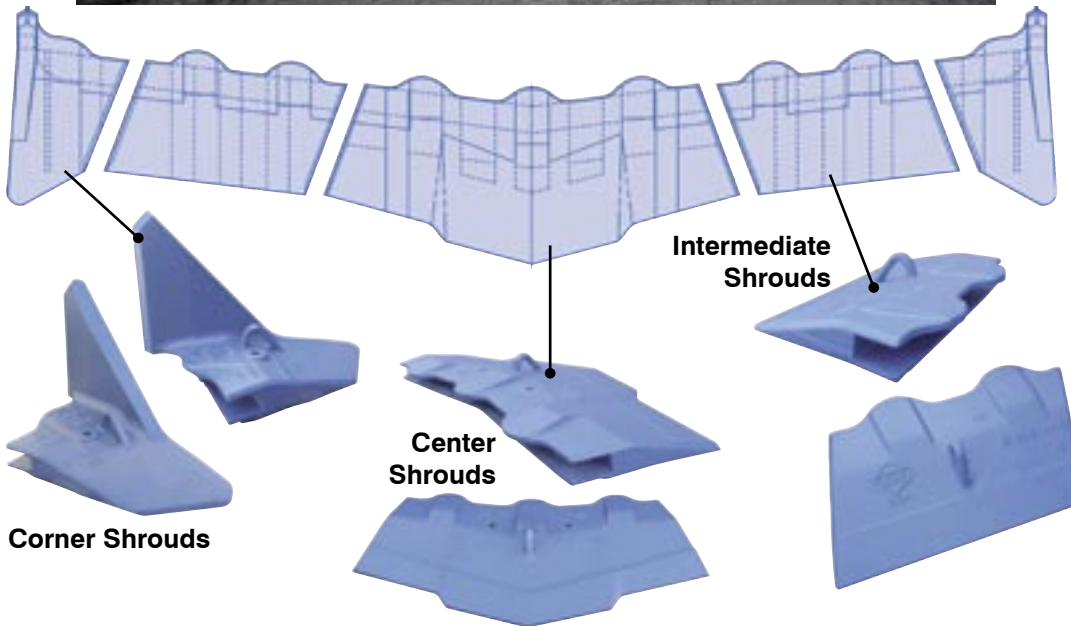




Cast Alloy Lip Shrouds for LHD Trams



Photo courtesy of Atlas Copco



Hensley cast alloy lip shrouds provide maximum wear and protection for bucket lips used on LHD (load-haul-dump) tram loaders.

Hensley has designed these shrouds with the following features:

- Extra material in high wear areas.
- Sharp contour for better penetration.
- Versatility to fit several different bucket widths.

These features add up to longer wear life and increased production between lip shroud change-outs.

Installation is fast and easy. Just trim the shrouds to the required length, then follow our simple welding instructions.

Use Hensley cast alloy lip shrouds on your next lip change-out.

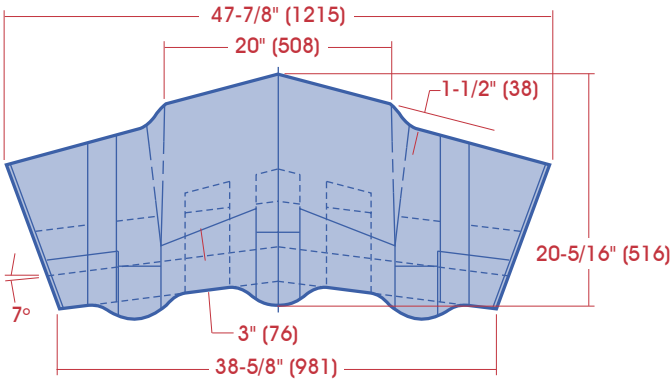
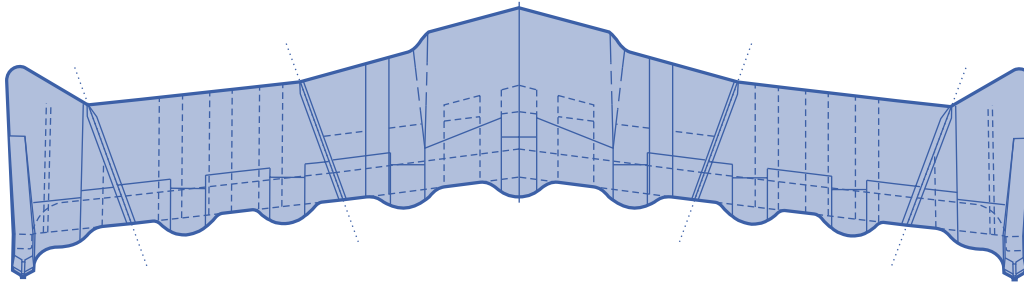


Photo courtesy of Atlas Copco



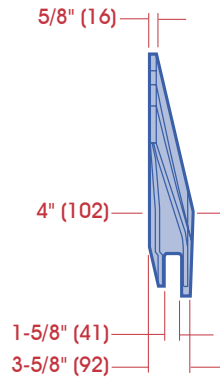
Cast Alloy Lip Shrouds for LHD Trams

Welding Instructions



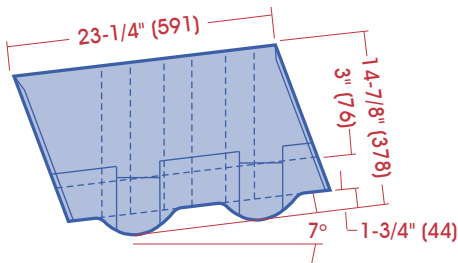
Center Shroud

18-7252HX (370.0 lbs./168.0 kg.)



Center Shroud

End View

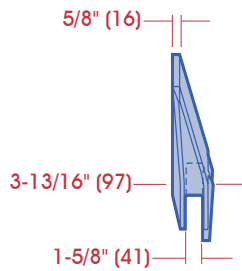


Intermediate Shroud

Left Hand Shown;

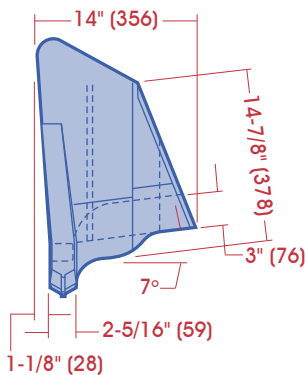
Right Hand Opposite

18-5370HX (143.0 lbs./64.9 kg.)



Intermediate Shroud

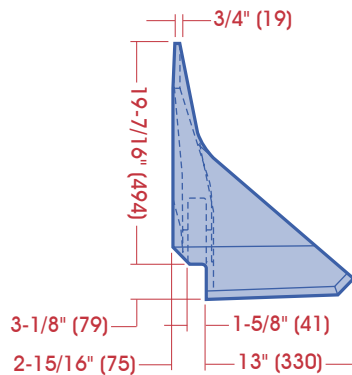
End View



Corner Shroud

Left Hand

ET10015LHX (150.0 lbs./68.1 kg.)



Corner Shroud

End View

(Read all instructions carefully before welding.)

The material of the cast lip assembly is Hensley alloy #3, which has been heat-treated to a hardness of approximately 477 Brinell. The alloy is a nickel/chrome/molybdenum steel with approximately 0.20% carbon. Therefore, the material is quite weldable if the proper precautions are followed.

Recommendations:

- Use E7018 low hydrogen rod or E70 wire. Be sure the welding materials are free of moisture.
- Preheat to 350° - 500° F (175° - 257° C).
- Interpass temperature should not exceed 500° F (260° C).
- Start at the center of the blade and weld toward the edges of the bucket.
- Use 2" (51mm) minimum tack welds on both sides.
- Weld both sides alternately between passes.
- Remove all slag subsequent to weld passes.
- Post-heat the entire assembly uniformly to 350° - 400° F (176° - 204° C) and cover with a thermal blanket. This serves as stress relief and to temper any martensite that may have formed during cooling from the weld. This is important as the steel contains a

Safety First: Hensley recommends that you use a soft-faced hammer and ANSI-approved (Z87-1) eye protection while using our products.

Your Authorized Hensley Dealer

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