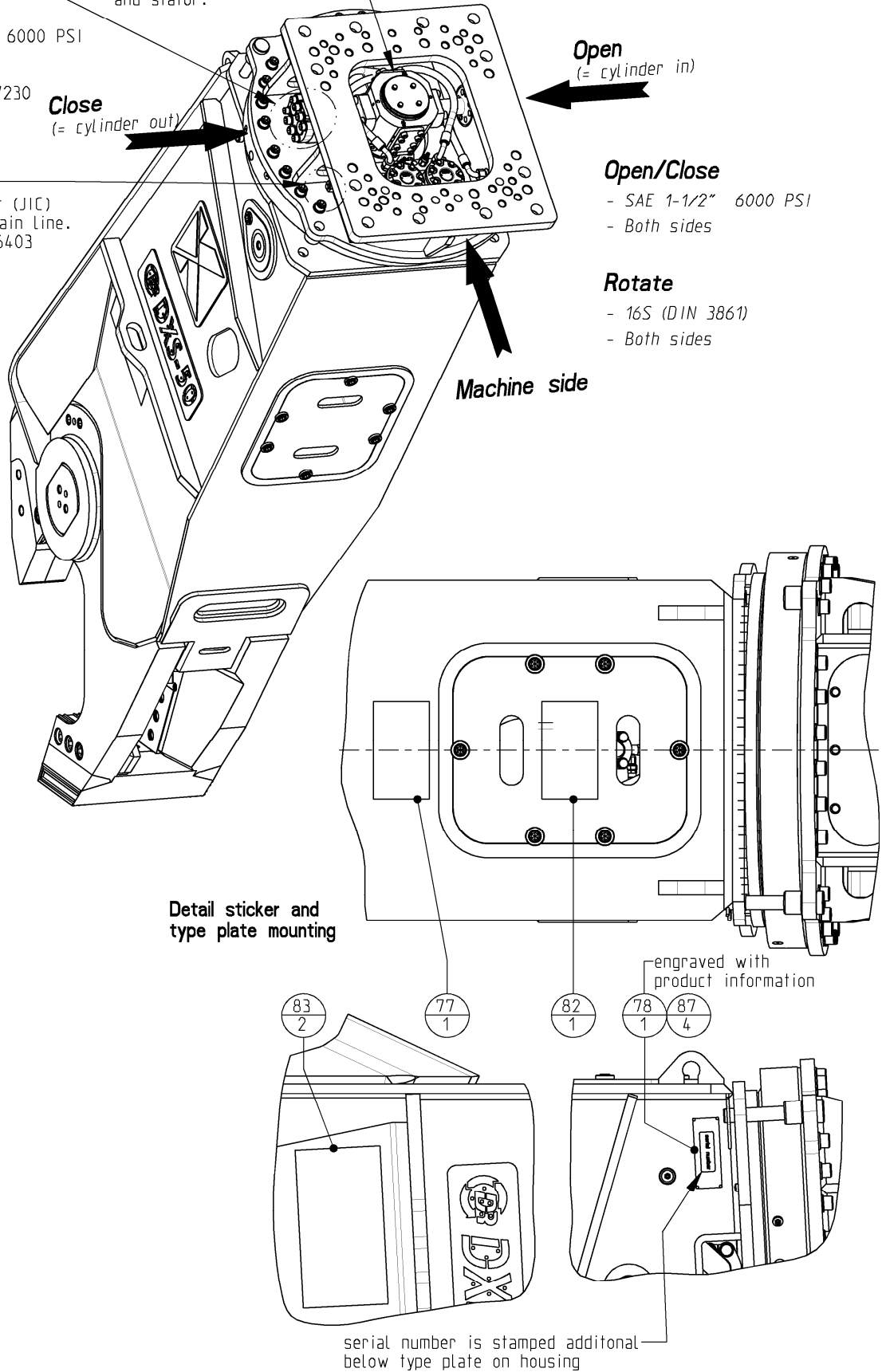
Page	3	of	38
Date	June 2022		
Product type	DXS-50-A		
Number	DXS050E546BAB6-C		

Housing GP

Caution;
 - Take care of position of swivel-housing O + C and stator.

Optional;
 Connection kit:
 - 2x SAE 1-1/4" 6000 PSI
 - both sides
 - for open/close
 - flange kit: 507230

Optional;
 - N.A. fitting kit (JIC)
 - for rotation/drain line.
 - Fitting kit: 406403



Open/Close
 - SAE 1-1/2" 6000 PSI
 - Both sides

Rotate
 - 16S (DIN 3861)
 - Both sides

Detail sticker and type plate mounting

engraved with product information

serial number is stamped additional below type plate on housing

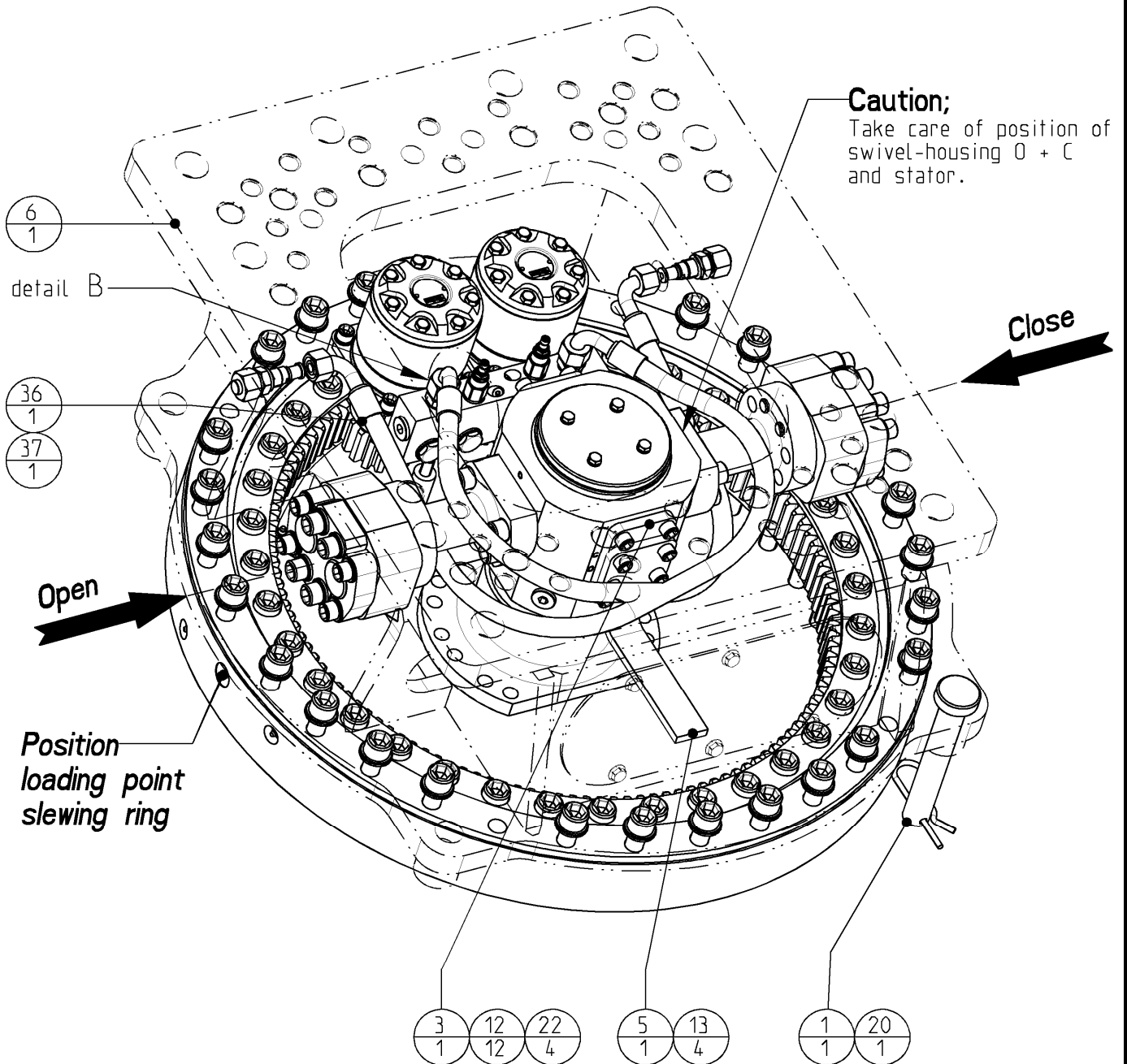
Rotatable Shear	Page	4	of	38
	Date	June 2022		
	Product type	DXS-50-A		
Housing GP	Number	DXS050E546BAB6-C		

	90	296012594_DXS-50-2	Hydr. hose asm. 3/16" SAE 100R1AT	1		45	500540	Springtype straight pin	2
	89	192072799	Screwdriver bit socket	1	a	44	500297	Hex. socket head cap screw	3
	88	192072798	Screwdriver bit socket	1	a	43	500295	Hex. socket head cap screw	7
	87	130059276	Screw - drive	4		42	500286	Hex. socket head cap screw	3
a	86	508277	Shearblade - diamond sloped	1	a	41	500285	Hex. socket head cap screw	2
a	85	508169	Shim straight	3		40	500281	Hex. socket head cap screw	1
	84	508168	Shear - blade straight	1	b	39	500276	Hex. socket head cap screw	2
	83	508162	Sticker	2		38	500274	Hex. socket head cap screw	4
	82	508152	Sticker	1		37	500263	Hex. socket head cap screw	12
	81	508136	Toolbox GP	1		36	500261	Hex. socket head cap screw	8
a	80	508134	Shim - trapezium	1		35	500259	Hex. socket head cap screw	4
a	79	508129	Shim - diamond	4		34	500258	Hex. socket head cap screw	15
	78	508115	Type plate	1		33	500240	Hex. socket head cap screw	1
	77	508113	Sticker	1		32	500223	Hex. socket head cap screw	3
a	76	508104	Shim - diamond	7		31	500147	Bolts Hexagon	16
a	75	508103	Shim - diamond	5		30	500138	Bolts Hexagon	4
a	74	508102	Shearblade - diamond	3		29	500134	Bolts Hexagon	4
a	73	508101	Shim - trapezium	2		28	500054	Washer HV	28
a	72	508100	Shim - trapezium	1		27	500053	Washer HV	8
a	71	508099	Shearblade - trapezium	1		26	409656	Endcap - pin Ø140	1
	70	507336	Hydraulic Cylinder & Valve GP	1		25	409634	Housing machined	1
	69	507048	Bushing	1		24	408500	Rotatorhead GP	1
	68	507007	Bushing	1		23	408340	Shim	2
b	67	506025	Shoulder bolt	2		22	408339	Spacer	2
	66	505239_DXS50	Hydr. hose asm. 1" SAE 100R15	1		21	408338	Flange - intermed. SAE 1"	1
	65	505238_RH_DXS50	Hydr. hose asm. 1½" SAE 100R15	1		20	408334	Pin	1
	64	505238_LH_DXS50	Hydr. hose asm. 1½" SAE 100R15	1		19	408332	Pin asm.	1
	63	504217	Tube + V-ring	1		18	408330	Cover	2
	62	504187	O-ring	2		17	408283	Jaw asm. machined	1
	61	504097	Seal - flange	6		16	407821	Pin asm.	1
	60	503612	Banjo Coupling	1		15	407800	Spacer	2
	59	503505	SAE split flange	8		14	407787	Lock bushing	1
	58	503503	SAE split flange	4		13	407153	Key GP	1
	57	501986	Valve GP (Large)	1		12	406898	Lock	1
	56	501985	Base flange - DXS	1		11	406897	Shim - puck	4
	55	501980_DXS_RH	Swivel GP	1		10	406896	Shim - puck	2
	54	501980_DXS_LH	Swivel GP	1		9	406895	Shim - puck	4
	53	501936	Test-point	1		8	406894	Slide puck	2
	52	501935	Plug - breather	1		7	406824	Fixture DRS-60/75/90 (V2)	1
	51	500936	Nut coupling	2	b	6	406796	Piercingblade (V3) RH	1
	50	500933	Ring - profile	2	b	5	406795	Piercingblade (V3) LH	1
	49	500690	Male stud coupling	2		4	406071	Lock	1
	48	500603	Seal - flange	6		3	405104	Lock bushing	12
	47	500601	Seal - flange	3		2	405078	Locknut	1
	46	500560	Grease - nipple	8	a	1	404749	Hex. socket head cap screw	6
					Set	POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear

Page	5	of	38
Date	June 2022		
Product type	DXS-50-A		
Number	408500-03		

Rotatorhead GP



Note A
Mount with Cyberbound TT62 according instruction at the end of this partsbook.

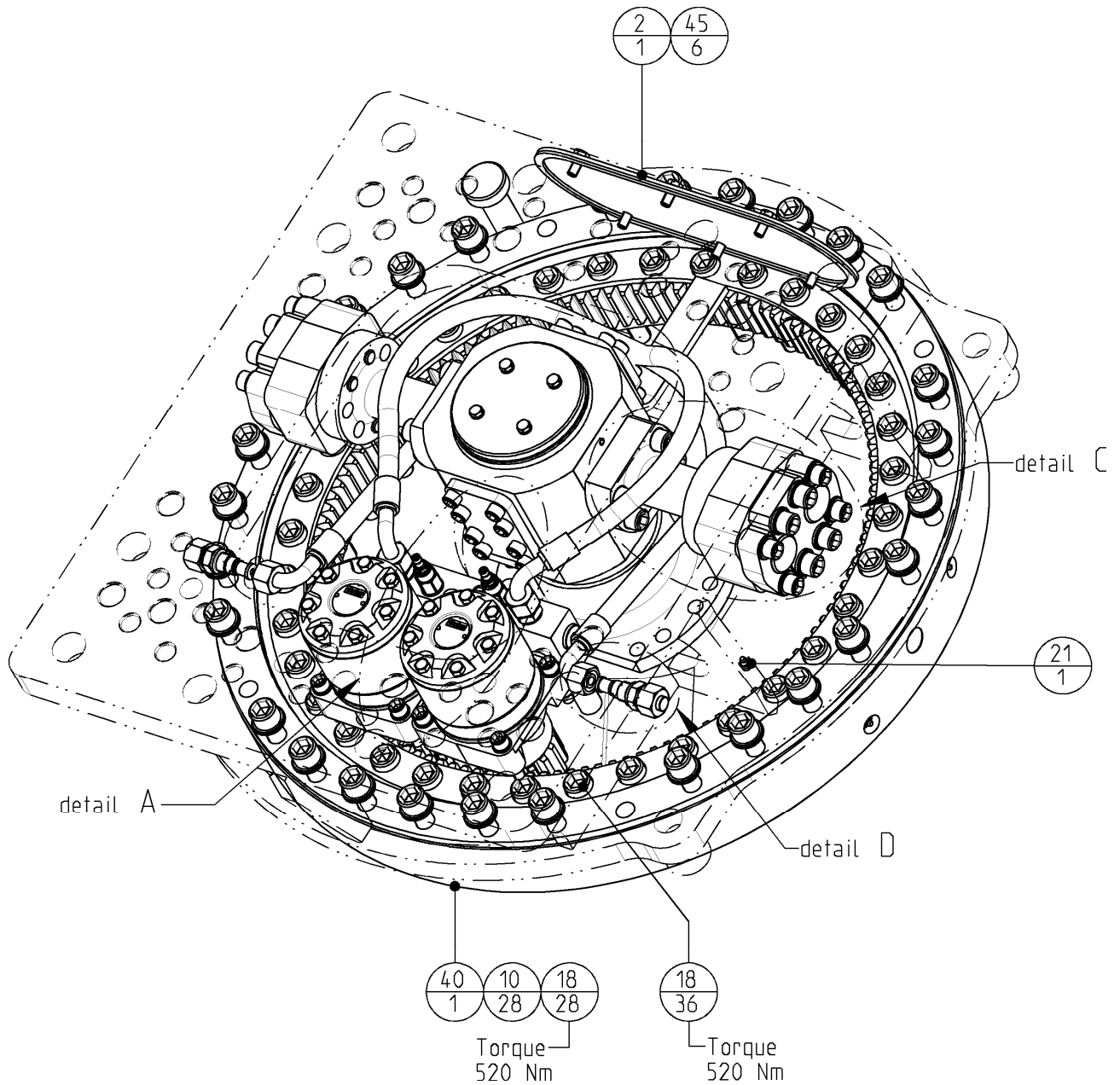
Note B
Optional open/close connection kit
Flange kit: 507230

Note C
Optional N.A. fitting kit (JIC)
Fitting kit: 406403

Rotatable Shear

Page	6	of	38
Date	June 2022		
Product type	DXS-50-A		
Number	408500-03		

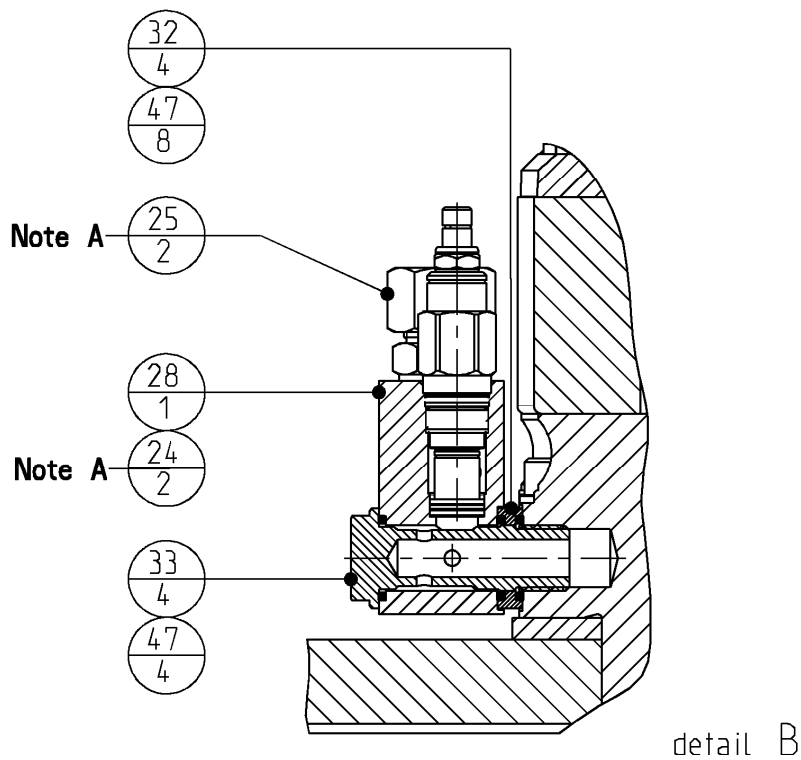
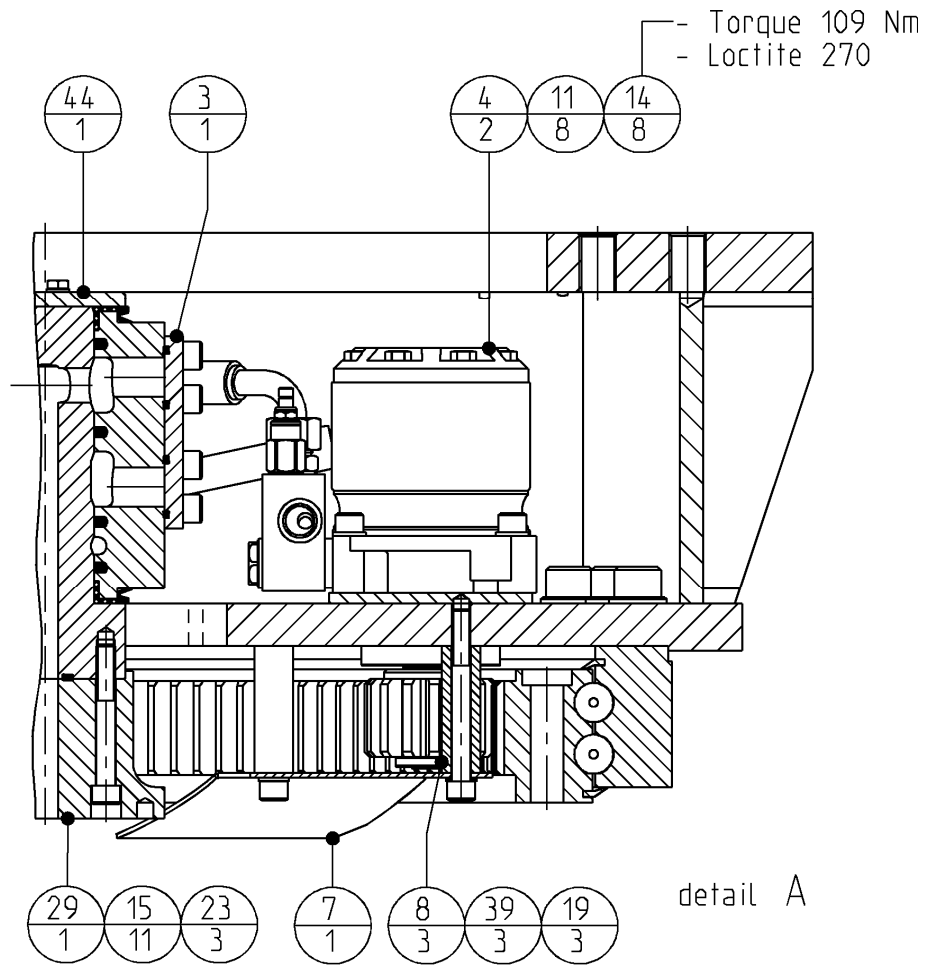
Rotatorhead GP



Rotatable Shear

Page	7	of	38
Date	June 2022		
Product type	DXS-50-A		
Number	408500-03		

Rotatorhead GP



Rotatable Shear

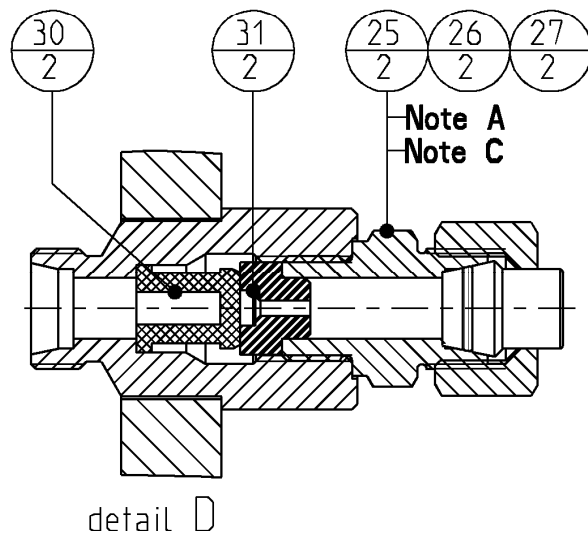
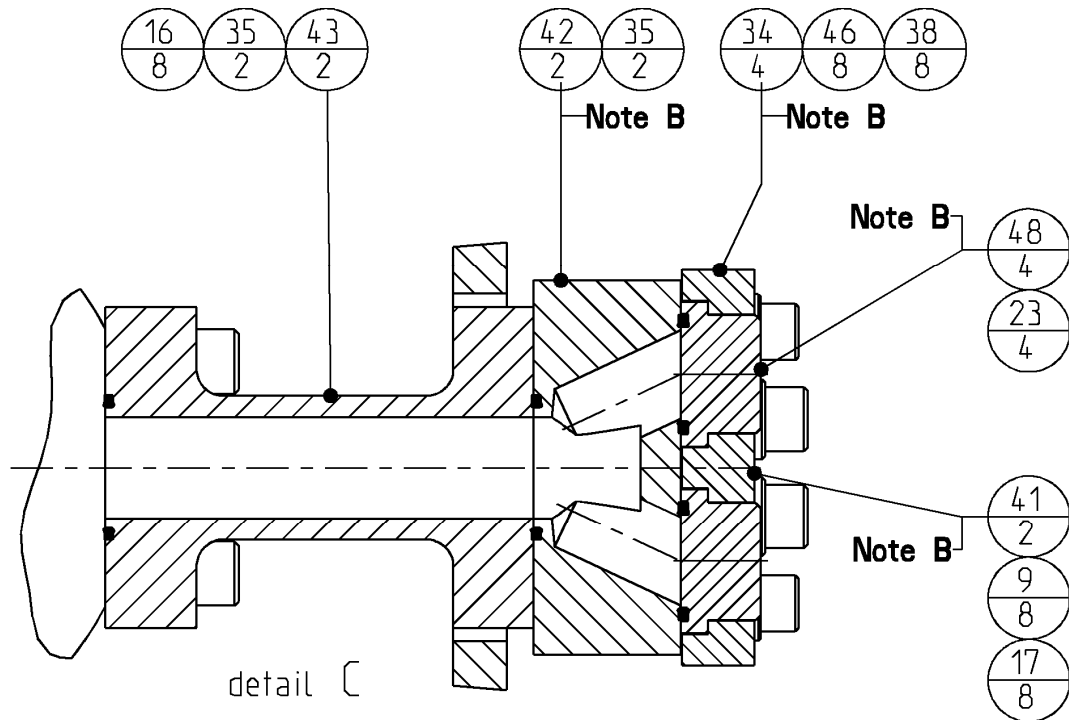
Page **8** of **38**

Date **June 2022**

Product type **DXS-50-A**

Rotatorhead GP

Number **408500-03**



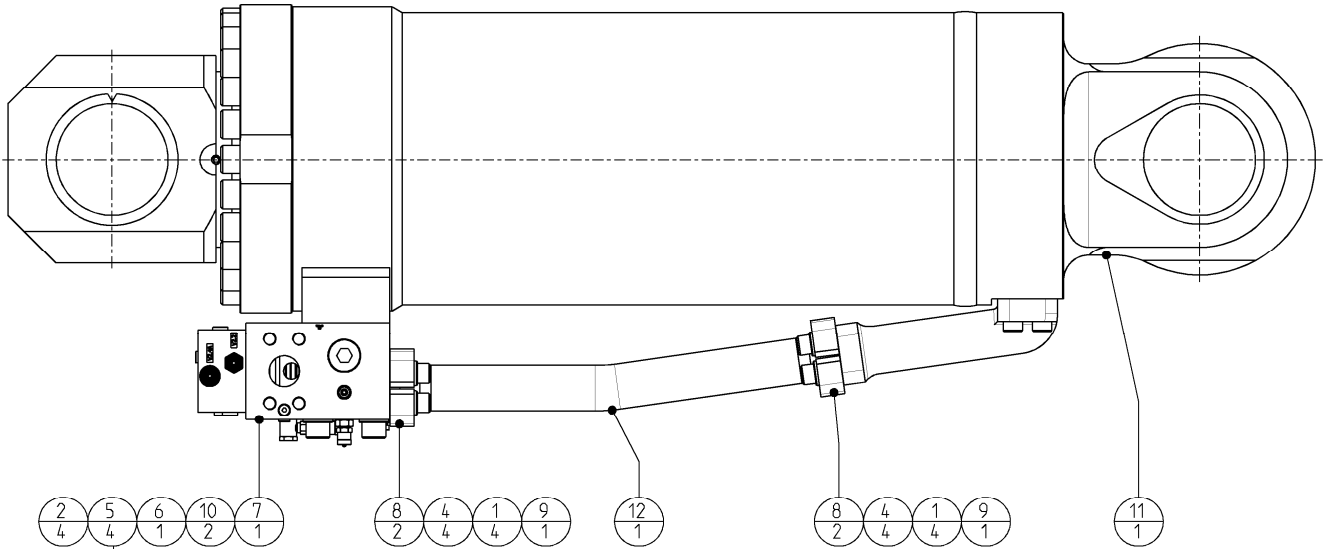
Rotatable Shear	Page	9	of	38
	Date	June 2022		
	Product type	DXS-50-A		
Rotatorhead GP	Number	408500-03		

POS	PARTNUMBER	PARTNAME	QT
25	500693	Male stud coupling	4
24	500652	Blanking end	2
23	500603	Seal - flange	7
22	500601	Seal - flange	4
21	500560	Grease - nipple	1
20	500504-2	Locking pin (hair-pin)	1
19	500303	Hex. socket head cap screw	3
18	500278	Hex. socket head cap screw	64
17	500268	Hex. socket head cap screw	8
16	500263	Hex. socket head cap screw	8
15	500255	Hex. socket head cap screw	11
14	500252	Hex. socket head cap screw	8
13	500250	Hex. socket head cap screw	4
12	500248	Hex. socket head cap screw	12
11	500068	Washer spring	8
10	500055	Washer HV	28
9	500054	Washer HV	8
8	408519	Spacer sleeve	3
7	408518	Blade - greasing	1
6	408501	Rotatorhead asm. machined	1
5	408057	Plate - Lock	1
4	407855	Motor GP	2
3	407706	SAE blind flange	2
2	406332	Cover asm.	1
1	405866	Lockpin	1
48	291065241	SAE stop	4
47	257066194	Kantseal	12
46	122000163	Washer normal	8
45	120013828	Bolts Hexagon - self locking	6
44	507260	Swivel GP	1
43	507202	Flange pipe 1-1/2" 6000 PSI	2
42	507201	Double flange 1-1/4" 6000 PSI	2
41	507200	SAE split flange - double	2
40	507000	Slewing Ring; Internal Gear	1
39	506055	Lockwasher - Nordlock	3
38	506005	Hex. socket head cap screw	8
37	505183_V65_1	Hydr. hose asm. 1/2" SAE 100 R2AT	1
36	505182_V65_1	Hydr. hose asm. 1/2" SAE 100 R2AT	1
35	504097	Seal - flange	4
34	503504	SAE split flange	4
33	502907	Banjo bolt	4
32	502903	Spacer	4
31	502001	Drossel - ring	2
30	502000	Filter	2
29	501911	Intermediate flange	1
28	501733	Valve GP	1
27	500945	Blanking plug	2
26	500940	Nut coupling	2

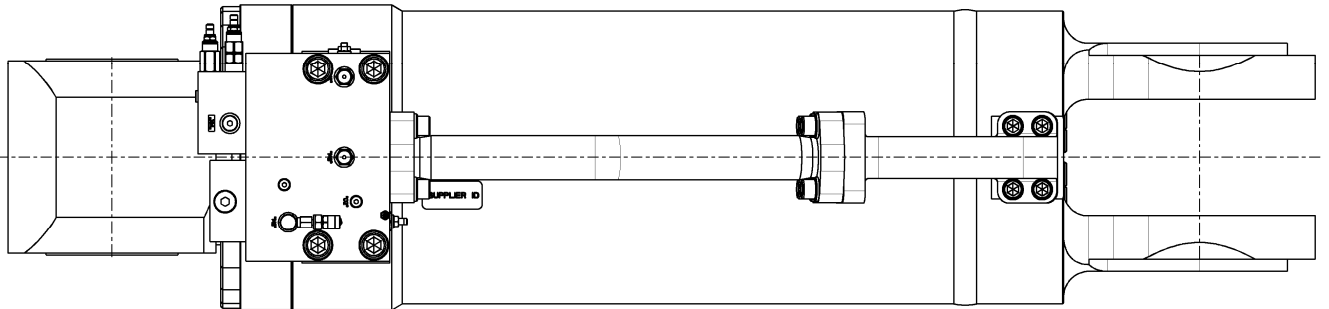
Rotatable Shear

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Date	June 2022		
Product type	DXS-50-A		
Number	507336-08		

Cylinder & Valve GP



torque 520 Nm

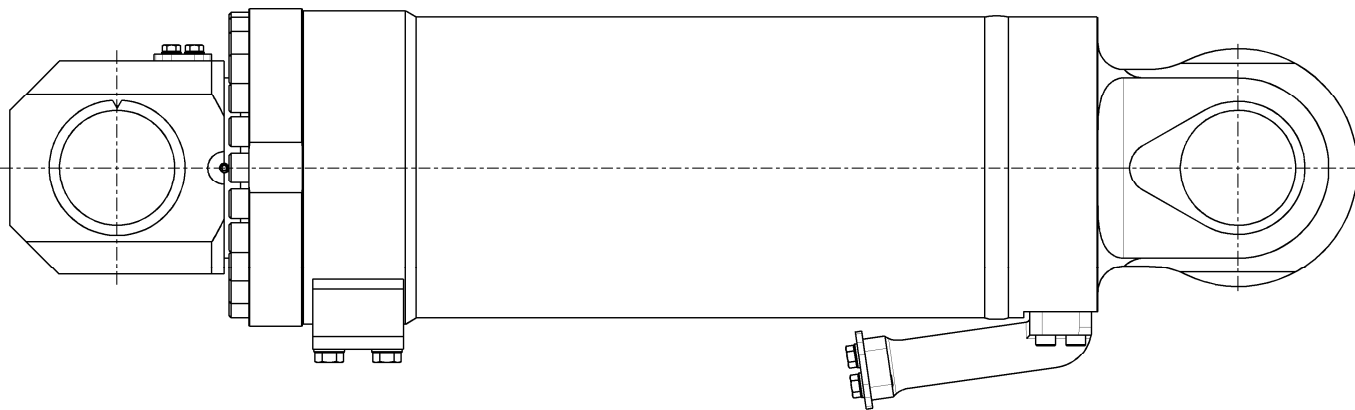


12	507345	Tube - DXS-50	1
11	507337	Hydraulic Cylinder GP	1
10	506105	Dowel pin	2
9	504097	Seal - flange	3
8	503505	SAE split flange	4
7	501975	Speedvalve GP - NG32	1
6	500603	Seal - flange	1
5	500280	Hex. socket head cap screw	4
4	500263	Hex. socket head cap screw	8
3	500262	Hex. socket head cap screw	4
2	500055	Washer HV	4
1	500054	Washer HV	8
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear

<i>Page</i>	11	<i>of</i>	38
<i>Date</i>	June 2022		
<i>Product type</i>	DXS-50-A		
<i>Number</i>	507337-07		

Cylinder GP



Note

When seals inside the cylinder must be exchanged it is important to exchange also the bolts from bottom and head! Seals, bolts and Loctite can be ordered as one set, see below.

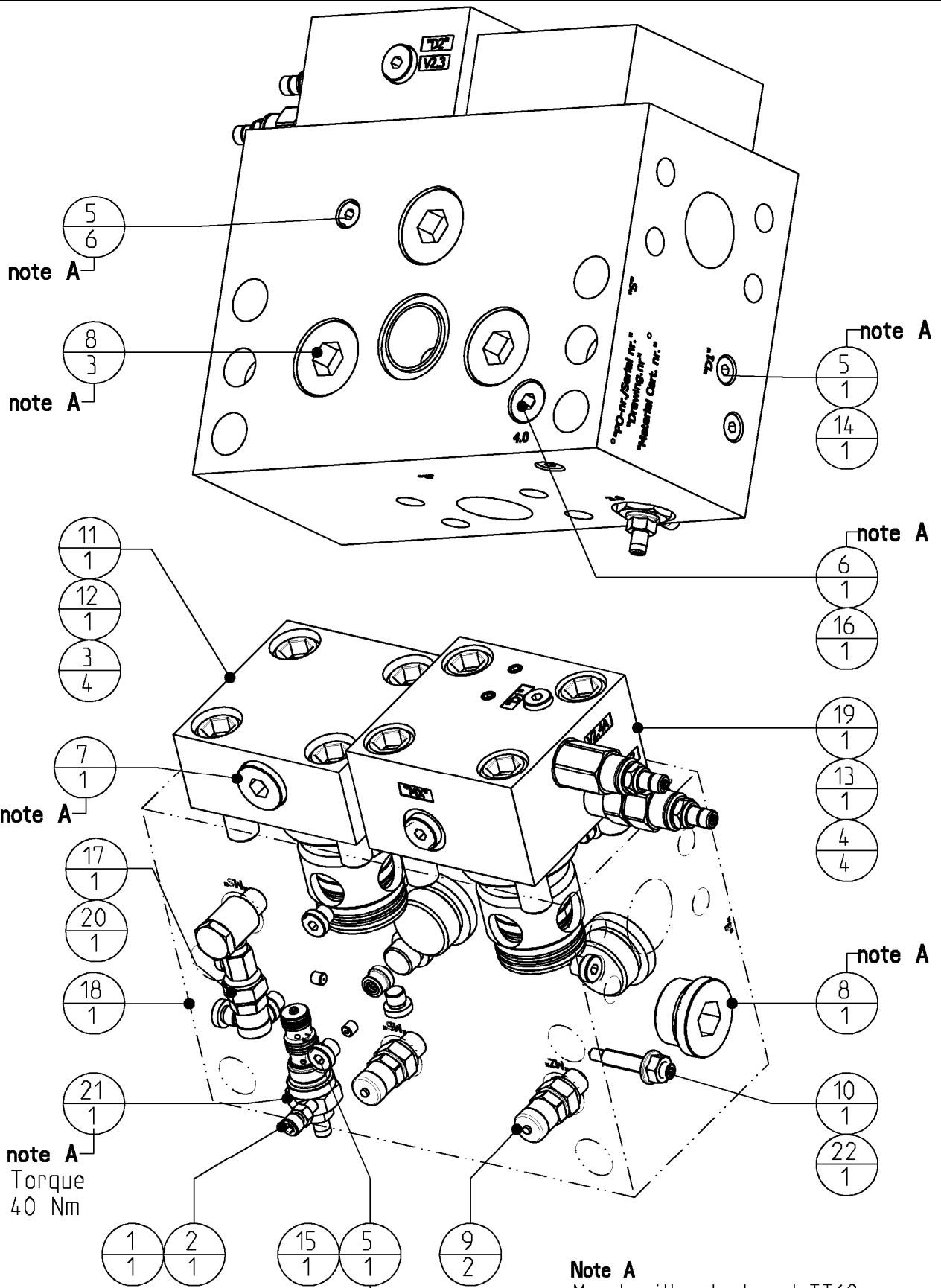
Service set	Itemnumber
Service seal set	504227
Service set (seals , bolts & Loctite)	504228

For more detailed information contact your local dealer or Demarec.

Rotatable Shear

Page	12	of	38
Date	June 2022		
Product type	DXS-50-A		
Number	501975-04		

Speed valve GP



note A

note A

note A

note A

note A

note A

note A
Torque
40 Nm

note A

Note A
Mount with cyberbound TT62
according insrtruction at the
end of this partsbook.

Rotatable Shear	<i>Page</i>	13	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Speed valve GP	<i>Number</i>	501975-04		

22	121067231	Nut Hexagon sealing	1
21	507391	Priority cartridge valve	1
20	503612	Banjo Coupling	1
19	501977	Cover GP - NG32	1
18	501976	Housing - valve	1
17	501936	Test-point	1
16	501934	Valve - non return	1
15	501929	Restrictor - plug	1
14	501928	Restrictor - plug	1
13	501789	Cartridge slip-in NG32	1
12	501788	Cartridge slip-in NG32	1
11	501783	Cover NG32	1
10	501244	Bleeding screw	1
9	500740	Test-point	2
8	500654	Blanking end	4
7	500652	Blanking end	1
6	500651	Blanking end	1
5	500649	Blanking end	8
4	500264	Hex. socket head cap screw	4
3	500262	Hex. socket head cap screw	4
2	500212	Hex. socket head cap screw	1
1	500001	Nut Hexagon	1
POS	PARTNUMBER	PARTNAME	QT

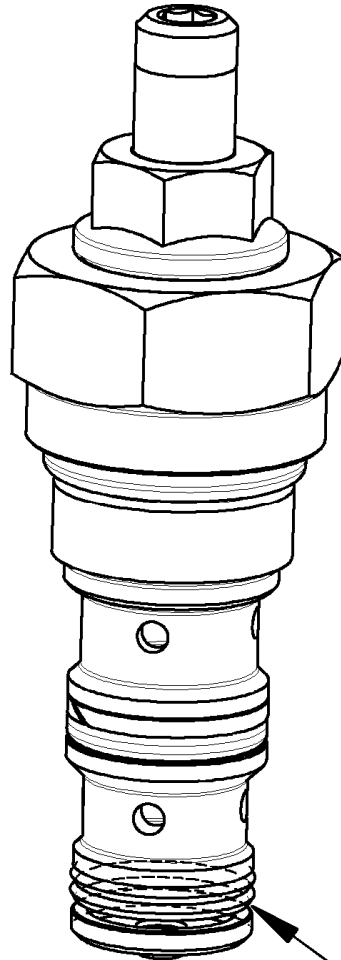
Rotatable Shear	<i>Page</i>	14	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Cartridge - slip-in valve	<i>Number</i>	501788-01		



Rotatable Shear	<i>Page</i>	15	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Cartridge - slip-in valve	<i>Number</i>	501789-01		



Rotatable Shear	<i>Page</i>	16	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Cartridge – priority valve	<i>Number</i>	507391-00		



Sealset 504202

Rotatable Shear

Page	17	of	38
Date	June 2022		
Product type	DXS-50-A		
Number	501977-02		

Cover GP

note A

7
1

8
2

6
4

4
1

9
1

note A

Torque
41-47 Nm

3
1

note A

Torque
41-47 Nm

note A

5
2

note A

2
2

note A

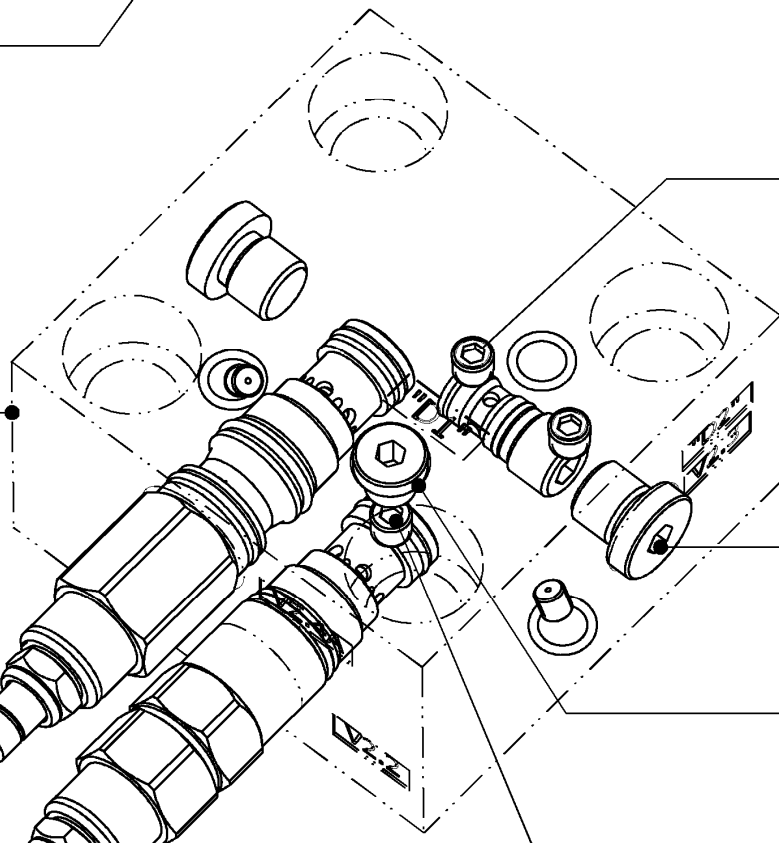
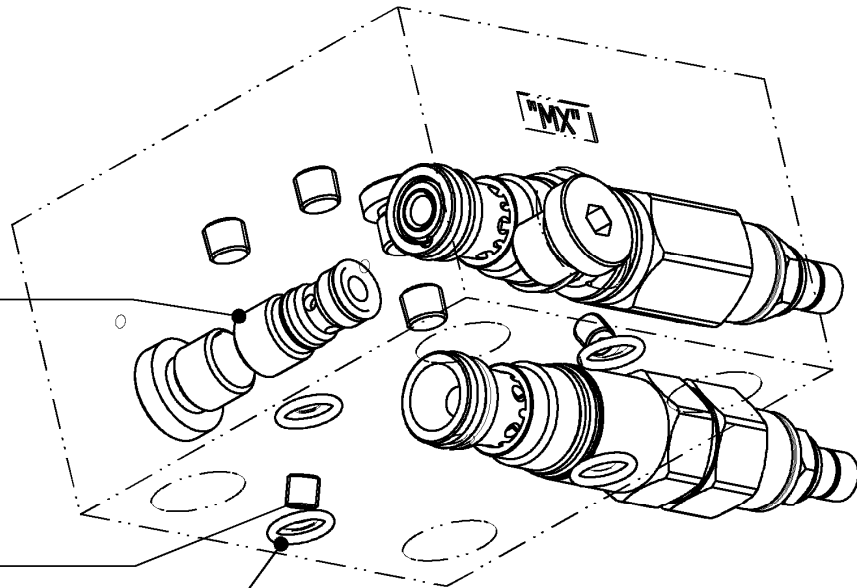
1
1

note A

5
1

Note A

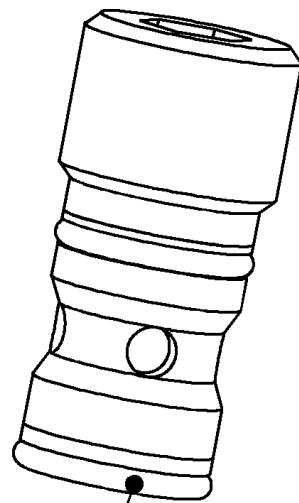
Mount with cyberbound TT62 according instruction at the end of this partsbook.



Rotatable Shear	<i>Page</i>	18	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Cover GP	<i>Number</i>	501977-02		

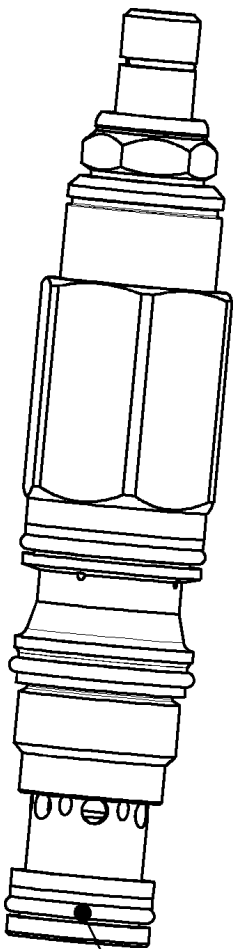
9	507510	Cartridge - sequence valve	1
8	507323	Restrictor - plug	2
7	507060	Cartridge - shuttle valve	1
6	504160	O-ring (ORFS -06)	4
5	502132	Hex.socket plug-tapped	3
4	501978	Cover	1
3	501537	Cartridge - sequence valve	1
2	500650	Blanking end	2
1	500649	Blanking end	1
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear	<i>Page</i>	20	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Cartridge - shuttle valve	<i>Number</i>	507060-00		



sealset 504239

Rotatable Shear	<i>Page</i>	21	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Cartridge – sequence valve	<i>Number</i>	507510-00		

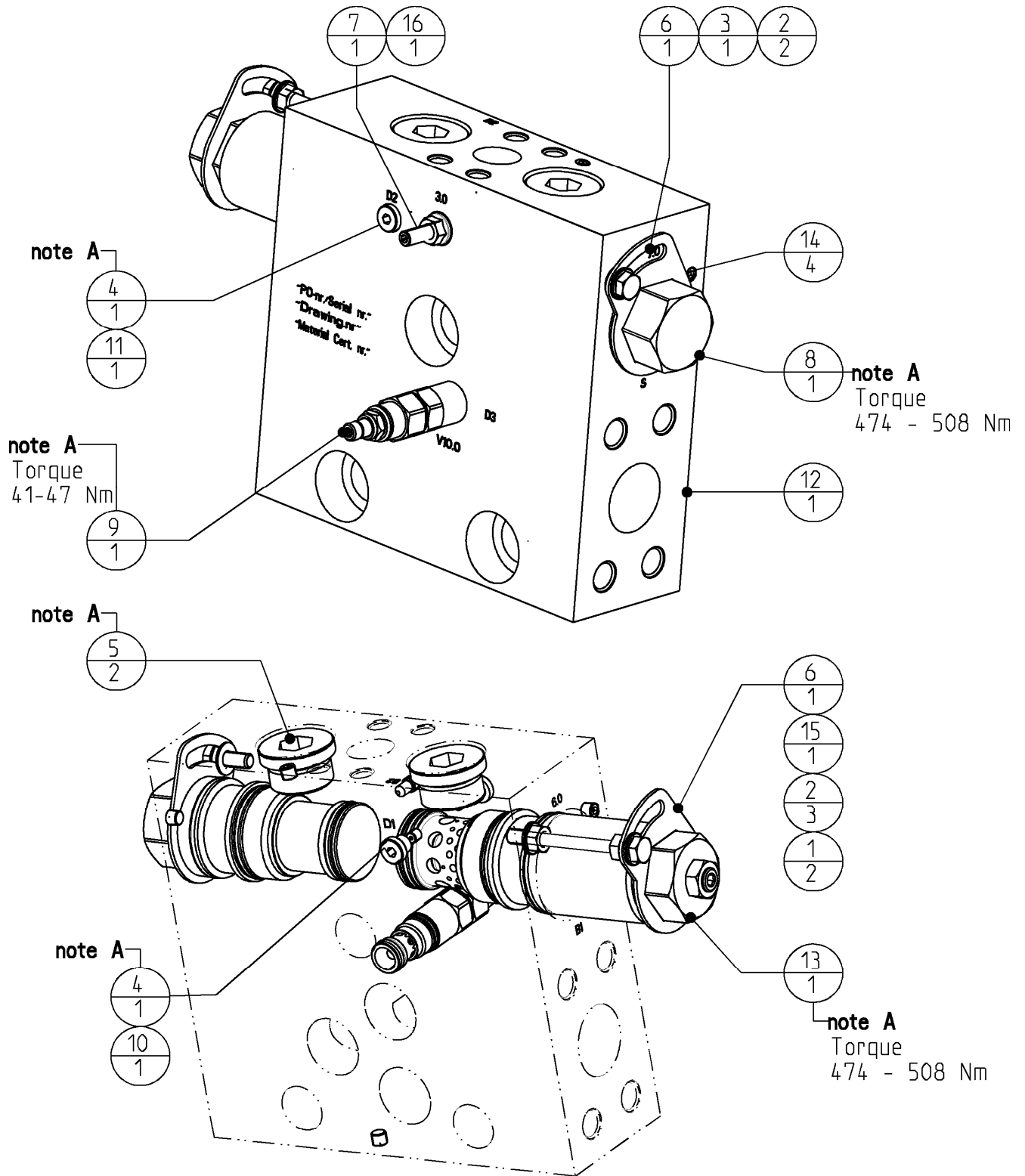


Sealset 504250

Rotatable Shear

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Date	June 2022		
Product type	DXS-50-A		
Number	501986-07		

DemaPower valve GP

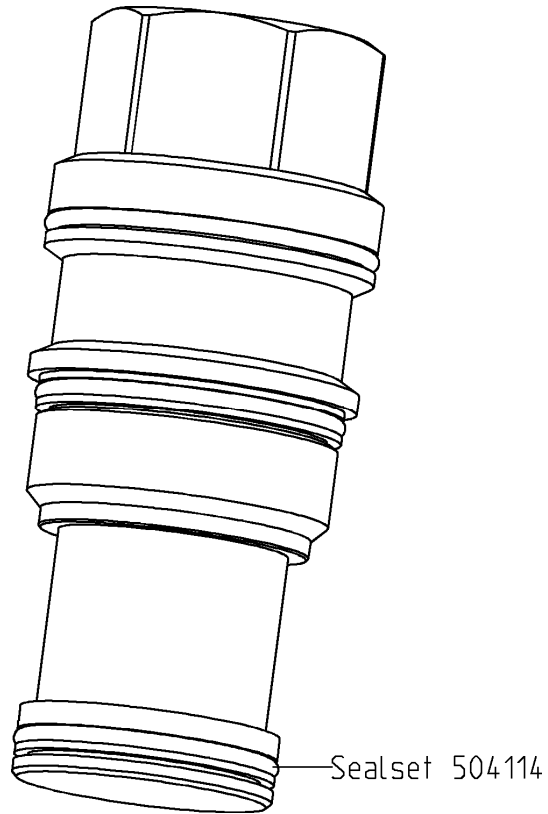


Note A
Mount with cyberbound TT62 according instruction at the end of this partsbook.

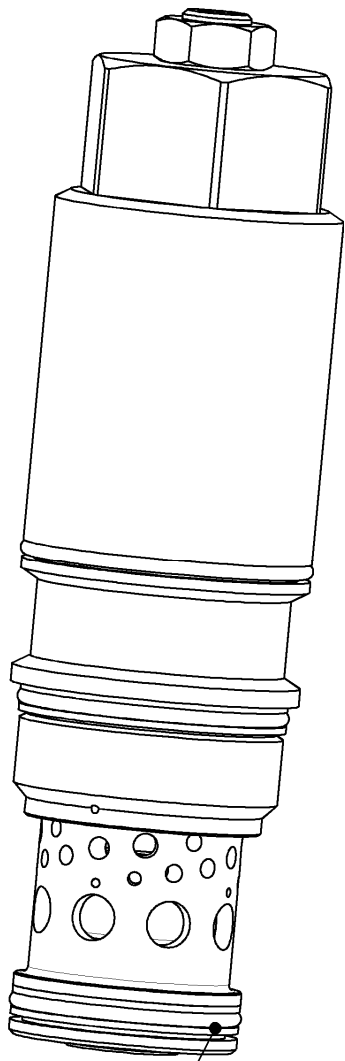
Rotatable Shear	<i>Page</i>	23	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
DemaPower valve GP	<i>Number</i>	501986-07		

16	121067231	Nut Hexagon sealing	1
15	506098	Bolts Hexagon	1
14	502132	Hex.socket plug-tappered	4
13	501990	Cartridge - counter balance valve	1
12	501987	Valve housing (large)	1
11	501929	Restrictor - plug	1
10	501928	Restrictor - plug	1
9	501537	Cartridge - sequence valve	1
8	501377	Cartridge - check valve	1
7	501244	Bleeding screw	1
6	501239	Lockplate Key 41	2
5	500654	Blanking end	2
4	500649	Blanking end	2
3	500103	Bolts Hexagon	1
2	500041	Washer normal	5
1	500002	Nut Hexagon	2
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear	<i>Page</i>	24	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Cartridge - check valve	<i>Number</i>	501377-02		



Rotatable Shear	<i>Page</i>	25	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Cartridge – counter balance valve	<i>Number</i>	501990-01		

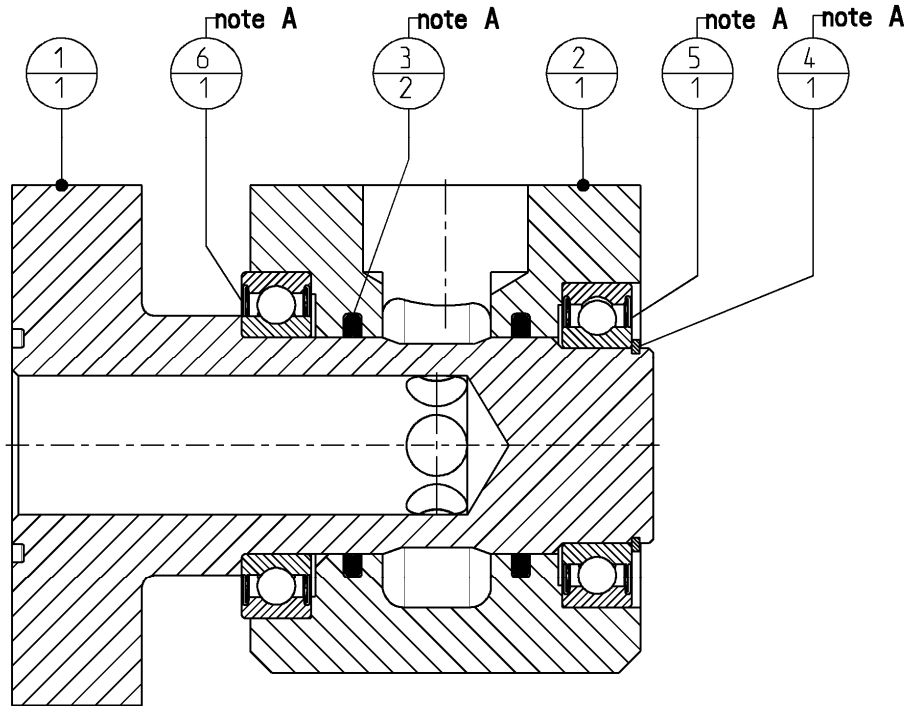
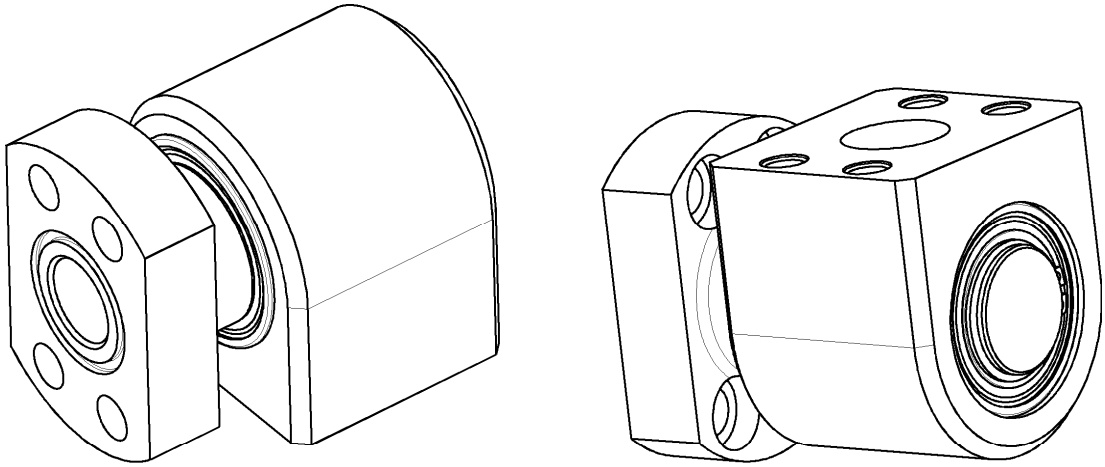


Sealset 504114

Rotatable Shear

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Product type	DXS-50-A		
Number	501980-04		

Swivel GP



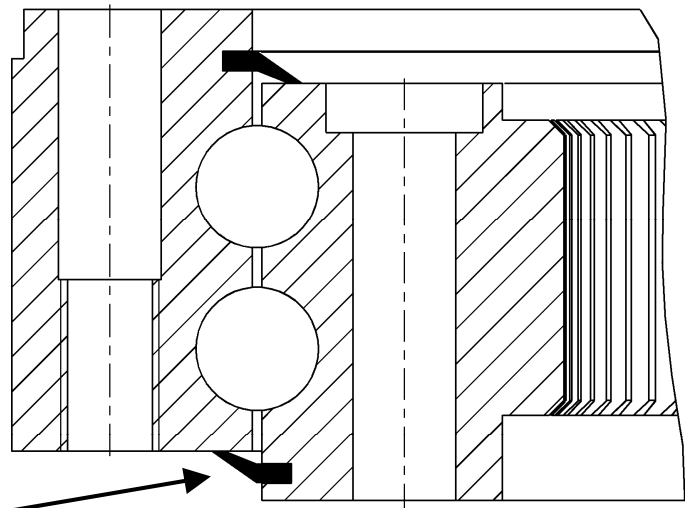
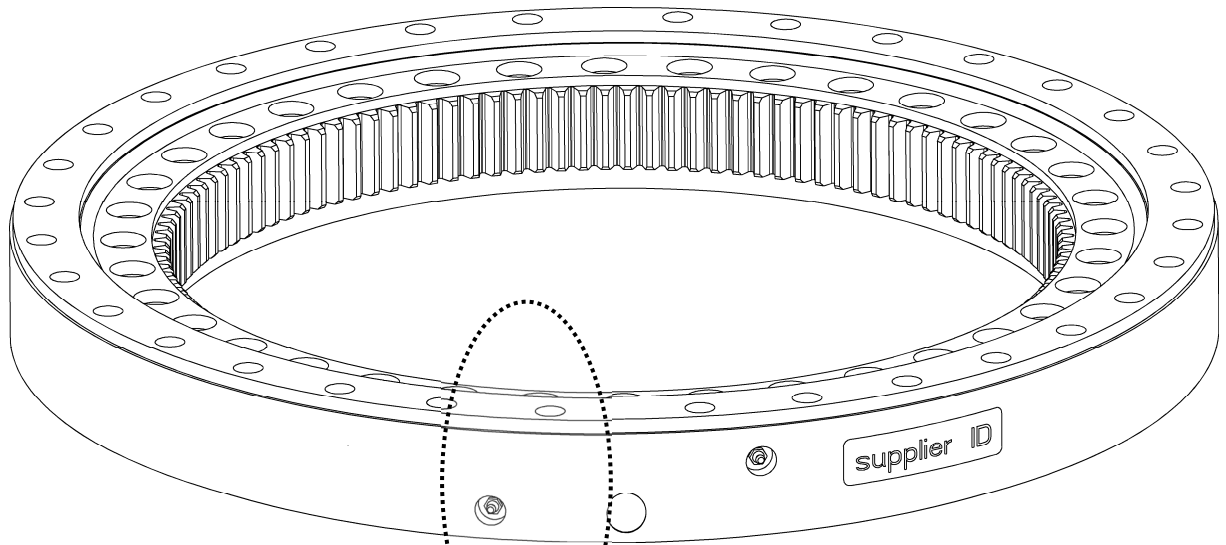
note A
Part of service set 501984

6	507057	Ball bearing	1
5	507056	Ball bearing	1
4	506088	Retainingring	1
3	504201	Roto seal $\varnothing 50 \times \varnothing 61,0 \times 4,2$	2
2	501982	Housing SAE 1-1/2" 6000 PSI	1
1	501981	Stator SAE 1-1/2" 6000 PSI	1
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear

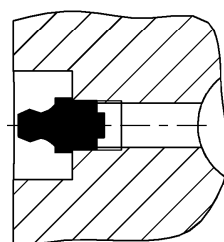
Page	27	of	38
Date	June 2022		
Product type	DXS-50-A		
Number	507000-01		

Slewing ring

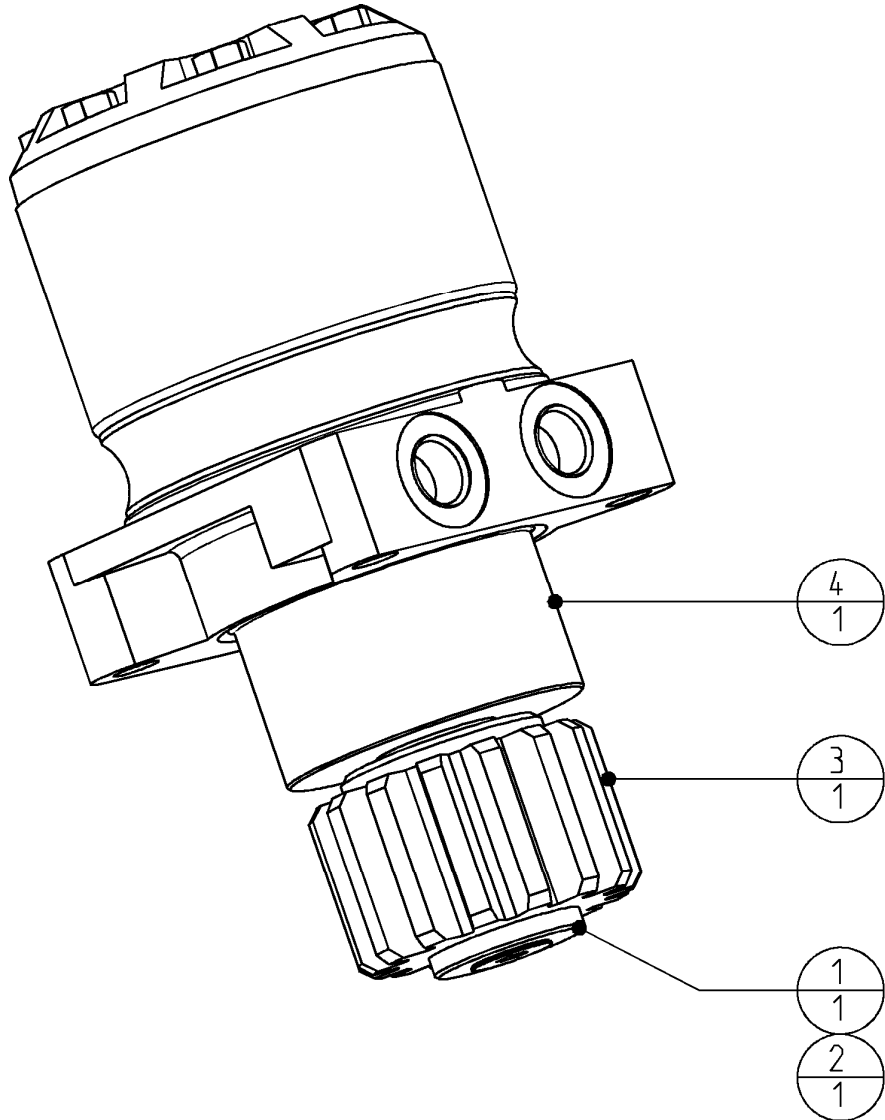


**2x seal 256060902
mount with Loctite 480**

**4x grease nipple
500560**



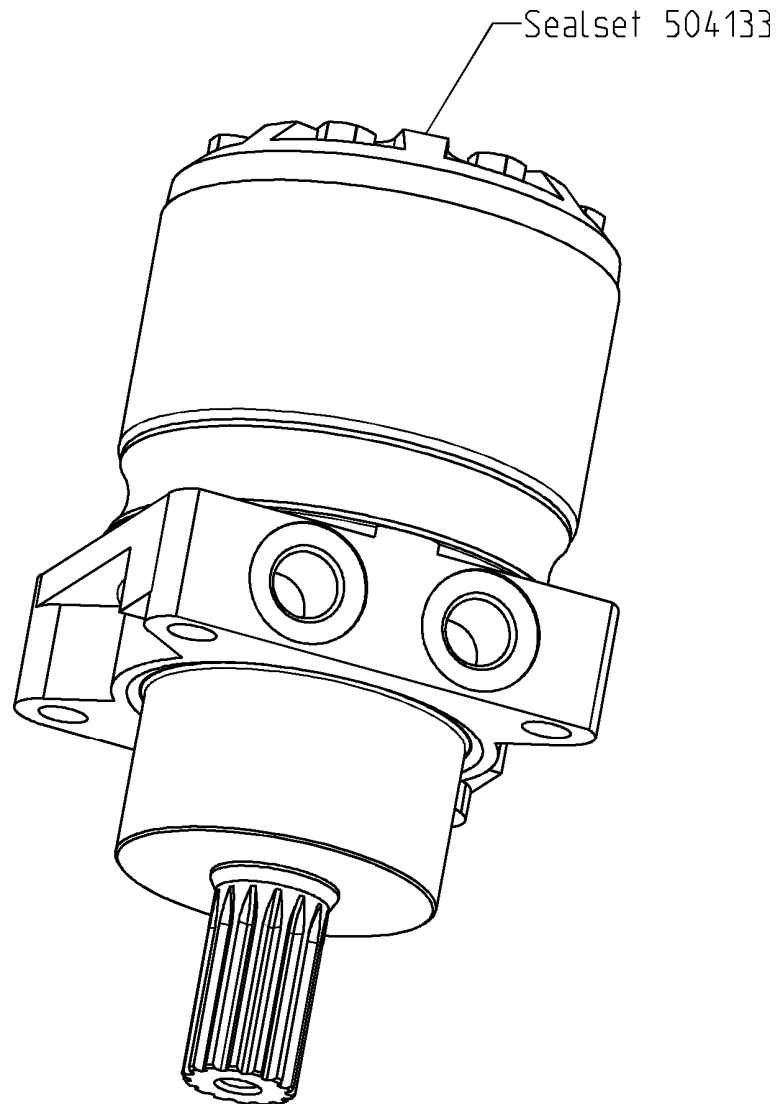
Rotatable Shear	Page	28	of	38
	Date	June 2022		
	Product type	DXS-50-A		
Hydraulic motor GP	Number	407855-02		



Loctite 638

4	501801	Hydraulic motor	1
3	501099	Pinion	1
2	500347	Flat countersunk head cap screws	1
1	407692	Washer	1
POS	PARTNUMBER	PARTNAME	QT

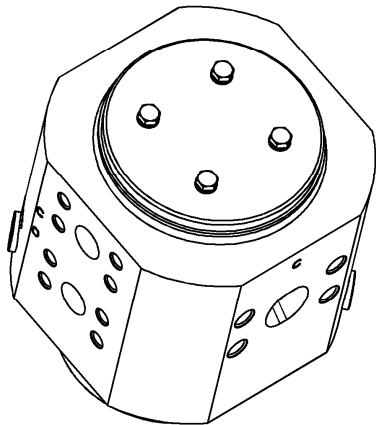
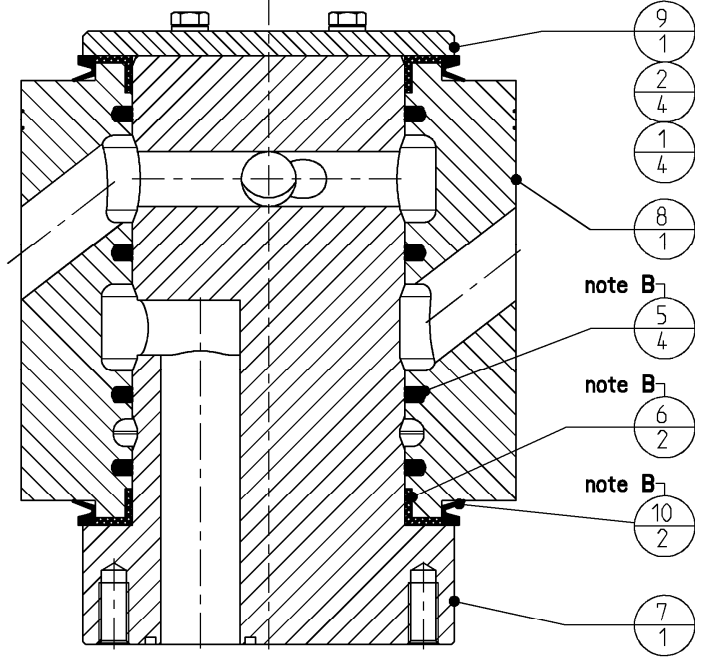
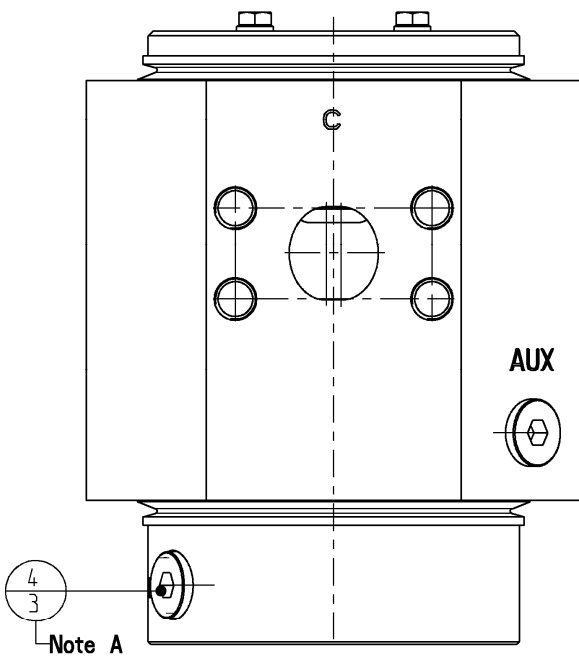
Rotatable Shear	<i>Page</i>	29	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Hydraulic motor	<i>Number</i>	501801-00		



Rotatable Shear

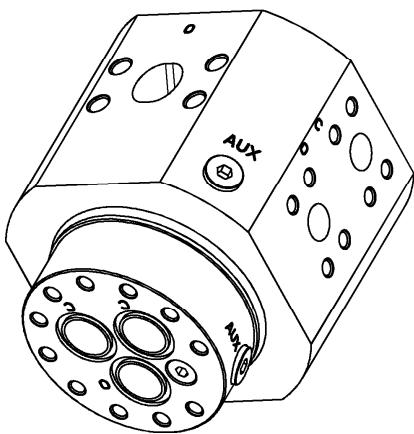
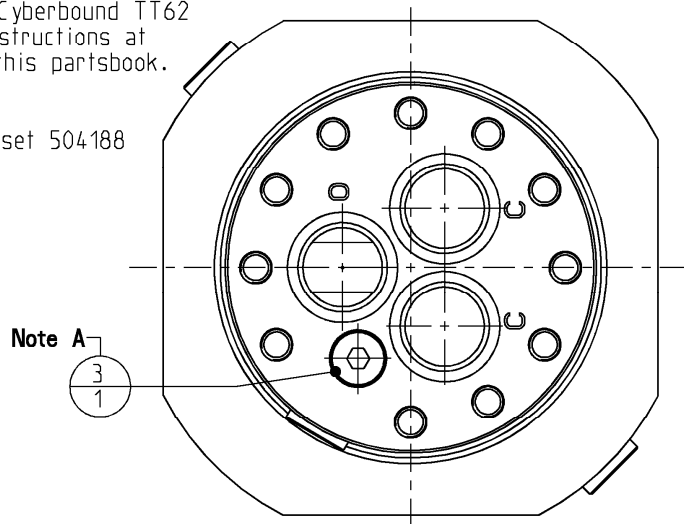
Page	30	of	38
Date	June 2022		
Product type	DXS-50-A		
Number	507260-00		

Swivel GP



note A
Mount with Cyberbound TT62 according instructions at the end of this partsbook.

note B
Part of sealset 504188

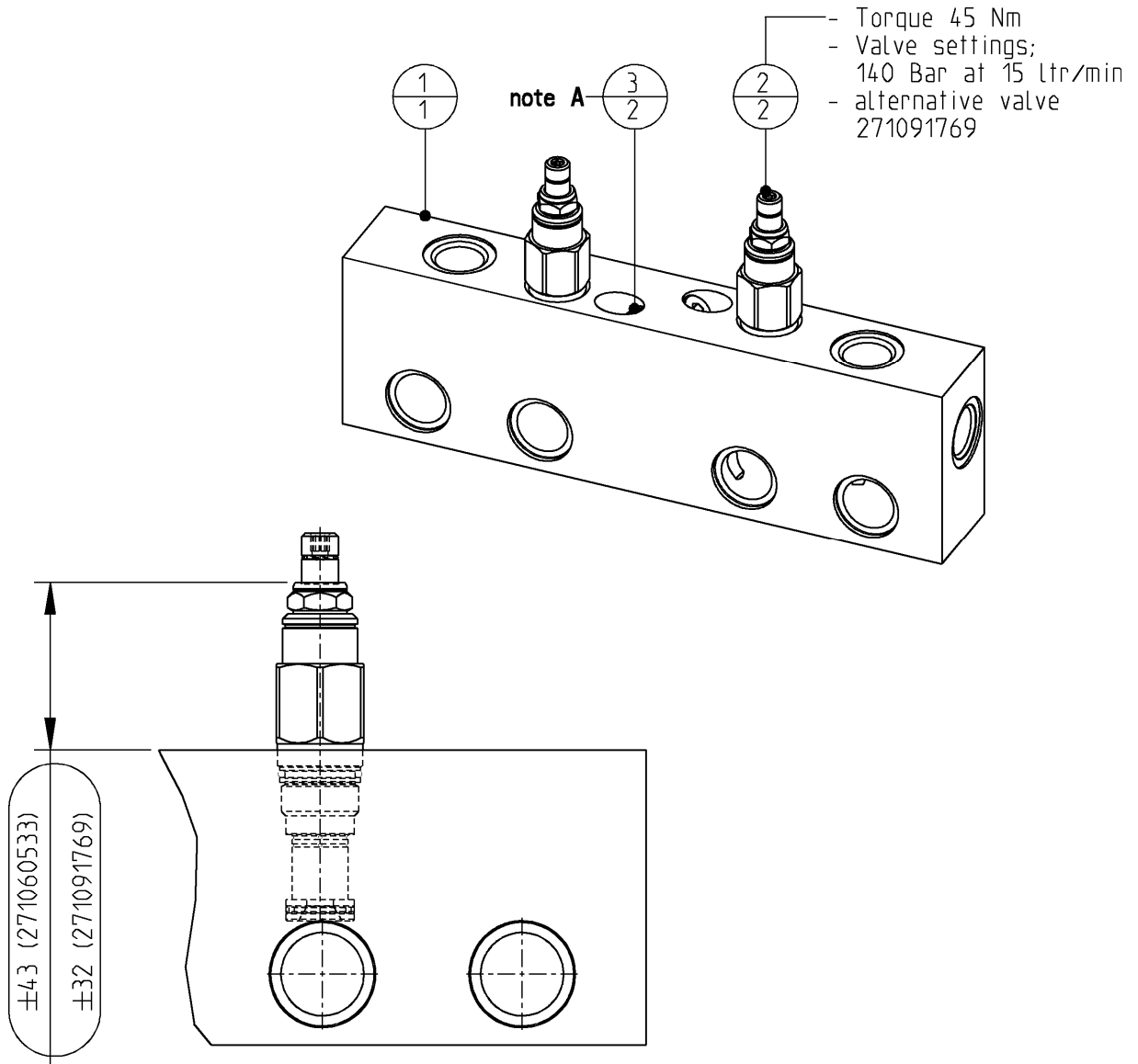


10	504054_VG_D140	Seal	2
9	507263	Cover	1
8	507262	Housing	1
7	507261	Stator	1
6	504222	Axial ring	2
5	504206	Roto seal	4
4	500652	Blanking end	3
3	500651	Blanking end	1
2	500105	Bolts Hexagon	4
1	500066	Washer spring	4
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear

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Date	June 2022		
Product type	DXS-50-A		
Number	501733-01		

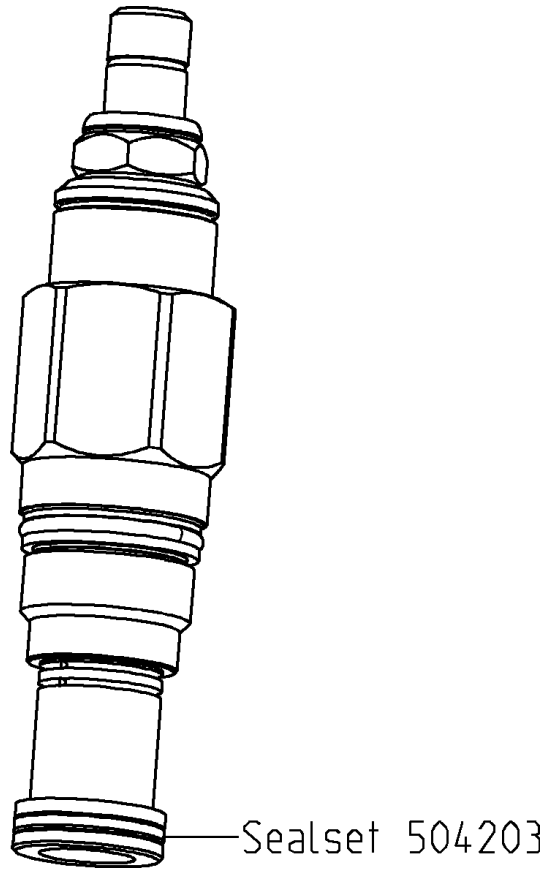
Valve GP



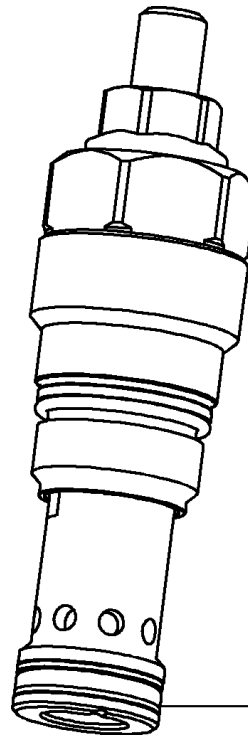
Note A:
 Mount with Cyberbound TT62
 according instructions at the end
 of this partsbook.

3	290066544	Blanking end ISO 6149	2
2	271060533	Cartridge- relief valve	2
1	501734	Baseplate	1
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear	<i>Page</i>	32	<i>of</i>	38
	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Cartridge - relief valve	<i>Number</i>	271060533-C		



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	<i>Date</i>	June 2022		
	<i>Product type</i>	DXS-50-A		
Cartridge - relief valve	<i>Number</i>	271091769-A		

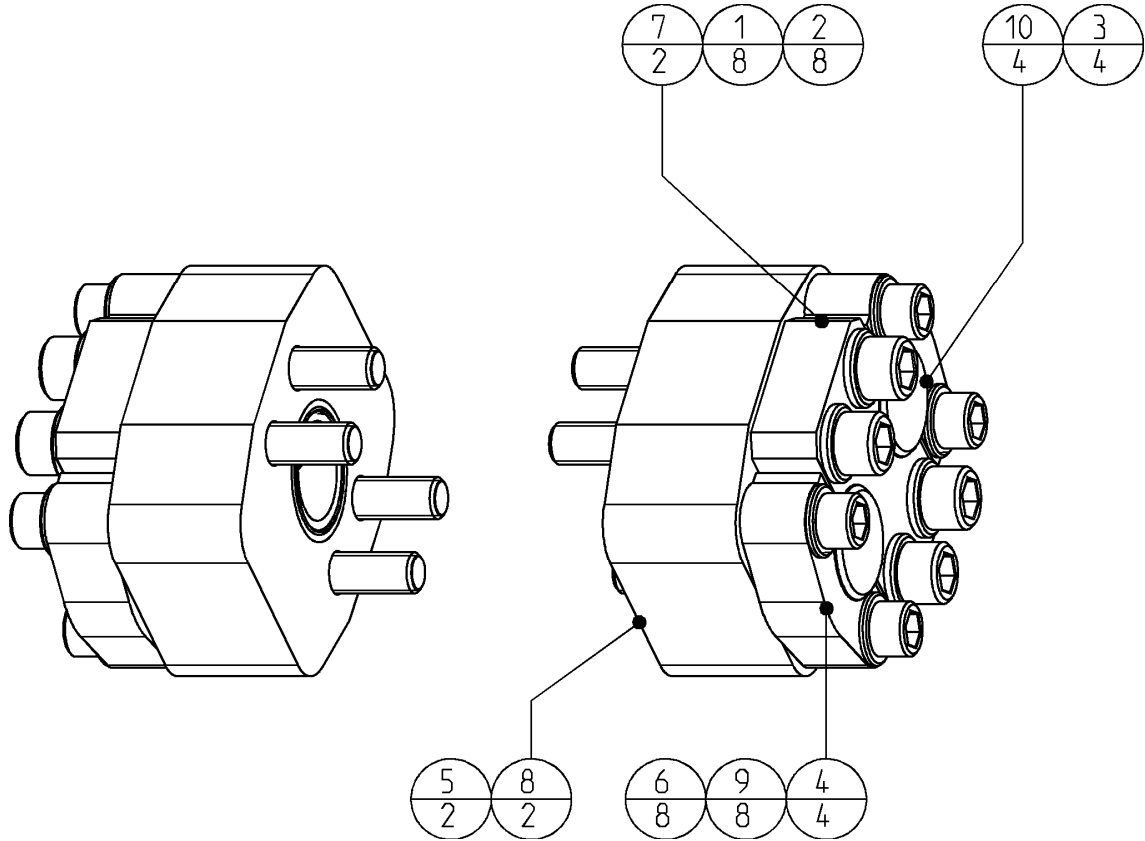


Sealset 504213

Rotatable Shear

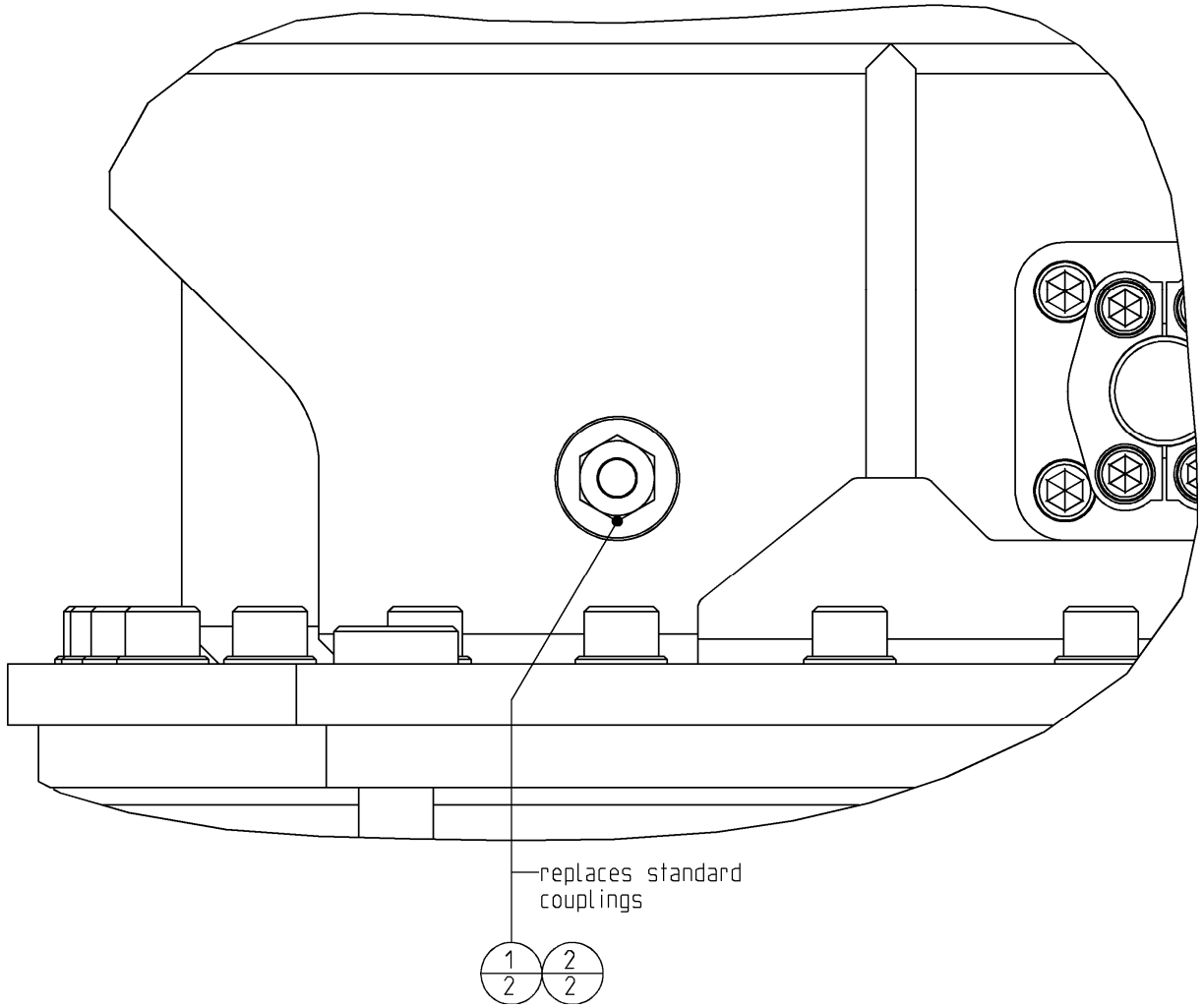
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Date	June 2022		
Product type	DXS-50-A		
Number	507230-02		

Flange kit (optional)



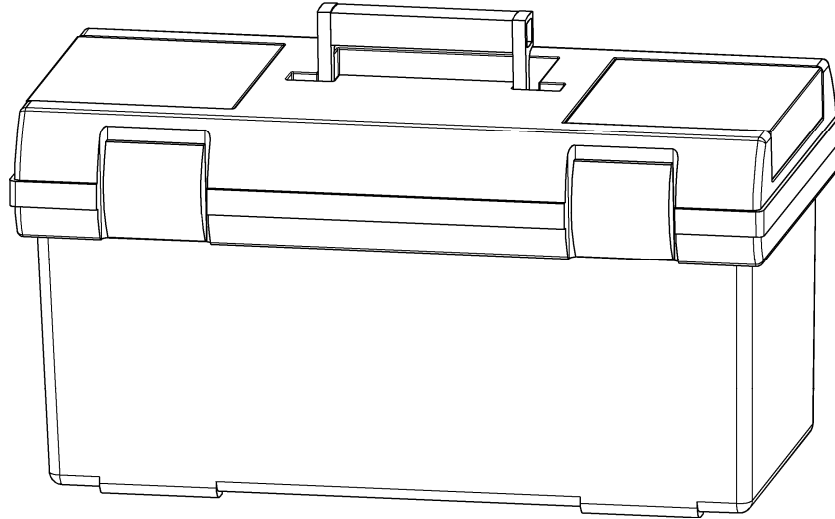
10	291065241	SAE stop	4
9	122000163	Washer normal	8
8	507201	Double flange 1¼" 6000 PSI	2
7	507200	SAE split flange - double	2
6	506005	Hex. socket head cap screw	8
5	504097	Seal - flange	2
4	503504	SAE split flange	4
3	500603	Seal - flange	4
2	500268	Hex. socket head cap screw	8
1	500054	Washer HV	8
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear	Page	35	of	38
	Date	June 2022		
	Product type	DXS-50-A		
Fitting kit JIC (optional)	Number	406403-00		



2	503662	Blanking cap	2
1	503650	Male stud coupling	2
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear	Page	36	of	38
	Date	June 2022		
	Product type	DXS-50-A		
Toolbox	Number	508136-02		



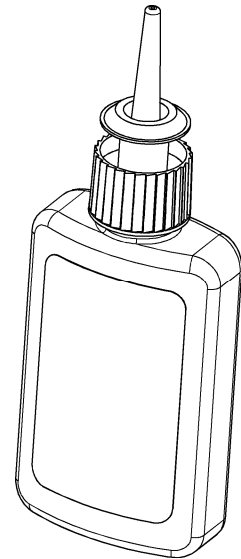
**Content of toolbox,
completed with shims, partsbook and manual of the shear**

				25	257013302	Kantseal 15,54 x 2,51	2
				24	121060762	Locknut M10 SEAL LOCK	2
				16	504009	O-ring 44,04x 3,53	3
				17	504017	O-ring 36,09x 3,53	2
				18	504048	O-ring 25,3 x 2,4	3
				19	504047	O-ring 20,3 x 2,4	3
				20	504046	O-ring 16,3 x 2,4	3
				21	504070	O-ring 12,37x 2,62	3
				22	504045	O-ring 12,0 x 2,0	3
				23	504043	O-ring 6,0 x 1,5	3
				15	504041	Seal 1-1/4" 38,8x45,8x2	2
				14	504040	Seal 1" 29,7x35,7x2	2
				13	504039	Seal 3/4" 23,9x29,2x1,5	2
				12	504036	Seal 1/4" 11,6x16,5x1,5	2
				11	504038	Seal 1/2" 18,5x23,9x1,5	2
				10	504097	Seal Flange 1-1/2"	3
				9	500603	Seal Flange 1-1/4"	3
				8	500601	Seal Flange 1"	3
				7	500600	Seal Flange 3/4"	3
				6	189069365	Sticker "Free to tank"	2
				5	508152	Sticker "Maintenance"	4
				4	508113	Sticker "Safety"	4
				3	503638	Testpoint 7/16"UNF	2
				2	500740	Testpoint G1/4"	2
				1	508137	Toolbox 580x290x300	1
				POS	PARTNUMBER	PARTNAME	QT
45	251065237	Back-up ring 50,0x 44,6x1,4	2				
44	504026	Back-up ring 44,5x42,5x2,9	2				
43	290058186	Blanking end M33x2 OR	1				
42	290058185	Blanking end M27x2 OR	1				
41	290058184	Blanking end M22x1,5 OR	1				
40	290066544	Blanking end M10x1,0 OR	1				
39	500654	Blanking end 1" -WD	1				
38	500653	Blanking end 3/4"-WD	1				
37	500652	Blanking end 1/2"-WD	1				
36	500651	Blanking end 3/8"-WD	1				
35	500650	Blanking end 1/4"-WD	1				
34	500649	Blanking end 1/8"-WD	1				
33	502562	Bleedingscrew M10 L=58,5	2				
32	120075770	Blanking screw M8x1,0	4				
31	502000	Filter line built-in	2				
30	506046	Glue Loctite 2701 5ml	1				
29	195050158	Glue TT62 pump gel	1				
28	508139	Grease cartridge	1				
27	508138	Grease pistol	1				
26	500560	Grease-nipple, straight M10x1	10				

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	Date	June 2022		
	Product type	DXS-50-A		
Additional parts	Number	n.a.		

Chemical lock

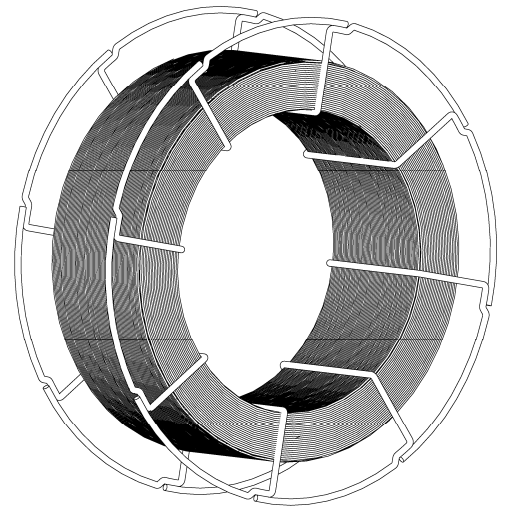
195050158	Cyberbond TT62 Pumpgel	1
506018	Loctite 480 Flacon 20 gr	1
506017	Loctite 638 Flacon 50 ml	1
506016	Loctite 270 Flacon 50 ml	1
PARTNUMBER	PARTNAME	QT



MAG welding wire

- for hard facing cutting blades
- 48-52 HRc
- Standards;
 - AWS A 5.21: no standard
 - EN ISO 14700: ~S Fe14
 - DIN: W.Nr. 1.8425
 - DIN 8555: MSG 2-GZ-500

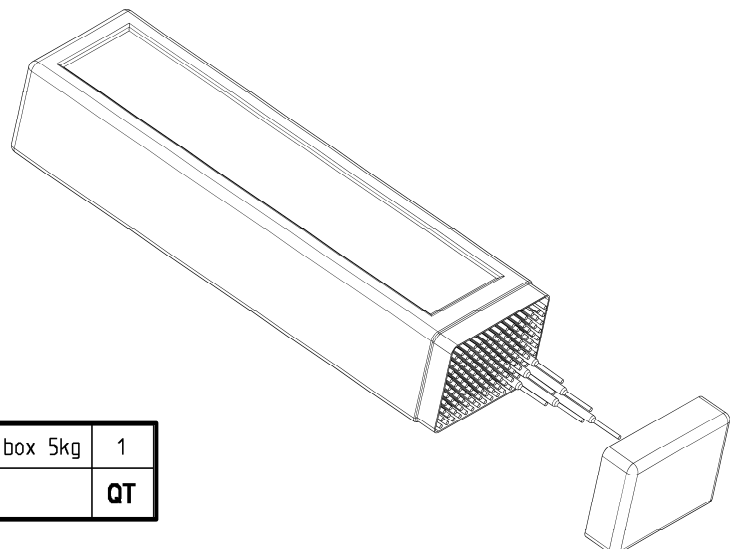
501237	Welding wire MAG; 1.8425, coil 15kg	1
PARTNUMBER	PARTNAME	QT



Welding electrodes

- for hard facing cutting blades
- 48-52 HRc
- Standards;
 - AWS A 5.21: no standard
 - EN ISO 14700: ~S Fe14
 - DIN: W.Nr. 1.8425
 - DIN 8555: MSG 2-GZ-500

501238	Weld. electr.:1.8425, Ø 2.5mm, box 5kg	1
PARTNUMBER	PARTNAME	QT



Rotatable Shear	Page	38	of	38
	Date	June 2022		
	Product type	DXS-50-A		
Instructions	Number	n.a.		

Mounting instructions for Cyberbound TT 62

This instruction shall guarantee that all hydraulic fittings and cartridges will be mounted and glued in correctly.

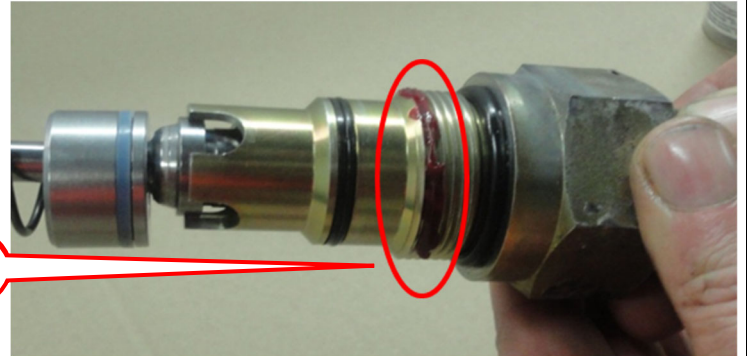
Procedure:

Clean and degrease thoroughly all components with a special cleaner for anaerobic adhesives (e.g. Loctite cleaner 7063) or acetone.

Apply on the outside thread only a bead of Cyberbond TT62 pump gel to approx. 2/3 of the girth of the second thread for fittings up to a diameter of 20mm or to the entire girth for fittings with a diameter larger than 20mm.



Cyberbound
TT 62



Clean from adhesive residues pressed out from the bore hole after fitting.

ATTENTION. The sealings shall be free of adhesive residues!

Tighten fittings with given fastening torques.

Standard torque values for bolts

(when not indicated)

Thread size	Torque (Nm) for quality		
	8.8	10.9	12.9
M8	22,5	32,4	38,7
M10	45,0	63,0	75,6
M12	77,4	109,0	131,0
M16	194,0	270,0	324,0
M20	369,0	522,0	630,0
M24	639,0	900,0	1080,0
M27	945,0	1305,0	1575,0
M30	1260,0	1800,0	2160,0



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