

INSTRUCTIONS FOR INSTALLATION & COMMISSIONING OF MKTOOL HIGHLY WEAR RESTISTANT TAMPING TINES

The following instructions must be followed at all times when fitting or refitting on Plasser tamping machines fitted with tapered tamping tine holders :

A) Ensure thread of headbolt is OK

B) Ensure headbolt is new (part of supply with tool) and side bolt or sidekey are in good condition and clean

C) Ensure keyways of the tool are OK and not damaged

D) Ensure taper on top of tool is clean and not damaged

E) Ensure the tine holder of the machine is clear, clean and not damaged
If in doubt, check condition of the tool holder in the following way:
- Clean tine holder
- Take new MKTool and paint tapered section thinly with spray paint
- Let paint dry for 15 minutes
- Insert tine into tine holder and tighten it as usual
- Dismantle tine after 5 minutes
- Check tool taper, paint should be visibly touched by 70-80% as this shows the real bearing surface of the tool taper inside the tine holder

If the contact surface is less than 70%, clean the tool holder by a suitable reamer (MK800/Mors 6) or replace tine holder



MK800

CAUTION:
Incase of a poor contact surface between holder and tool, the tool will inevitably break in tapered section or below the tapered section below the ring. This results in a complete loss of the tine !

F) Insert the tool into the tool holder. Do not use any grease or other lubricant !

CAUTION :
The use of a lubricant will prevent a tight fitting of the tool and the tool may break or may get loose and lost !

G) Fit cap and spring washer and insert headbolt and tighten it slightly

H) In case of sidebolts, fit sidebolts before the tool is completely tight in the tool holder, without pulling them tight

I) Tighten headbolt to maximum

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K) Drop tamping banks into full bed of ballast with vibration motors running and press squeeze pedal four times

L) Untighten sidebolts slightly and tighten headbolts to maximum

M) Tighten sidebolts to maximum

N) Repeat this process six times before commissioning the machine to regular work

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certified Quality management system AGQS DIN EN ISO 9001:2008
AGQS OHSAS 18001:2007
certified Environmental management system AGQS DIN EN ISO 14001:2009

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O) Check tightness of headbolts and sidebolts every day for the next ten working shifts and enter this into machine log book

P) Note the recording of the insertion counter when fitting new tines

Q) When tamping, try to avoid hitting sleepers, rails, railclamps etc. This may cause side and bottom chipping of the tool.

CAUTION :

Tungsten carbide as used to hardface TCTT belongs to the hardest metals in the world. When hitting rail foots, rails, clamps, sleepers or other hard objects in the ballast, this will result in chipping. While you cannot avoid hitting objects hidden in the ballast, you can avoid damage by accurately positioning tamping banks towards the sleepers and, in curves, to shift banks in order to avoid rail hitting.Instruct the crew to watch out for rail clamps or other obstacles. Make sure to set penetration depth correctly. Be aware of rocks in low ballast beds, particularly in tunnels.

R) Do not tap tamping tool spade at any place with steel hammer. Use brass hammer, if necessary.

CAUTION :

Tapping with steel hammer creates chipping and damages the tool. It is only allowed to use a steel hammer when dismantling a worn tool not supposed to be reused.

!WARNING ! :

WHEN TAPPING THE TOOL SPADE WITH STEEL HAMMER OR SIMILAR, TUNGSTEN CARBIDE MAY CHIP OFF AND HURT YOU.
PROTECT YOUR EYES BY GOGGLES WHEN DISMANTLING TINES.
SEE A DOCTOR SHOULD TUNGSTEN CARBIDE CHIPS HAVE ENTERED INTO YOUR SKIN OR EYES.

S) For removal of tine, use steel wedge and cap as supplied with the machine. Alternatively use hydraulic extractor.

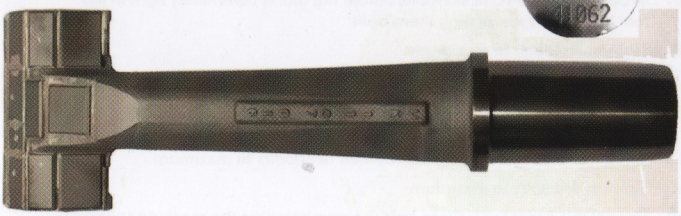
T) Keep new tools in the original packing (corregated box) with the protection strap on the tapered section. The corregated box carries the type designation as well as the quantity packed in the box. It protects the tool from damage. Keep new tools dry and prevent corrosion. Do not throw tools.

CAUTION :

Any damage like deep scratches, grooves etc as well as corrosion on the tapered section of the tine will result in fatique cracks which may cause tool breakage !

U) If there are any irregularities with the tools, report the serial number and the position of the tool in the tamping bank as well as the number of insertions of the specific tool and describe irregularity or damage and transmit a photo of the damaged tool. The serial number as well as the manufacturing date and type designation are engraved at the headside of the tine around the headbolt thread.

Thanks for reading those advices
Best Regards from all our team !



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