



**MTG**

No limits innovation



**INS.1.2.3**

# **TWINMET retrofit (MJ square series)**

Installation procedure

## DISCLAIMER

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## 1. SAFETY

The practices described in this manual can be taken as guidelines for operating safely in many conditions and in addition to the safety standards that are current and enforceable in your area or region.

Your safety and the safety of third parties is the result of putting into practice your knowledge of the correct operational procedures.

Attention, when performing the work described in these instructions, always work safely and use the personal protection elements required to minimize or avoid injury. Always wear:



**HARD  
HAT**



**SAFETY  
GLASSES**



**EAR  
PROTECTION**



**STEEL TOED  
BOOTS**



**PROTECTION  
GLOVES**

To avoid eye injury, always wear safety goggles or a protective mask when using any equipment, hammer or similar tool. When equipment is under pressure or when objects are struck, chips or other debris can be thrown out. Make sure no one gets hurt by the debris that is fired before applying pressure or hitting an object. Wear eye protection that complies with ANSI Z87.1 and OSHA standards. Also wear hearing protection and gloves.

Lifting a heavy object can cause serious or fatal injury. DO NOT exceed the maximum rated capacity of lifting and positioning devices: Stay away from the area under a suspended load.

Make sure that the chain is not damaged and that the load is always balanced.



**LIFTING  
LUG**

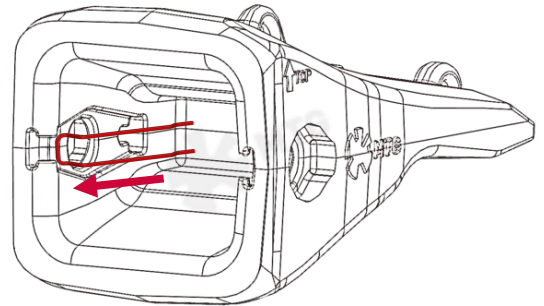
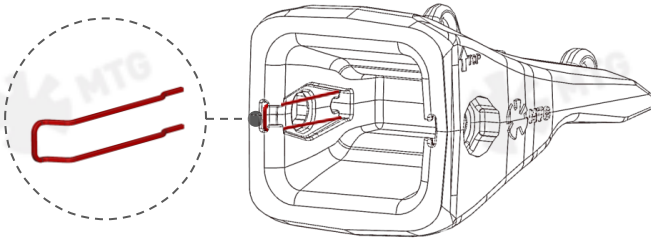
## 2. INSTALLATION PROCEDURE

**NOTE:** Neither the steel retainer nor the pin or sleeve are reusable, especially for safety reasons. When exchanging or rotating positions for any reason, involving the disassembly process, a new pin, retainer and sleeve **MUST** be installed.



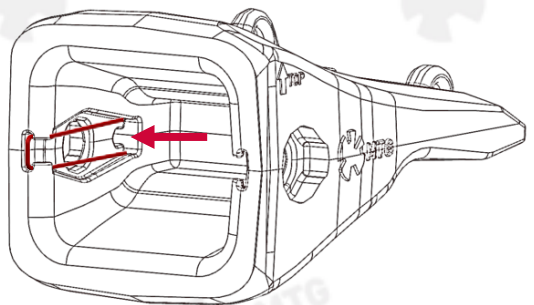
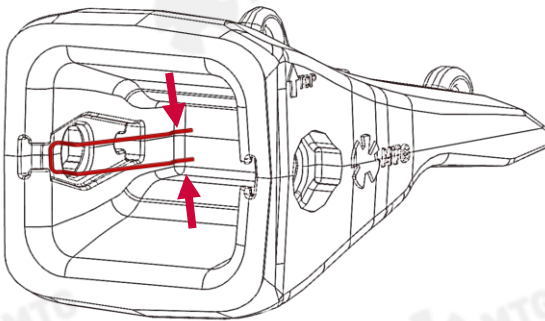
**2.1** Make sure the retainer is properly seated in its mounting position. If so, go to step 2.5 otherwise go to the next step.

**2.2** Place the retainer in the open slot until it remains anchored / fixed.



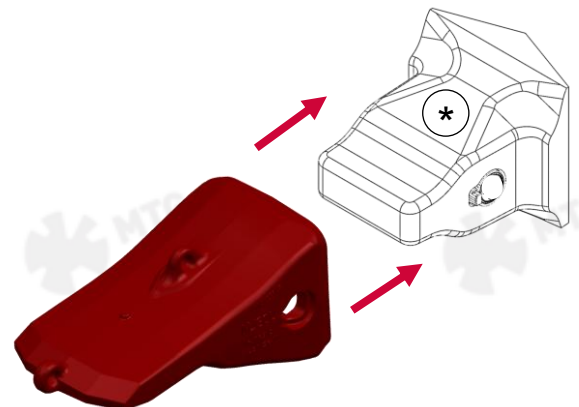
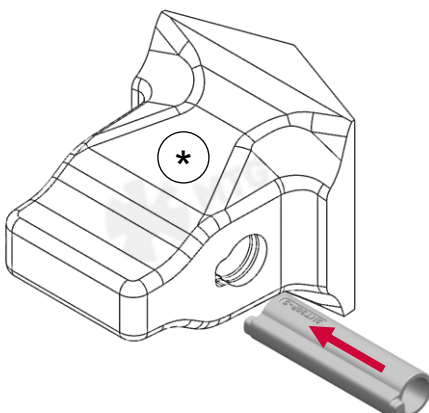
**2.3** Slightly press both ends of the retainer and turn them towards the 2nd slot (internal side) to allow both ends to anchor inside the slot.

**2.4** Release the pressure on the retainer once placed inside the slot and verify that it has opened, and it is in its final position.

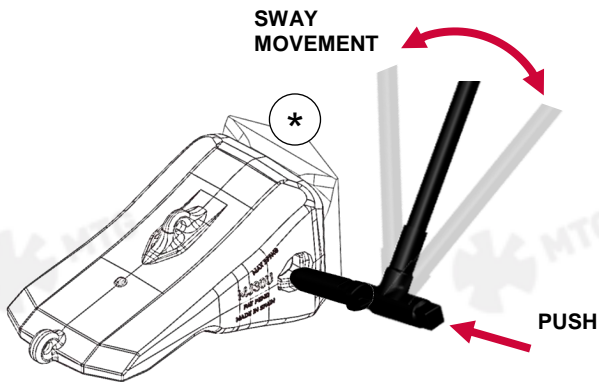


**2.5** Insert the sleeve on either side of the nose.

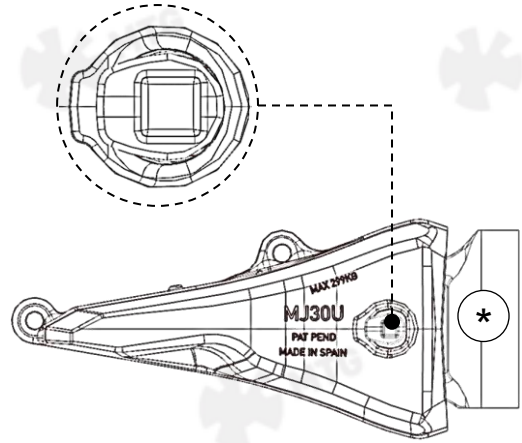
**2.6** Insert the tooth into the nose with the help of the lifting lug and a crane.



- 2.7** Insert the pin on one of the sides by its chamfered end and push it against the retainer with the help of the removal tool. A sway motion (back and forth) of the removal tool while pushing the pin in will help the operation.



- 2.8** When the pin reaches its final position, the pin tab should be aligned with its housing.



- 2.9** Once the pin is locked (working position) a "Click" sound should be heard.



- 2.10** Repeat the previous steps (2.7-2.9) with the pin on the other side.

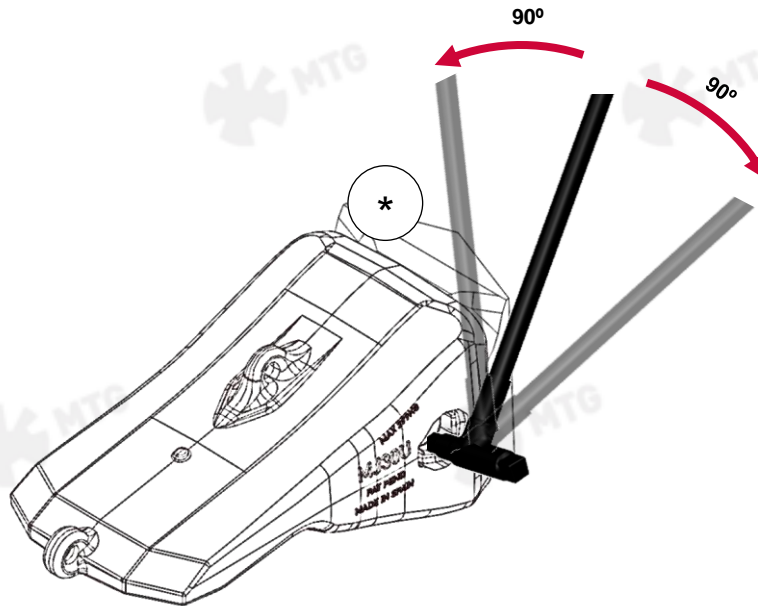
### 3. REMOVAL PROCEDURE

**NOTE:** Prior starting the removal procedure, check that the lifting lug is still in working order. If the lifting lug is damaged, or shows clear signs of wear, proceed to weld a new lifting lug capable of withstand 300 kg (661 lb).

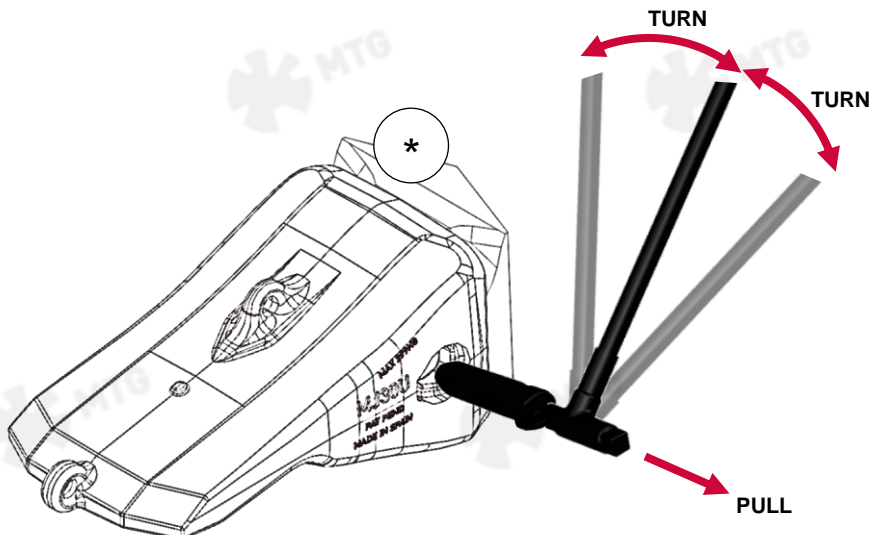


**3.1** Clean the fines stuck inside the square pin cavity. Then insert the removal tool and rotate the pin 90° in either direction to unlock the retainer from the pin.

If the pin is hard to turn, do not force it and proceed with several sway movements (back and forth) to break up the fines stuck inside the hole. An impact gun can be used for this operation.



**3.2** Once the pin has turned 90°, remove it from its housing by pulling and turning with the removal tool.



**3.3** Repeat the previous steps 3.1 and 3.2 with the pin on the other side.



## Service Instructions

The latest welding recommendations and assembly / disassembly instructions can be found online:

[www.mtgcorp.com/manuals](http://www.mtgcorp.com/manuals)

Please contact Technical Services in case of questions:

[technical.services@mtgcorp.com](mailto:technical.services@mtgcorp.com)



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### MTG HEADQUARTERS

Carrer d'Àvila, 45  
08005 Barcelona (Spain)  
(+34) 93 741 70 00  
[info@mtgcorp.com](mailto:info@mtgcorp.com)

### MTG NORTH AMERICA

4740 Consulate Plaza Drive  
Houston, TX 77032 (USA)  
+1 (281) 872 1500  
[Info.na@mtgcorp.com](mailto:Info.na@mtgcorp.com)

### MTG AUSTRALIA

16 – 18 Thorpe Close  
Welshpool, WA, 6106 (AUS)  
+61 8 6248 6513  
[Info.au@mtgcorp.com](mailto:Info.au@mtgcorp.com)