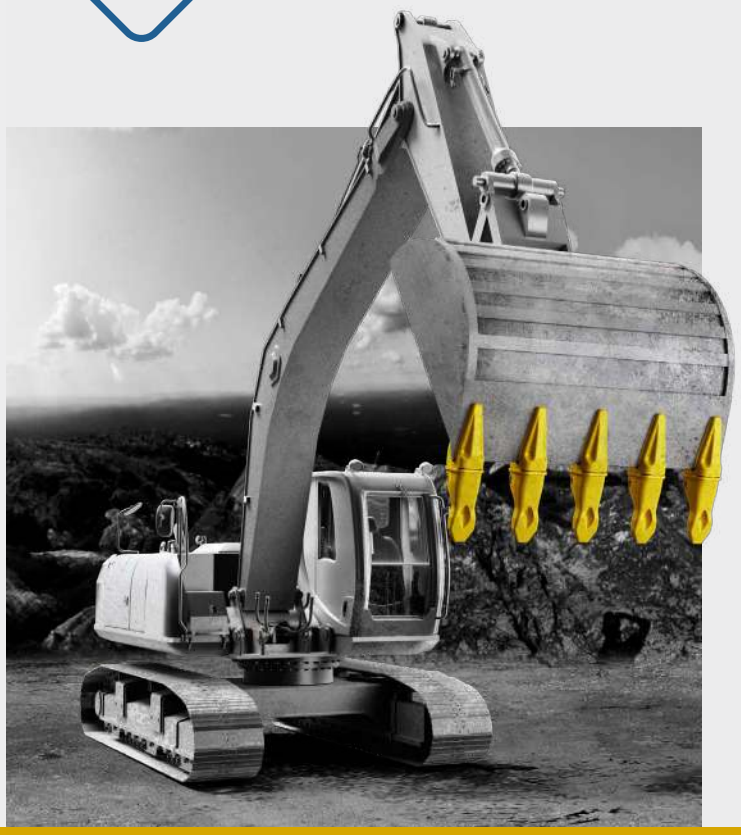
ESTI



# Gold

BUCKET TOOTH SYSTEM

ACCIAIERIE VENETE SPA

# Gold

## BUCKET TOOTH SYSTEM

## Size couplings

| |  |  |  |  |  |  |
|---|---|---|---|---|---|---|
| **SIZE** | **1** | **2** | **3** | **4** | **5** | **6** |
| **G1** | E 961 | E 981 | E 901 | - | E 921 | E 741 |
| **G6** | E 966 | E 986 | E 905 | E 906 | E 926 | E 745 |
| **G8** | - | - | - | E 908 | E 928 | E 746 |
| **G13** | - | - | - | E 913 | E 933 | E 751 |
| **G15** | - | - | - | E 915<br>E 915.1 | E 935 | E 753 |
| **G17** | - | - | - | E 917 | E 937 | E 755 |

# Gold

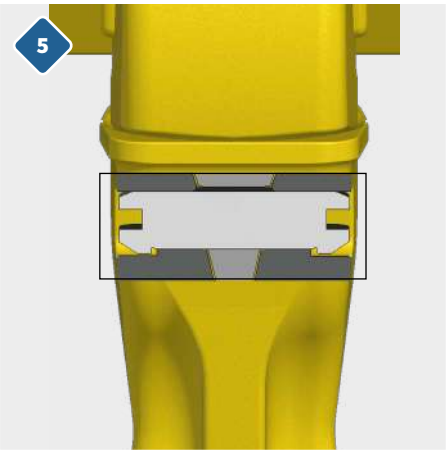
PATENT PENDING


Simple and reliable assembly

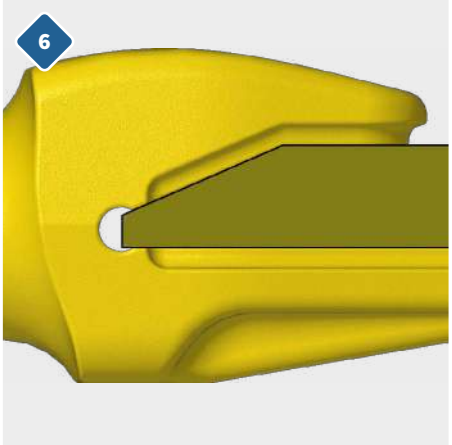

Replacement of parts with bucket in any position (no effect of gravity)


No holes in the nose of the adapter


No sharp edges on the nose of the adapter




Totally secured locking (not stressed during use, tied only to the tip)

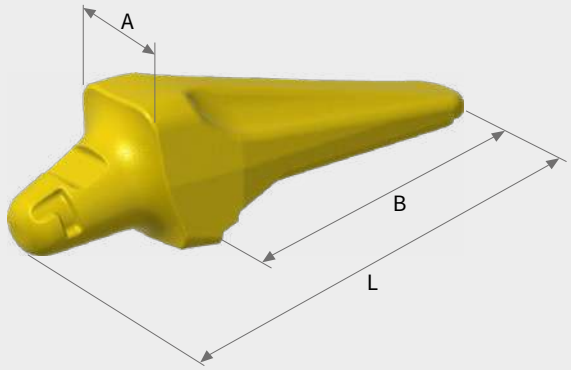



Optimized shapes for all ESTRONG profiles

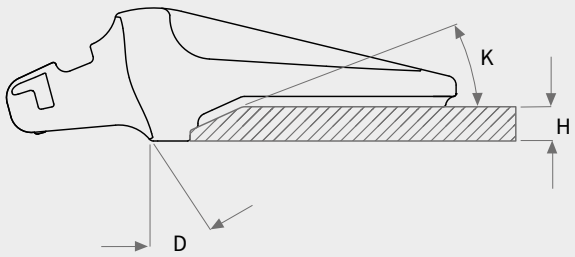
## Legend

| | |
|---|---|
| | REFERENCE |
| | WEIGHT |
| | BREAKOUT WEIGHT |
| | ADAPTER |
| | TIP |
| | LOCK |

# Gold type weld-on adapters for loaders

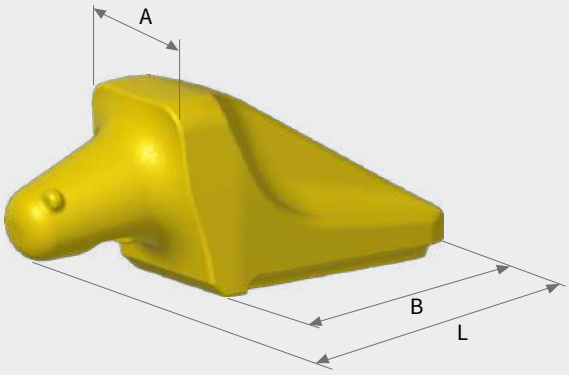



1

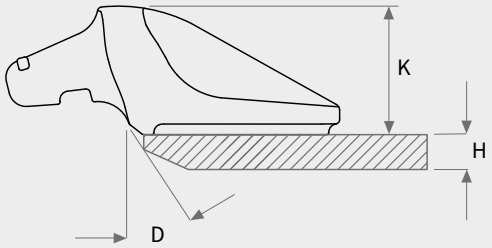



| SIZE | | L | A | B | K | H | D | KG | KG | |
|---|---|---|---|---|---|---|---|---|---|---|
| G1 | E 961 | 171 | 46 | 101 | 24° | 12 - 16 | 15° | 1,0 | 3500 | E 921 |
| G6 | E 966 | 228 | 60 | 140 | 23° | 20 | 15° | 2,2 | 6000 | E 926 |

# Gold type weld-on adapters for clamshell buckets

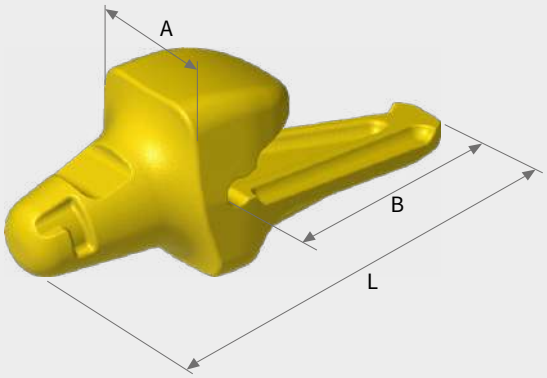



2

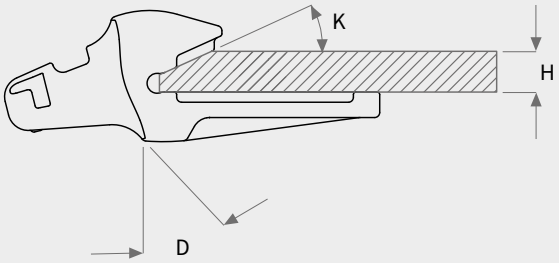



| SIZE | | L | A | B | K | H | D | KG | KG | |
|---|---|---|---|---|---|---|---|---|---|---|
| G1 | E 981 | 153 | 46 | 90 | 59 | 12 - 16 | 14° | 1,3 | 3500 | E 921 |
| G6 | E 986 | 195 | 60 | 117 | 77 | 20 | 14° | 2,8 | 6000 | E 926 |

# Gold type weld-on adapters for mini excavators

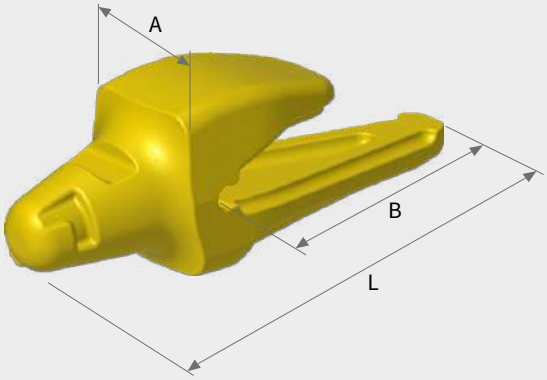



3

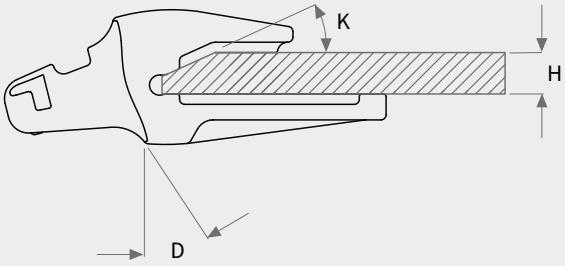



| SIZE | | L | A | B | K | H | D | KG | KG | |
|---|---|---|---|---|---|---|---|---|---|---|
| G1 | E 901 | 147 | 46 | 89 | 24° | 16 | 14° | 0,8 | 3500 | E 921 |
| G6 | E 905 | 174 | 60 | 104 | 24° | 16 - 20 | 13,5° | 1,6 | 6000 | E 926 |

# Gold type weld-on adapters for excavators

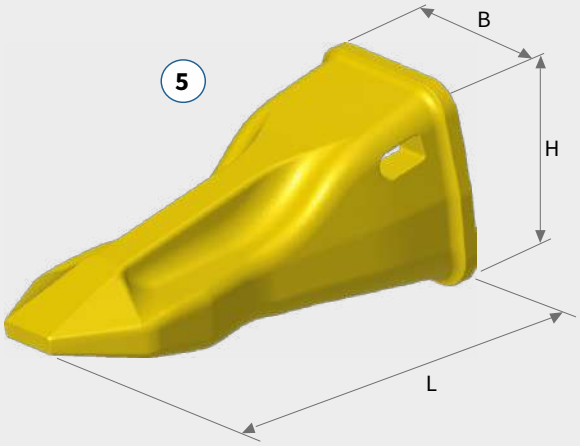



4



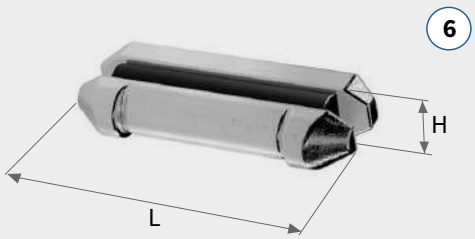

| SIZE | | L | A | B | K | H | D | KG | KG | |
|---|---|---|---|---|---|---|---|---|---|---|
| G6 | E 906 | 179 | 60 | 109 | 23° | 20 | 12,5° | 1,8 | 6500 | E 926 |
| G8 | E 908 | 222 | 68 | 137 | 23° | 25 | 11° | 2,8 | 8500 | E 928 |
| G13 | E 913 | 300 | 90 | 187 | 23° | 30 | 9° | 6,9 | 14000 | E 933 |
| G15 | E 915.1 | 338 | 104 | 209 | 23° | 35 | 9° | 9,4 | 17000 | E 935 |
| G15 | E 915 | 338 | 104 | 207 | 24° | 40 | 9° | 9,0 | 17000 | E 935 |
| G17 | E 917 | 438 | 128 | 272 | 24° | 50 | 8° | 19,2 | 26500 | E 937 |

# Gold type tips



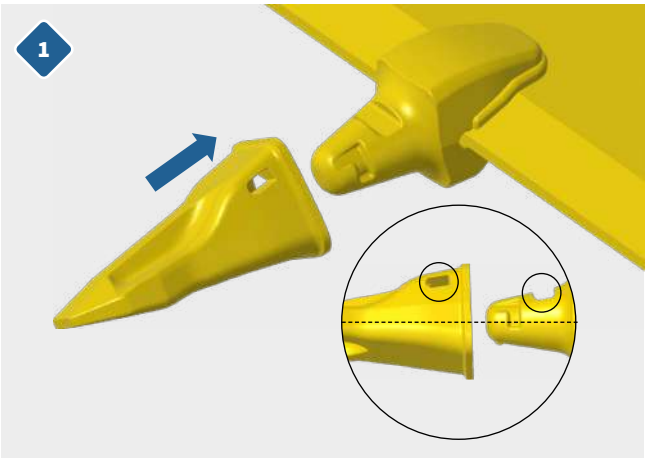

| SIZE | | L | B | H | KG | | |
|---|---|---|---|---|---|---|---|
| G1 | E 921 | 109 | 50 | 52 | 0,7 | E 901 - E 961 - E 981 | E 741 |
| G6 | E 926 | 142 | 65 | 72 | 1,5 | E 905 - E 906<br>E 966 - E 986 | E 745 |
| G8 | E 928 | 158 | 74 | 78 | 2,0 | E 908 | E 746 |
| G13 | E 933 | 227 | 98 | 105 | 5,0 | E 913 | E 751 |
| G15 | E 935 | 252 | 110 | 112 | 6,8 | E 915 - E915.1 | E 753 |
| G17 | E 937 | 324 | 130 | 142 | 14,0 | E 917 | E 755 |

# Gold type locks

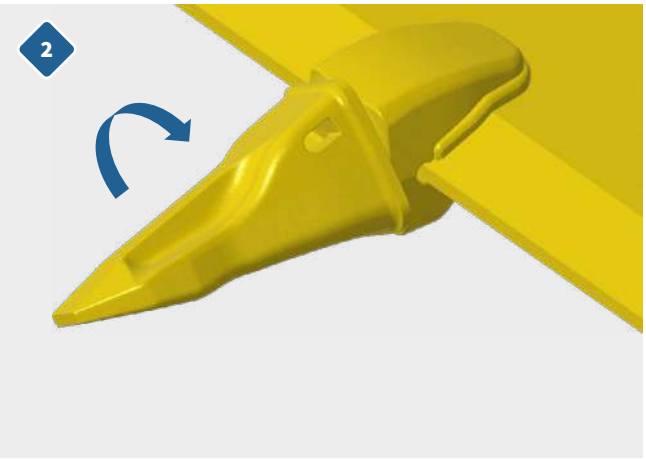



| SIZE | | L | H | | |
|---|---|---|---|---|---|
| G1 | E 741 | 43 | 8 | E 901 - E 961 - E 981 | E 921 |
| G6 | E 745 | 56 | 10 | E 905 - E 906<br>E 966 - E 986 | E 926 |
| G8 | E 746 | 64 | 10 | E 908 | E 928 |
| G13 | E 751 | 84 | 12 | E 913 | E 933 |
| G15 | E 753 | 102 | 13 | E 915 - E915.1 | E 935 |
| G17 | E 755 | 108 | 15 | E 917 | E 937 |

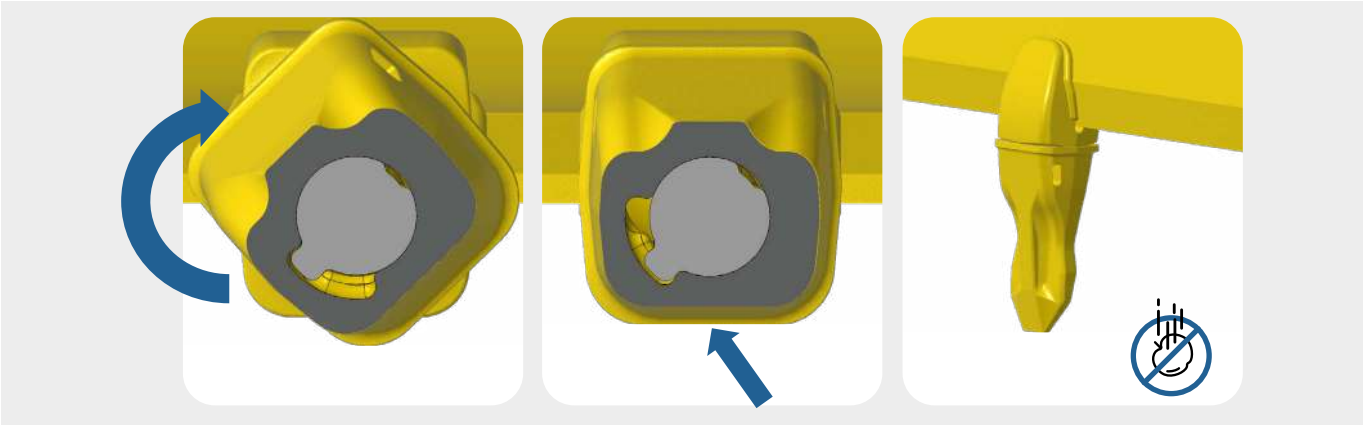
# Installation and removal

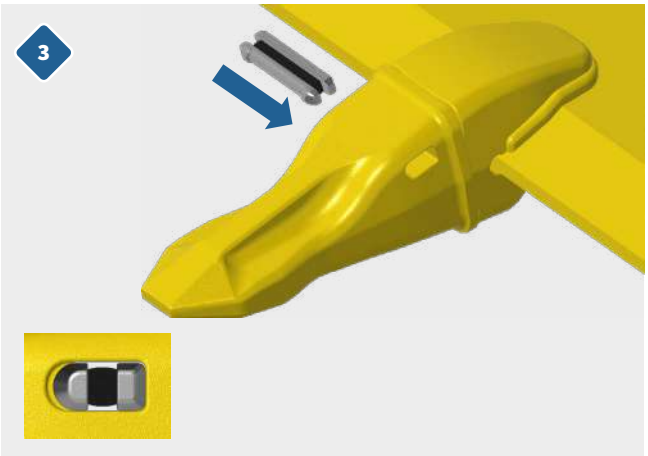



Assemble the tip on the already welded adapter, orienting it as in the figure

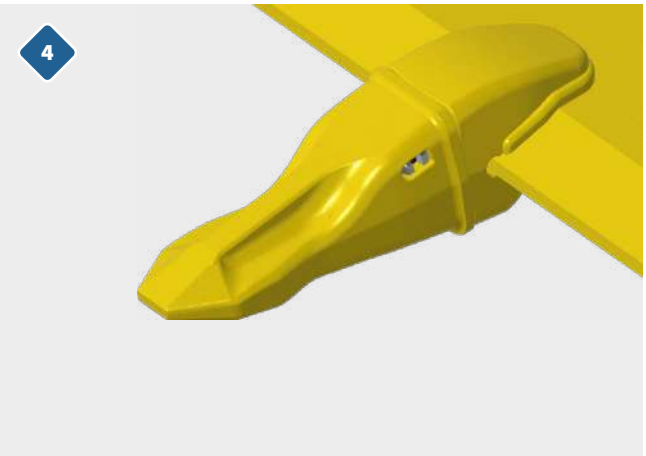



Rotate the tip completely, with complete rotation the components are constrained in such a way as to cancel the effect of the force of gravity





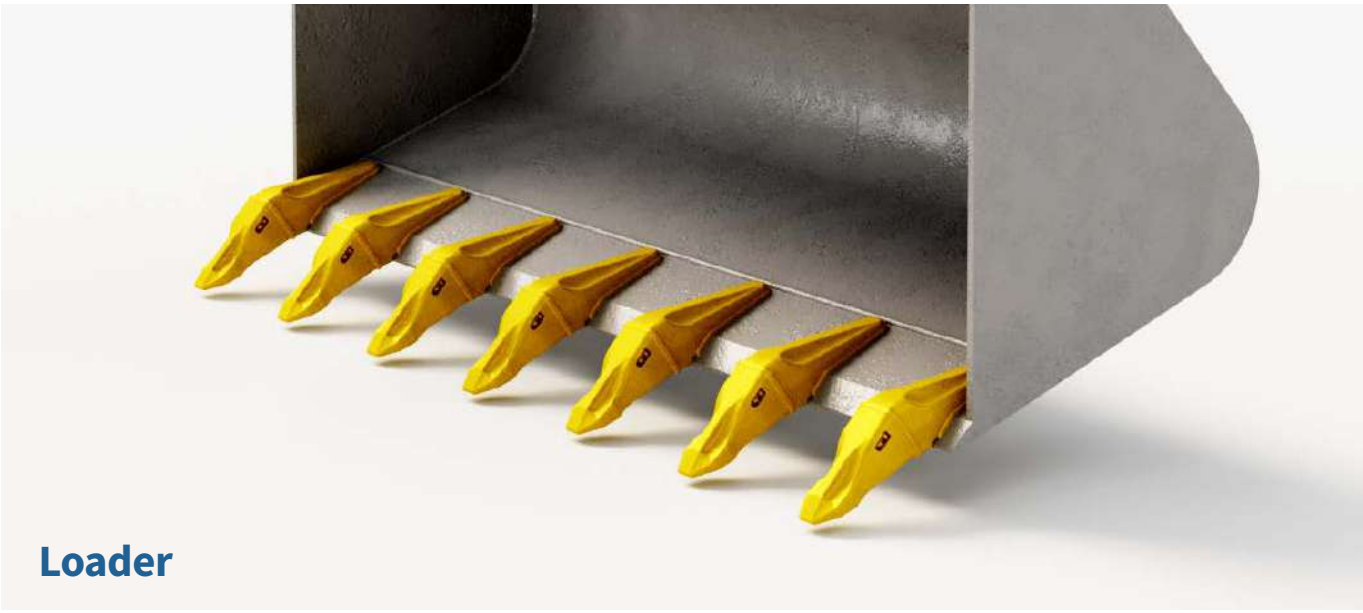

Position the lock in the hole of the tip according to the shape, and insert it along its entire length with a tool




Assembly completed

**To disassemble, remove the lock with a tool and repeat the previous steps in reverse order.**

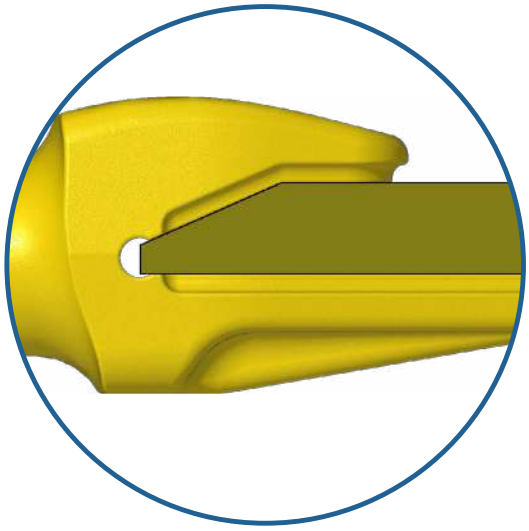
## Excavator



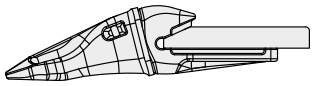
## Loader

## Clamshell

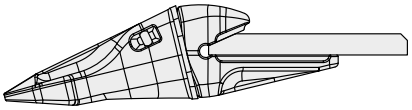
# Matching ESTRONG cutting edges



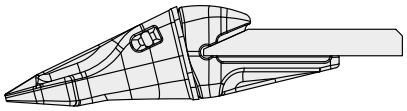
The adapters match perfectly with the complete range of ESTRONG profiles.



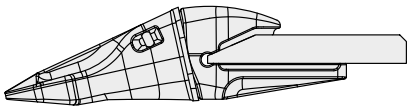
**E 901**
110x16



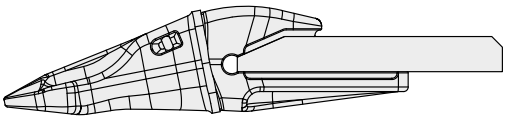
**E 905**
150x16



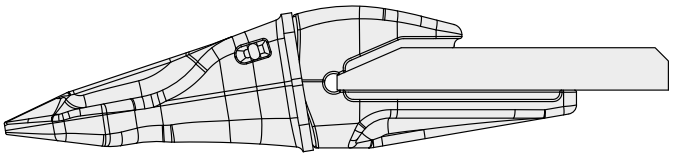
**E 905**
150x20



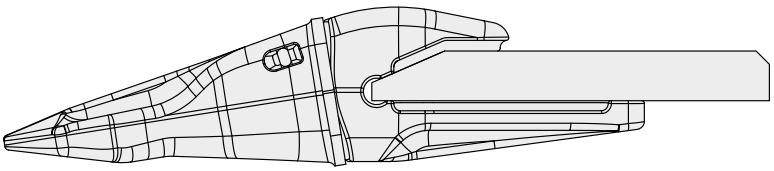
**E 906**
150x20



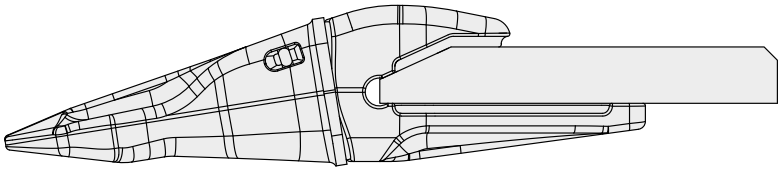
**E 908**
200x25



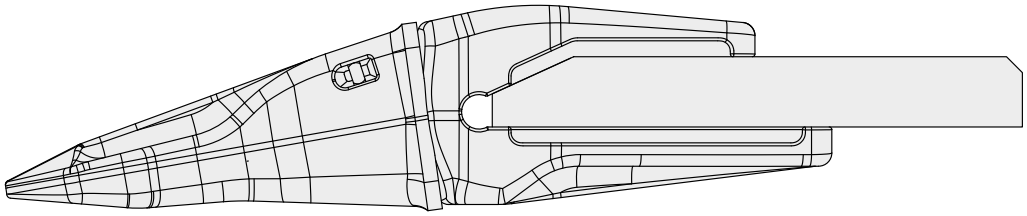
**E 913**
250x30



**E 915.1**
300x35

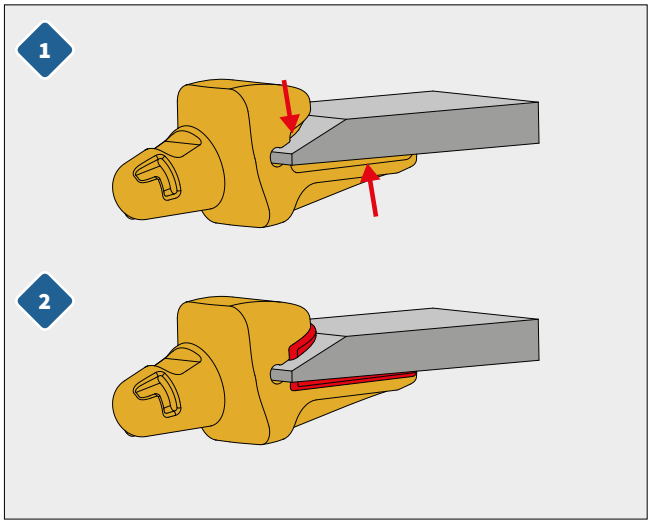


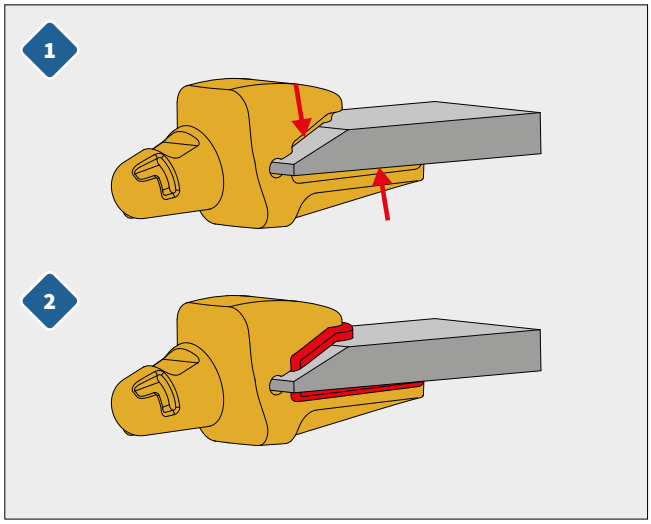
**E 915**
300x40

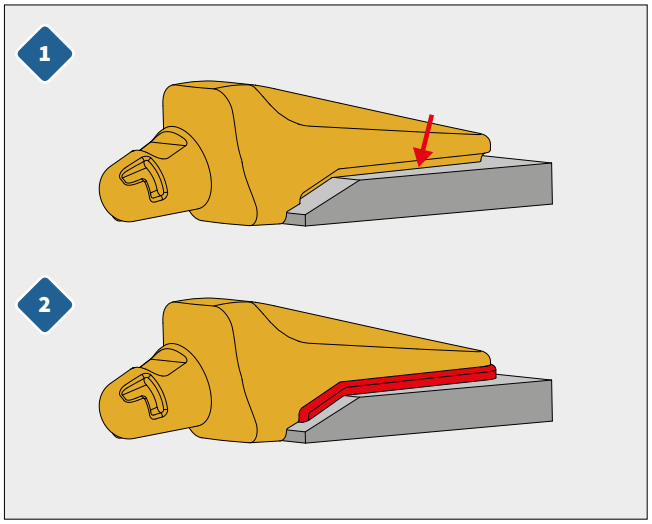


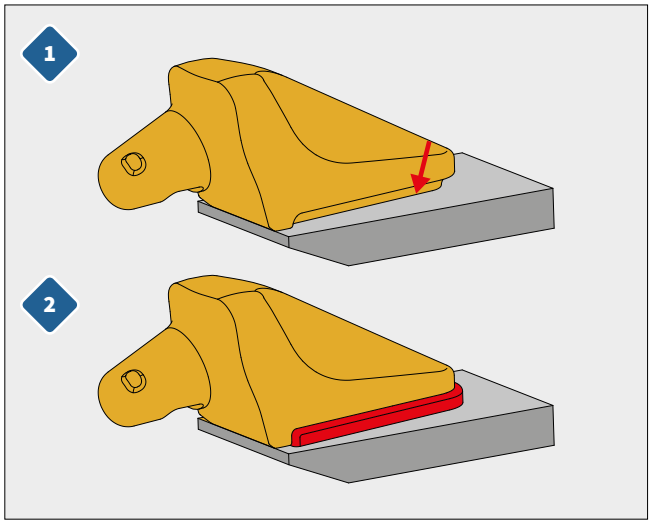
**E 917**
400x50

# Welding



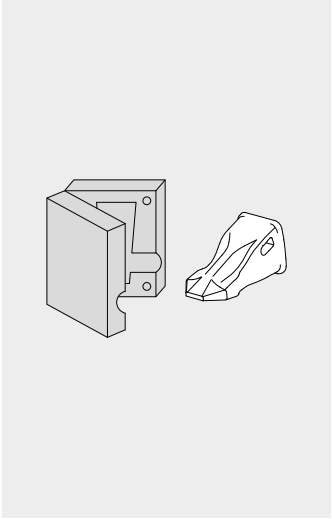




- The joint surfaces must be clean and dry. A good cleaning avoids formation of blowholes during the welding.
- Place the adapter making sure that the coupling with the blade is correct (fig. 1).
  Then weld the adapter by some points.
- It is advisable to carry out preheating of the parts being welded. Such operation does favor the emission of Hydrogen from steel reducing the risk of cracking.
- Use a basic flux with a low hydrogen content.
- Place the weld metal in the suitable spaces indicated by pointers (fig. 1).
- The width of the welding must be proportional to the dimensions of the adapter (fig. 2).

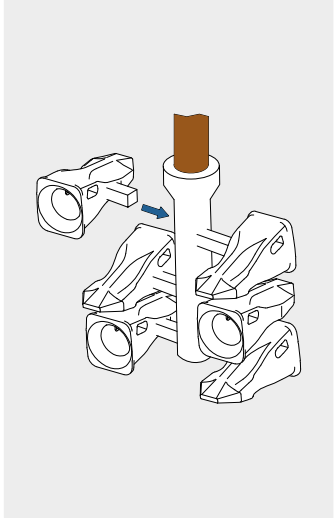
**ATTENTION:** never weld the assembled set on the blade.
This operation could damage the lock.

# General information

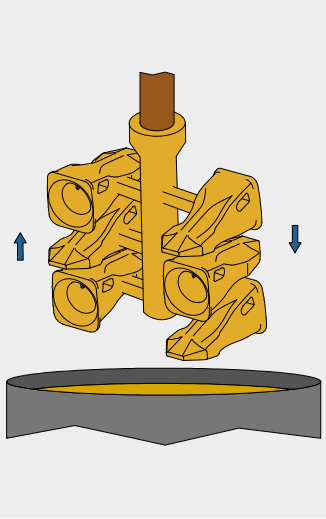
Tips and adapters are produced in hardened and tempered alloy steel, through lost foam casting.



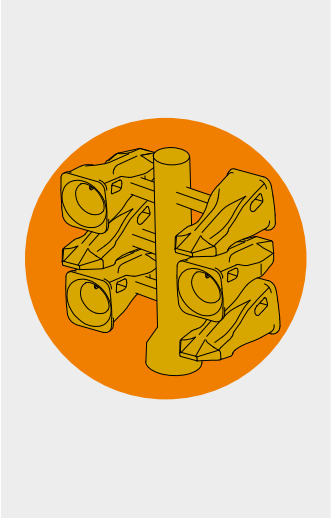
1 **Foam injection**



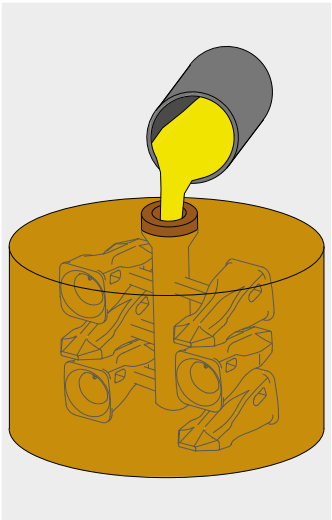
2 **Assembly**



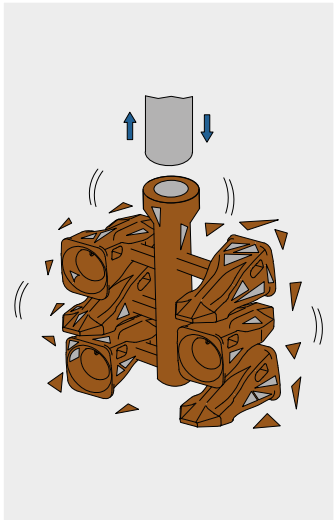
3 **Shell building**



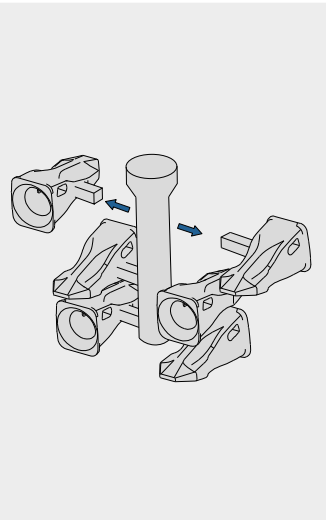
4 **Burnout**



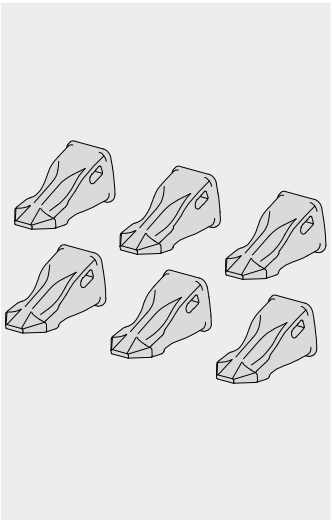
5 **Pouring**



6 **Knock out**

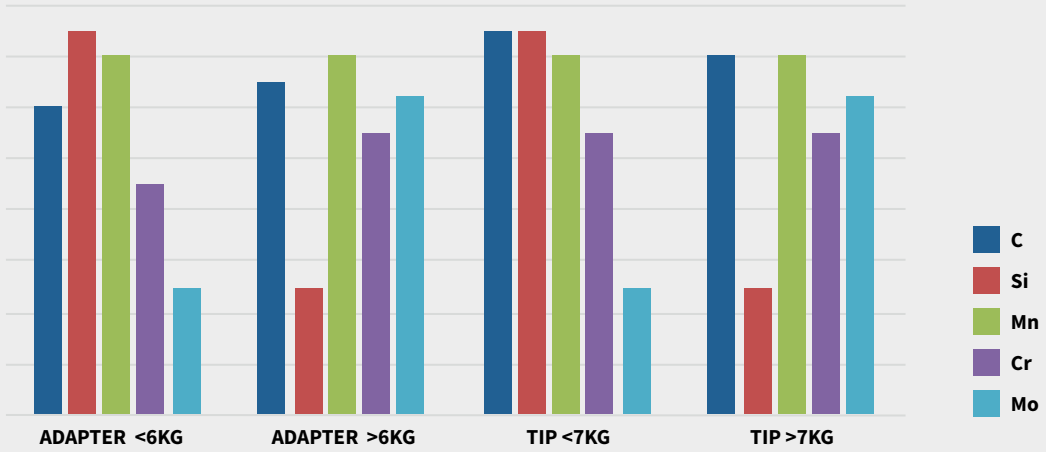


7 **Cut off**



8 **Finished castings**

The chemical composition of the steel used for tips and adapters is obtained from 30CrMo4, with optimization of the alloying elements to ensure adequate hardening depth for all sizes.




**Indicative mechanical features of tips**

| | |
|---|---|
| **Hardness:** | **450-500 HB** |
| **Tensile strength:** | **>1500 Mpa** |
| **Yield:** | **>1200 Mpa** |

---

Locks are made up of two metal inserts linked together through an internal rubber part, they have high elasticity and are reusable.

They can be used with temperature ranging from **-40 °C** a **+125 °C.**

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