



Partsbook
for
Rotatable shear
DRS-25-A

Product	Part Number	Ref.
DRS-25-A Serie 2	DRS025A250BAC5	



Partsbook_drs025b250bac5-b.docx

June 2015

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Rotatable Shear

Housing GP

Page

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Date

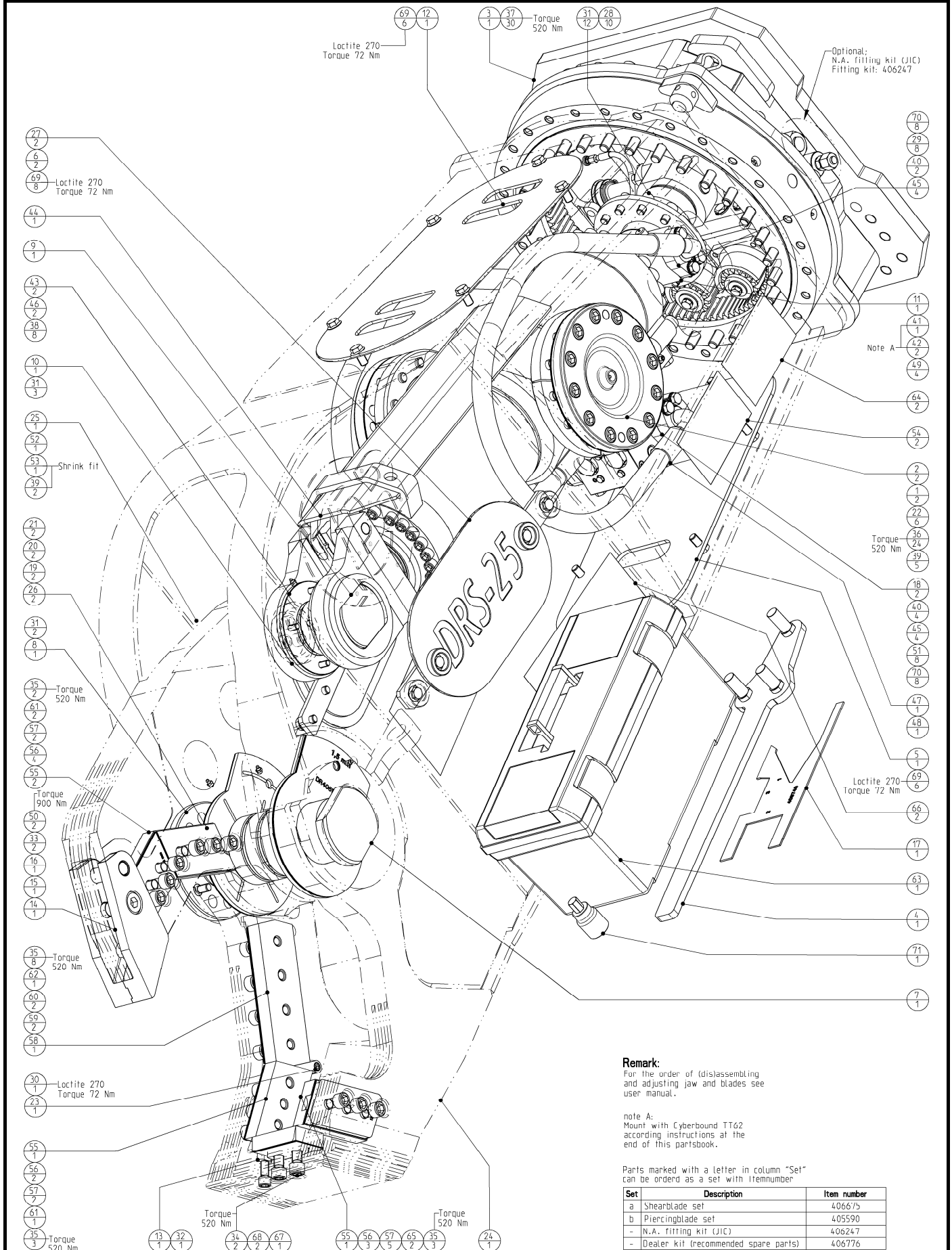
June 2015

Product type

DRS-25-A

Number

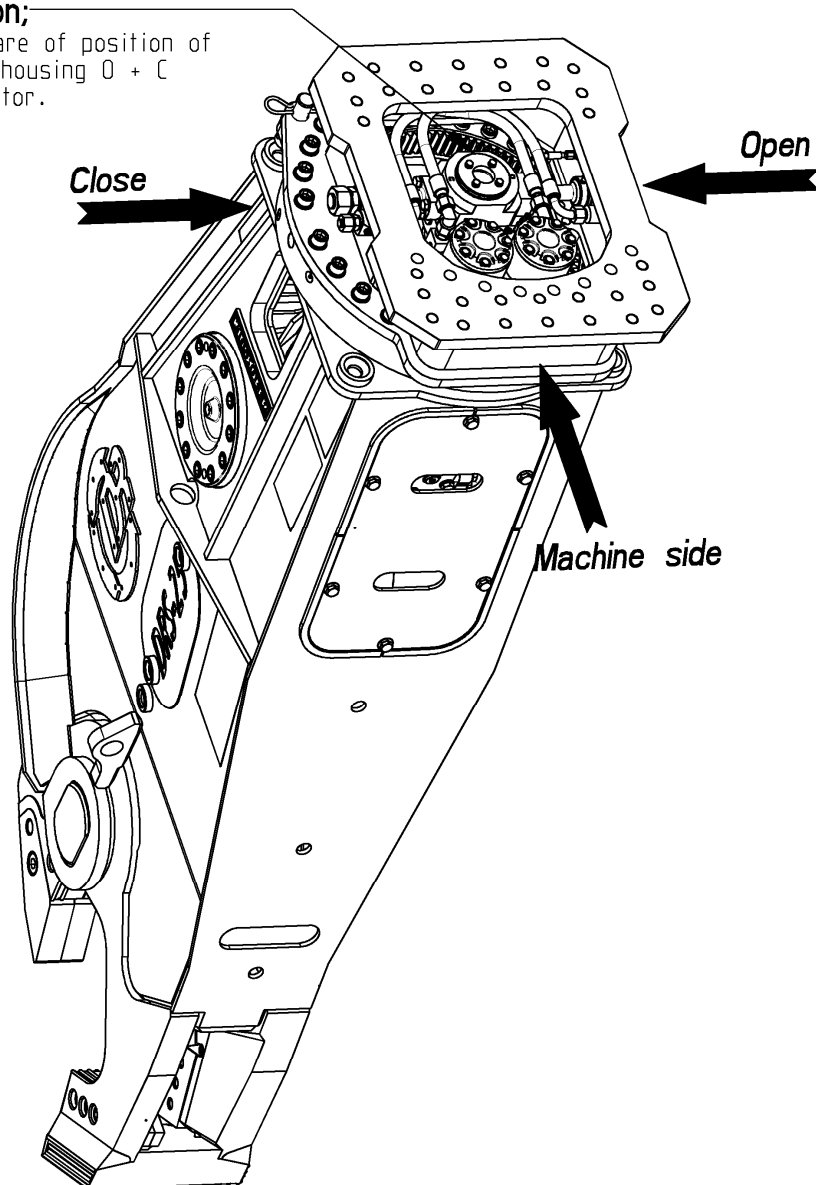
DRS025B250BAC5-B



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	Product type	DRS-25-A		
Housing GP	Number	DRS025B250BAC5-B		

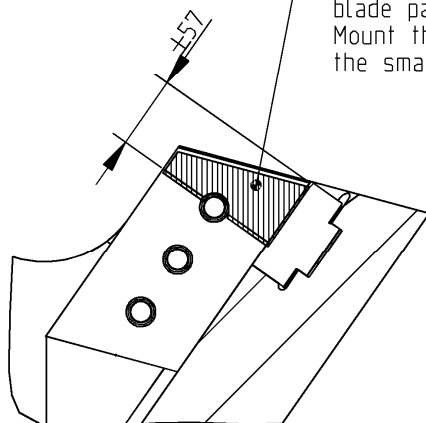
Caution;

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



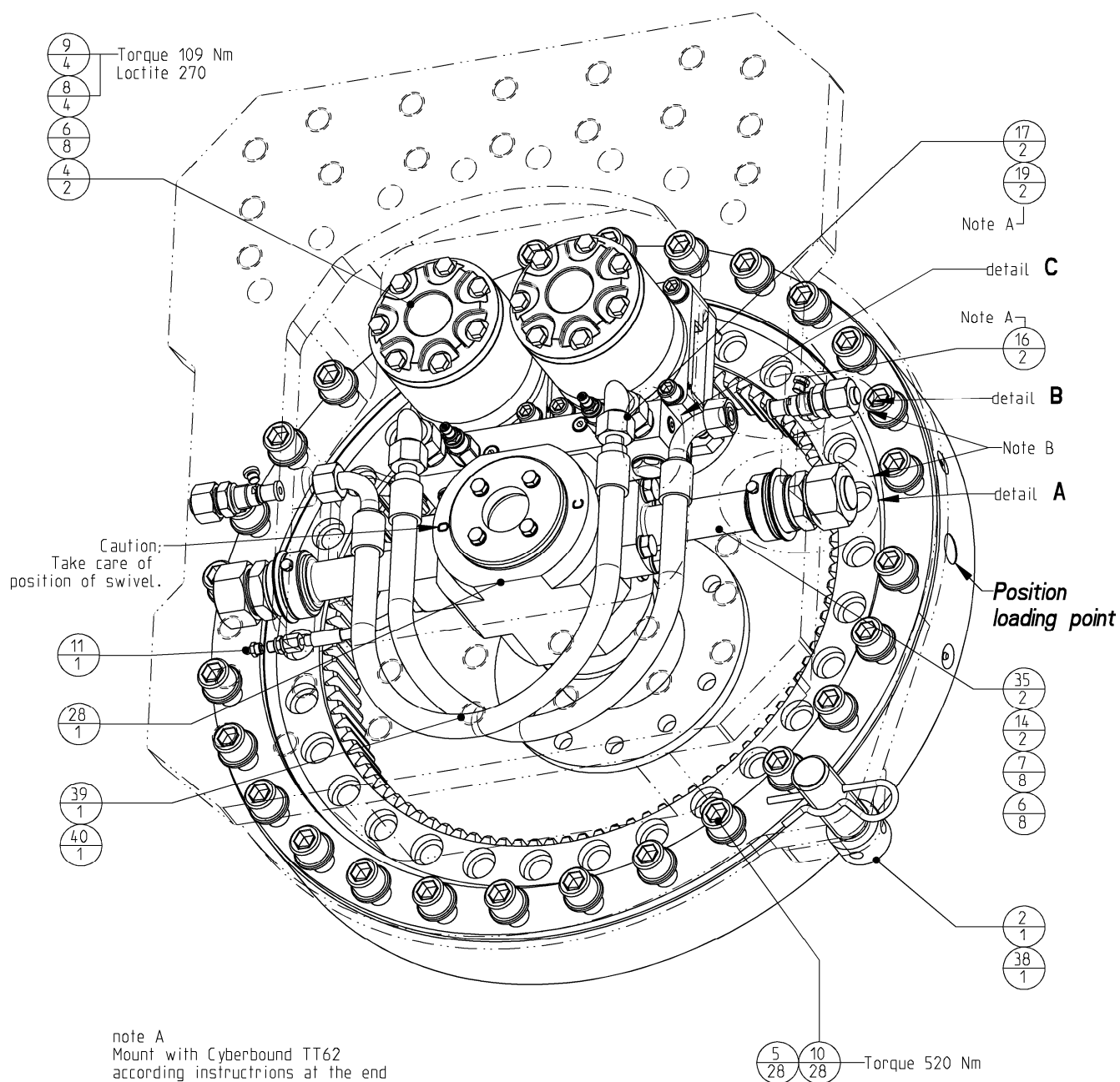
Guiding blade mounting instruction!

Grind the indicated area of the guiding blade parallel to the piercingblade.
Mount the guiding blade with shims with the smallest possible space to the piercingblade.

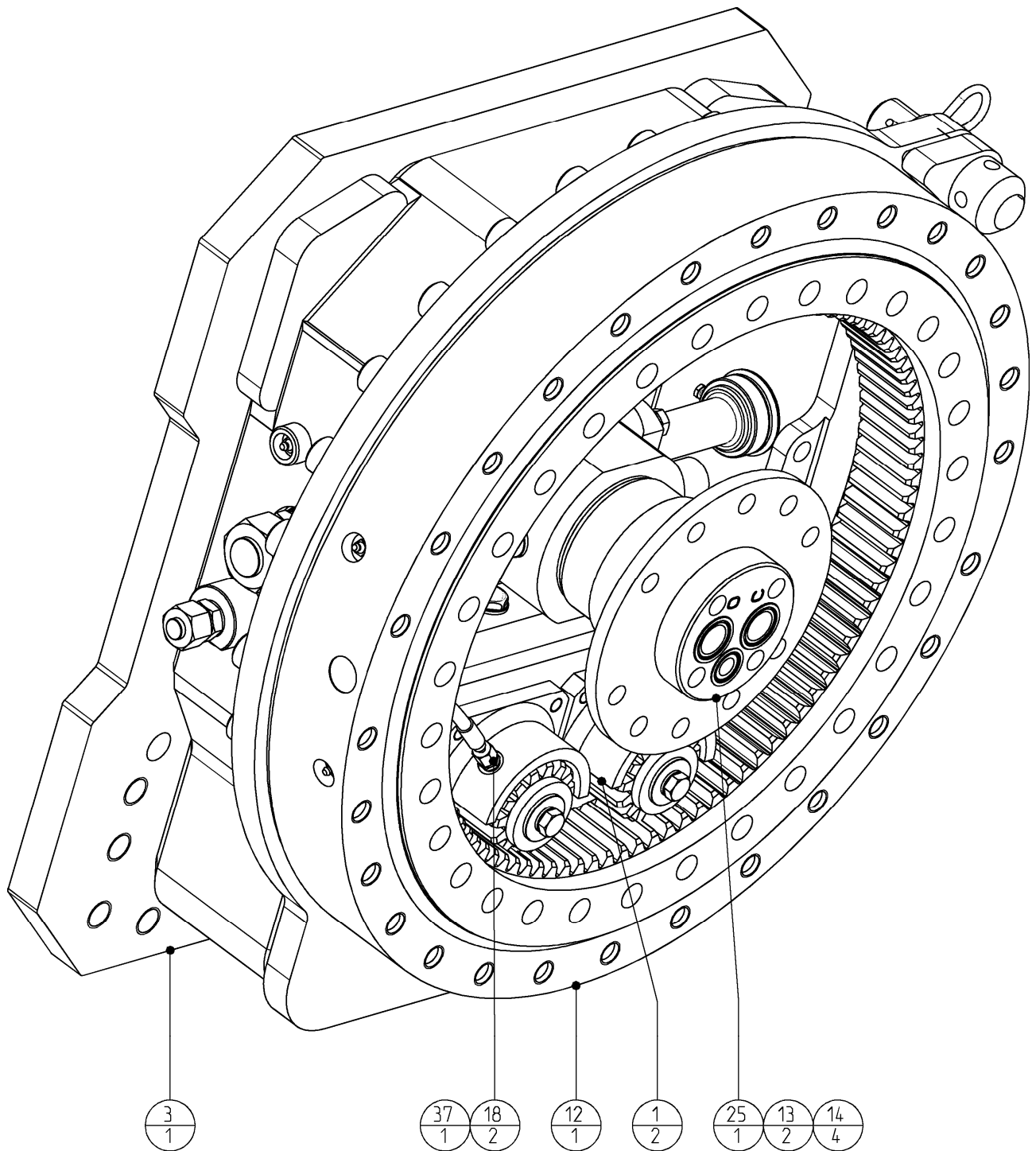


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					Date		June 2015			
					Product type		DRS-25-A			
Housing GP					Number		DRS025B250BAC5-B			
						40	500603	Seal - flange	6	
						39	500560	Grease - nipple	7	
						38	500347	Flat countersunk head cap screws	8	
						37	500302	Hex. socket head cap screw	30	
						36	500275	Hex. socket head cap screw	24	
					a	35	500274	Hex. socket head cap screw	16	
					a	34	500273	Hex. socket head cap screw	2	
						33	500264	Hex. socket head cap screw	2	
						32	500259	Hex. socket head cap screw	1	
	71	192072798	Screwdriver bit socket	1		31	500258	Hex. socket head cap screw	17	
	70	122000163	Washer normal	16		30	500237	Hex. socket head cap screw	1	
	69	120015514	Bolts Hexagon - self locking	20		29	500205	Bolts Hexagon	8	
a	68	508164	Shim straight	2		28	500054	Washer HV	10	
a	67	508163	Shear - blade straight	1		27	406670	Cover asm.	2	
	66	508162	Sticker	2		26	406660-B	Spacer	2	
a	65	508156	Shim - diamond	2		25	406645	Jaw asm. machined	1	
	64	508152	Sticker	2		24	406616	Housing machined	1	
a	63	508136	Toolbox GP	1		23	406613	Lock	1	
a	62	508131	Shim - straight	1		22	406500	Shim - bearinghouse	6	
a	61	508126	Shim - diamond	3		21	406152	Shim - bearing	2	
a	60	508122	Shim - straight	2		20	406151	Shim - bearing	2	
a	59	508121	Shim - straight	2		19	406150	Shim - bearing	2	
a	58	508120	Shearblade - trapezium	1		18	406073	Flange - intermed. SAE 1¼"	2	
a	57	508119	Shim - diamond	9		17	405740	Fixture DRS-25	1	
a	56	508118	Shim - diamond	9	b	16	405593	Lockpin	1	
a	55	508117	Shearblade - diamond	4	b	15	405592	Piercingblade (V1) RH	1	
	54	508113	Sticker	2	b	14	405591	Piercingblade (V1) LH	1	
	53	507015	Bushing	1		13	405582	Lock	1	
	52	507014	Bushing	1		12	405577	Cover	1	
	51	506050	Bolts Hexagon	8		11	405576	Swivel - flange	1	
b	50	506022	Shoulder bolt	2		10	405575	Lock cover	1	
	49	506021	Hex. socket head cap screw	4		9	405574	Pin	1	
	48	505145_RM405525-2	Hydr. hose asm. 1" SAE 100R15	1		8	405573	Locknut	1	
	47	505145_RM405525-1	Hydr. hose asm. 1" SAE 100R15	1		7	405572	Pin	1	
	46	504021	Scraper	2		6	405253	Lockbar - cover	2	
	45	503504	SAE split-flange	8		5	405232	Cover	1	
	44	502970	Hydraulic Cylinder & Valve GP	1		4	404990	Key GP	1	
	43	502127	Spacer	2		3	404726	Rotatorhead GP	1	
	42	500740	Test-point	2		2	402916	Bearing housing	2	
	41	500652	Blanking end	1		1	401437	Ring	2	
					Set	POS	PARTNUMBER	PARTNAME	QT	

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	Date	June 2015		
	Product type	DRS-25-A		
Rotatorhead GP	Number	404726-01		



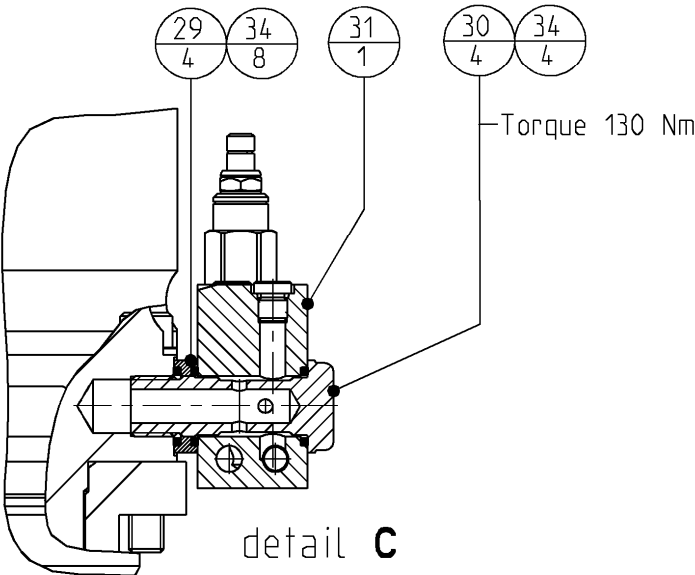
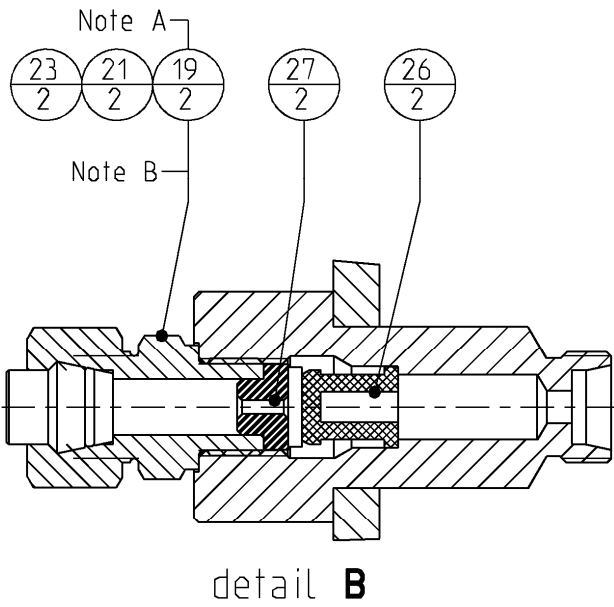
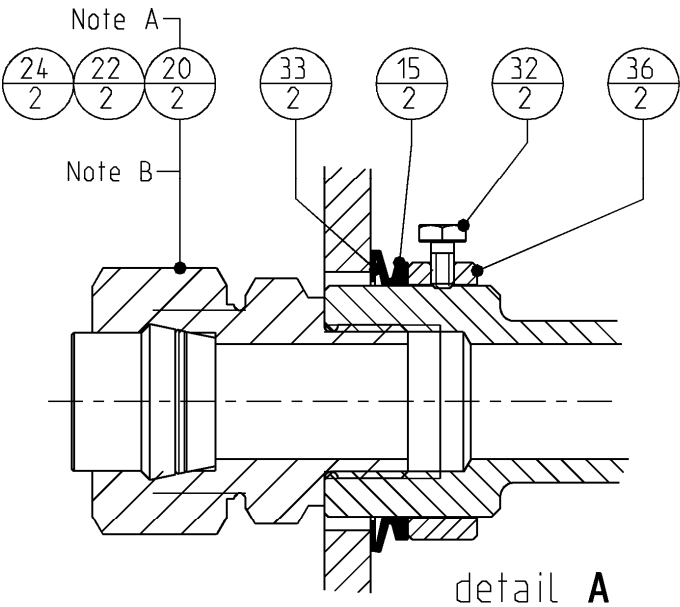
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	Date	June 2015		
	Product type	DRS-25-A		
Rotatorhead GP	Number	404726-01		



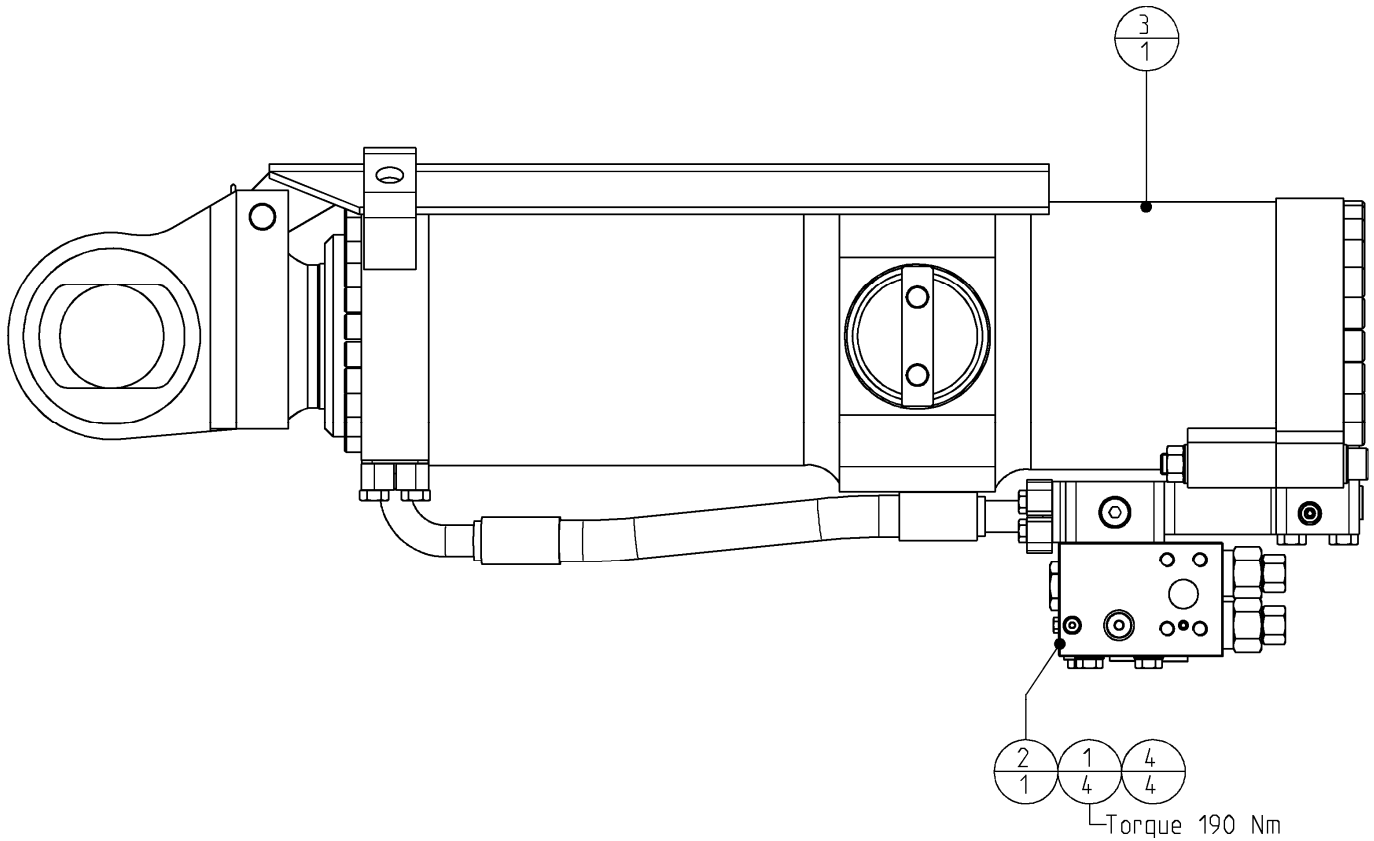
Rotatable Shear

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Date	June 2015		
Product type	DRS-25-A		
Number	404726-01		

Rotatorhead GP



Rotatable Shear	Page	8	of	23
	Date	June 2015		
	Product type	DRS-25-A		
Cylinder & Valve GP	Number	502970-02		



4	122000163	Washer normal	4
3	502971	Hydraulic Cylinder GP	1
2	500755	Overcentre valve	1
1	500200	Bolts Hexagon	4
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear

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Date

June 2015

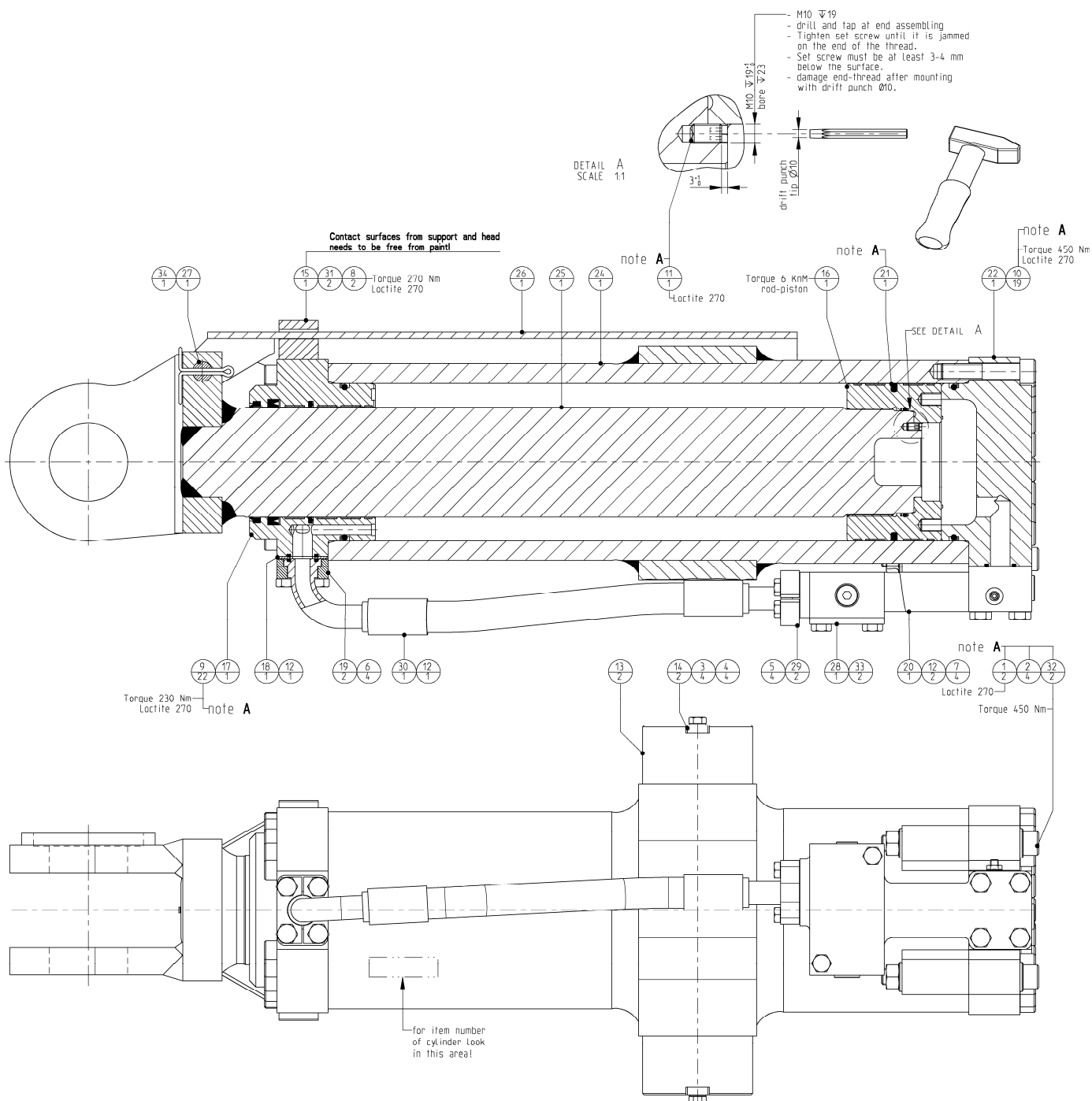
Product type

DRS-25-A

Cylinder GP

Number

502971-03



note A
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.

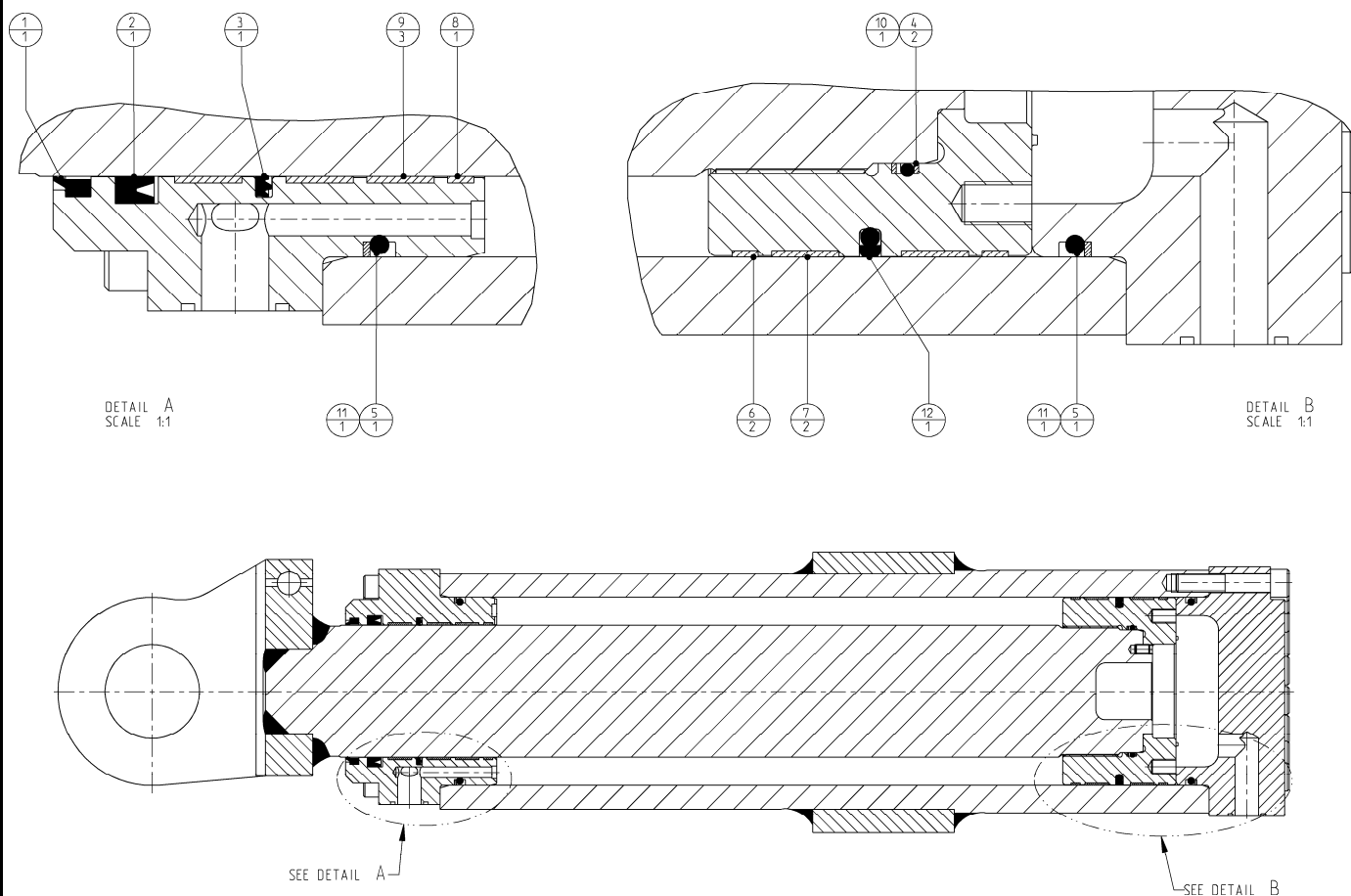
Parts marked with a letter in column "Set" can be ordered as a set with Itemnumber

Set	Service set	Itemnumber
a	Seal and bolt set	501255

Rotatable Shear	Page	10	of	23
	Date	June 2015		
	Product type	DRS-25-A		
Cylinder GP	Number	502971-03		

	34	125050846_VG50	Cotter pin	1
	33	120010334	Bolts Hexagon	2
a	32	506048	Hex. socket head cap screw	2
	31	506033	Lockwasher - Schnorr	2
	30	505144_RM502970	Hydr. hose asm. 1" SAE 100R15	1
	29	503503	SAE split - flange	2
	28	502999	Blanking cover	1
	27	502982	Lockpin	1
	26	502979	Protection cap asm.	1
	25	502974	Rod asm.	1
	24	502972	Cylinder - house asm.	1
	23	502971	Hydraulic Cylinder GP	1
	22	502715	Bottom asm.	1
a	21	502565_RM_502970	Seal - set	1
	20	502559	Flange - bottom GP	1
	19	502497	Split - flange spec.	2
	18	502496	Flange - intermed.	1
	17	502333	Cylinder - head	1
	16	502213	Piston	1
	15	502062	Support - protection cap	1
	14	502050	Lockplate	2
	13	502049	Bearing	2
	12	500601	Seal - flange	4
a	11	500417	Hex. socket set screw	1
a	10	500277	Hex. socket head cap screw	19
a	9	500267	Hex. socket head cap screw	22
	8	500260	Hex. socket head cap screw	2
	7	500149	Bolts Hexagon	4
	6	500146	Bolts Hexagon	4
	5	500134	Bolts Hexagon	4
	4	500133	Bolts Hexagon	4
	3	500068	Washer spring	4
a	2	500055	Washer HV	4
a	1	500006	Nut Hexagon	2
Set	POS	PARTNUMBER	PARTNAME	QT

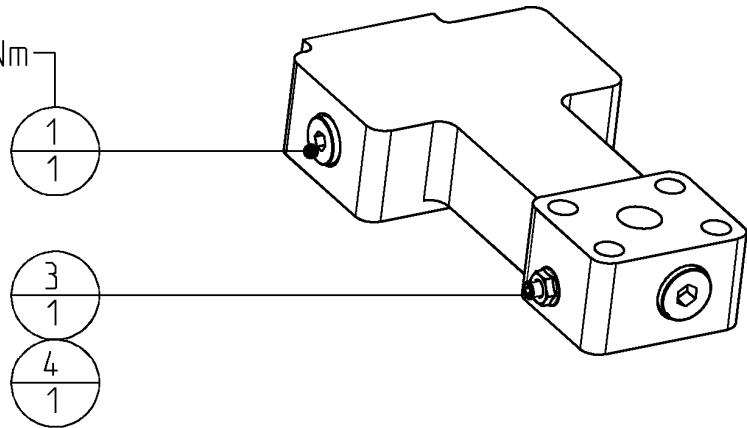
Rotatable Shear	Page	11	of	23
	Date	June 2015		
	Product type	DRS-25-A		
Sealset	Number	502565-00		



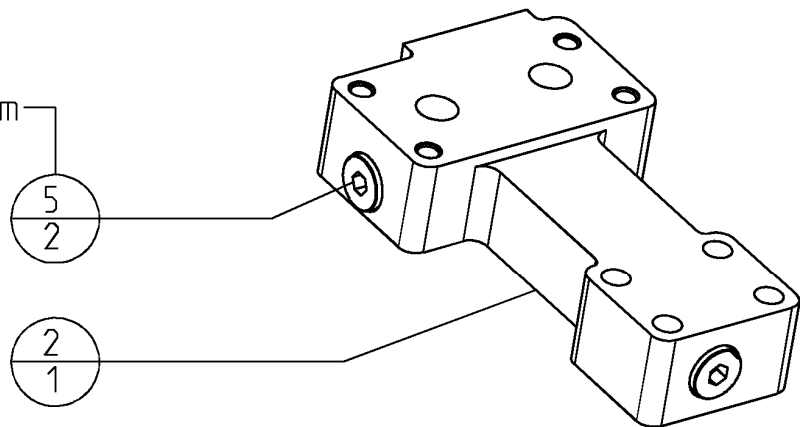
12	PT0402000	Turcon Glydring T	1
11	ORAR00442	O-ring	2
10	OR5013000	O-ring	1
9	GR7501400	Bearing Orkot (Luytex)	3
8	GR6901400	Bearing Turcite	1
7	GP7502000	Bearing Orkot (Luytex)	2
6	GP6902000	Bearing Turcite	2
5	BU5801884	Back-up ring	2
4	BU4001300	Back-up ring	2
3	BU014100664	Rod seal GP	1
2	B3E060P6000	U-Cup	1
1	504060	Scraper	1
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear	Page	12	of	23
	Date	June 2015		
	Product type	DRS-25-A		
Flange - bottom	Number	502559-03		

- Torque 90 Nm
- note A



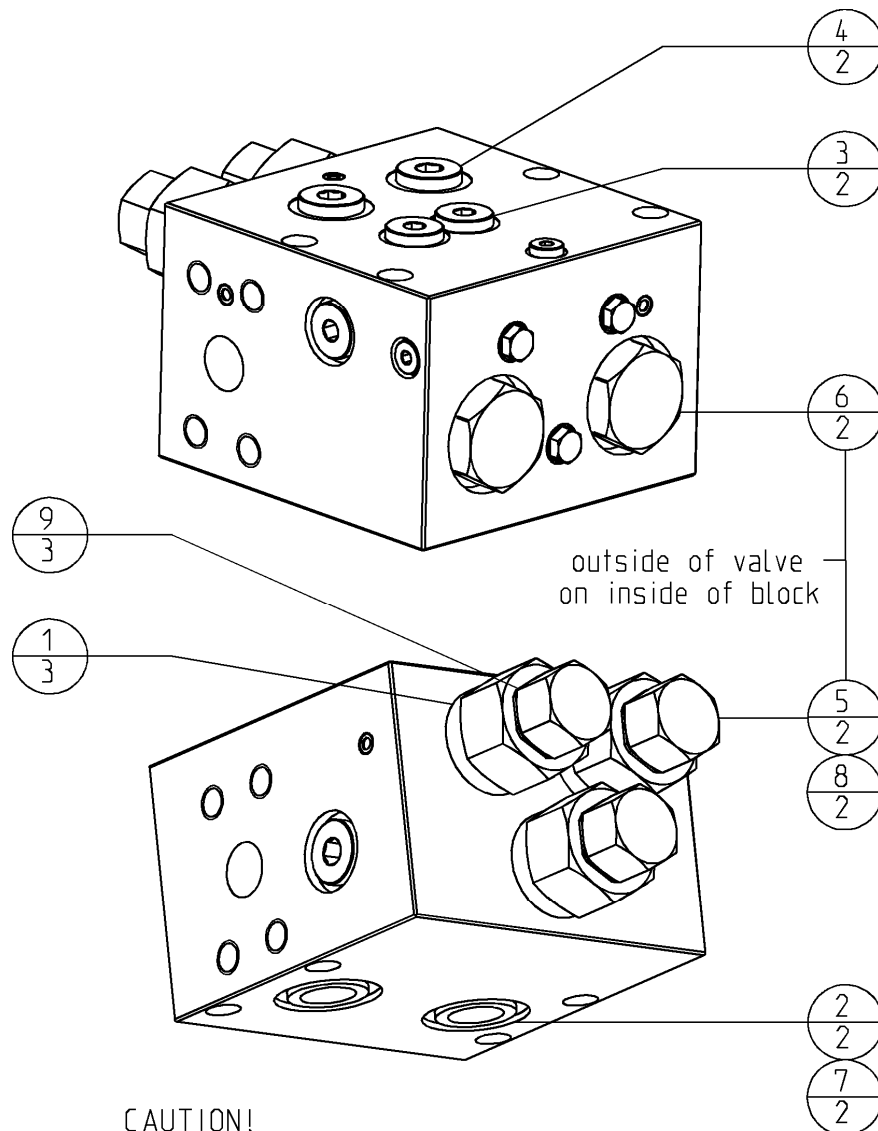
- Torque 150 Nm
- note A



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

5	290058185	Blanking end ISO 6149	2
4	121060762	Nut Hexagon sealing	1
3	502562	Bleeding screw	1
2	502560	Flange - bottom	1
1	500652	Blanking end	1
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear	Page	13	of	23
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	Product type	DRS-25-A		
Overcentre Valve	Number	500755-03		

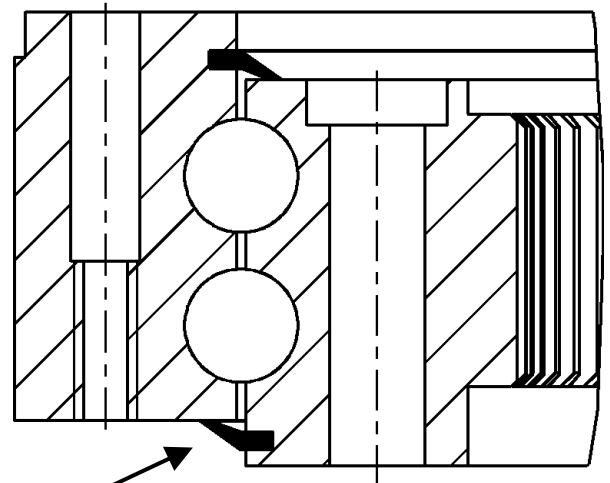
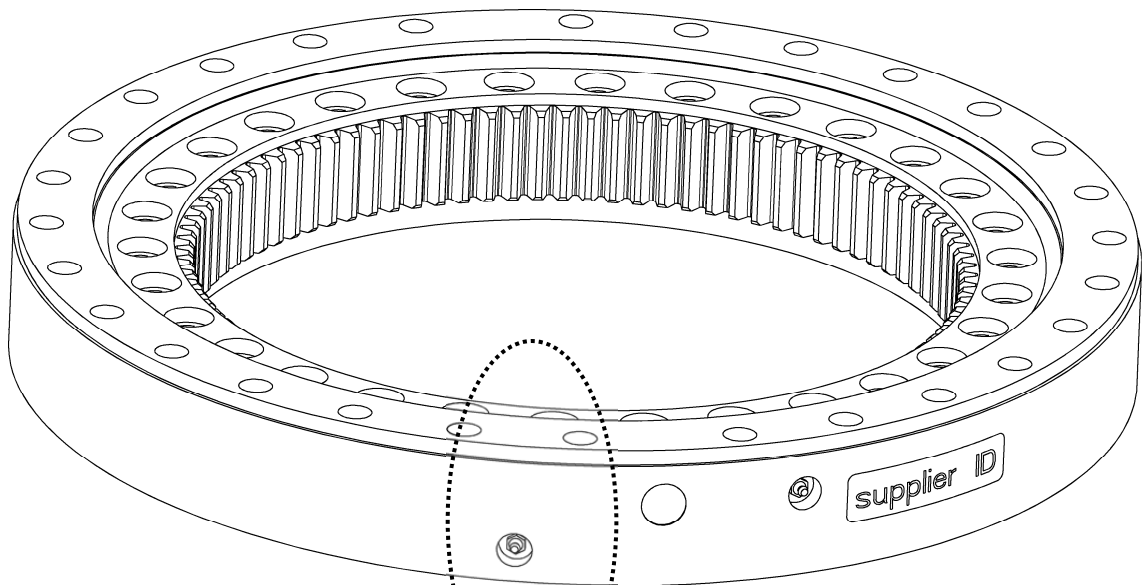


CAUTION!
Valve is equipped with high quality seals.
All valves and blanking ends are
mounted according special instructions.

For further information contact your dealer.

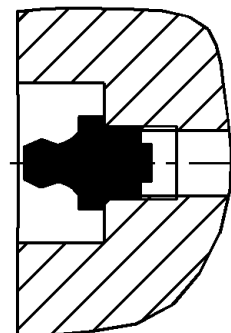
9	504034	Bonded seal	3
8	n.a.	Back-up ring	2
7	504026	Back-up ring	2
6	n.a.	O-ring	2
5	n.a.	O-ring	2
4	504083	O-ring	2
3	504082	O-ring	2
2	504017	O-ring	2
1	500601	O-ring	3
POS	PARTNUMBER	PARTNAME	QT
sealset 504080-01			

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	Product type	DRS-25-A		
Slewing ring	Number	500591-01		

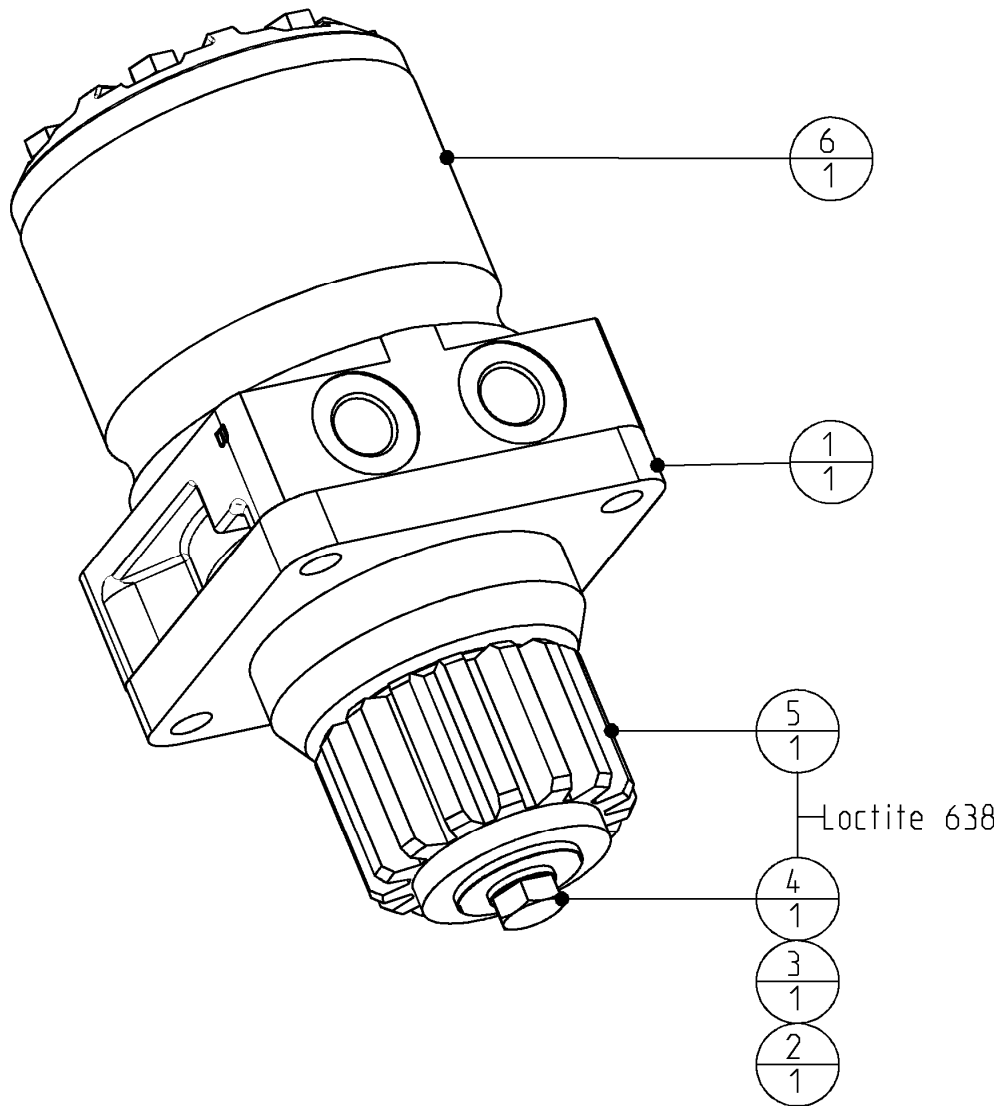


2x seal 256060900
mount with Loctite 480

4x grease nipple
500560

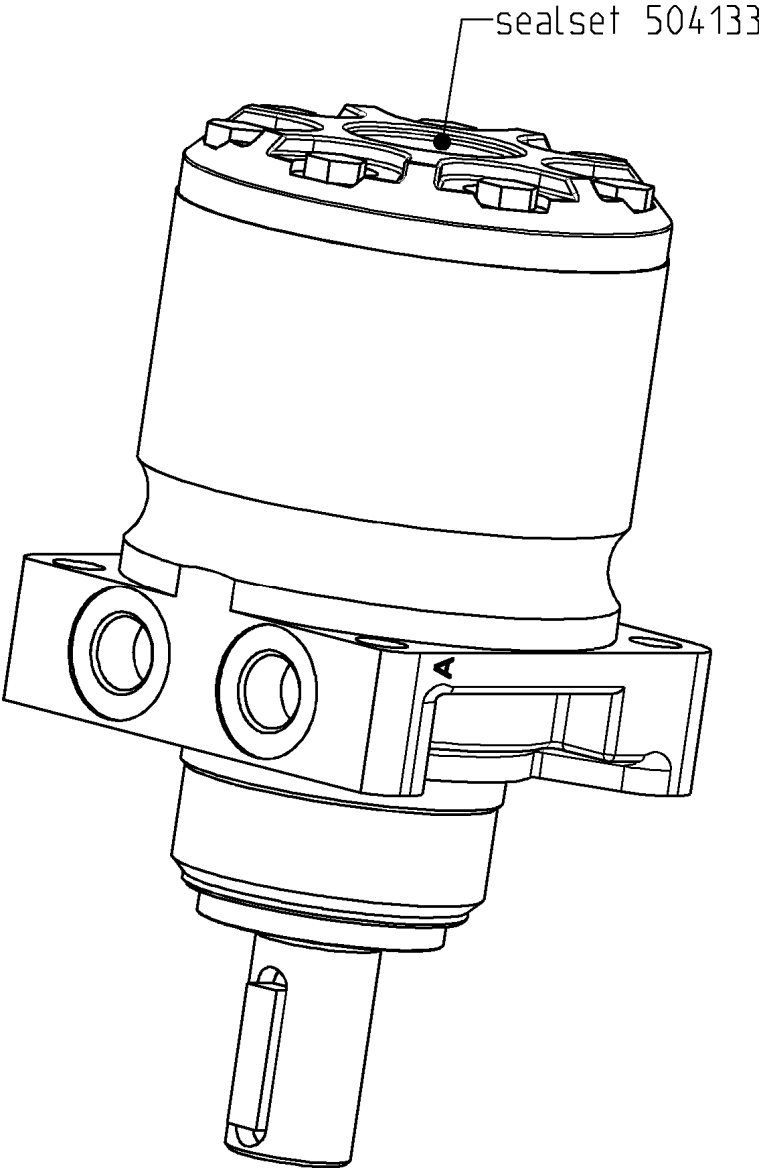


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	Product type	DRS-25-A		
Hydraulic motor GP	Number	406190-00		

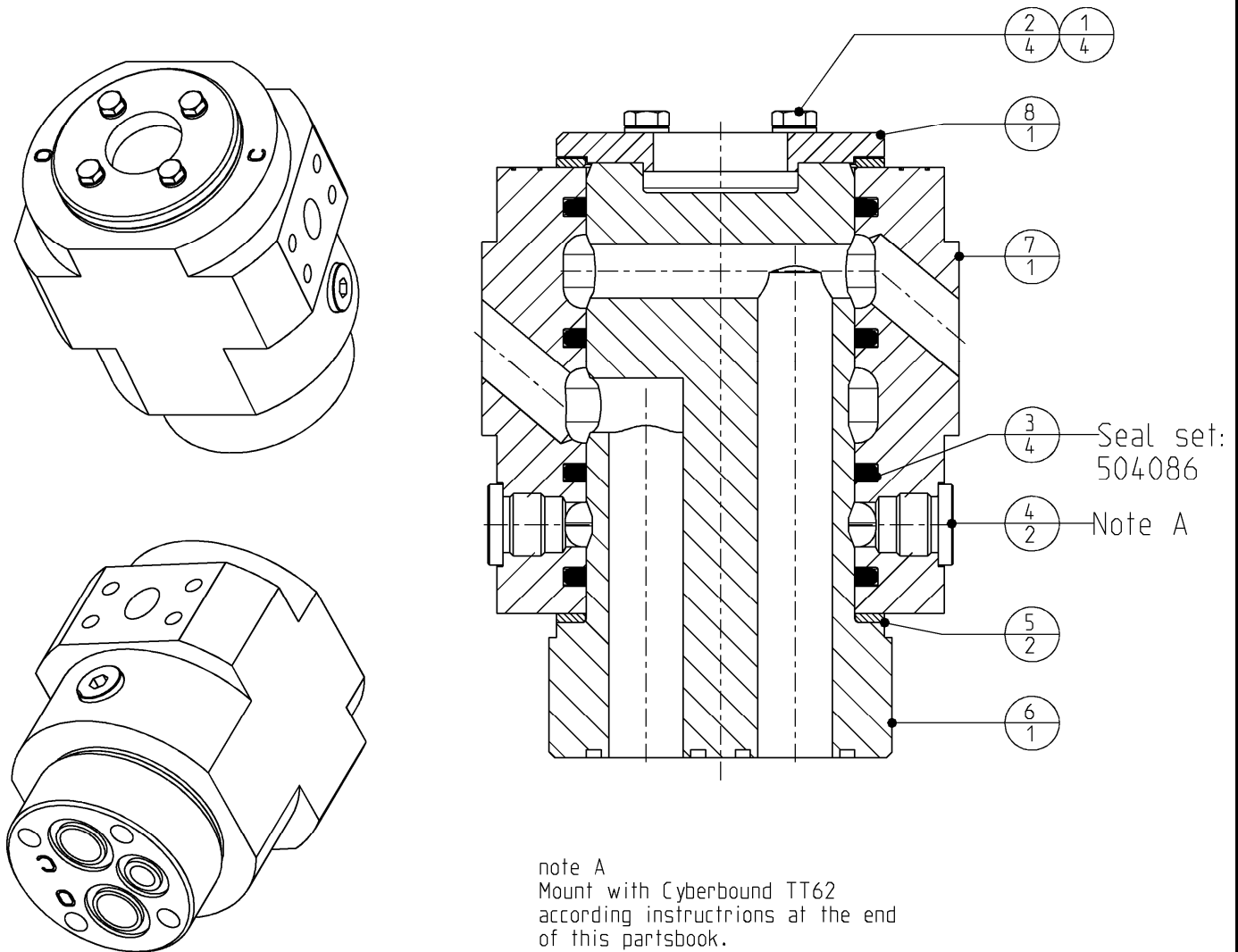


6	501375	Hydraulic motor	1
5	500851	Pinion	1
4	500131	Bolts Hexagon	1
3	500068	Washer spring	1
2	500062	Washer car	1
1	406191	Motorflange	1
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear	Page	16	of	23
	Date	June 2015		
	Product type	DRS-25-A		
Hydraulic motor	Number	501375-00		

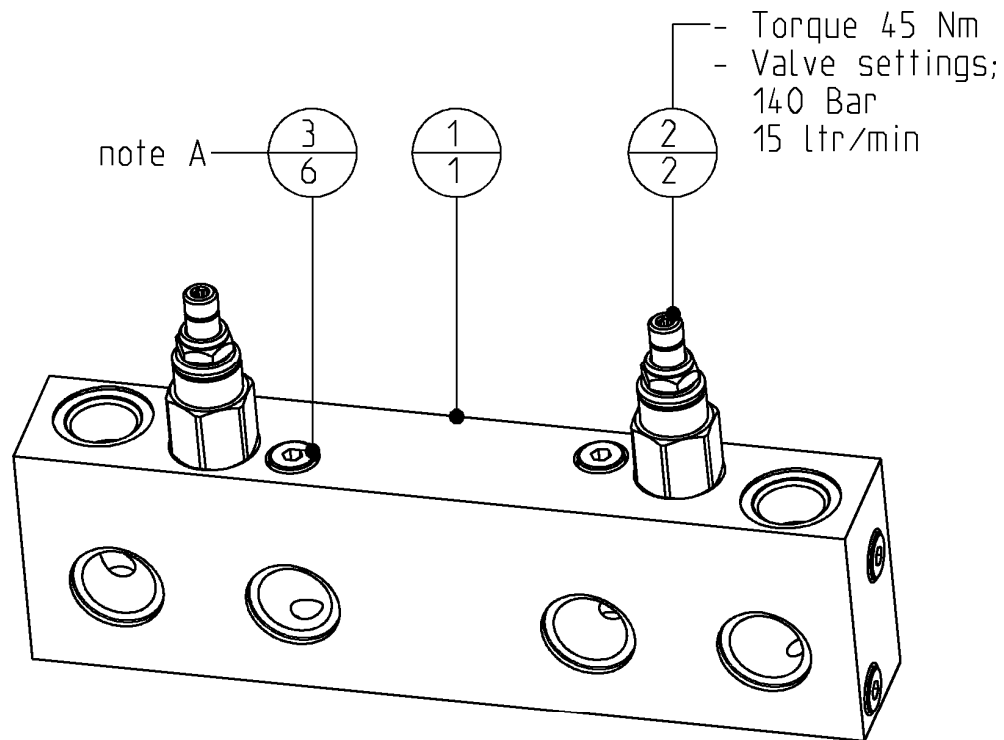


Rotatable Shear	Page	17	of	23
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	Product type	DRS-25-A		
Swivel GP	Number	502286-08		



8	502289	Cover	1
7	502288	Housing	1
6	502287	Stator	1
5	500832	Axial ring	2
4	500652	Blanking end	2
3	500630	Rotary Sealing set	4
2	500105	Bolts Hexagon	4
1	500066	Washer spring	4
POS	PARTNUMBER	PARTNAME	QT

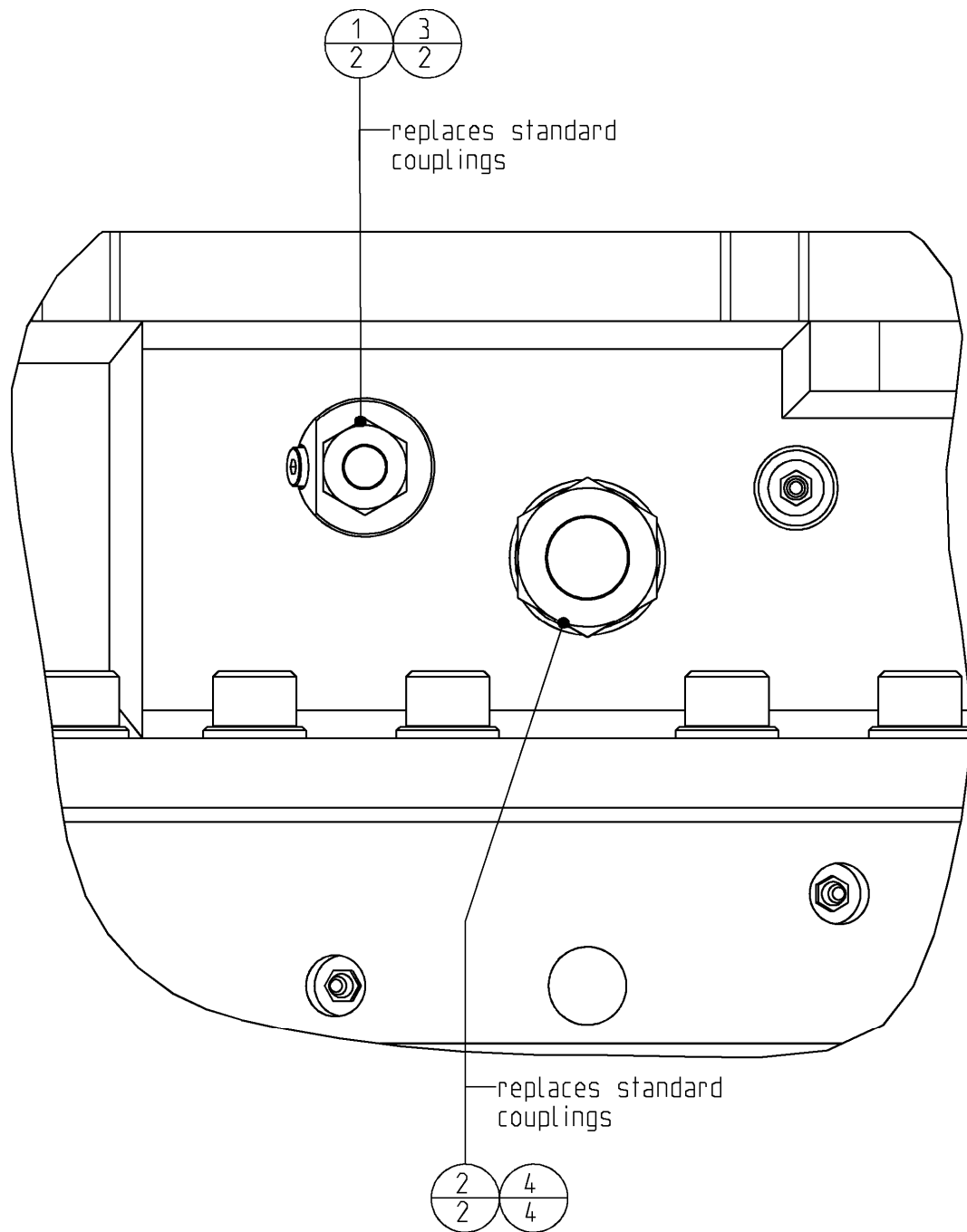
Rotatable Shear	Page	18	of	23
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	Product type	DRS-25-A		
Valve GP	Number	502910-03		



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

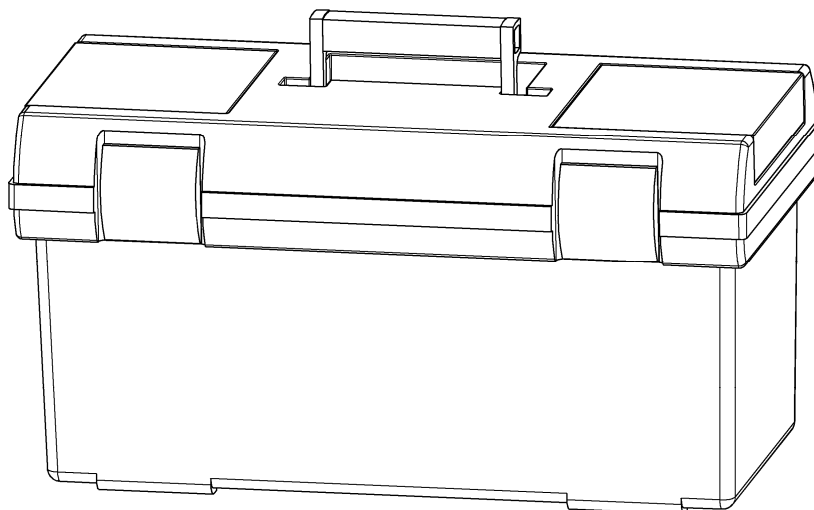
3	290066544	Blanking end ISO 6149	6
2	271060533	Cartridge- relief valve	2
1	502911	Baseplate	1
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear	Page	19	of	23
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	Product type	DRS-25-A		
Fitting kit JIC (optional)	Number	406247-00		



4	503665	Blanking cap	2
3	503662	Blanking cap	2
2	503654	Male stud coupling	2
1	503650	Male stud coupling	2
POS	PARTNUMBER	PARTNAME	QT

Rotatable Shear	Page	20	of	23
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	Product type	DRS-25-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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	Product type	DRS-25-A		
Dealer kit	Number	406776-00		

Recommend spare parts for dealers

15			
14			
13			
12			
11			
10	508136	Toolbox	1
9	504086	Sealset swivel	1
8	504080	Seal set speed valve	1
7	502979	Protection cap cylinder	1
6	502910	Valve - motor	1
5	501255	Seal + bolt set cylinder	1
4	500755	Speed valve	1
3	405590	Piercingblade set	1
2	406675	Shearblade set	1
1	406190	Hydraulic motor GP	2
POS	PARTNUMBER	PARTNAME	QT

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	Product type	DRS-25-A		
Additional parts	Number	n.a.		

Chemical lock

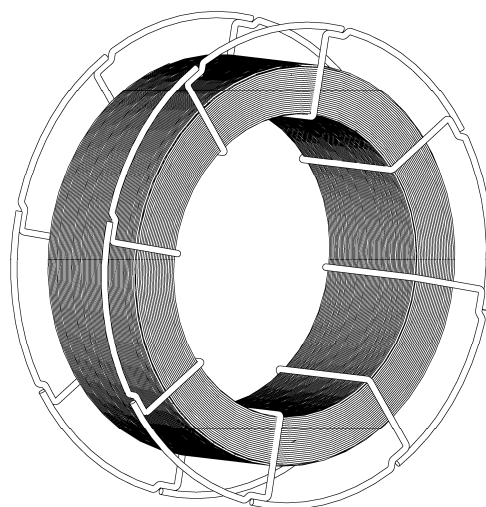
195050158	Cyberbond TT62 Pumpgel	1
506018	Loctite 480 Flacon 20 gr	1
506017	Loctite 638 Flacon 50 ml	1
506016	Loctite 270 Flacon 50 ml	1
PARTNUMBER	PARTNAME	QT



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

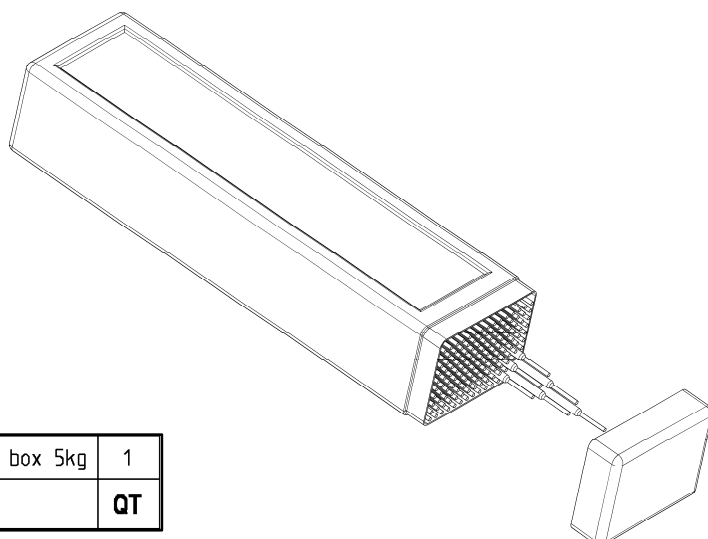
501237	Welding wire MAG; 1.8425, coil 15kg	1
PARTNUMBER	PARTNAME	QT



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



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	Product type	DRS-25-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 anarobic 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



DEMAREC AND KINSHOFER WORLDWIDE

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