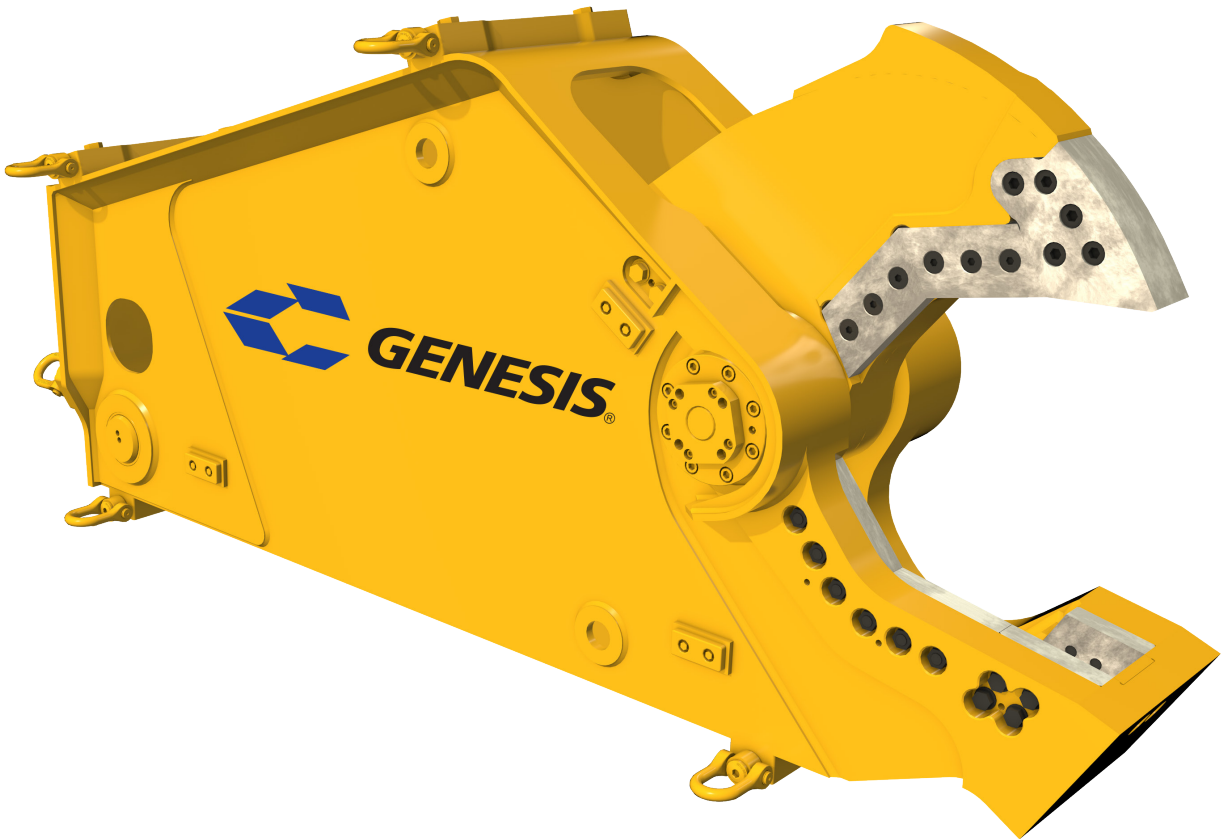




GSS 665 Subsea Shear

PARTS MANUAL



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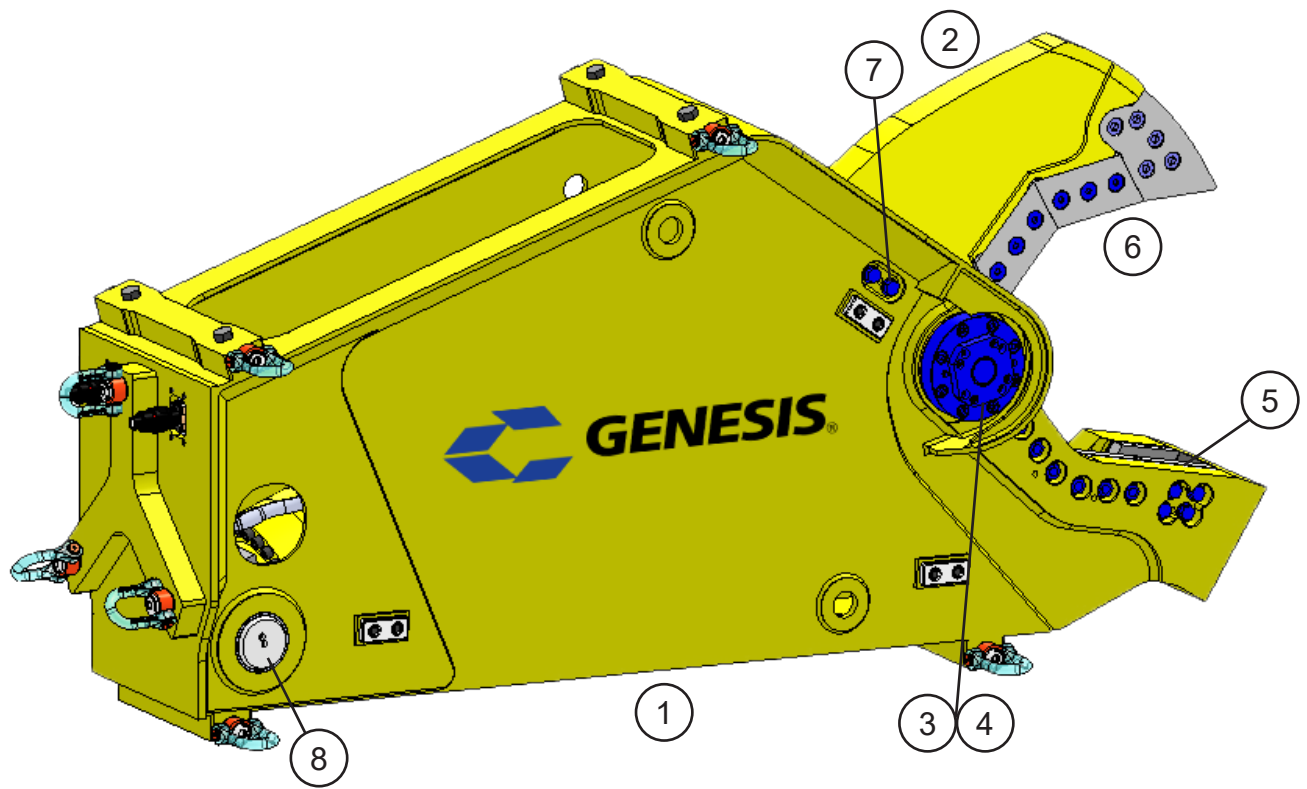
E-mail:
contact@themsagroup.com

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TABLE OF CONTENTS

CONTACT INFORMATION	2
GENERAL ARRANGEMENT	4
ASSEMBLY PIVOT GROUP - RIGHT SIDE	6
ASSEMBLY PIVOT GROUP - LEFT SIDE	8
ASSEMBLY LOWER BLADES	10
ASSEMBLY UPPER BLADES	12
ASSEMBLY AUTO GUIDE	14
ASSEMBLY CYLINDER PINS	16
ASSEMBLY BRACKET	18
ASSEMBLY CYLINDER - 6350182	20
ASSEMBLY HYDRAULICS	22
BOLT TORQUE SPECIFICATIONS	24
THREAD TREATMENT DIAGRAM	25
Mobile Shears.....	25
PROCEDURES	26
Cleaning.....	26
Threadlocker.....	26
Anti-Seize.....	27
No Thread Treatment.....	27
BOLT TORQUE SPECIFICATIONS	28
Dry Torque Values.....	28
Wet Torque Values.....	28
O-RING BOSS & FLAT FACE O-RING TORQUE SPECIFICATIONS	29
BOLT DRIVE SPECIFICATIONS	30
WARRANTY	31
Claim Procedure.....	31
Blade Warranty.....	31
PARTS ORDER POLICY AND PROCEDURE	32
Parts Orders Should Include.....	32
Placing Orders.....	32
Part Numbers.....	32
Shipping.....	32
Invoices.....	32
Returns.....	32
Warranty Returns.....	32
PARTS ORDER FORM	33
INDEX	34
CONTACT INFORMATION	35

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.

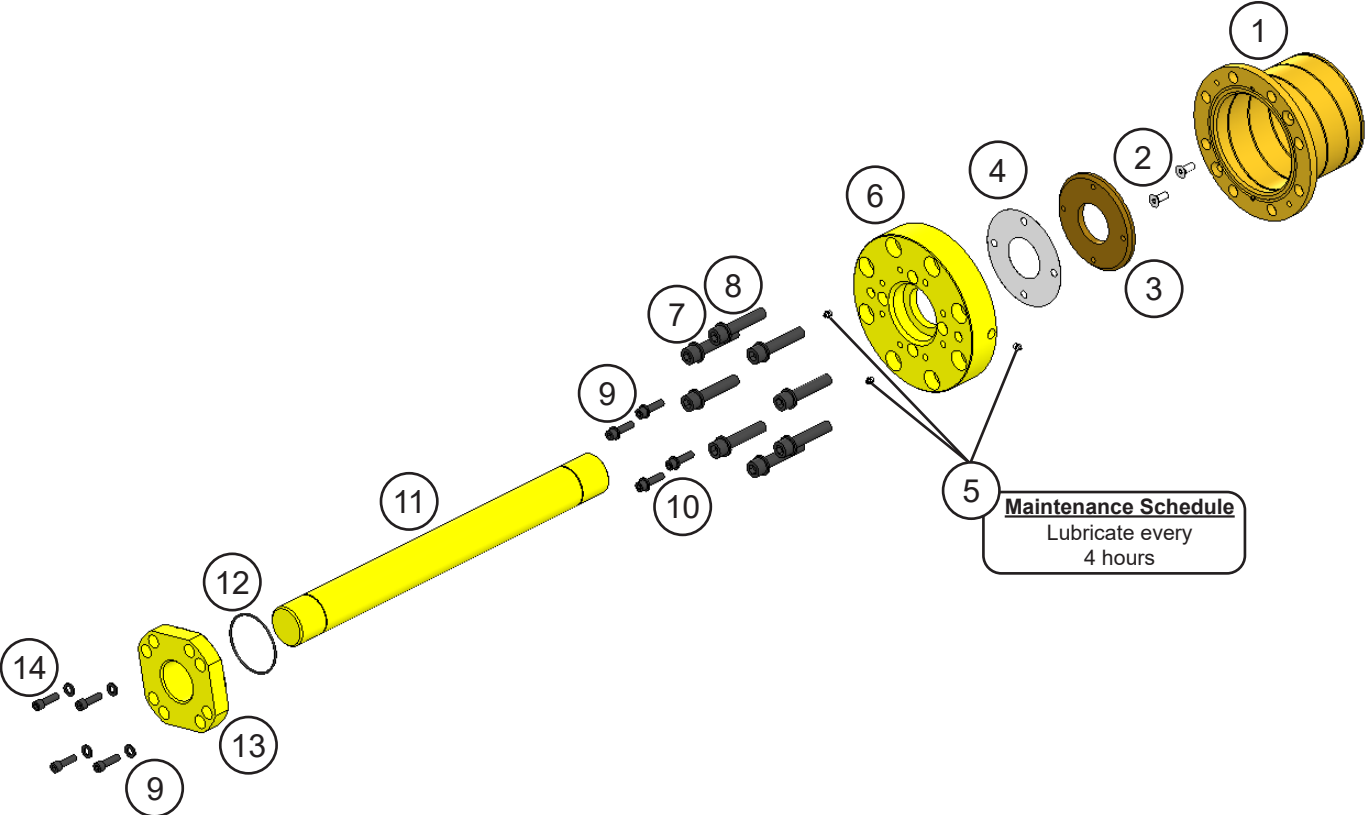
USA

715-395-3488

Europe

+49 83 31 9 25 98 0

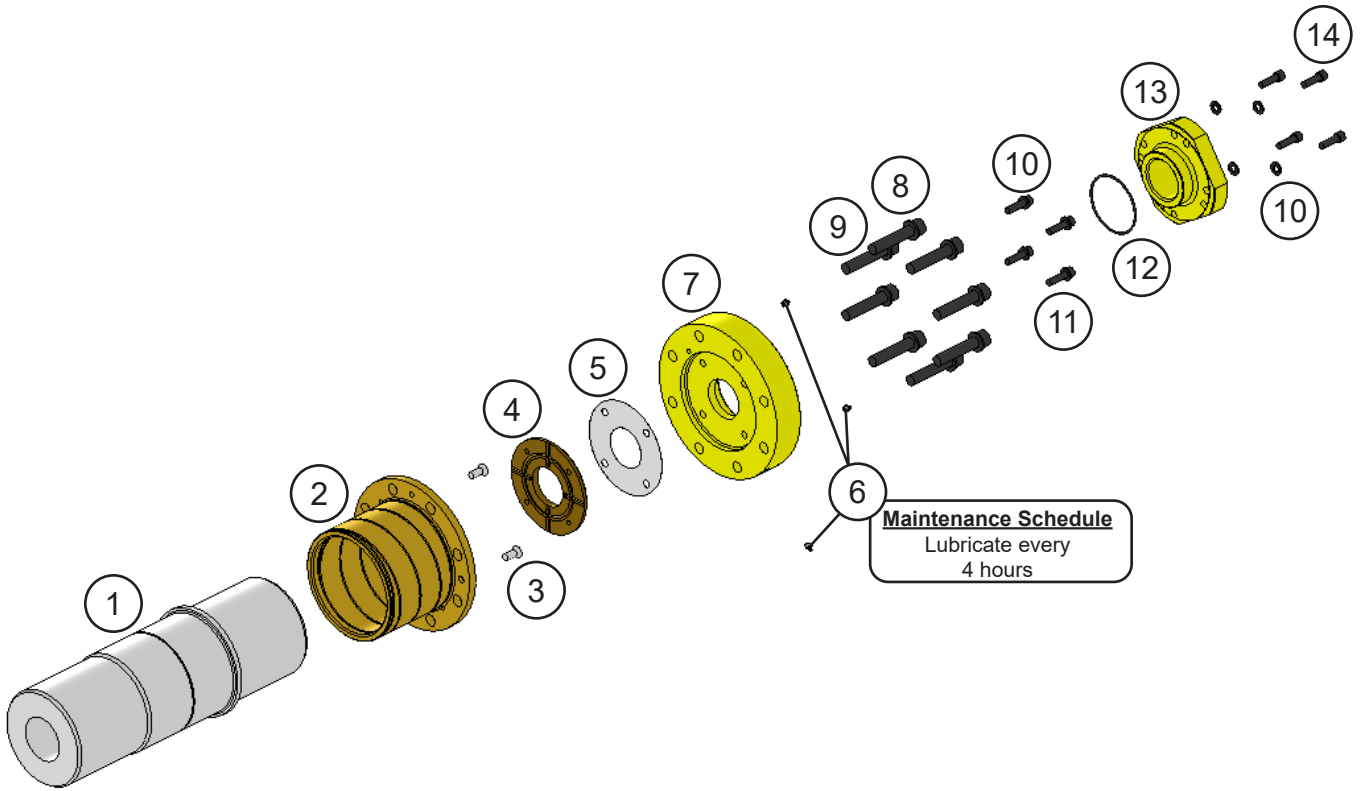
ASSEMBLY PIVOT GROUP - RIGHT SIDE



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.

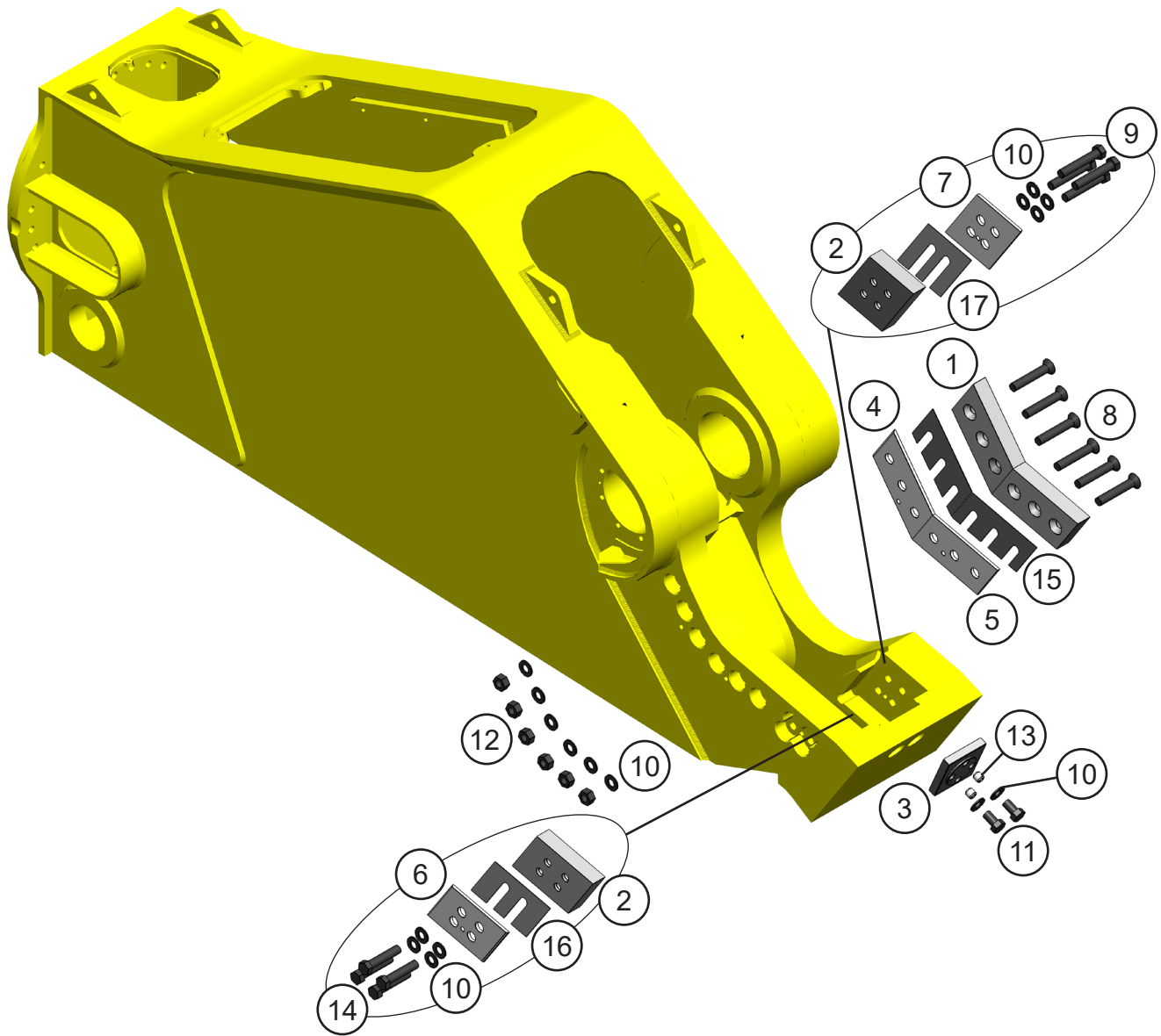
USA

715-395-3488

Europe

+49 83 31 9 25 98 0

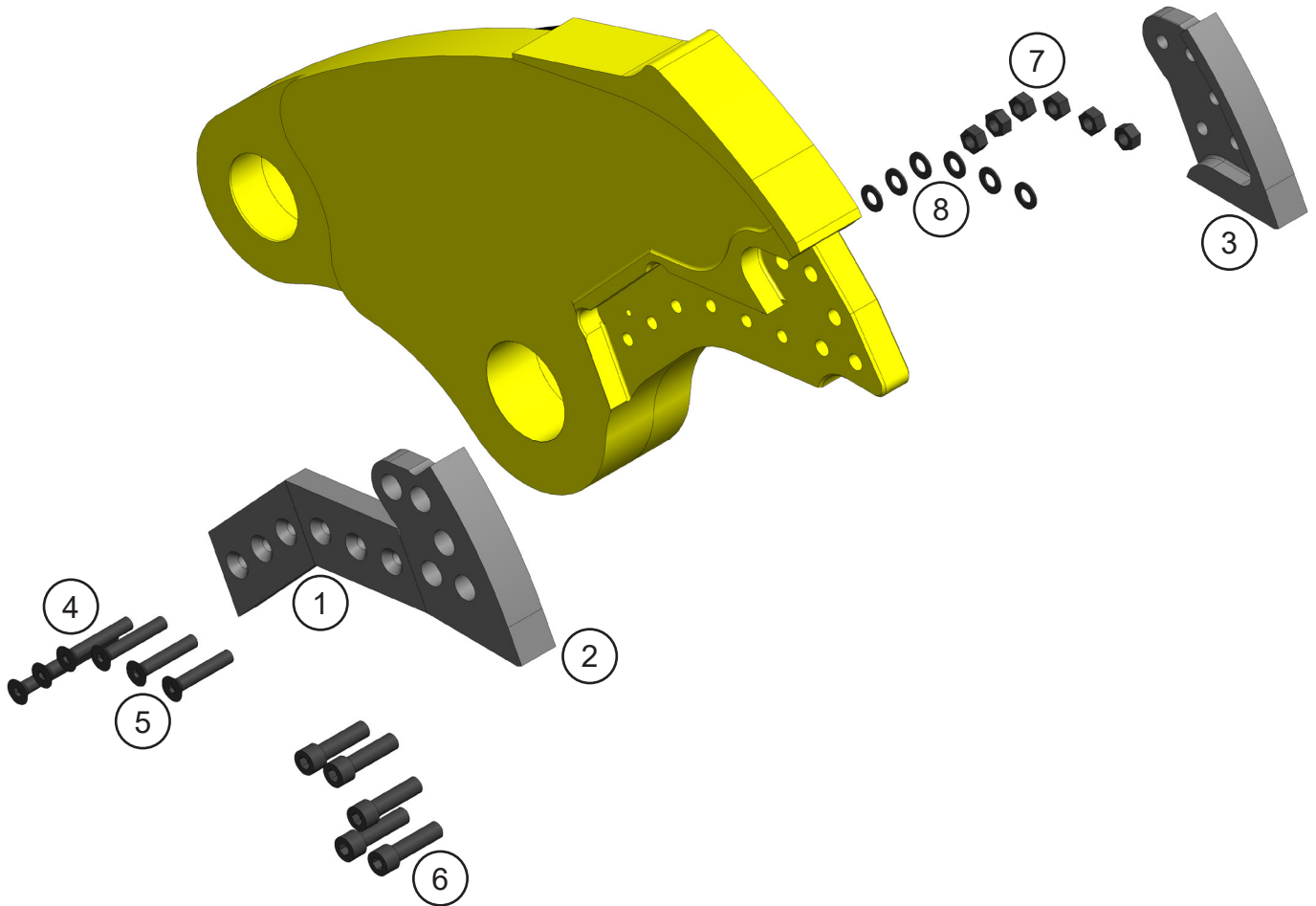
ASSEMBLY LOWER BLADES



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

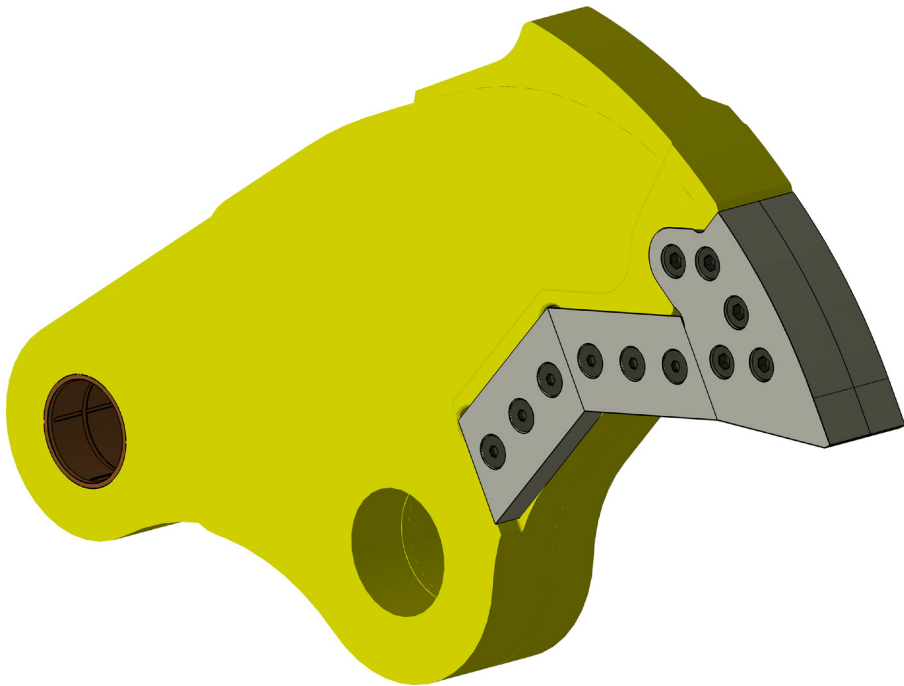
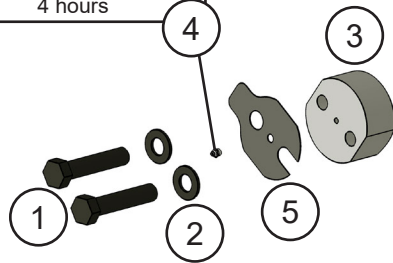


ASSEMBLY UPPER BLADES

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

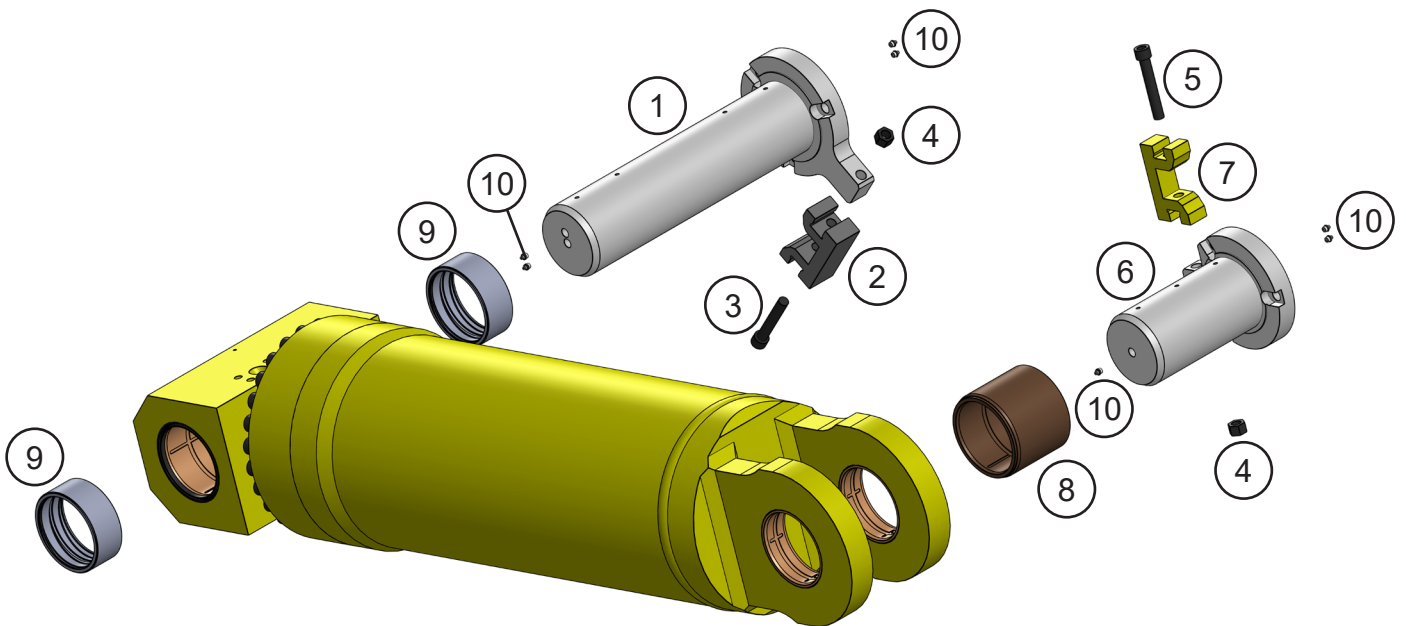
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	FE0210500	Hex Head Capscrew 1 - 8 x 5
2	2	FE1300100	Flat Washer Narrow 1"
3	1	*	Mach Auto Guide
4	1	6200002	Grease Fitting
5		1106478	Shim Set, Auto Guide

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

USA
715-395-3488

Europe
+49 83 31 9 25 98 0

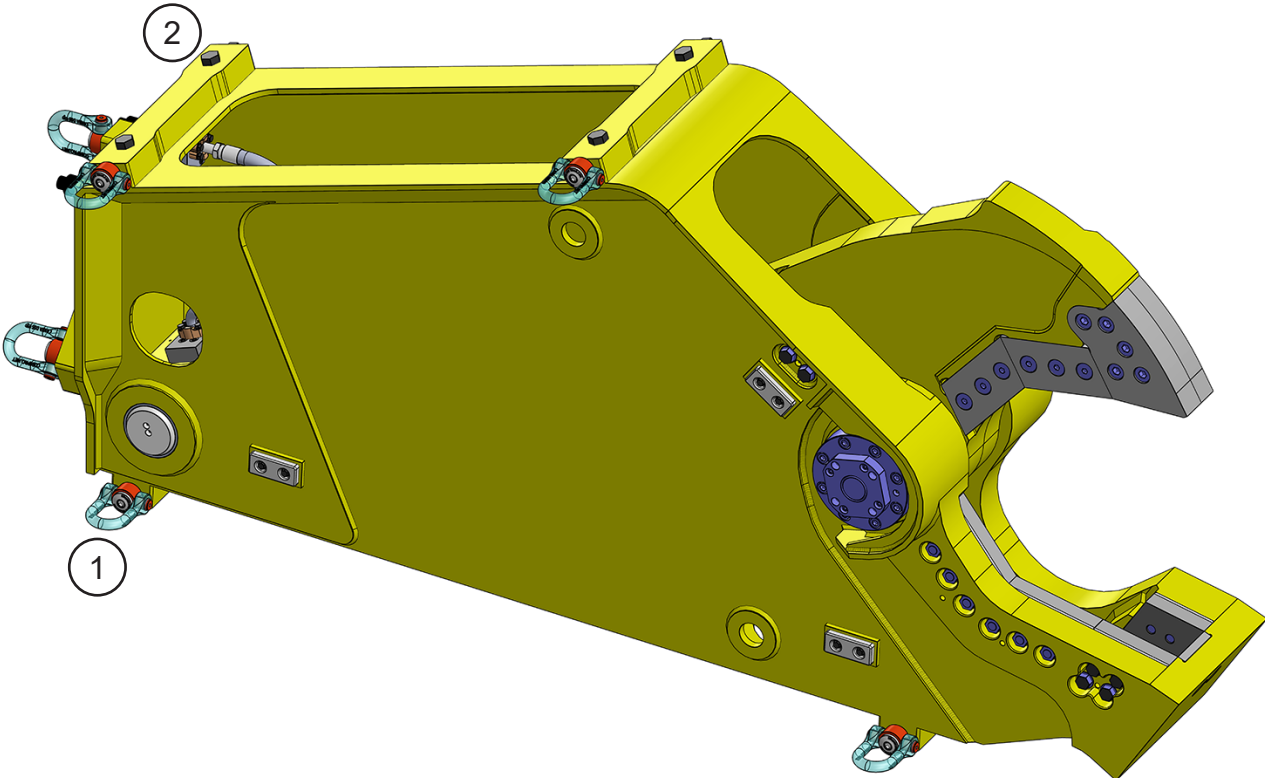
ASSEMBLY CYLINDER PINS



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

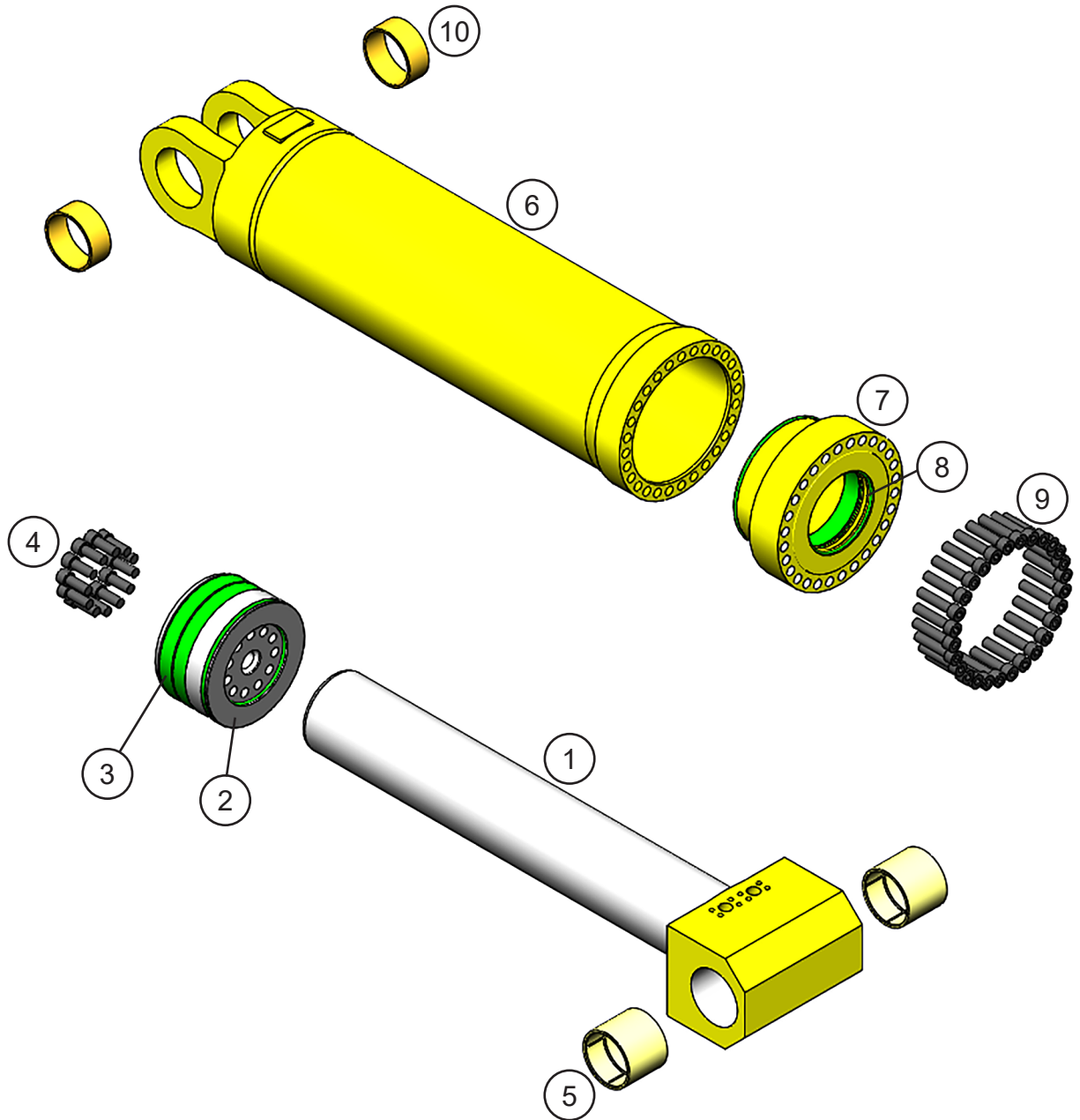
ASSEMBLY BRACKET



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

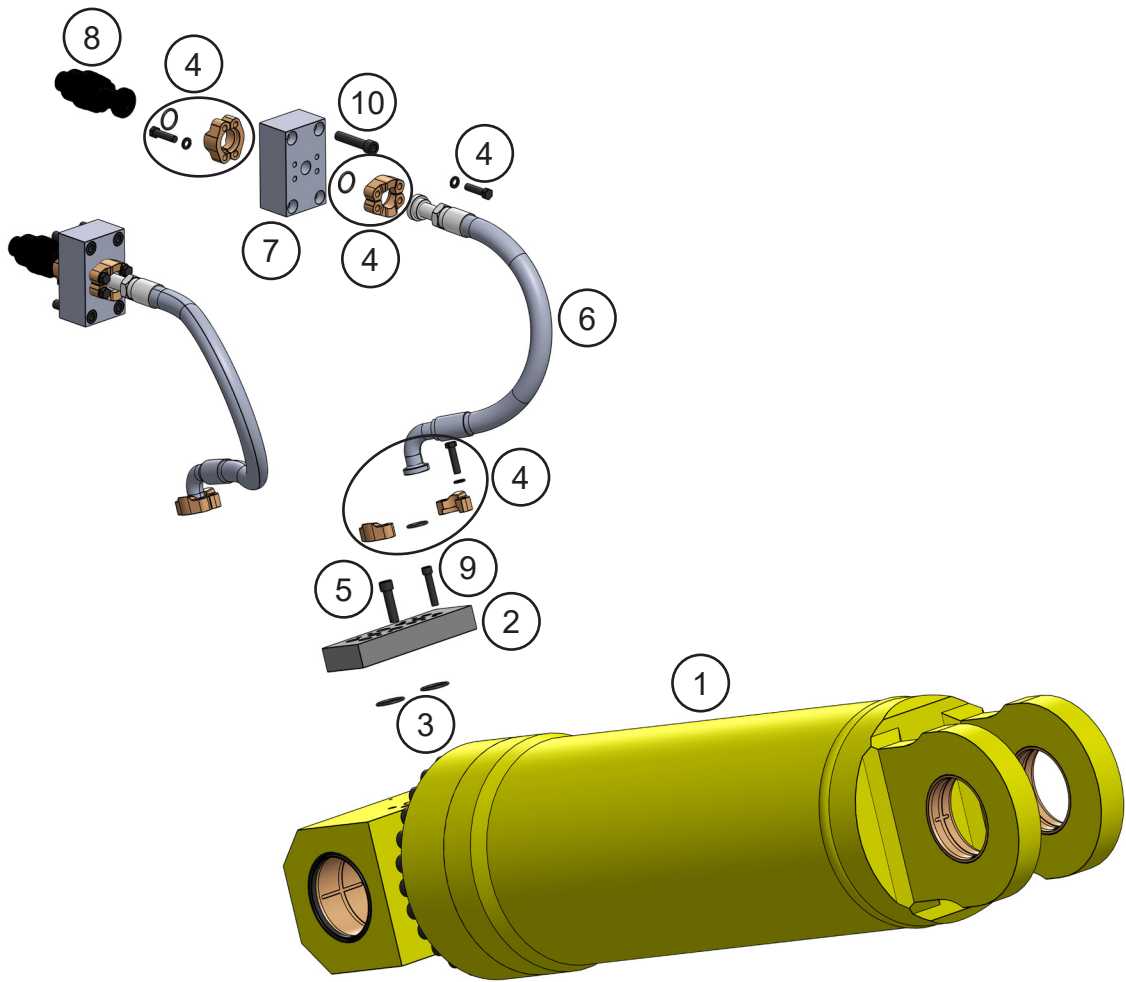
ASSEMBLY CYLINDER - 6350182



ASSEMBLY CYLINDER - 6350182

ITEM	QTY	PART NUMBER	DESCRIPTION
		6350182	Assembly Cylinder - Complete
1	1	For replacement parts call the Genesis parts department. USA 715-395-3488 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	1" Split Flange Kit	
	2	H0262100	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
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.

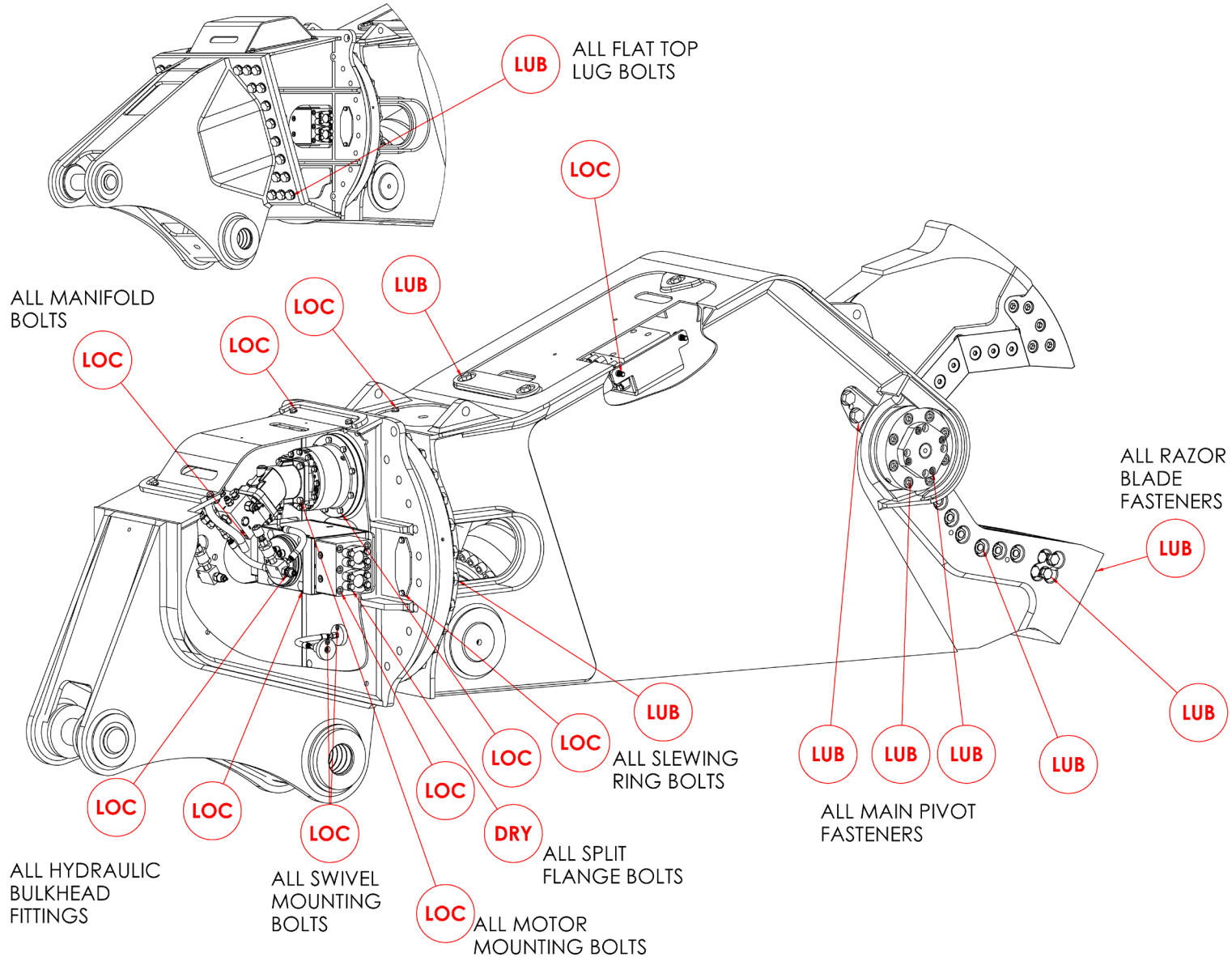
Never use an impact driver on a torque multiplier.

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

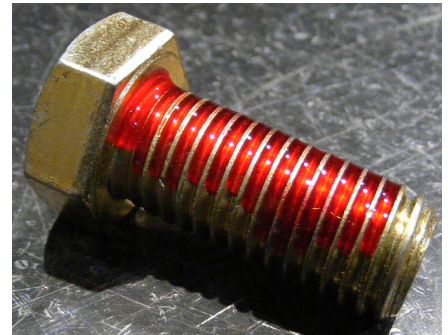
For bolted connections requiring threadlocker, use **Loctite 263** or equivalent applied using the following procedure:

- 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.

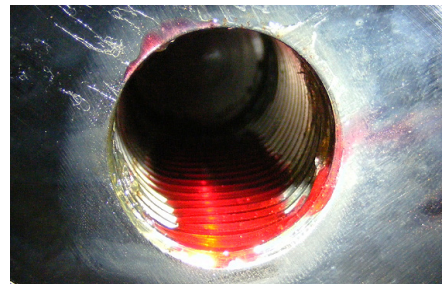
For threaded hydraulic fitting connections, use **Loctite 5452** or equivalent thread sealant in conjunction with **Loctite 7471** primer using the following procedure:

- 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

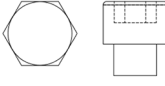



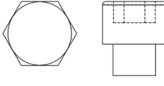

DRY

No Thread Treatment

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

BOLT TORQUE SPECIFICATIONS

Dry Torque Values					
		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
8/L9	1.50-6	4287	3162	3504	2529

Wet Torque Values					
		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
8/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.

Customer: _____ Date: _____

Phone: _____ Contact: _____

Shipping Address: _____ E-mail: _____

_____ Billing Address: _____

Purchase Order: _____ Shipping Method: _____

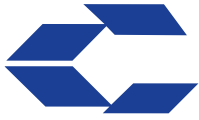
Model: _____ Serial Number: _____

Quantity	Part Number	Description	Price

E-mail to the Genesis Parts Department: genesisparts@genesisattachments.com
For assistance, call 715-395-5252

INDEX

- 1" Split Flange Kit 23
- 1101957 Mach Blade Razor 11
- 1102442 Mach Thrust Washer 7, 9
- 1102448 Shim Set Thrust Washer 7, 9
- 1102487 Mach Pin Keeper (Clevis) 17
- 1105721 Mach Blade 11, 13
- 1105722 Mach Blade Guide 11
- 1105723 Blade Shim Set 11
- 1105724 Guide Blade Shim Set 11
- 1105725 Guide Blade Shim Set 11
- 1105821 Mach Adjustment Plate Secondary 11
- 1105840 Mach Blade Tip RH 13
- 1105841 Mach Blade Tip LH 13
- 1105863 Mach Adjustment Plate Primary 11
- 1105865 Mach Guide Blade Adjustment Plate 11
- 1105867 Mach Guide Blade Adjustment Plate 11
- 1106478 Shim Set, Auto Guide 15
- 1107782 Mach Adapter Block 23
- 1109185 Mach Cylinder Manifold 23
- 1109273 Hose 23
- 1109281 Mach Bearing Rear Stick 17
- 1109285 Mach Pin Rear 17
- 1109290 Mach Pin Keeper Rear 17
- 1109295 Mach Bearing 7, 9
- 1109296 Mach Tie Rod 7
- 1109297 Mach End Cap 7, 9
- 1109298 Wldt Front Cylinder Pin 17
- 1109306 Mach Tie Rod Nut 7, 9
- 1109334 Mach Bolt Socket Head Capscrew 1¼ - 7 x 4½
Custom 13
- 3100061 Mach Bearing Upper Cylinder Connection 17
- 6200002 Grease Fitting 7, 9, 15, 17
- 6200092 Shackle Double Swing 19
- 6301209 Male Quick Connect 23
- 6350182 Assembly Cylinder - Complete 21
- 6350182 Assy Cyl. B14.0 R9.0 S32.75 23
- Assembly Auto Guide 5, 14, 15
- Assembly Bracket 18, 19
- Assembly Cylinder - 6350182 20, 21
- Assembly Cylinder Pins 5, 16, 17
- Assembly Hydraulics 22, 23
- Assembly Lower Blades 5, 10, 11
- Assembly Pivot Group - Left Hand Side 5
- Assembly Pivot Group - Left Side 8, 9
- Assembly Pivot Group - Right Hand Side 5
- Assembly Pivot Group - Right Side 6, 7
- Assembly Upper Blades 5, 12, 13
- Bolt Drive Specifications 30
- Bolt Torque Specifications 24, 28
- Butt and Tube Assembly 21
- Clevice Bearing 21
- Contact Information 2, 35
- F0112050 Socket Head Capscrew M20 x 2.5 x 70 23
- F0213200 Hex Head Capscrew 1.25 - 7.00 - 2.00
GR8 19
- F0412030 Flat Head Capscrew M12 x 1.75 x 30 7, 9
- F0612040 Socket Head Capscrew M12 x 1.75 x 40 7
- F0612060 Socket Head Capscrew M12 x 1.75 x 60 23
- F0616060 Socket Head Capscrew M16 x 2.0 x 60 23
- F0616080 Socket Head Capscrew M16 x 2.00 x 80 23
- F0620130 Socket Head Capscrew M20 x 2.50 x 130 17
- F0620130 Socket Head Capscrew M20 x 2.50 x 200 17
- F1020250 Nylock Hex Nut M20 x 2.50 17
- F1401200 Lock Washer M20 23
- F2510100 Set Screw Socket Head 1 - 8 x 1 11
- FE0210175 Hex Head Capscrew 1 - 8 x 1¾ 11
- FE0210500 Hex Head Capscrew 1 - 8 x 5 11, 15
- FE0210600 Hex Head Capscrew 1 - 8 x 6 11
- FE0510550 Flat Head Capscrew 1 - 8 x 5½ 13
- FE0510600 Flat Head Capscrew 1 - 8 x 6 11
- FE0510700 Flat Head Capscrew 1 - 8 x 7 13
- FE0612040 Socket Head Capscrew M12 x 1.75 x 40 7,
9
- FE0612045 Socket Head Capscrew M12 x 1.75 x 45 7,
9
- FE0620100 Socket Head Capscrew M20 x 2.50 x
100 7, 9
- FE0910008 Hex Nut 1 - 8 11, 13
- FE1201224 Flat Washer M12 7, 9
- FE1202037 Flat Washer M20 7, 9
- FE1300100 Flat Washer Narrow 1" 11, 13, 15
- General Arrangement 4, 5
- Gland 21
- Gland Seals 21
- H0262100 Split Flange Half 1.00 Code 62 23
- Mach Main Shaft 9
- Mach Stick 5
- O-Ring Boss & Flat Face O-Ring Torque Specifica-
tions 29
- Parts Order Form 33
- Parts Order Policy and Procedure 32
- Piston 21
- Piston Seals 21
- Procedures 26, 27
- Rod 21
- Rod Bearing 21
- S0190219 O-Ring 23
- S0190225 O-Ring 23
- S0190244 O-Ring 7, 9
- Socket Head Capscrew 21
- Table of Contents 3
- Thread Treatment Diagram 25
- Warranty 31
- Wldt Upper 5



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