



R0008013-ECO Ecoline dipper arm clacker

Bench assembly details for Ecoline clacker

 Difficulty Easy

 Duration 5 minute(s)

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Comments

Introduction

Tools Required

10mm spanner

5mm punch

Ball pein hammer

Parts Required

D0003196 Dipper Arm (Ecoline) x 1

D0003197 Dipper Base (Ecoline) x 1

D0003894 Flapper pivot pin x 1

M0000101 Compression Spring 11 D 15 D 25 Long x1

F0000185 M6 x 16 Hex set S/S x 1

Step 1 - M000101 Compression spring

M000101 is not required for bench assembly , and will not be shown within the work instruction .
Ensure this part is issued with each assembled clacker



Step 2 - Components

D0003196 Dipper Arm (Ecoline) x 1
D0003197 Dipper Base (Ecoline) x 1
D0003894 Flapper pivot pin x 1
F0000185 M6 x 16 Hex set S/S x 1



Step 3 - Fit D0003894 Flapper pivot pin

Use ball peen hammer to locate D0003894 Flapper pivot pin into D0003197 Dipper Base as shown

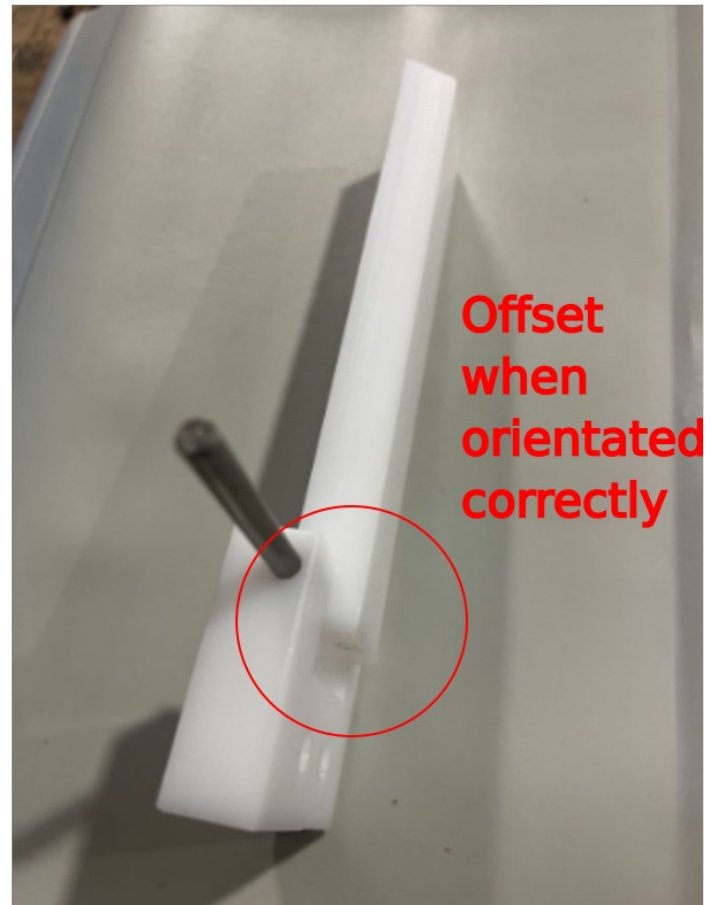
Ensure pin does not go past indicated face



Step 4 - Position D0003196 Dipper Arm

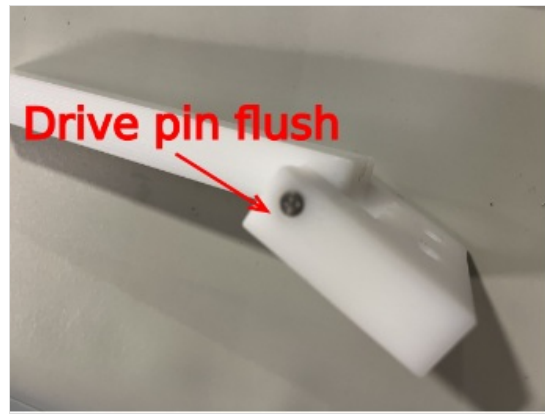
Position D0003196 Dipper Arm as shown

⚠It is vital to orientate this part correctly . Note the offset between the arm and base when orientated correctly



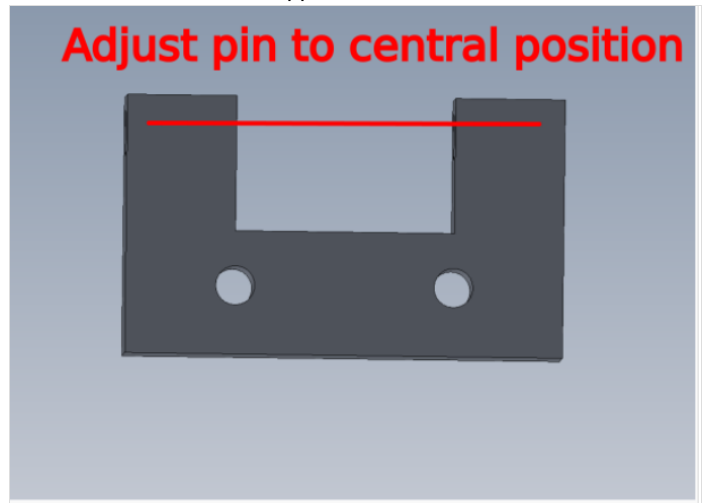
Step 5 - Drive in pin

Drive pin through parts until flush with face



Step 6 - Centralise pin

Use a 5mm punch and ball peen hammer to centralise pin between the 2 outer faces of D0003197 Dipper Base



Step 7 - Fit stop

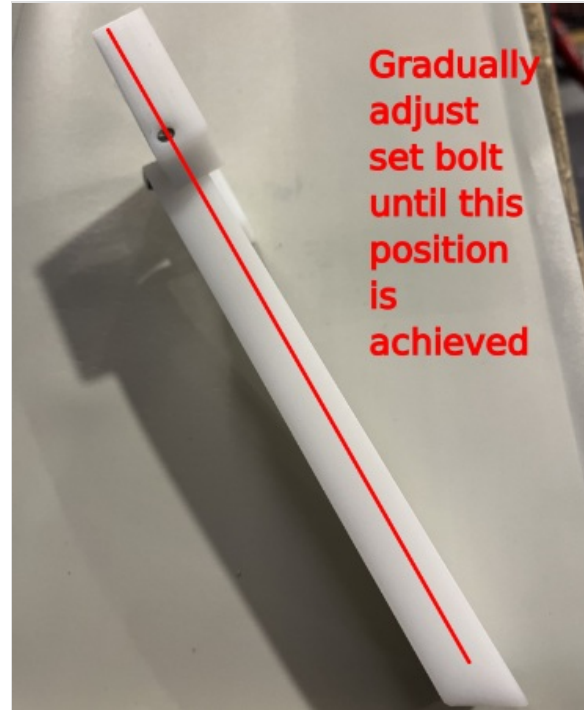
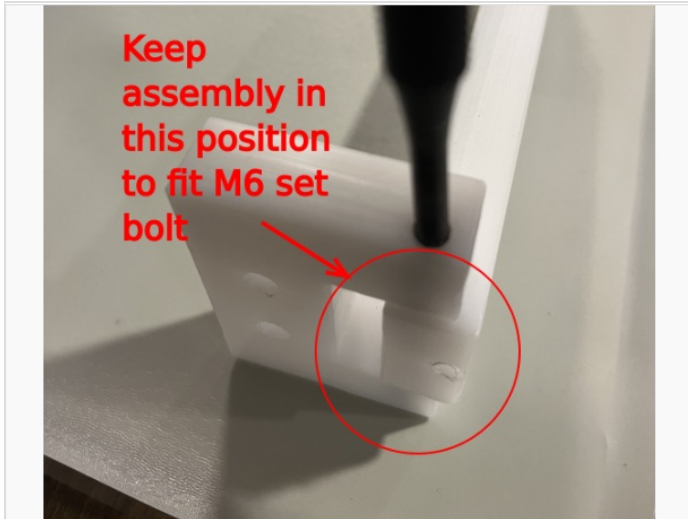
⚠ ...F0000185 M6 x 16 Hex set S/S bolt is used as a stop .It is vital that this part is not set any further into the assembly than described in the steps below

Position assembly as shown

Fit M6 set bolt by hand

Slowly adjust set bolt by winding into the assembly until the shown position is achieved by the base and arm when Head of set bolt contacts the clacker base

DO NOT SET ANY FURTHER THAN THIS POSITION



Step 8 - Finish

Check list

Pin centralised

Set bolt adjusted

Clacker arm and base pivots on pin by hand



