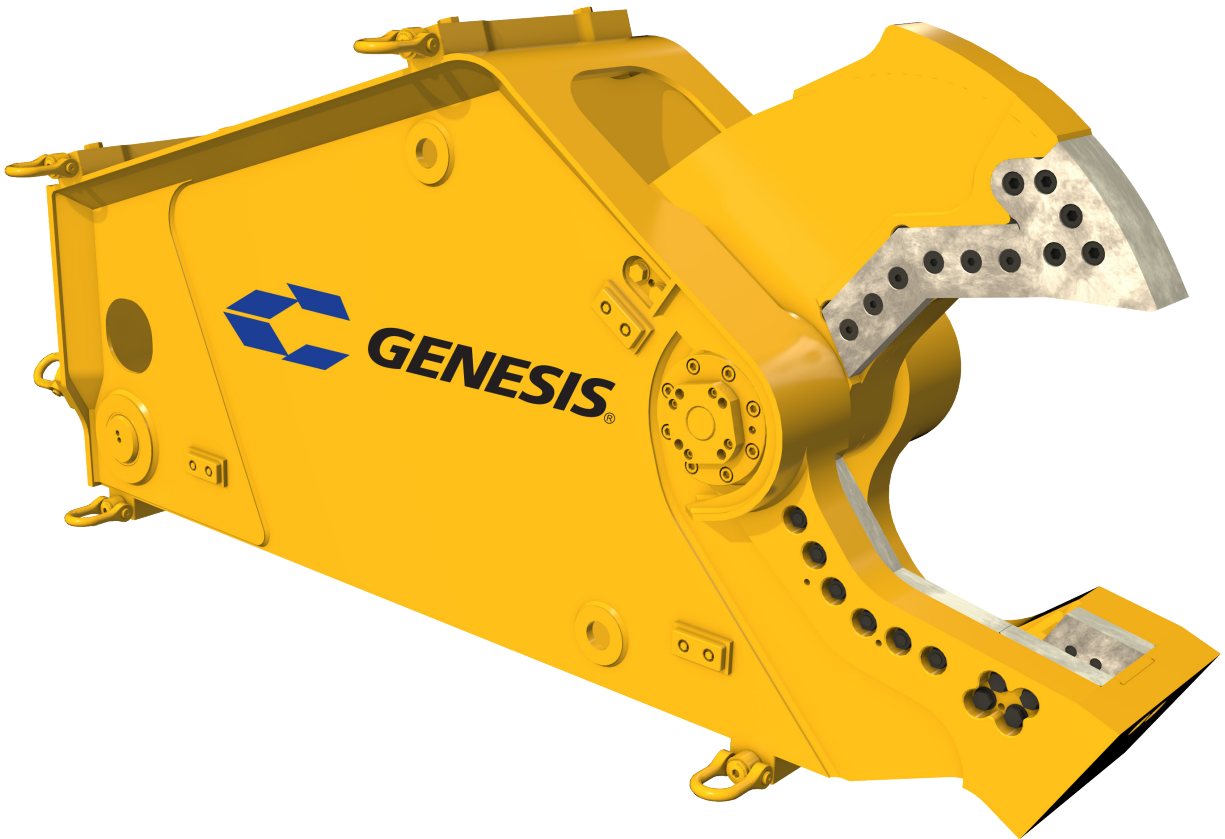




# GSS 665 Subsea Shear

## PARTS MANUAL



## CONTACT INFORMATION

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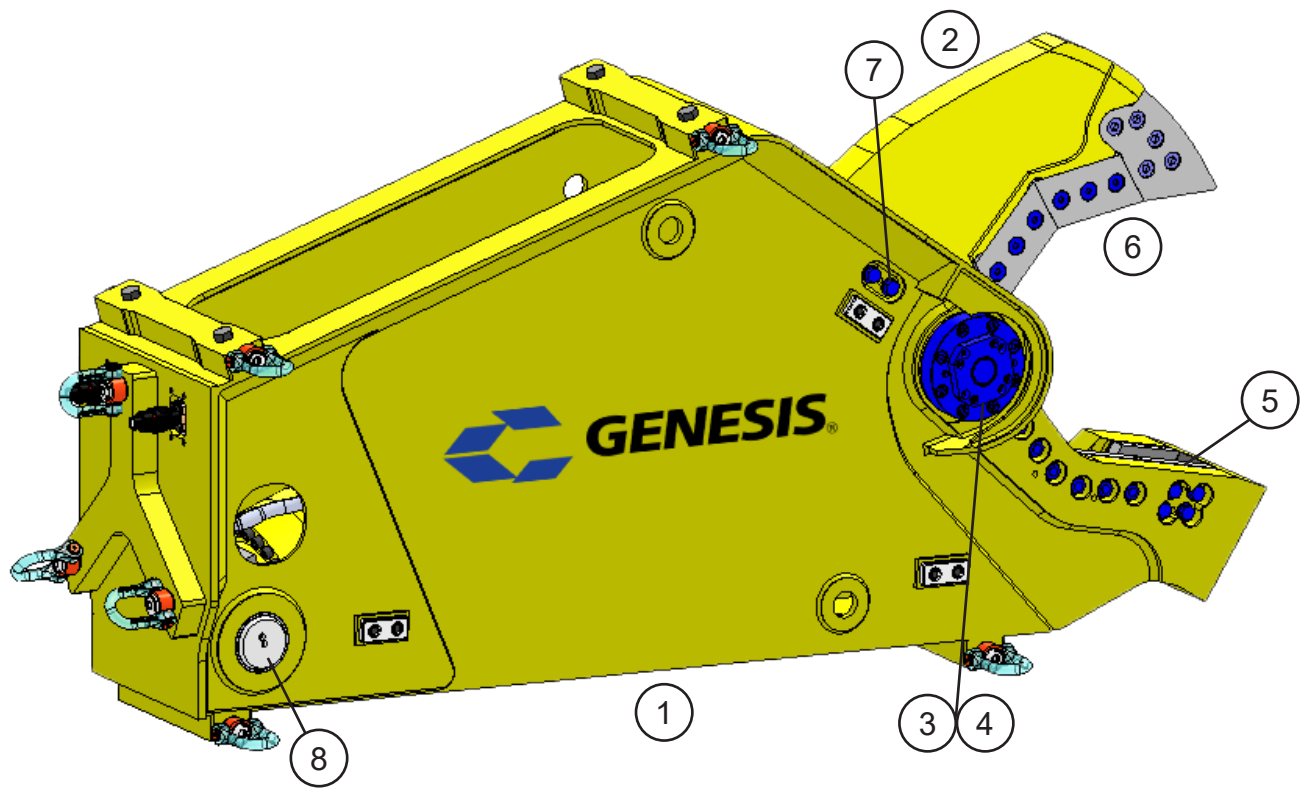
E-mail:  
contact@themsagroup.com

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# GENERAL ARRANGEMENT



# GENERAL ARRANGEMENT

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	*	Mach Stick
2	1	*	Wldt Upper
3		See page 6	Assembly Pivot Group - Right Side
4		See page 8	Assembly Pivot Group - Left Side
5		See page 10	Assembly Lower Blades
6		See page 12	Assembly Upper Blades
7		See page 14	Assembly Auto Guide
8		See page 16	Assembly Cylinder Pins

\* Part numbers are Serial Number specific. For replacement parts call the Genesis Parts Department.

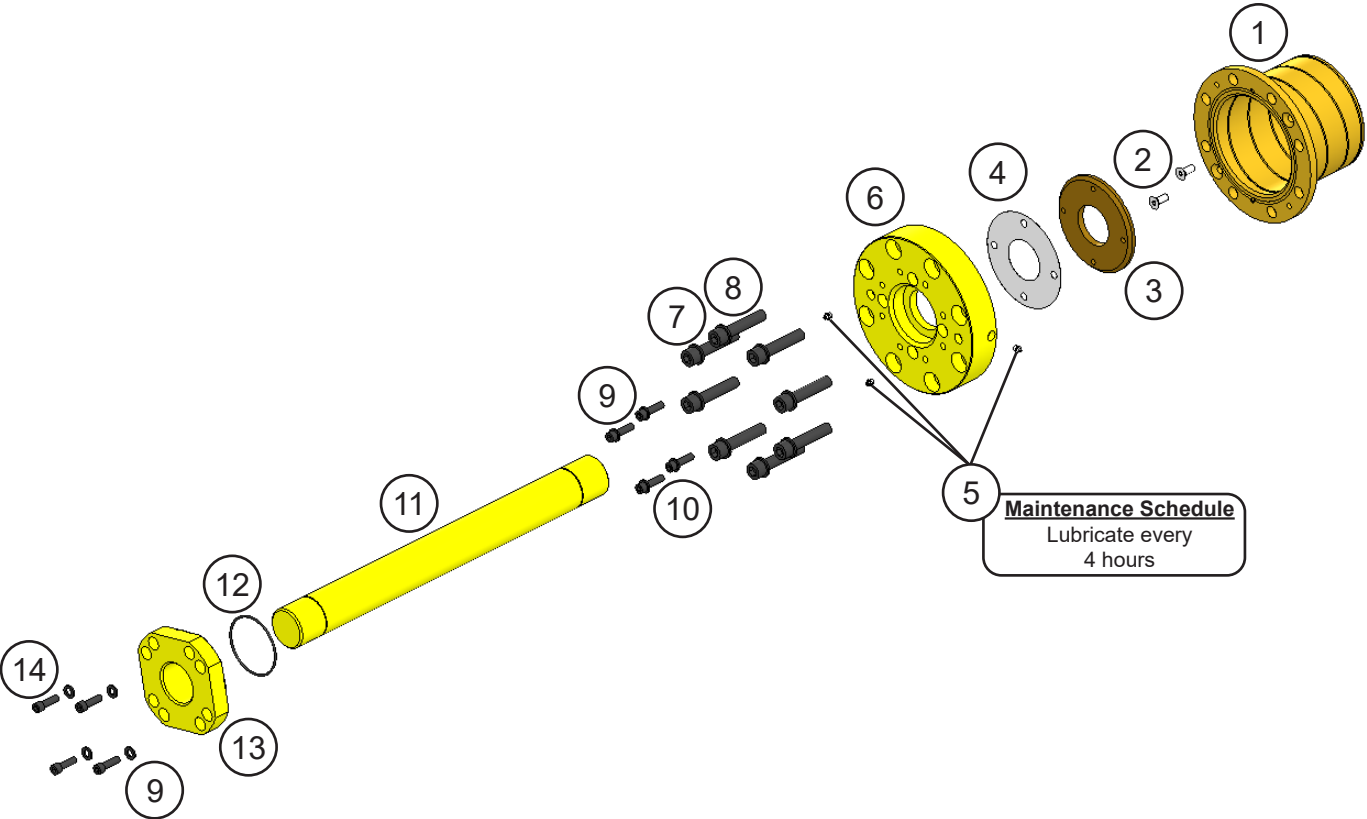
**USA**

715-395-5614  
715-395-3405

**Europe**

+49 83 31 9 25 98 0

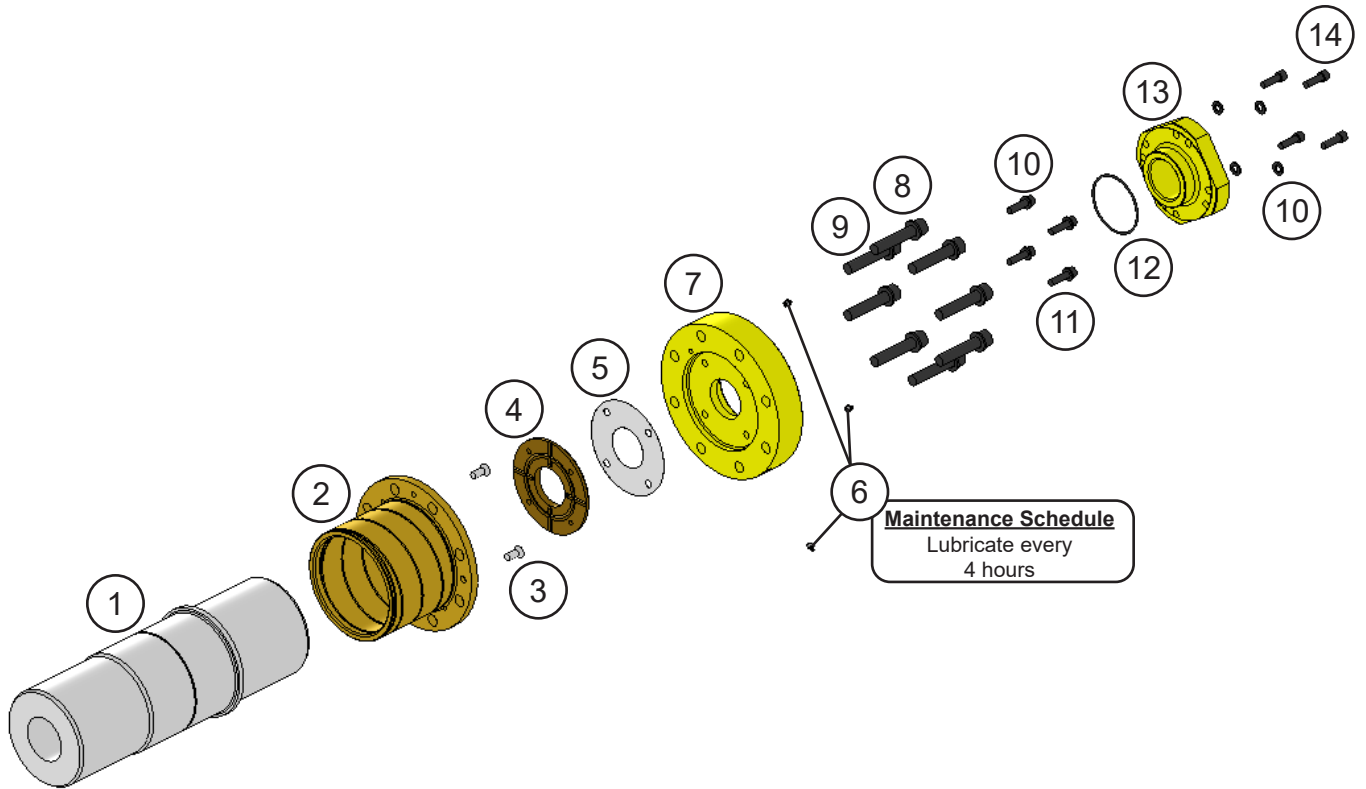
# ASSEMBLY PIVOT GROUP - RIGHT SIDE



## ASSEMBLY PIVOT GROUP - RIGHT SIDE

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1109295	Mach Bearing
2	2	F0412030	Flat Head Capscrew M12 x 1.75 x 30
3	1	1102442	Mach Thrust Washer
4	1	1102448	Shim Set Thrust Washer
5	3	6200002	Grease Fitting
6	1	1109297	Mach End Cap
7	8	FE1202037	Flat Washer M20
8	8	FE0620100	Socket Head Capscrew M20 x 2.50 x 100
9	8	FE1201224	Flat Washer M12
10	4	FE0612045	Socket Head Capscrew M12 x 1.75 x 45
11	1	1109296	Mach Tie Rod
12	1	S0190244	O-Ring
13	1	1109306	Mach Tie Rod Nut
14	4	FE0612040	Socket Head Capscrew M12 x 1.75 x 40

# ASSEMBLY PIVOT GROUP - LEFT SIDE





## ASSEMBLY PIVOT GROUP - LEFT SIDE

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	*	Mach Main Shaft
2	1	1109295	Mach Bearing
3	2	F0412030	Flat Head Capscrew M12 x 1.75 x 30
4	1	1102442	Mach Thrust Washer
5	1	1102448	Shim Set Thrust Washer
6	3	6200002	Grease Fitting
7	1	1109297	Mach End Cap
8	8	FE1202037	Flat Washer M20
9	8	FE0620100	Socket Head Capscrew M20 x 2.50 x 100
10	8	FE1201224	Flat Washer M12
11	4	FE0612045	Socket Head Capscrew M12 x 1.75 x 45
12	1	S0190244	O-Ring
13	1	1109306	Mach Tie Rod Nut
14	4	FE0612040	Socket Head Capscrew M12 x 1.75 x 40

\* Part number is Serial Number specific. For replacement parts call the Genesis Parts Department.

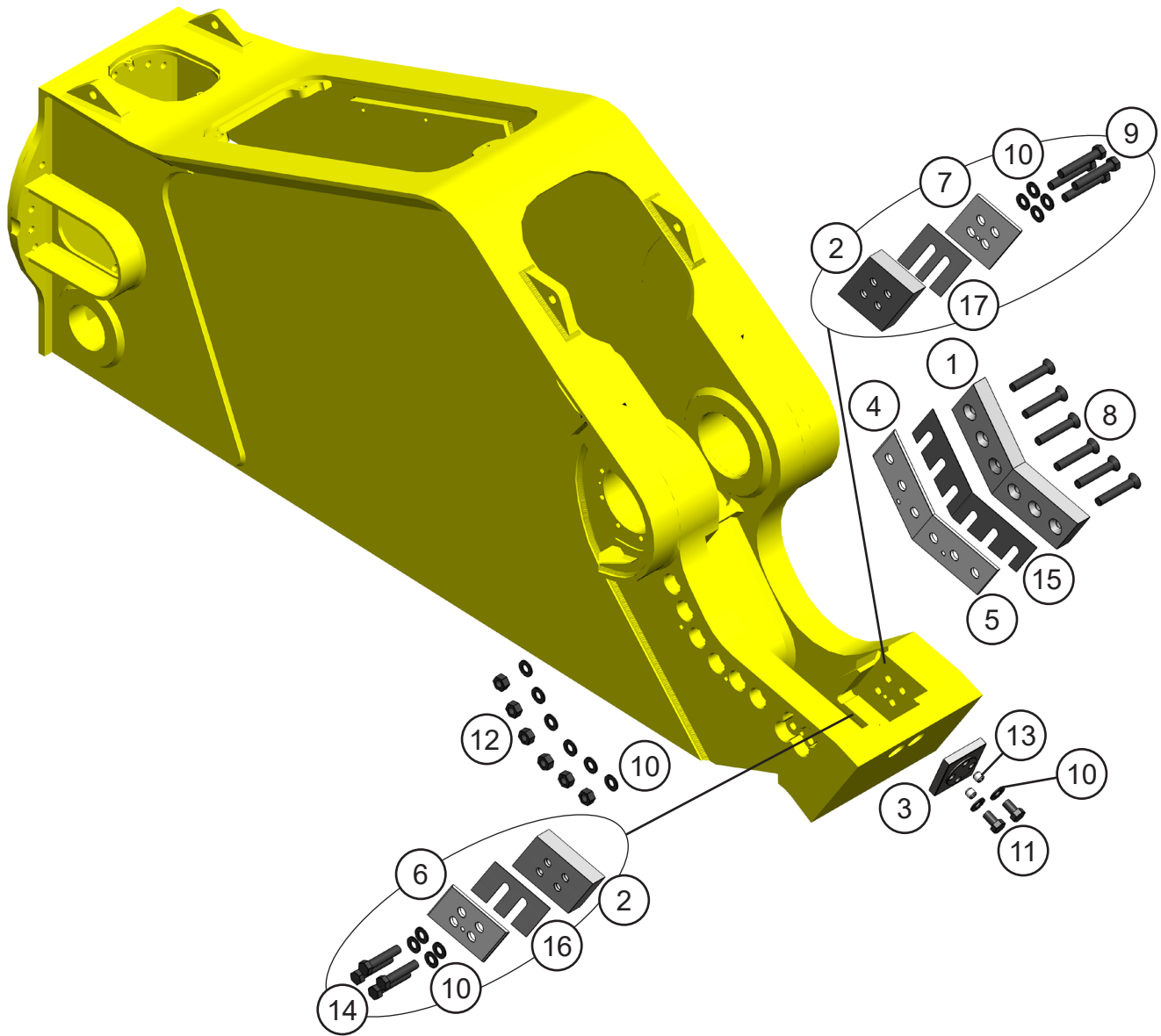
**USA**

715-395-5614  
715-395-3405

**Europe**

+49 83 31 9 25 98 0

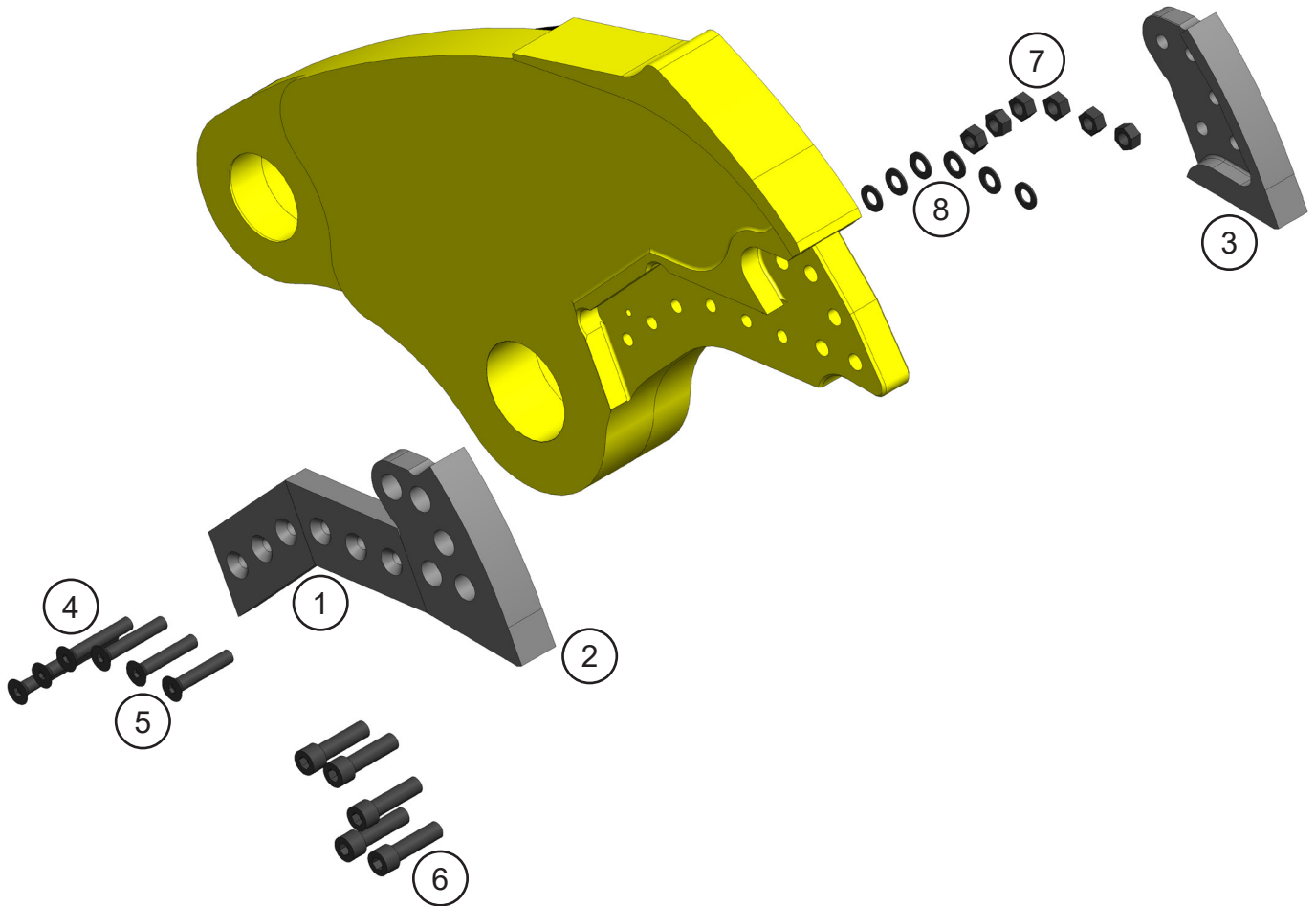
# ASSEMBLY LOWER BLADES



## ASSEMBLY LOWER BLADES

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	1105721	Mach Blade
2	2	1105722	Mach Blade Guide
3	1	1101957	Mach Blade Razor
4	1	1105863	Mach Adjustment Plate Primary
5	1	1105821	Mach Adjustment Plate Secondary
6	1	1105865	Mach Guide Blade Adjustment Plate
7	1	1105867	Mach Guide Blade Adjustment Plate
8	6	FE0510600	Flat Head Capscrew 1 - 8 x 6
9	4	FE0210600	Hex Head Capscrew 1 - 8 x 6
10	16	FE1300100	Flat Washer Narrow 1"
11	2	FE0210175	Hex Head Capscrew 1 - 8 x 1 $\frac{3}{4}$
12	6	FE0910008	Hex Nut 1 - 8
13	2	F2510100	Set Screw Socket Head 1 - 8 x 1
14	4	FE0210500	Hex Head Capscrew 1 - 8 x 5
15		1105723	Blade Shim Set
16		1105724	Guide Blade Shim Set
17		1105725	Guide Blade Shim Set

# ASSEMBLY UPPER BLADES

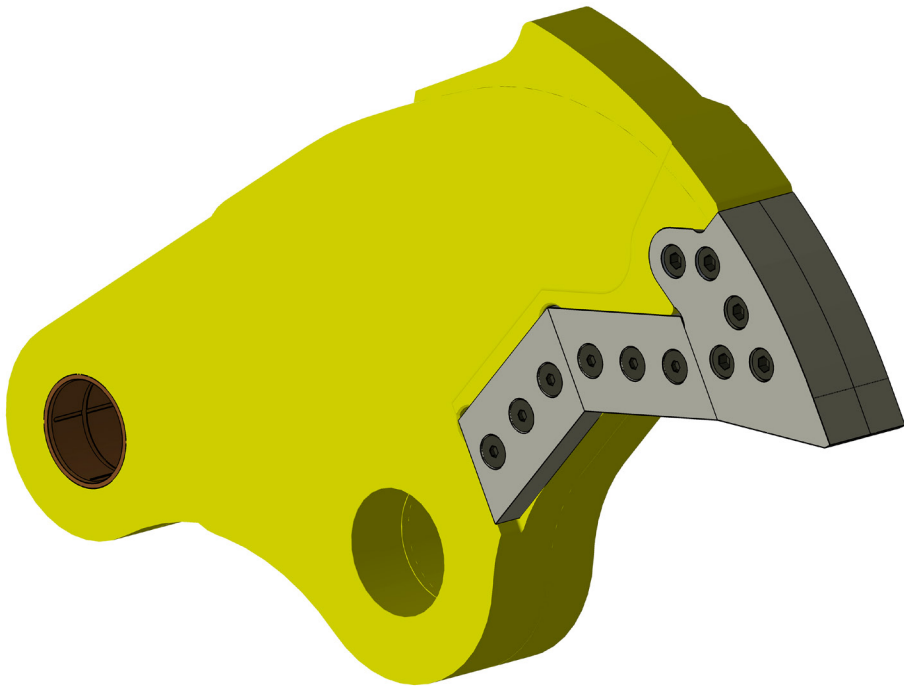
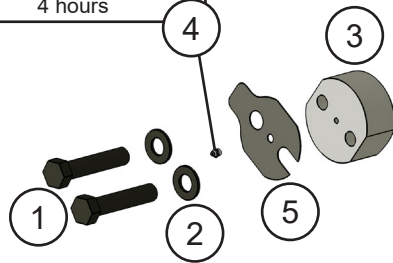


## ASSEMBLY UPPER BLADES

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	1105721	Mach Blade
2	1	1105840	Mach Blade Tip RH
3	1	1105841	Mach Blade Tip LH
4	4	FE0510700	Flat Head Capscrew 1 - 8 x 7
5	2	FE0510550	Flat Head Capscrew 1 - 8 x 5½
6	5	1109334	Mach Bolt Socket Head Capscrew 1¼ - 7 x 4½ Custom
7	6	FE0910008	Hex Nut 1 - 8
8	6	FE1300100	Flat Washer Narrow 1"

# ASSEMBLY AUTO GUIDE

**Maintenance Schedule**  
Lubricate every  
4 hours



# ASSEMBLY AUTO GUIDE

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	FE0210500	Hex Head Capscrew 1 - 8 x 5
2	2	FE1300100	Flat Washer Narrow 1"
3	1	*	Mach Auto Guide
4	1	6200002	Grease Fitting
5		1106478	Shim Set, Auto Guide

\* Part number is Serial Number specific. For replacement parts call the Genesis Parts Department.

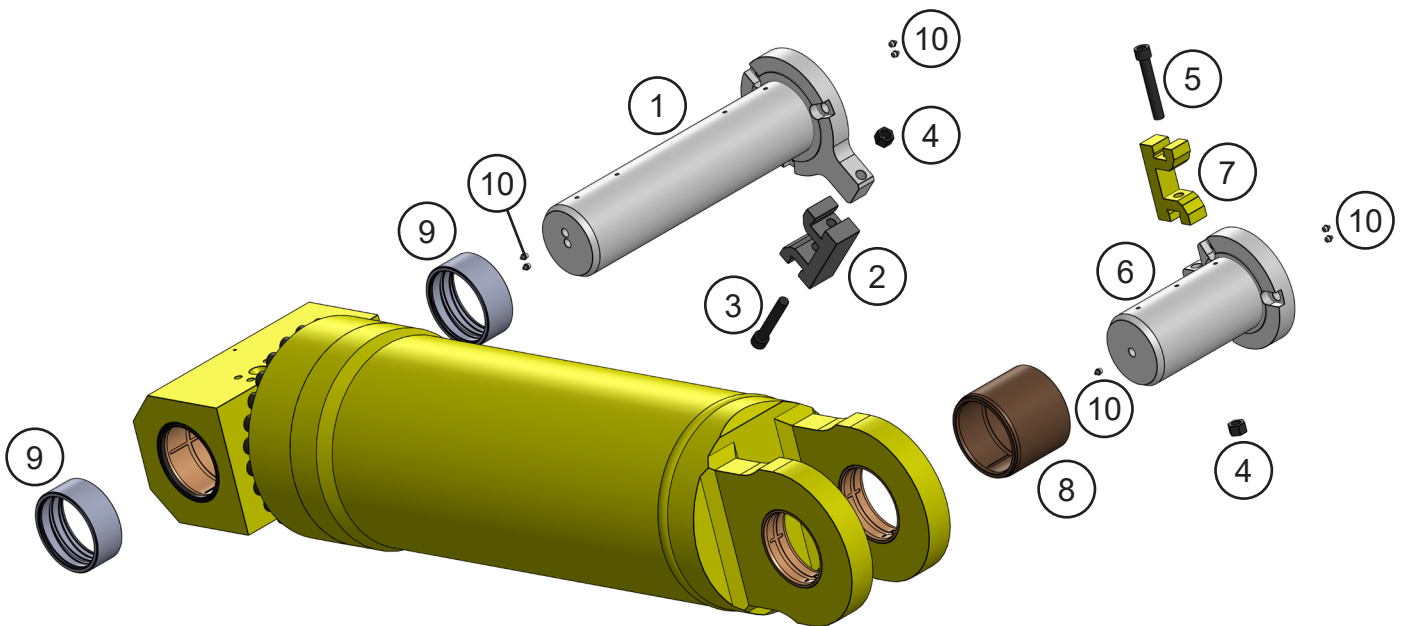
**USA**

715-395-5614  
715-395-3405

**Europe**

+49 83 31 9 25 98 0

# ASSEMBLY CYLINDER PINS

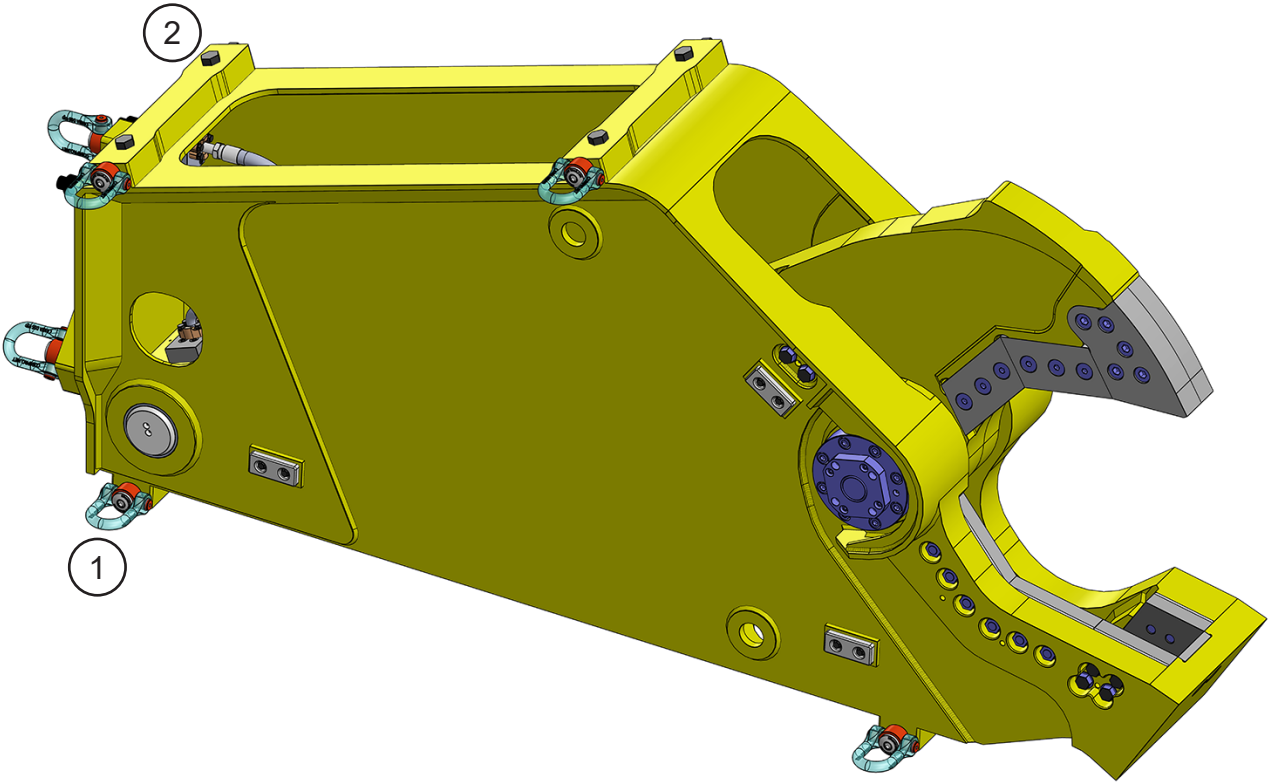




## ASSEMBLY CYLINDER PINS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1109285	Mach Pin Rear
2	1	1109290	Mach Pin Keeper Rear
3	1	F0620130	Socket Head Capscrew M20 x 2.50 x 200
4	2	F1020250	Nylock Hex Nut M20 x 2.50
5	1	F0620130	Socket Head Capscrew M20 x 2.50 x 130
6	1	1109298	Wldt Front Cylinder Pin
7	1	1102487	Mach Pin Keeper (Clevis)
8	1	3100061	Mach Bearing Upper Cylinder Connection
9	2	1109281	Mach Bearing Rear Stick
10	7	6200002	Grease Fitting

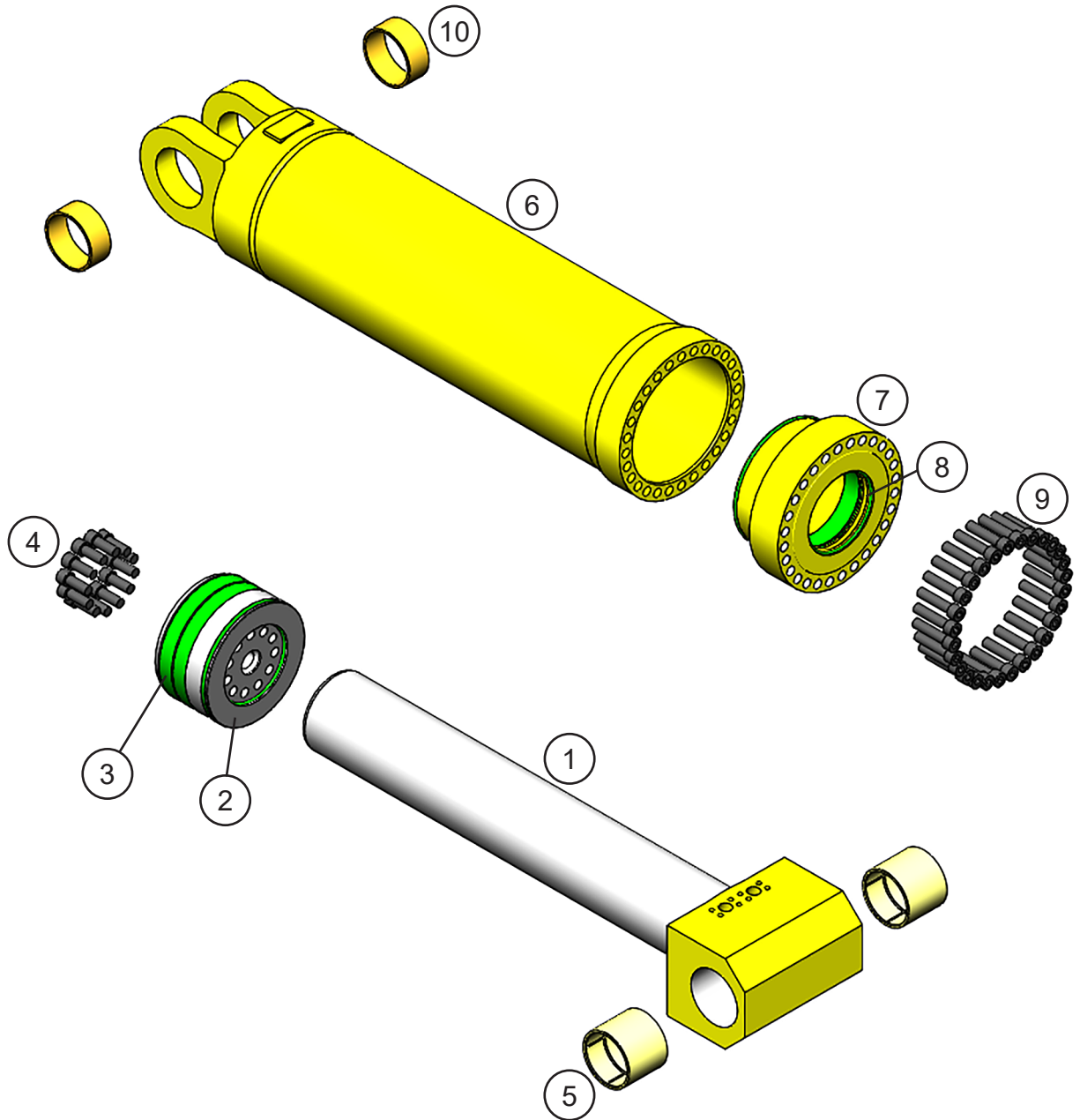
# ASSEMBLY BRACKET



## ASSEMBLY BRACKET

ITEM	QTY	PART NUMBER	DESCRIPTION
1	7	6200092	Shackle Double Swing
2	8	F0213200	Hex Head Capscrew 1.25 - 7.00 - 2.00 GR8

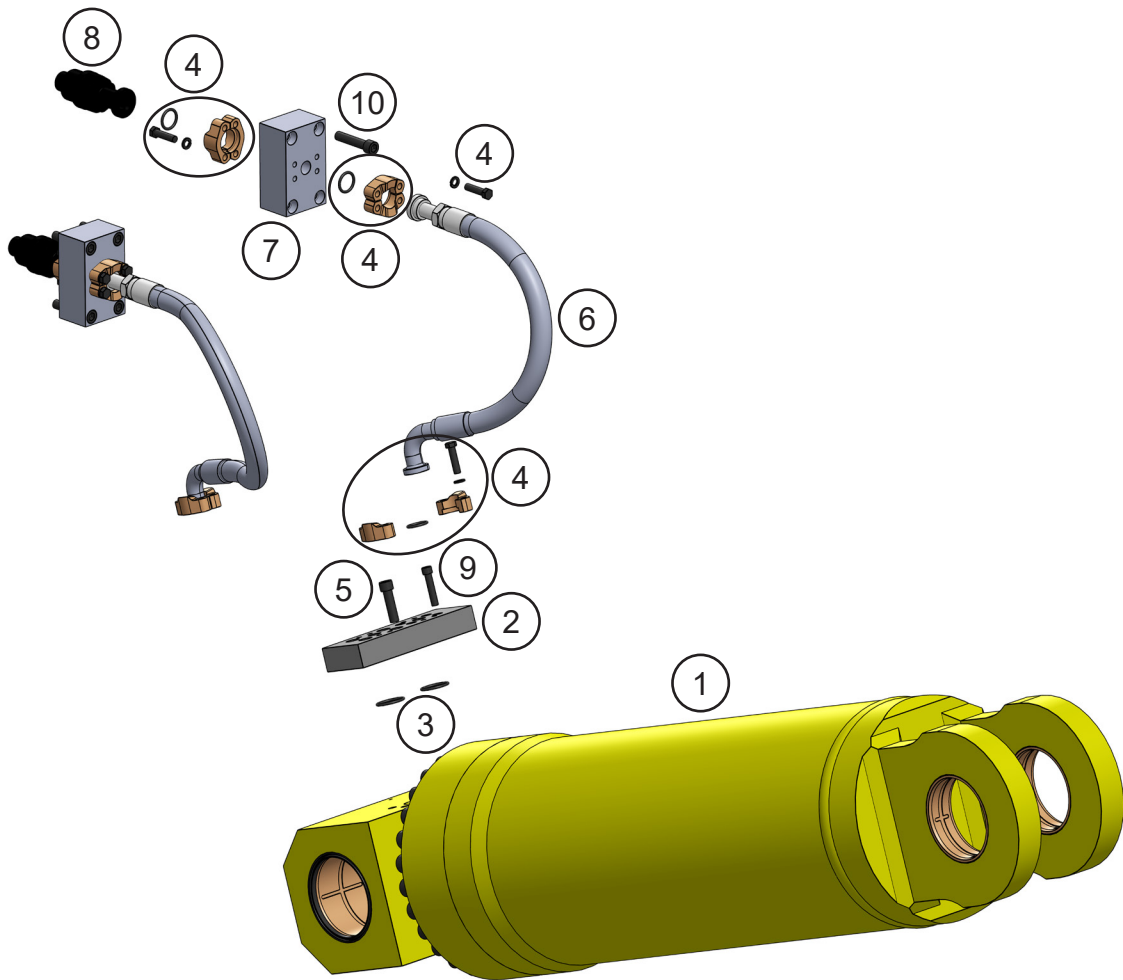
# ASSEMBLY CYLINDER - 6350182



## ASSEMBLY CYLINDER - 6350182

ITEM	QTY	PART NUMBER	DESCRIPTION
		6350182	Assembly Cylinder - Complete
1	1	For Replacement parts, call the Genesis parts department.  USA 715-395-5614 715-395-3405 Europe +49 83 31 9 25 98 0	Rod
2	1		Piston
3	1		Piston Seals
4	11		Socket Head Capscrew
5	2		Rod Bearing
6	1		Butt and Tube Assembly
7	1		Gland
8	1		Gland Seals
9	28		Socket Head Capscrew
10	2		Clevice Bearing

# ASSEMBLY HYDRAULICS



## ASSEMBLY HYDRAULICS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	6350182	Assy Cyl. B14.0 R9.0 S32.75
2	1	1109185	Mach Cylinder Manifold
3	2	S0190225	O-Ring
4	6	<b>1" Split Flange Kit</b>	
	2	HS262100	Split Flange Half 1.00 Code 62
	4	F0112050	Socket Head Capscrew M20 x 2.5 x 70
	4	F1401200	Lock Washer M20
	1	S0190219	O-Ring
5	4	F0616060	Socket Head Capscrew M16 x 2.0 x 60
6	2	1109273	Hose 16EFG6K - 16FL - 16FL90M - 30.75
7	2	1107782	Mach Adapter Block
8	2	6301209	Male Quick Connect
9	4	F0612060	Socket Head Capscrew M12 x 1.75 x 60
10	8	F0616080	Socket Head Capscrew M16 x 2.00 x 80

## BOLT TORQUE SPECIFICATIONS

Reference the product Thread Treatment Diagram on page 25 to determine whether to use wet or dry torque values for specific bolts.

Reference Procedures on page 26 for threadlocker or anti-seize application and bolt and bolt hole cleaning.

Prior to torquing, clean all bolt holes, bolts and nuts to remove dirt, grease and oil, and identify bolt type.

Never re-torque bolts that use Loctite. If a bolt becomes loose or damaged after the initial use when Loctite was applied and the bolt was torqued, the bolt must be replaced.

Never break tightened bolts loose with a torque wrench. Doing so may break the torque wrench or take it out of calibration.

Torque wrenches should be calibrated on an annual basis.

When using a torque multiplier with a torque wrench, incorrect settings will be multiplied by the ratio of the torque wrench.

Never use an impact driver on a torque multiplier.

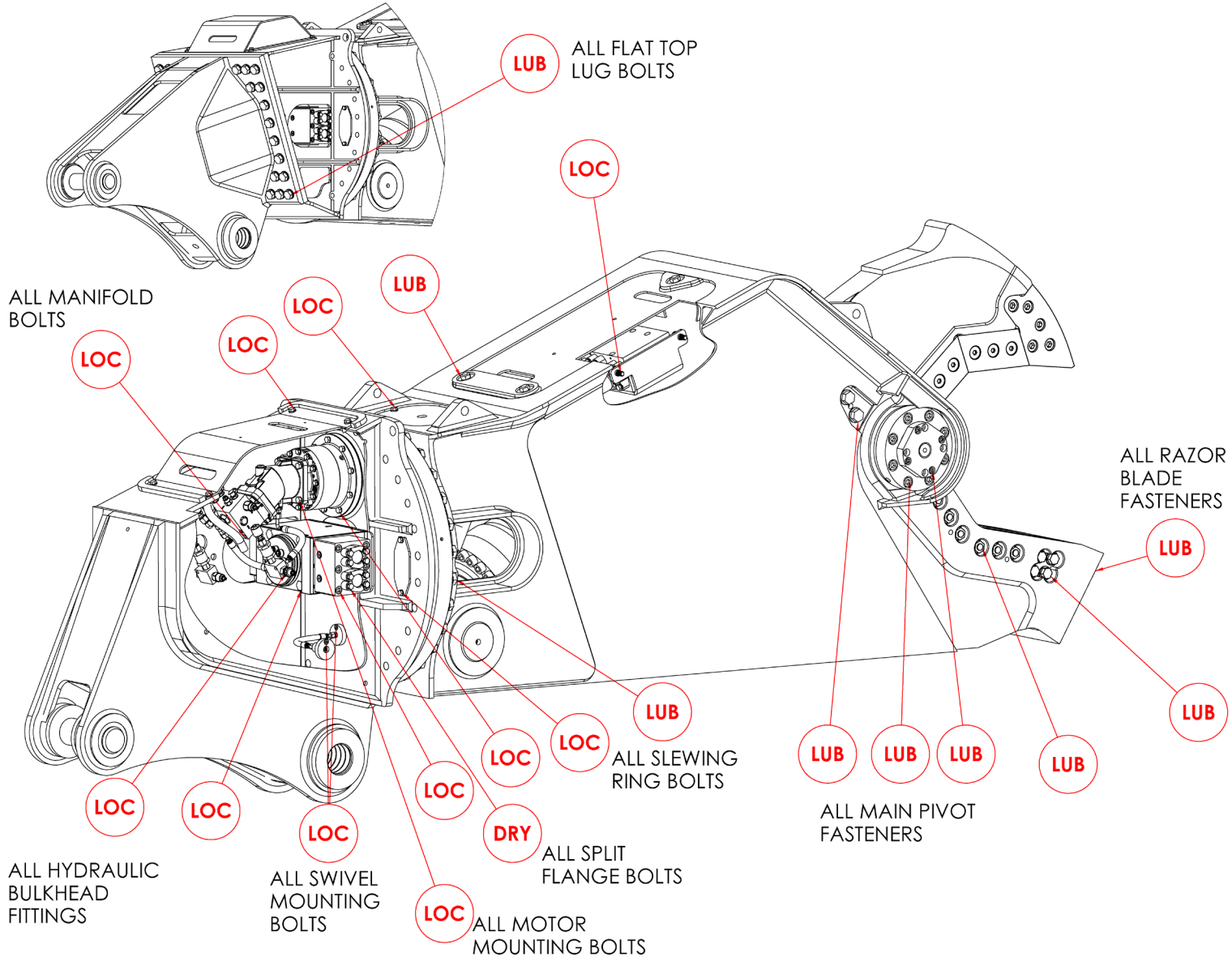


# THREAD TREATMENT DIAGRAM

## Mobile Shears

Use this diagram to determine what thread treatment, if any, is required for each fastener.

For thread treatment application procedures, see page 26. For prescribed torque values, see page 28.



# PROCEDURES

Reference the product Thread Treatment Diagram on page 25 to determine which of the following procedures is required.

## Cleaning

To ensure proper performance of thread treatment and accurate torque values, clean and degrease **all internal and external threads** prior to application of threadlocker, anti-seize or primer and before installation of hardware.

- Ensure both internal and external threads are free of dirt or debris.
- Use brake cleaner or similar cleaning solvent on all threads to remove any grease or oil.
- Allow threads to dry.

## NOTICE

Failure to properly clean threads will cause threadlocker, primer, and/or anti-seize to not properly cure!

LOC

## Threadlocker

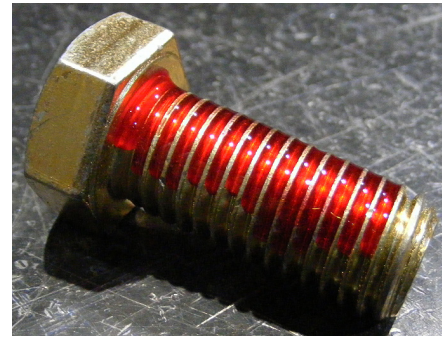
For bolted connections requiring threadlocker, use **Loctite 263** or equivalent applied using the following procedure:

- Clean and degrease all threads.
- For thru holes or nuts, apply threadlocker to bolt threads.
- For blind holes, apply stripe of threadlocker along the length of the hole (applying to the bolt can cause escaping air to remove threadlocker as the bolt is inserted).
- Torque bolt to specified **Wet Torque Value**, see page 28.

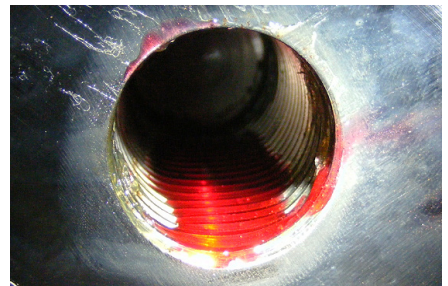
For threaded hydraulic fitting connections, use **Loctite 5452** or equivalent thread sealant in conjunction with **Loctite 7471** primer using the following procedure:

- Clean and degrease all threads.
- Apply Loctite 7471 primer to both external and internal threads and allow to dry.
- Apply threadlocker to 360 degrees of the threads on the male fitting, ensuring adequate coverage.
- Assemble fitting per directions in operator's manual.
- For O-ring boss and flat face O-ring connections, torque fittings to values specified on page 29.

Threadlocker



Blind Hole



Hydraulic Fitting



## PROCEDURES

LUB

### Anti-Seize

For bolted connections requiring anti-seize lubrication, use **Loctite LB8008** or equivalent using the following procedure:

- Clean and degrease all threads.
- Apply thin coat of anti-seize to internal and external threads and under bolt head and/or nut, ensuring complete coverage.
- Torque bolt to specified **Wet Torque Value**, see page 28.

Anti-Seize

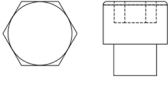



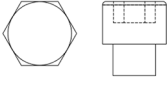

DRY

### No Thread Treatment

- Clean and degrease all threads.
- Torque bolt to specified **Dry Torque Value**, see page 28.

# BOLT TORQUE SPECIFICATIONS

<b>Dry Torque Values</b>					
		Hex/Socket Head		Flat Head	
					
Fastener Grade	Size x Pitch	Nm	Ft-lb	Nm	Ft-lb
CL 10.9	M8 x 1.25	35	26	27	20
	M10 x 1.50	71	53	58	42
	M12 x 1.75	124	92	101	73
	M14 x 1.50	200	148	163	118
	M14 x 2.00	200	148	163	118
	M16 x 2.00	311	230	254	184
	M20 x 1.50	610	450	498	360
	M20 x 2.50	608	449	497	359
	M24 x 3.00	1054	778	861	622
	M27 x 3.00	1543	1138	1260	910
	M30 x 3.50	2095	1545	1712	1236
	M36 x 4.00	3659	2699	2991	2159
8	1/4-20	14	11	11	8
	5/16-18	32	24	26	19
	3/8-16	59	44	48	35
	7/16-14	94	70	77	56
	1/2-13	143	106	116	84
	1/2-20	162	120	133	96
	5/8-11	287	212	234	169
	3/4-10	509	376	415	300
	7/8-9	821	606	670	484
	1.00-8	1232	909	1007	727
	1.00-14	1383	1020	1130	816
	1.25-7	2463	1817	2013	1453
L9	1.50-6	4287	3162	3504	2529

<b>Wet Torque Values</b>					
		Hex/Socket Head		Flat Head	
					
Fastener Grade	Size x Pitch	Nm	Ft-lb	Nm	Ft-lb
CL 10.9	M8 x 1.25	29	22	23	17
	M10 x 1.50	61	45	49	36
	M12 x 1.75	105	78	85	62
	M14 x 1.50	150	111	121	88
	M14 x 2.00	170	126	138	100
	M16 x 2.00	265	196	216	156
	M20 x 1.50	456	337	372	269
	M20 x 2.50	517	382	422	305
	M24 x 3.00	894	660	731	528
	M27 x 3.00	1312	968	1072	774
	M30 x 3.50	1779	1312	1453	1049
	M36 x 4.00	3110	2294	2542	1835
8	1/4-20	13	10	11	8
	5/16-18	27	20	22	16
	3/8-16	50	37	40	29
	7/16-14	80	59	65	47
	1/2-13	122	90	99	72
	1/2-20	138	102	112	81
	5/8-11	244	180	199	144
	3/4-10	433	320	354	256
	7/8-9	698	515	570	412
	1.00-8	1046	772	854	617
	1.00-14	1175	867	960	693
	1.25-7	2095	1545	1712	1236
L9	1.50-6	3644	2688	2979	2150

# O-RING BOSS & FLAT FACE O-RING TORQUE SPECIFICATIONS

O-Ring Boss Torque Values		
Size Dash	Nm	Ft-lb
-4	22	16
-5	27	20
-6	36	26
-8	83	60
-10	110	80
-12	187	135
-14	249	180
-16	304	220
-20	387	280
-24	498	360

Flat Face O-Ring Torque Values		
Size Dash	Nm	Ft-lb
-4	18	13
-6	30	22
-8	60	44
-10	85	62
-12	121	88
-14	121	88
-16	160	116
-20	213	154
-24	274	198

# BOLT DRIVE SPECIFICATIONS

Thread Size x Pitch	Hex Head	Socket Head	Flat Head
			
	Wrench/Drive Size		
M8 x 1.25	13mm	6mm	5mm
M10 x 1.50	17mm	8mm	6mm
M12 x 1.75	19mm	10mm	8mm
M14 x 1.50	22mm	12mm	10mm
M14 x 2.00	22mm	12mm	10mm
M16 x 2.00	24mm	14mm	10mm
M20 x 1.50	30mm	17mm	12mm
M20 x 2.50	30mm	17mm	12mm
M24 x 3.00	36mm	19mm	14mm
M27 x 3.00	41mm	19mm	-
M30 x 3.50	46mm	22mm	-
M36 x 4.00	55mm	27mm	-
1/4-20	7/16"	3/16"	5/32"
5/16-18	1/2"	1/4"	3/16"
3/8-16	9/16"	5/16"	7/32"
7/16-14	5/8"	3/8"	1/4"
1/2-13	3/4"	3/8"	5/16"
1/2-20	3/4"	3/8"	5/16"
5/8-11	15/16"	1/2"	3/8"
3/4-10	1-1/8"	5/8"	1/2"
7/8-9	1-5/16"	3/4"	9/16"
1.00-8	1-1/2"	3/4"	5/8"
1.00-14	1-1/2"	3/4"	5/8"
1.25-7	1-7/8"	7/8"	7/8"
1.50-6	2-1/4"	1"	1"

# WARRANTY

## **Claim Procedure**

Notify the Genesis Service Department of the potential warranty claim prior to making the repair. Digital pictures are very helpful for diagnosing problems and recommending repairs.

Contact the Genesis Service Department before making alterations, changes or repairs to any component that is going to be considered for warranty. Not doing so will void all Genesis warranty consideration.

The Genesis Service Department will issue an authorization number to track the repair costs, outgoing parts, and/or defective parts returning to the factory.

Replacement parts must be ordered using a purchase order number. Shipping is standard ground. Overnight shipping is available by request, and Genesis will not cover the shipping charge.

When the repair is complete, submit an invoice to the Genesis Service Department within 30 days. Include itemized internal labor reporting, parts lists and invoices for outside contractors. Reference the authorization number on all invoices.

When returning parts for warranty consideration, include a copy of any related Genesis paperwork along with any other necessary documentation to ensure proper processing and credit. The Genesis Service Department will provide the necessary forms.

Your account will be credited when the warranty claim is accepted.

## **Blade Warranty**

Standard warranty on blades will only be considered on the first edge, and wear on the edge must be 1/8" radius or less. Genesis does not warranty cutting blades that are cracked or broken from top to bottom (perpendicular to the long edge of the blade). Genesis also does not cover fasteners, the labor to replace wear components or collateral damage, such as blade seats, from broken blades, the piercing blade tang or adjustment plates.

**Please direct any questions to the Genesis Service Department: 715-395-5252**

# PARTS ORDER POLICY AND PROCEDURE

## **Parts Orders Should Include**

- Purchase order number
- Model and serial number of attachment
- Part number and quantity needed
- Shipping and billing address
- Method of shipment or required delivery date

## **Placing Orders**

Orders may be placed by phone or e-mail. To e-mail an order, use the form on the following page or your purchase order form. Contact information is located at the front of this manual.

## **Part Numbers**

Part numbers are listed in a separate Parts Manual or, if included, the Parts section of this manual. Contact the Genesis Parts Department with questions regarding part numbers, availability and pricing.

## **Shipping**

All orders will be shipped best way surface unless an alternate shipping method is requested. Shipping charges are not included in the purchase price of parts.

## **Invoices**

All invoices are due upon receipt. Any accounts with invoices open beyond 60 days are subject to review and may be placed on C.O.D. status without further notice.

## **Returns**

Many unused Genesis parts may be returned with proper documentation. Return shipping is the responsibility of the purchaser. Credit will be issued upon return, less a 25% restocking fee. Documentation is required for credit of returned parts. Contact the Genesis Service Department at 715-395-5252 for an RGA (Return Goods Authorization) number and form. An RGA must accompany every return. Items shipped without an RGA may be returned to sender.

## **Warranty Returns**

All parts returned to Genesis for warranty consideration must be returned with a completed RGA (Return Goods Authorization) provided by the Genesis Service Department. The form needs to be completed in its entirety, including any additional information requested by the Service Department. Return shipping is the responsibility of the sender and will be credited upon claim approval. A determination to accept or deny the claim will be made based upon the information available to Genesis. Warranty on purchased parts other than wear components is 6 months. Genesis does not cover labor costs to replace purchased parts replaced under warranty. There is no warranty period on wear parts or components.





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