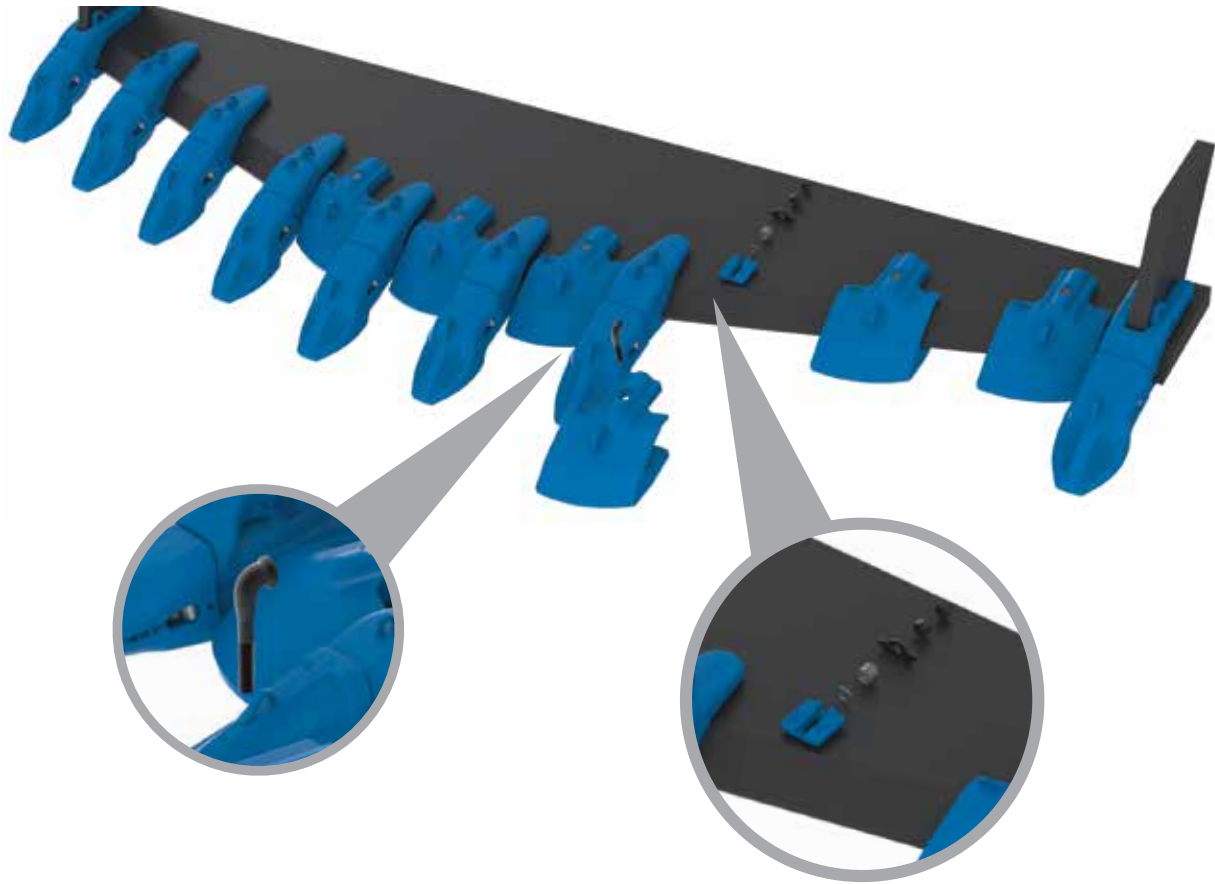


J-BOLT LIP SHROUDS
FOR LOADERS AND SHOVELS
2" – 6 1/4" Lip Thickness
INSTALLATION GUIDE

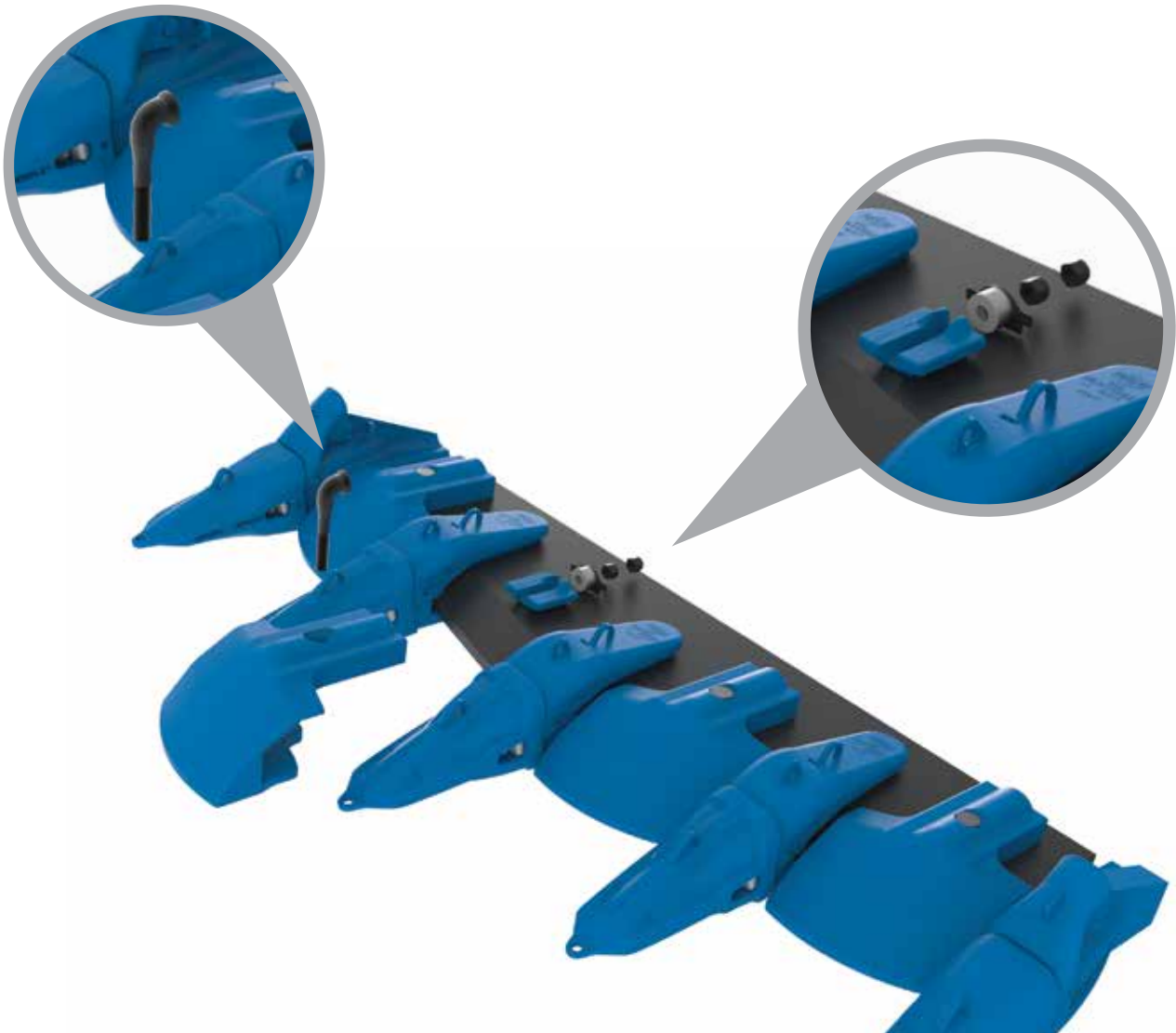


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J-Bolt bases	8
J-Bolt assemblies	9
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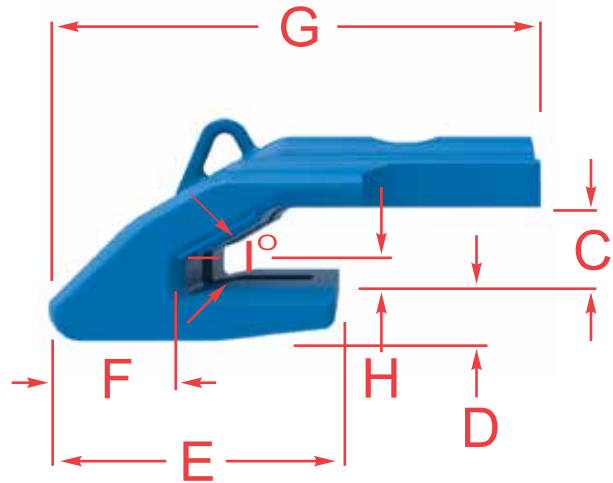
Safety First! Hensley Industries, Inc. recommends following all safety protocols when using our products and utilizing all PPE. PPE should comply with worksite regulations as well as any applicable local, state or federal requirements (OSHA and MSHA) to help avoid injuries. Keep others at the safe distance to ensure safety.



Hensley J-Bolt lip shrouds offer a quick and effective solution to add wear protection to large loader and hydraulic shovel lips. Some simple welding is required to initially attach the mounting base to the lip. The shrouds are mechanically attached to the base making installation, removal and replacement as easy as turning a socket. Mechanically attached shrouds are made from a hard alloy, achieving greater wear and abrasion resistance than weld-on shrouds.

- Hensley J-Bolt lip shrouds are a mechanical system for easy assembly.
- Higher hardness than weld-on shrouds for longer wear life.
- Currently available for 2" [50 mm] through 6-1/4" [160 mm] lips.
- Mechanical system is self-tightening to the lip, reducing wear.
- Shroud changes are quick, downtime is reduced.
- Safe installation and removal.

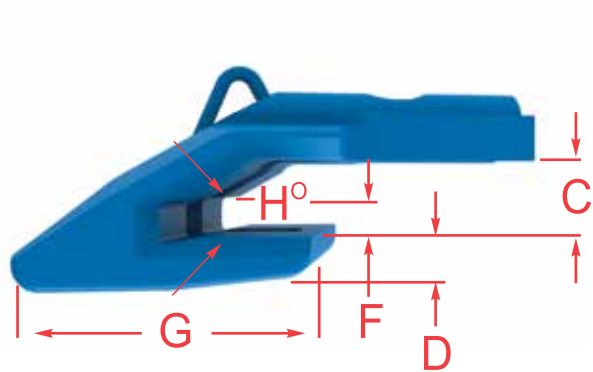
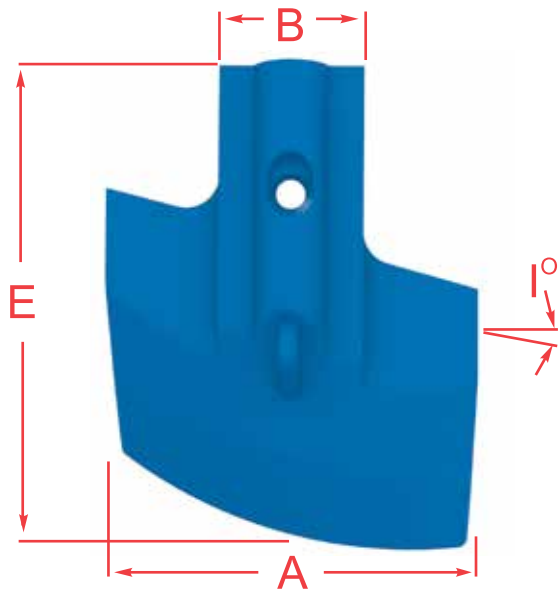
J-BOLT SHROUDS CENTER



LIP THICKNESS INCHES	CENTER SHROUD	DIMENSIONS - INCHES (MM)								DEG.	LIP BLUNT	WEIGHT LB/KG	WELD BASE	J-BOLT	MACHINE TYPE
		A	B	C	D	E	F	G	H						
2	LS2001350J	13-1/2 [343]	5 [127]	2-1/8 [54]	1-3/8 [35]	8-1/4 [210]	3-1/2 [89]	13-5/8 [346]	3/4 [19]	30°	1/2 [12]	64/ 29	LSWB3	SFA34J4	FEL
2-1/2	LSL2501300J	13 [330]	5 [127]	2-5/8 [66]	2-1/2 [63]	13-3/8 [346]	5-1/2 [139]	20-3/16 [512]	5/8 [15]	30°	1/2 [12]	169/ 76	LSWD3	SFA34J4	FEL
	LS2501500J	15 [381]	5 [127]	2-5/8 [67]	1-5/8 [41]	9-3/4 [248]	4-1/2 [114]	15 [381]	1-1/16 [27]	30°	5/8 [15.8]	82/ 37.2	LSWB3	SFA34J4	FEL
	LS2501500J2L	15 [381]	5 [127]	2-3/8 [61]	2-5/8 [66]	5-3/16 [132]	4-5/8 [117]	15 [381]	1-1/8 [28]	30°	5/8 [15.8]	125/ 57	LSWB3	SFA34J4	FEL
2-3/4	LS2751675J	13-3/4 [425]	6-1/2 [165]	2-7/8 [48]	1-7/8 [48]	11 [279]	6-3/8 [162]	18-3/4 [476]	1-5/8 [41]	35°	1-9/32 [32.5]	160/ 72.6	LSWB8	SFA1J4	FEL
3	LS3001000J	10 [254]	6-1/2 [165]	3-3/16 [81]	2 [51]	11-3/16 [284]	7-13/16 [198]	17-11/16 [449]	3-3/16 [81]	Blunt	N/A	125/ 56.7	LSWB8	SFA1J4	BH/HFS
	LS3001000J2B	10 [254]	6-1/2 [165]	3-1/8 [79]	2 [51]	12-1/8 [308]	6-3/8 [162]	20-11/16 [525]	15/16 [23]	30°	3/4 [19]	143/ 64.9	LSWB8	SFA1J4	BH/HFS
	LS3001600J	16-3/8 [416]	6-3/8 [162]	3-1/4 [82]	3-1/4 [83]	13 [331]	7-1/4 [184]	24-1/2 [622]	1-5/8 [41]	30°	3/4 [19]	277/ 125.6	LSWB8	SFA1J4	FEL
	LS300M256J	10 [256]	6-1/2 [165]	3-1/4 [82]	2 [51]	5-3/4 [146]	6-3/8 [162]	22 [556]	1-5/8 [41]	30°	3/4 [19]	144/ 65.4	LSWB8	SFA1J4	BH/FFS
3-1/2	LS3501250J	12-1/2 [317]	6-1/2 [165]	3-11/16 [91]	2-3/4 [70]	18-1/2 [470]	6-3/8 [162]	20-11/16 [525]	1 [25]	30°	7/8 [22]	180/ 81.7	LSWB8	SFA1J4	BH/HFS
	LS3501750J	17-1/2 [444]	6-1/2 [165]	3-9/16 [91]	3-1/2 [89]	12-1/8 [308]	6-3/8 [162]	20-5/8 [525]	1 [25]	30°	7/8 [22]	285.5/ 129.6	LSWB8	SFA1J4	FEL
	LS350M275J	10-7/8 [276]	6-1/2 [165]	3-9/16 [91]	2-3/4 [70]	5-3/4 [146]	6-3/8 [162]	20-11/16 [526]	1-3/8 [37]	30°	7/8 [22]	162/ 73.5	LSWB8	SFA1J4	BH/HFS
	LS350925J	9-1/4 [234]	6-1/2 [165]	3-9/16 [91]	2-1/2 [63]	11-1/2 [292]	3-3/4 [95]	20-1/32 [508]	1-1/16 [26]	30°	7/8 [22]	132/ 59.8	LSWB8	SFA1J4	BH/HFS

LIP THICKNESS INCHES	CENTER SHROUD	DIMENSIONS - INCHES (MM)								DEG.	LIP BLUNT	WEIGHT LB/KG	WELD BASE	J-BOLT	MACHINE TYPE
		A	B	C	D	E	F	G	H						
4	LS400900J	9 [229]	6-1/2 [165]	4-3/16 [106]	2-3/4 [70]	12-1/8 [308]	6-3/8 [162]	21-3/4 [552]	1-3/16 [30]	30°	1 [25]	160/ 72.6	LSWB8	SFA1J4	HFS
	LS4001175J	11-3/4 [298]	6-1/2 [165]	4-1/16 [103]	1-5/16 [33]	10-11/16 [271]	4-13/16 [122]	20-7/16 [519]	1-1/4 [32]	30°	1 [25]	110/ 50	LSWB1	SFA1J3	FEL
	LS4001200J	12 [305]	6-1/2 [165]	4-3/16 [106]	2-3/4 [70]	12-1/8 [308]	6-3/8 [162]	21-3/4 [553]	1-1/4 [32]	30°	1 [25]	187/ 84.8	LSWB8	SFA1J4	BH/HFS
	LS4001600J	16 [406]	6-1/2 [165]	4-3/16 [106]	2-3/4 [70]	12-5/8 [321]	6-3/8 [162]	21-3/4 [552]	1 [25]	30°	7/9 [19.8]	194/ 88	LSWB8	SFA1J4	FEL
	LS4001600JCS	16 [406]	6-1/2 [165]	4-3/16 [106]	1-3/4 [44]	11-3/4 [299]	6 [153]	21-3/4 [553]	1-1/4 [32]	30°	7/9 [19.8]	182/ 82.6	LSWB8	SFA1J4	BH/HFS
	LS4001750J	17-1/2 [445]	6-1/2 [165]	4-3/16 [106]	3-1/4 [83]	12-1/4 [311]	7-1/2 [191]	21-11/16 [551]	1-1/2 [38]	30°	1-11/32 [34]	290/ 131.6	LSWB8	SFA1J4	FEL
	LS4002450J	24-1/2 [622]	6-1/2 [165]	4-3/16 [106]	3-1/4 [83]	13-1/4 [337]	7-1/2 [190]	21-11/16 [551]	1-11/16 [43]	30°	1-11/32 [34]	380/ 172.5	LSWB8	SFA1J4	FEL
4-3/4	LS4751300J	13 [330]	8-3/8 [213]	4-15/16 [125]	2-1/4 [57]	7-1/4 [184]	7-3/8 [187]	26-7/8 [683]	1-3/4 [44]	30°	1-1/2 [40]	280/ 127	LSWB6	SFA125J6	BH/HFS
	LS4751400J	14 [356]	8-3/8 [213]	4-15/16 [125]	2-1/4 [57]	14-5/8 [372]	7-3/8 [187]	26-7/8 [683]	1-3/4 [44]	30°	1-1/2 [40]	262/ 118.9	LSWB6	SFA125J6	BH/HFS
	LS4751700J	17 [432]	8-3/8 [213]	4-15/16 [125]	2-1/4 [57]	14-5/8 [372]	7-3/8 [187]	26-7/8 [683]	1-3/4 [44]	30°	1-1/2 [40]	354/ 160.7	LSWB6	SFA125J6	BH/HFS
	LS4751950J	19-1/2 [495]	8-3/8 [213]	4-7/8 [123]	2-1/4 [57]	7-1/4 [184]	7-3/8 [187]	26-3/4 [679]	1-3/4 [44]	30°	1-1/2 [40]	374/ 169.6	LSWB6	SFA125J6	BH/HFS
5-1/2	LS5501600J	16 [406]	8-3/8 [213]	5-11/16 [144]	2-1/4 [57]	15-3/4 [400]	7-3/8 [187]	27-11/16 [705]	2 [51]	30°	1-7/10 [45]	361/ 163.7	LSWB6	SFA125J6	BH/HFS
	LS5501750J	17-1/2 [444]	8-3/8 [213]	5-11/16 [144]	2-1/4 [57]	15-3/4 [400]	7-3/8 [187]	27-3/4 [705]	2 [51]	30°	1-7/10 [45]	396/ 179.8	LSWB6	SFA125J6	BH/HFS
	LS5502200J	22 [559]	8-3/8 [213]	5-11/16 [144]	2-1/4 [57]	15-3/4 [400]	7-3/8 [187]	27-3/4 [705]	2 [51]	30°	1-7/10 [45]	388/ 176	LSWB6	SFA125J6	BH/HFS
6-1/4	LS6251400J	14 [356]	8-3/8 [213]	6-1/2 [165]	2-1/4 [57]	17-3/4 [451]	8 [203]	29-13/16 [757]	2 [51]	30°	2-1/10 [54]	330/ 149.8	LSWB6	SFA125J6	BH/HFS
	LS6251600J	16 [406]	8-3/8 [213]	6-7/16 [164]	2-5/8 [67]	17-3/4 [451]	8 [203]	29-13/16 [757]	2 [51]	30°	2-1/10 [54]	430/ 195	LSWB6	SFA125J6	BH/HFS
	LS6251800J	18 [457]	8-3/8 [213]	6-7/16 [164]	2-5/8 [67]	9-3/4 [248]	8 [203]	29-1/8 [740]	3 [76]	30°	2-1/10 [54]	467.5/ 212.1	LSWB6	SFA125J6	BH/HFS
	LS6252000J	20 [508]	8-3/8 [213]	6-7/16 [164]	2-5/8 [67]	9-3/4 [248]	8 [203]	29-1/8 [740]	2-5/16 [59]	30°	2-1/10 [54]	496/ 255	LSWB6	SFA125J6	BH/HFS

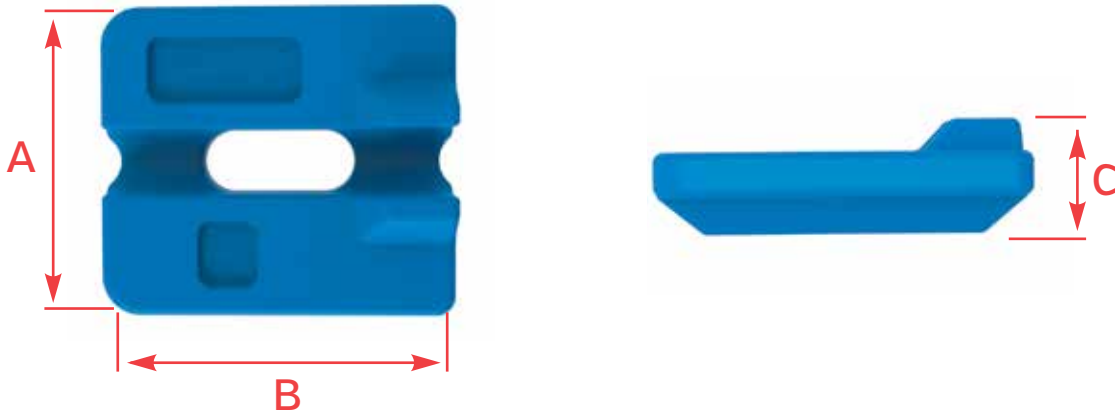
J-BOLT SHROUDS LEFT AND RIGHT HAND



LIP THICKNESS INCHES	ANGLE SHROUD	DIMENSIONS - INCHES (MM)							DEGREE		LIP BLUNT	WEIGHT LB/KG	WELD BASE	J-BOLT	MACHINE TYPE
		A	B	C	D	E	F	G	H	I					
2	LS2001350JR LS2001350JL	13-1/2 [343]	5 [127]	2-1/8 [54]	1-3/8 [35]	13-5/8 [346]	3/4 [16]	8-1/4 [210]	30°	10°	1/2 [12]	59/ 26.8	LSWB3	SFA34J4	FEL
2-1/2	L2501300JR L2501300JL	13 [330]	5 [127]	2-5/8 [67]	2-1/2 [63]	21-1/8 [536]	5/8 [15]	13-3/8 [339]	30°	15°	5/8 [15.8]	163/ 73.9	LSUB3	SFA34J4	FEL
	LS2501500JR LS2501500JL	15 [381]	5 [127]	2-5/8 [67]	1-5/8 [41]	15 [381]	1-1/16 [27]	9-3/4 [248]	30°	15°	5/8 [15.8]	82/ 37.2	LSWB3	SFA34J4	FEL
	LS2501500JR2L LS2501500JL2L	15 [381]	5 [127]	2-5/8 [67]	2-5/8 [67]	15-1/2 [394]	1-1/16 [27]	11-5/16 [287]	30°	15°	5/8 [15.8]	125/ 57	LSWB3	SFA34JA	FEL
2-3/4	LS2751675JR LS2751675JL	16-3/4 [425]	6-1/2 [165]	2-7/8 [73]	1-7/8 [48]	18-3/4 [476]	1-5/8 [41]	11 [279]	35°	15°	1-9/32 [32]	160/ 72.6	LSWB8	SFA1J4	FEL
3	LS3001000JR LS3001000JL	10 [254]	6-1/2 [165]	3-3/16 [81]	2 [51]	17-13/16 [452]	3-3/16 [81]	11-3/16 [284]	BLUNT	15°	N/A	127/ 57.6	LSWB8	SFA1J4	BH/HFS
	LS300M257JR LS300M257JL	10-1/8 [257]	6-1/2 [165]	3-1/4 [82]	2 [51]	22-5/8 [574]	1-5/8 [41]	12-1/8 [307]	30°	15°	3/4 [19]	146/ 66.3	LSWB8	SFA1J4	BH/HFS
	LS3001000JR2B LS3001000JL2B	10 [254]	6-1/2 [165]	3-1/8 [79]	2 [51]	21-7/8 [556]	5/16 [23]	14-5/16 [363]	29.1°	15°	3/4 [19]	146/ 66.2	LSWB8	SFA1J4	BH/HFS
	LS3001700JR LS3001700JL	17 [432]	6-3/8 [162]	3-1/4 [82]	3-1/4 [83]	25-13/16 [657]	1-5/8 [41]	12-3/4 [324]	30°	15°	3/4 [19]	294/ 133.4	LSWB8	SFA1J4	FEL

LIP THICKNESS INCHES	ANGLE SHROUD	DIMENSIONS - INCHES (MM)							DEGREE		LIP BLUNT	WEIGHT LB/KG	WELD BASE	J-BOLT	MACHINE TYPE
		A	B	C	D	E	F	G	H	I					
3-1/2	LS350925JR LS350925JL	9-1/4 [235]	6-1/2 [165]	3-9/16 [91]	2-1/2 [63]	20-7/16 [520]	1-1/16 [26]	13-9/16 [344]	29.1°	15°	7/8 [22]	132/ 59.9	LSWB8	SFA1J4	BH/HFS
	LS3501250JR LS3501250JL	12-1/2 [317]	6-1/2 [165]	3-9/16 [91]	2-3/4 [70]	22-1/8 [562]	1 [25]	11-15/16 [379]	30°	15°	7/8 [22]	180/ 81.7	LSWB8	SFA1J4	BH/HFS
	LS3501750JL LS3501750JR	17-1/2 [445]	6-1/2 [165]	3-9/16 [91]	3-1/2 [89]	20-1/2 [521]	1 [26]	12-1/8 [308]	30°	10°	7/8 [22]	287/ 130.2	LSWB8	SFA1J4	FEL
4	LS400900JR LS400900JL	9 [229]	6-1/4 [159]	4-5/32 [106]	2-3/4 [70]	22-7/32 [564]	1-1/4 [32]	12-1/8 [308]	30°	15°	1 [25]	162/ 73.5	LSWB8	SFA1J4	BH/HFS
	LS4001200JL LS4001200JR	12 [305]	6-1/4 [159]	4-3/16 [106]	2-3/4 [70]	21-7/8 [558]	1-1/4 [32]	14-1/16 [358]	30°	15°	1 [25]	176/ 79.8	LSWB8	SFA1J4	BH/HFS
	LS4001600JR LS4001600JL	16 [406]	6-1/2 [165]	4-3/16 [106]	2-3/4 [70]	21-3/4 [552]	1 [25]	12-5/8 [321]	30°	15°	7/9 [19.8]	207/ 93.9	LSWB8	SFA1J4	FEL
	LS4001600JRS LS4001600JLS	16 [406]	6-1/4 [159]	4-3/16 [106]	1-3/4 [44]	22-5/8 [573]	1 [25]	11-5/8 [296]	30°	15°	7/9 [19.8]	182/ 82.6	LSWB8	SFA1J4	BH/HFS
	LS4001750JR LS4001750JL	17-1/2 [445]	6-1/2 [165]	4-3/16 [106]	3-1/4 [83]	21-11/16 [551]	1-1/2 [38]	12-1/4 [311]	30°	14°	1-11/32 [34]	300/ 136.1	LSWB8	SFA1J4	FEL
4-3/4	LS4751300JR LS4751300JL	13 [330]	8-3/8 [213]	4.9 [125]	2-1/4 [57]	27-1/2 [697]	1-3/4 [44]	14-5/8 [371]	30°	14°	1-1/2 [40]	280/ 127	LSWB6	SFA125J6	BH/HFS
	LS4751400JR LS4751400JL	14 [356]	8-3/8 [213]	4-7/8 [123]	2-1/4 [57]	27-7/16 [697]	1-3/4 [44]	14-5/8 [371]	30°	14°	1-1/2 [40]	315/ 143	LSWB6	SFA125J6	BH/HFS
	LS4751700JR LS4751700JL	17 [432]	8-3/8 [213]	4-15/16 [125]	2-1/4 [57]	27-1/2 [699]	1-3/4 [44]	14-3/4 [375]	30°	14°	1-1/2 [40]	305/ 138.3	LSWB6	SFA125J6	BH/HFS
	LS4751950JR LS4751950JL	19-1/2 [432]	8-3/8 [213]	4-15/16 [125]	2-1/4 [57]	27-1/2 [699]	1-3/4 [44]	14-3/4 [375]	30°	14°	1-1/2 [40]	400/ 182	LSWB6	SFA125J6	BH/HFS
5-1/2	LS5501600JR LS5501600JL	16 [406]	8-3/8 [213]	5-11/16 [144]	2-1/4 [57]	28 [711]	2 [51]	15-3/4 [400]	30°	14°	1-7/10 [45]	375/ 170	LSWB6	SFA125J6	BH/HFS
	LS5501750JR LS5501750JL	17-1/2 [445]	8-3/8 [213]	5-11/16 [144]	2-1/4 [57]	28-1/32 [712]	2 [51]	15-3/4 [400]	30°	14°	1-7/10 [45]	400/ 182	LSWB6	SFA125J6	BH/HFS
	LS5502200JR LS5502200JL	22 [559]	8-3/8 [213]	5-11/16 [144]	2-1/4 [57]	28-5/8 [727]	2 [51]	13-7/8 [352]	30°	14°	1-7/10 [45]	405/ 183.7	LSWB6	SFA125J6	BH/HFS
6-1/4	LS6251600JL LS6251600JR	16 [406]	8-3/8 [213]	6-7/16 [164]	2-5/8 [66]	31-1/4 [793]	2-5/16 [58]	17/3/4 [450]	30°	14°	2-1/10 [54]	445/ 201	LSWB6	SFA125J6	BH/HFS
	LS6251800JR LS6251800JL	18 [457]	8-3/8 [213]	6-7/16 [164]	2-11/16 [68]	31-1/2 [799]	3 [76]	203 [516]	30°	14°	2-1/10 [54]	504.2/ 228.7	LSWB6	SFA125J6	BH/HFS
	LS6252000JR LS6252000JL	20 [508]	8-3/8 [213]	6-1/2 [165]	2-1/4 [57]	30-3/16 [767]	2 [51]	17-3/4 [451]	30°	14°	2-1/10 [54]	420/ 190.5	LSWB6	SFA125J6	BH/HFS
	LS6252200JR LS6252200JL	22-1/4 [565]	8-3/8 [213]	6-7/16 [164]	2-11/16 [68]	31-11/16 [804]	2-11/16 [67]	20-9/16 [523]	30°	14°	2-1/10 [54]	635/ 288.3	LSWB6	SFA125J6	BH/HFS
	LS6252400JR LS6252400JL	24 [610]	8-3/8 [213]	6-7/16 [164]	2-11/16 [68]	31-15/16 [811]	3 [76]	20-3/4 [527]	30°	14°	2-1/10 [54]	690/ 131	LSWB6	SFA125J6	BH/HFS

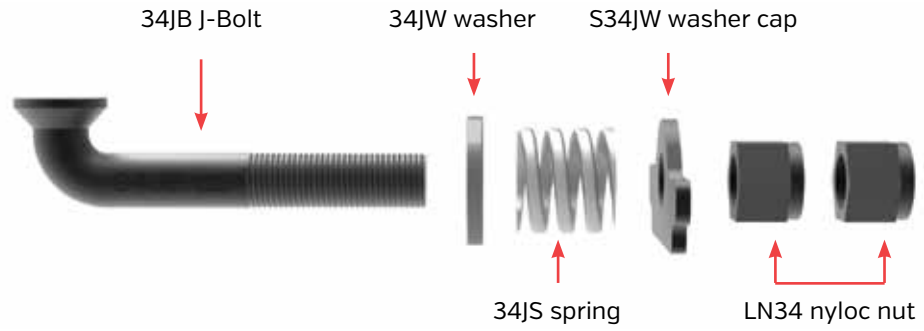
J-BOLT BASES



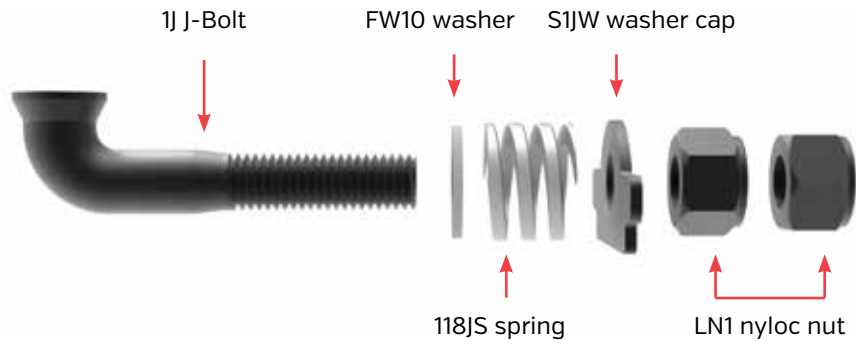
WELD BASE	WEIGHT		DIMENSIONS - INCHES (MM)		
	LB	KG	A	B	C
LSWB1	8.5	3.9	5-1/8 [130]	6 [152]	2-1/8 [54]
LSWB3	3.2	1.5	3-7/8 [98]	4-1/2 [114]	1-7/16 [36]
LSWB6	13.5	6.1	6-5/8 [168]	6-3/4 [171]	2-3/4 [70]
LSWB8	6.5	2.9	5-1/8 [130]	5-1/4 [133]	1-7/8 [48]

J-BOLT ASSEMBLIES

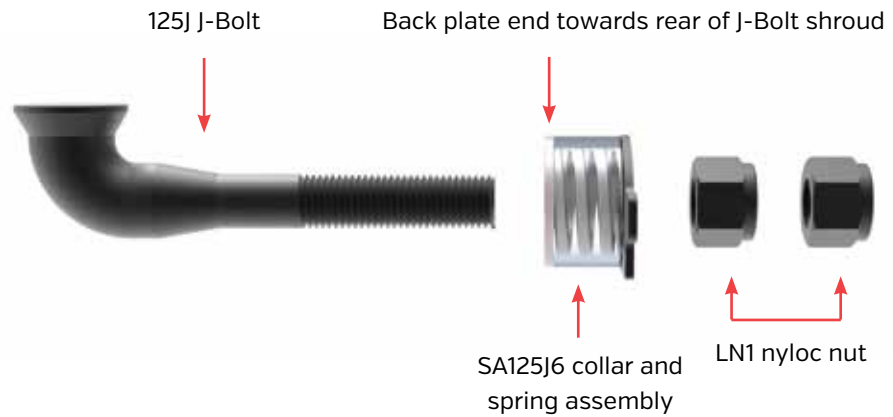
SFA34J4



SFA1J4



SFA125J6



J-BOLT INSTALLATION AND WELDING INSTRUCTIONS



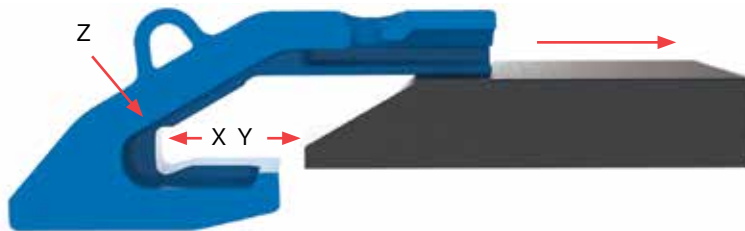
READ ALL OF THE INSTRUCTIONS COMPLETELY PRIOR TO ASSEMBLY.

STEP 1

NEW INSTALLATION

Position the shroud on the lip making sure that the blunt throat surface of the shroud “X” contacts the blunt front surface of the lip “Y”. There should be no contact between the bevel of the lip and area “Z” of the shroud.

NOTE: This contact between X and Y must be maintained throughout the assembly process to insure the proper location of the weld base.



REPLACEMENT INSTALLATION

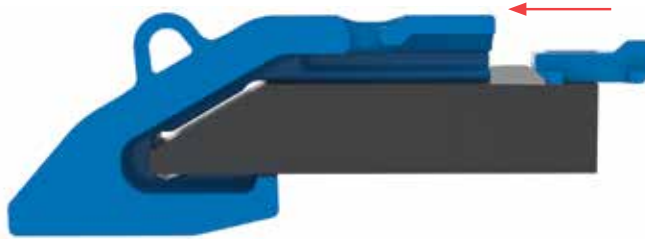
Grind the top surface of the lip material that will be affected by weld. Insure all carbon slag or other impurities from the removal of the old base are ground out. The use of non-destructive testing at this point will help determine if there are any cracks present in the base material. Repair base material as needed. [Now proceed as with new installation.]

Position the shroud on the lip making sure that the blunt throat surface of the shroud “X” contacts the blunt front surface of the lip “Y”. There should be no contact between the bevel of the lip and area “Z” of the shroud.

NOTE: This contact between X and Y must be maintained throughout the assembly process to insure the proper location of the weld base.

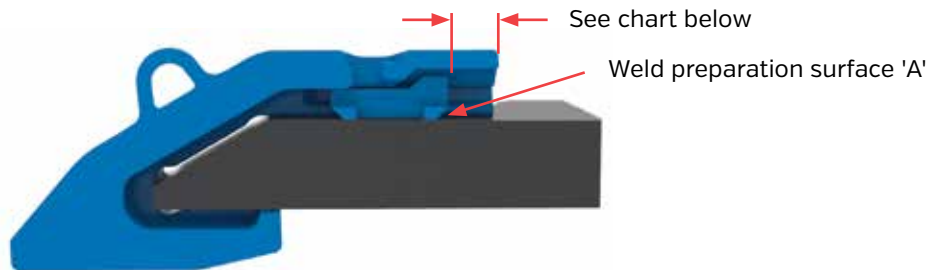
STEP 2

Slide the weld base from the rear into the receiving slots of the shroud.

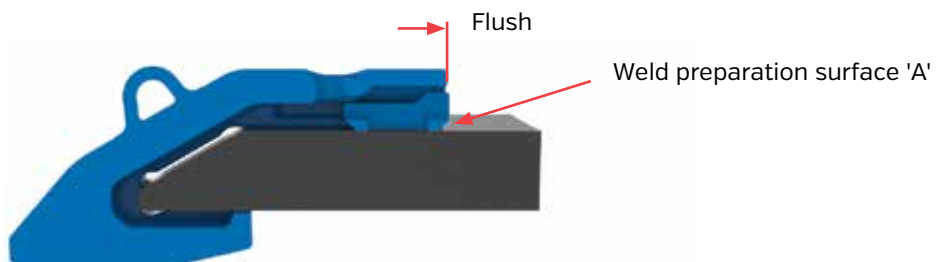


STEP 3

Position the weld base according to the chart below [a deviation of $\pm 3/32$ " [2.5 mm] is allowable]. After placement has been confirmed, preheat the base material to 300°F [147°C] and tack weld the base at the rear along weld prep surface "A".



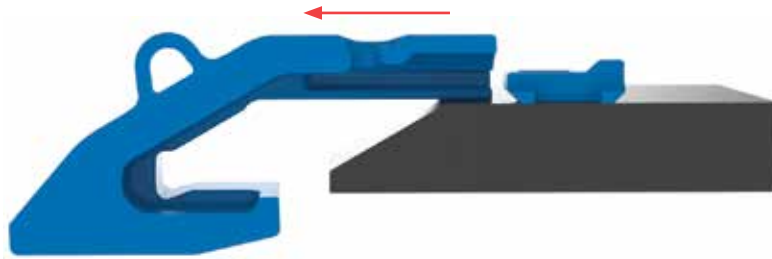
LSWB9 only



WELD BASE PLACEMENT ($\pm 3/32$ " [2.5 MM] ALLOWABLE)		
BASE	INCHES	MM
LSWB1	2-1/4	57
LSWB3	2-1/4	57
LSWB6	3-1/2	89
LSWB8	2-1/4	57

STEP 4

Remove the shroud and prepare to weld-out the base by re-establishing the preheat temperature of 300°F [147°C] for the base material. Maintain this temperature throughout the welding process.



NOTES:

Recommended filler material:

AWS specification A5.1, class E7018, stick electrode. Stick electrodes should be kept in a heated rod oven at 250°/120°C prior to use.

See manufacturers recommended procedures for storage and preservation of low hydrogen electrodes.

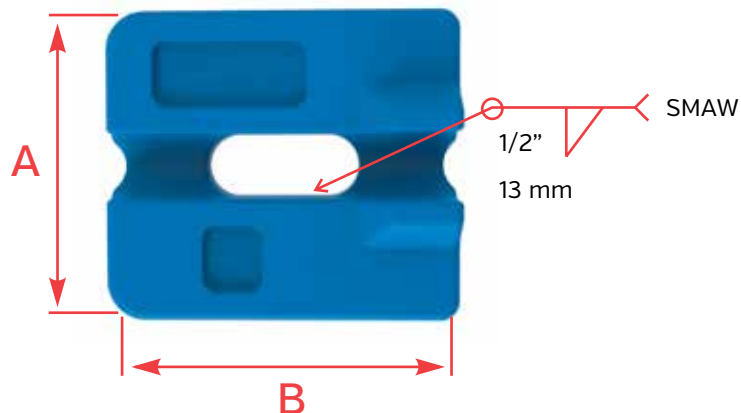
Recommended weld types:

Stringer beads are recommended for higher strength and less distortion. The use of weave or wash beads is **NOT** recommended and should not be used. Arc strikes should be avoided or ground down.

STEP 5

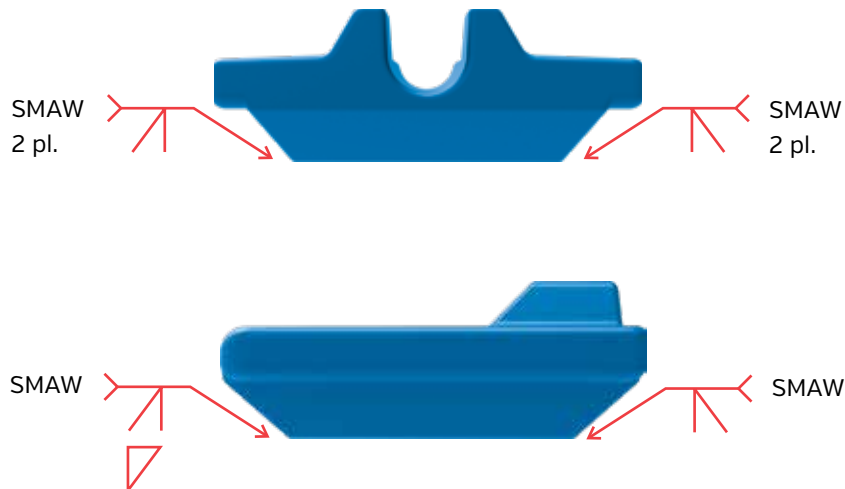
Weld-out for the base should begin with the slot weld. A 1/2" [13 mm] fillet weld should be deposited in this area.

NOTE: Be sure that the entire bottom surface of the weld base maintains contact with the lip during entire weld-out process.

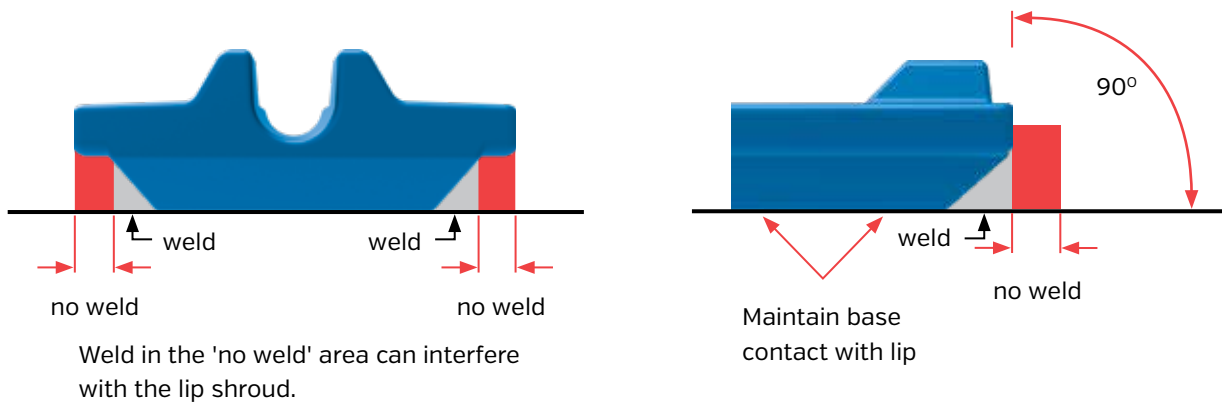


STEP 6

Apply weld to the base perimeter next. Utilizing groove welds, fill the 1/2" [13 mm] weld groove on the base completely. Care must be taken at this point not to add too much weld. If joint is over welded, the weld material can interfere with the lip shroud.



The idea is to add as much weld as possible to the base without causing interference with the lip shroud. When the welding process has been completed, allow a slow cool down period to ambient temperature. A cool down rate of no greater than 35°F [2°C] per hour is recommended.



Weld in this area will interfere with the front washer of the J-Bolt assembly which must fit flush against the rear of the weld base.

Ensure contact with lip on entire length of weld base bottom surface as indicated.

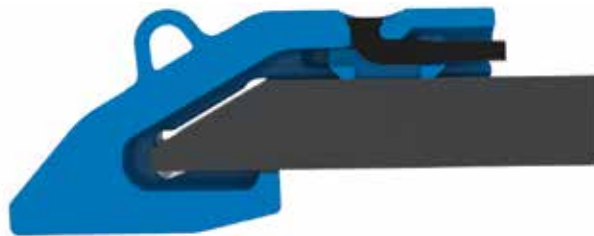
STEP 7

Before repositioning the shroud on the lip, insert the J-Bolt into the shroud through the top hole. Rotate the bolt 90° so that the threaded end is facing the rear of the shroud.



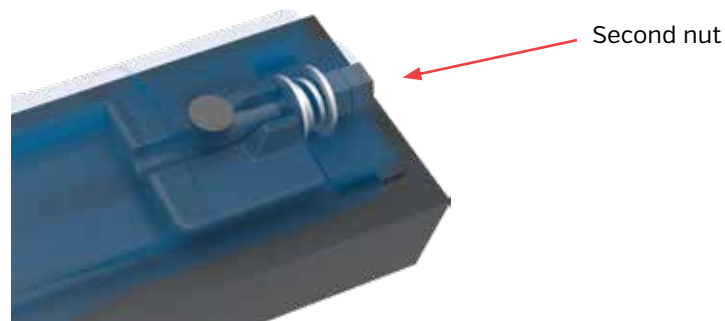
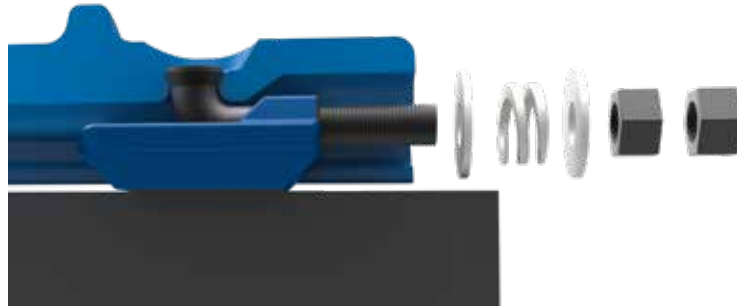
STEP 8

Reposition the shroud on the lip by sliding it onto the weld base as far as it will go, once again, making sure surface "X" contacts surface "Y".



STEP 9

Attach the washers, the spring and the nuts in the order indicated for J-Bolt assembly type J, J4, J6
[NOTE: The locking nut can not be hand-threaded onto the J-Bolt.] then torque to specifications listed.



J-BOLT ASSEMBLY TORQUE RECOMMENDATIONS

J-BOLT ASSEMBLY	LOCKING NUT MAX TORQUE		GRADE 8 BOLT MAX TORQUE	
	FT-LB	NM	FT-LB	NM
SFA34J4	175	237	N/A	N/A
SFA1J4	200	271	N/A	N/A
SFA125J	225	305	N/A	N/A
SFA125J6	225	305	N/A	N/A

NOTE:

SEATING FOR NEW INSTALLATION:

It is normal that the shrouds migrate back slightly with the force of the machine. Therefore, it is recommended that the following procedure be followed to ensure proper seating of the shrouds.

Instructions:

1. Run machine for 10 non-production digging cycles.
2. Remove 2nd locking nut from shroud installation.
3. Re-tighten the 1st locking nut to torque specification.
4. Re-install 2nd locking nut to torque specification.
5. Release machine for production.

Note: if the first nut on any installation is excessively loose, then repeat this procedure.

RETIGHTENING AND MAINTENANCE





Check and retighten the nuts after 6 hours of service, then after 24 hrs.

Generally, nuts should be periodically checked after 750 to 1000 hrs. In extreme conditions, and 1500 to 2000 hrs. In moderate conditions, or by the frequency dictated by your specific application.

J-BOLT ASSEMBLIES TOOL LIST

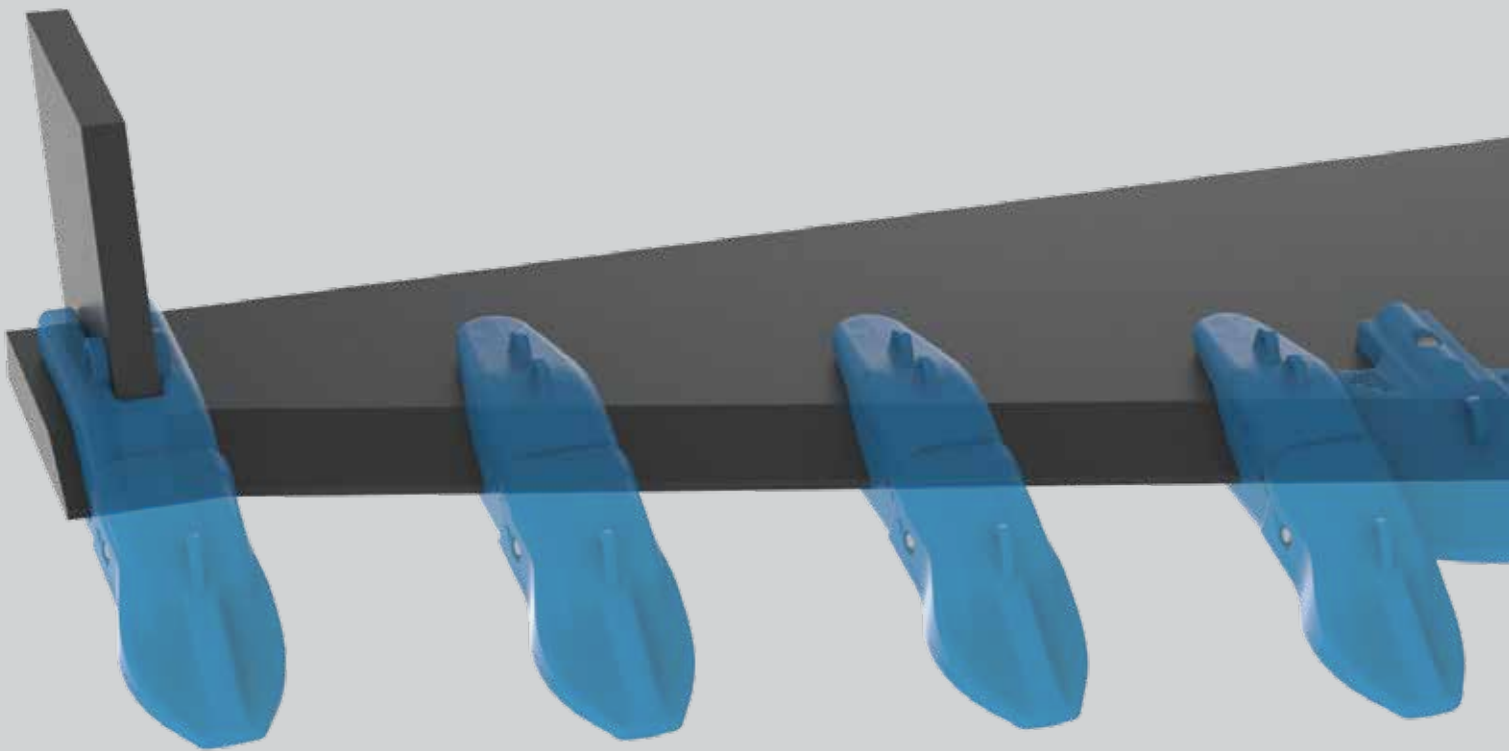
PART NUMBER	REQUIRED TOOL	TOOL PART NUMBER	TOOL STOCK NUMBER	
SFA34J4		1-1/8" DEEP SOCKET 3/4" DR	118DS34D	90-0260
SFA1J4, SFA1J3 (LHD)		1-1/2" DEEP SOCKET 3/4" DR	112DS34D	90-0270
SFA118J5		1-5/8" DEEP SOCKET 3/4" DR	158DS34D	90-0280
SFA125J6		1-7/8" DEEP SOCKET 3/4" DR	178DS34D	90-0290

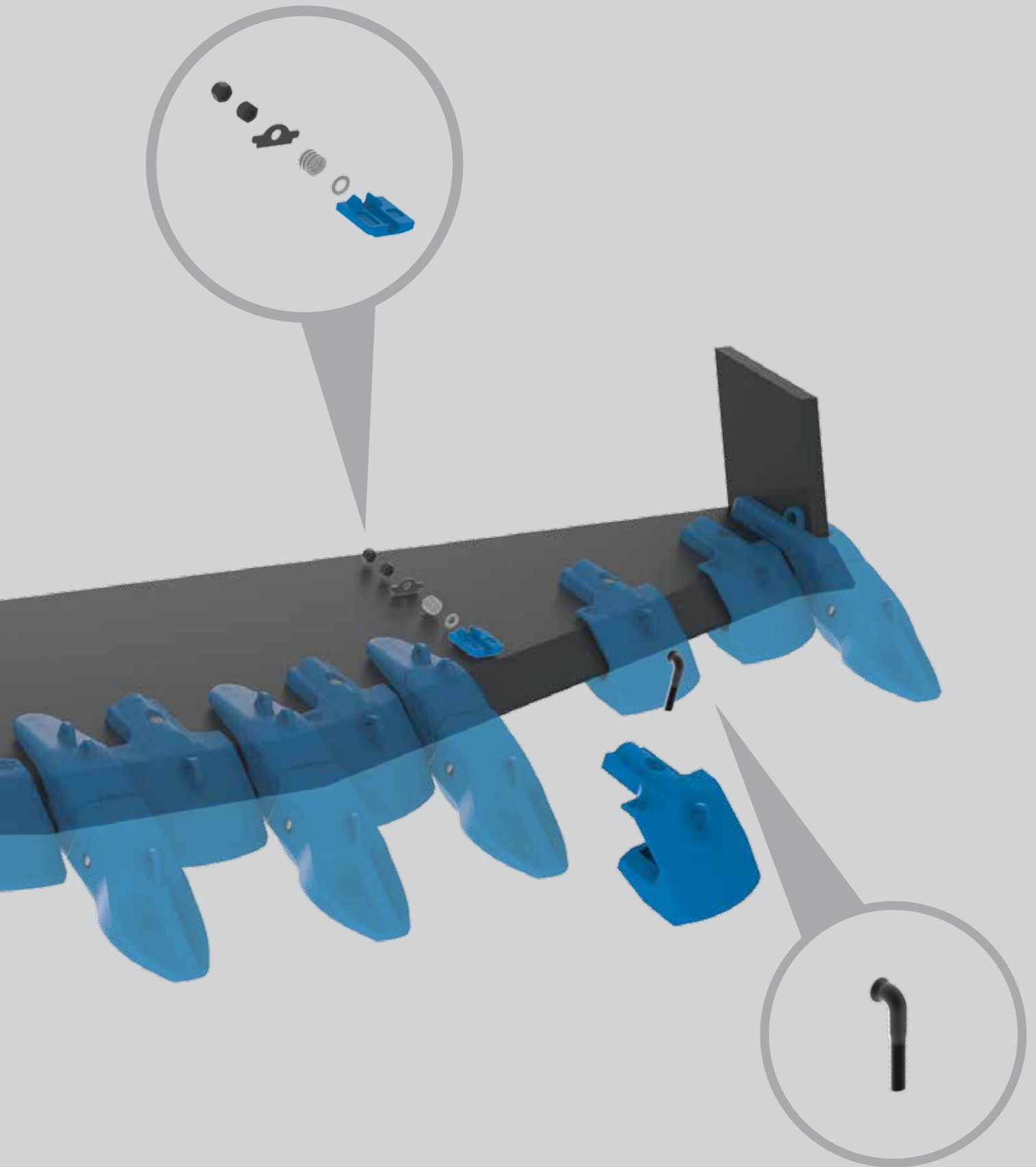
GAUGES

LIP SHROUD CHANNEL GAUGE	DESCRIPTION	STOCK NUMBER	PART NUMBER
 	160 MM LIP TEMPLATE	90-28140	160LT
	120 MM LIP TEMPLATE [BASED ON 6694TLC LIP]	90-32400	6694TLC120MLT
	120 MM LIP TEMP. [BASED ON LS475-1400JL/JR]	90-31560	LS120MLT
	140 MM LIP TEMPLATE [BASED ON LS550-1750]]	90-31320	LS140MLT
	LS400 LIP TEMPLATE [BASED ON CAT 994 LIP]	90-30990	LS400C994LT
	LS400900 LIP TEMPLATE - ALUMINUM [BASED ON LS400-900]]	90-33010	LS400900LTAL
	LS4001600 LIP TEMPLATE - ALUMINUM [BASED ON LS400-1600]]	90-33020	LS4001600LTAL
	6.25" LIP TEMPLATE [BASED ON LS625-2400JR/JL]	90-31140	LS625LT
	LS350LT LIP TEMPLATE [BASED ON LS350-1750]]	90-33410	LS350LT
LIP SHROUD WELD BASE GAUGE	DESCRIPTION	STOCK NUMBER	PART NUMBER
 	LSWB3 WELD BASE GAUGE-OPEN	90-30190	LSWB3GO
	LSWB5 WELD BASE GAUGE-OPEN	90-33690	LSWB5GO813
	LSWB6 WELD BASE GAUGE-OPEN	90-31610	LSWBGO6
	LSWB8 WELD BASE GAUGE-OPEN	90-29980	LSWBGO8

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