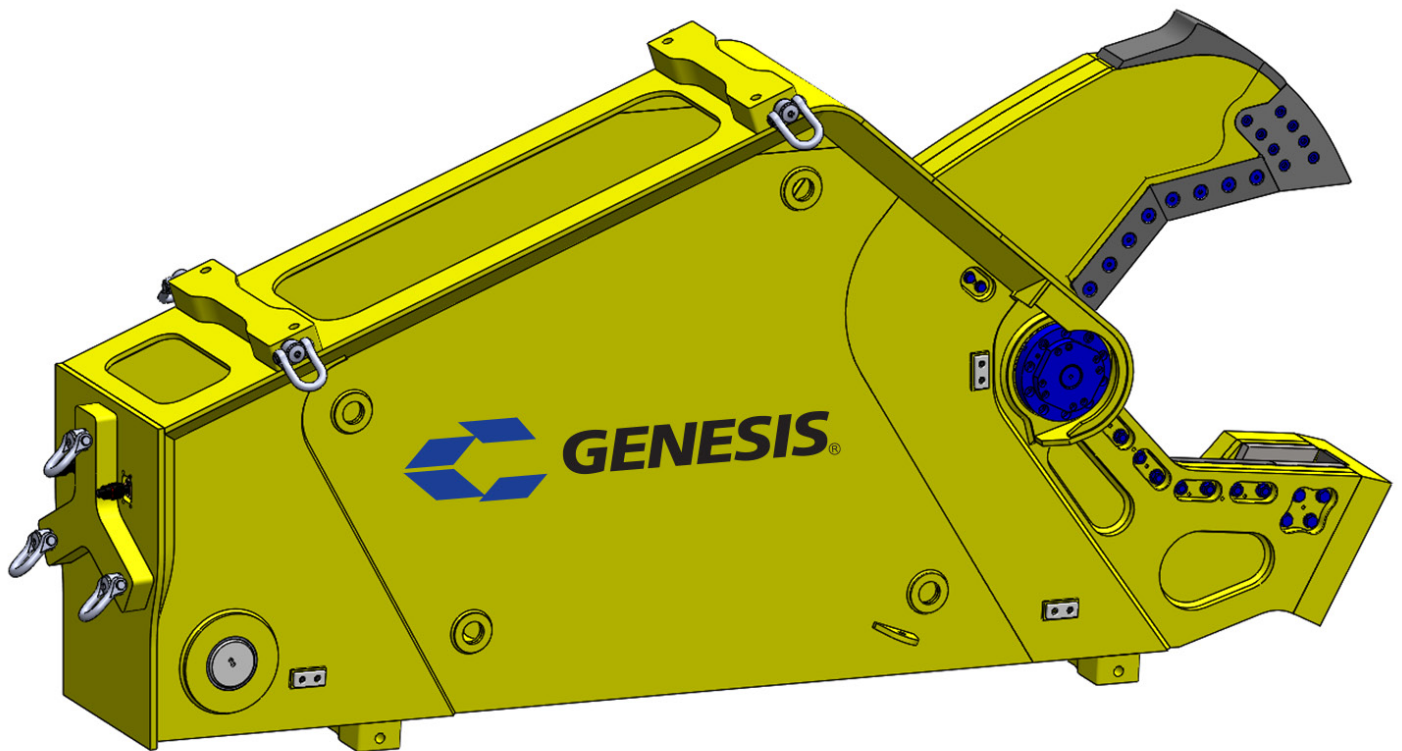


GSS 2555 Subsea Shear

PARTS MANUAL



CONTACT INFORMATION

Genesis Attachments

1000 Genesis Drive
Superior, WI 54880 USA

Toll Free: 888-SHEAR-IT
(888-743-2748)

Phone: 715.395.5252

E-mail:
info@genesisattachments.com

Europe/Africa/Middle East Genesis GmbH

Teramostrasse 23
87700 Memmingen, Germany

Phone: +49 83 31 9 25 98 0
Fax: +49 83 31 9 25 98 80
genesis-europe.com

E-mail:
info@genesis-europe.com

Asia Pacific Representative Office

24 Upper Serangoon View #12-28
Singapore 534205

Phone: +65 9673 9730

E-mail:
tchoo@genesisattachments.com

Central America & Colombia

Cra 13A #89-38 / Ofi 613
Bogota, Colombia

Phone: +57 1 610 8160 / 795 8747

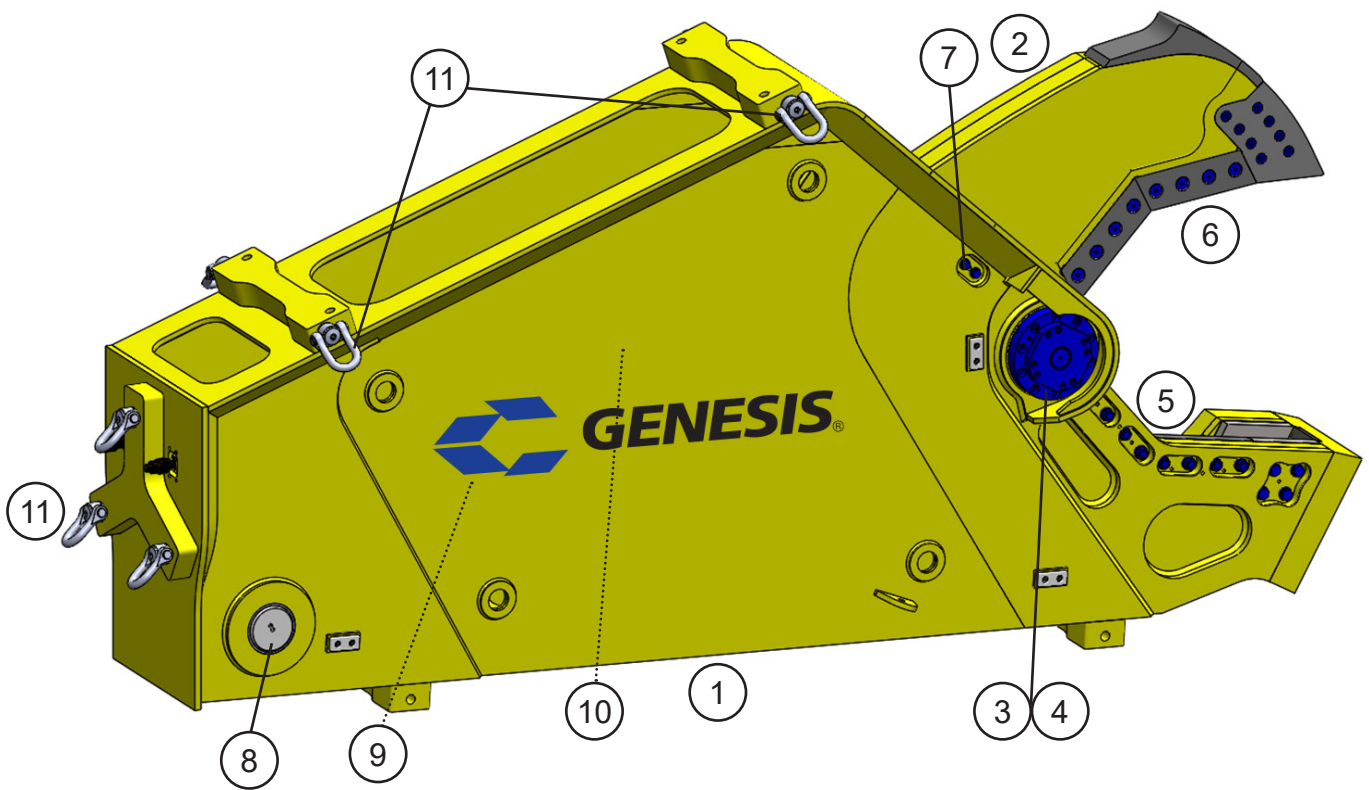
E-mail:
contact@themsagroup.com

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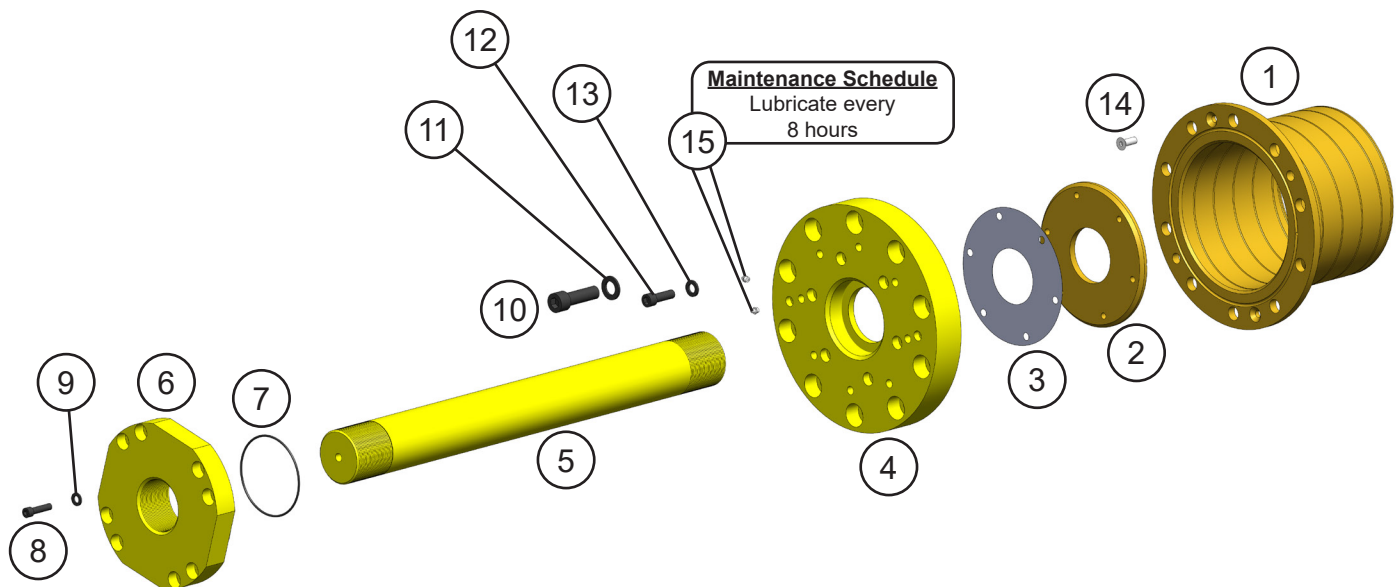
GENERAL ARRANGEMENT



GENERAL ARRANGEMENT

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1108319	Wtmg Stick
2	1	1107632	Wtmg Upper
3	1	See page 6	Assembly Pivot Group - Right Hand Side
4	1	See page 8	Assembly Pivot Group - Left Hand Side
5	--	See page 10	Assembly Lower Blades
6	--	See page 14	Assembly Upper Blades
7	--	See page 18	Assembly Auto Guide
8	--	See page 20	Assembly Cylinder Pins
9	--	See page 22	Assembly Cylinder
10	--	See page 24	Assembly Hydraulics
11	4	6200077	Shackle Double Swing

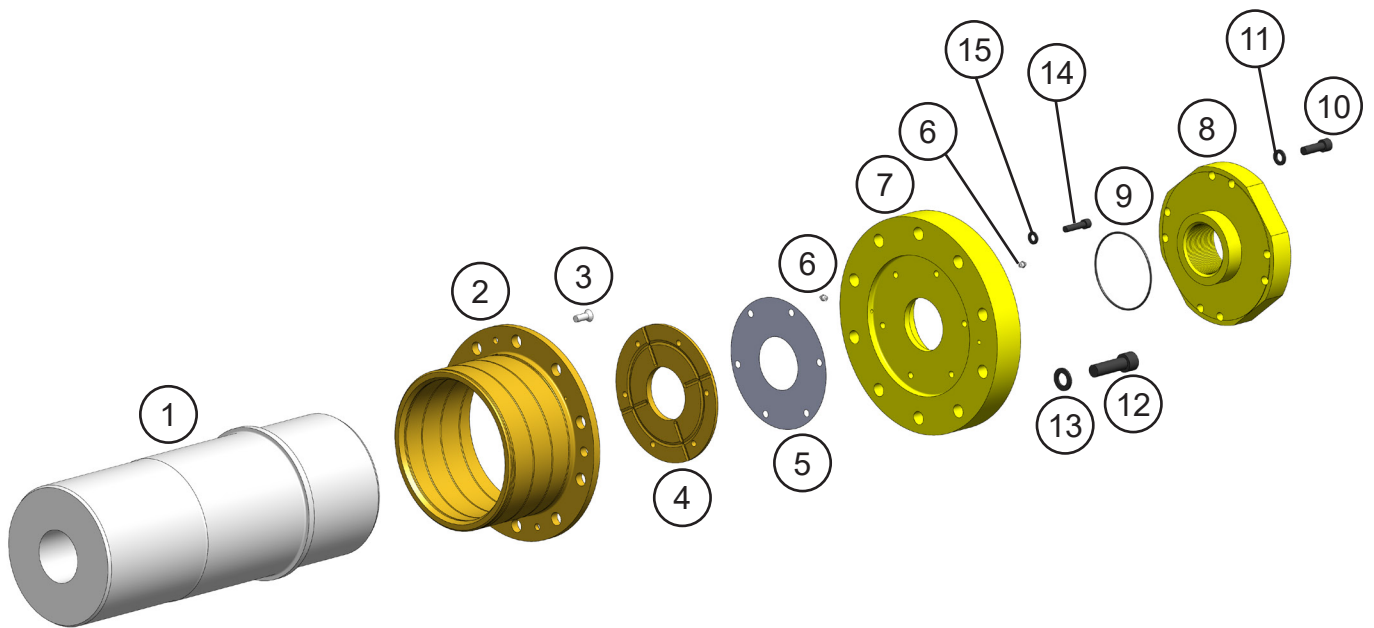
ASSEMBLY PIVOT GROUP - RIGHT HAND SIDE



ASSEMBLY PIVOT GROUP - RIGHT HAND SIDE

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1108329	Mach Bearing RH
2	1	1104048	Mach Thrust Washer
3	1	1104049	Shim Set Thrust Washer
4	1	1108301	Mach End Cap
5	1	1108299	Mach Tie Rod
6	1	1108300	Mach Tie Rod Nut
7	1	S0190357	O-Ring
8	4	FE0616050	Socket Head Capscrew M16 x 2.00 x 50 with EcoGuard
9	4	FE1201630	Flat Washer M16 with EcoGuard
10	10	FE0624080	Socket Head Capscrew M24 x 3.00 x 80 with EcoGuard
11	10	FE1202444	Flat Washer M24 with EcoGuard
12	6	FE0612050	Socket Head Capscrew M12 x 1.75 x 50 with EcoGuard
13	6	FE1201224	Flat Washer M12 with EcoGuard
14	2	FE0412035	Flat Head Capscrew M12 x 1.75 x 35 with EcoGuard
15	2	6200002	Grease Fitting

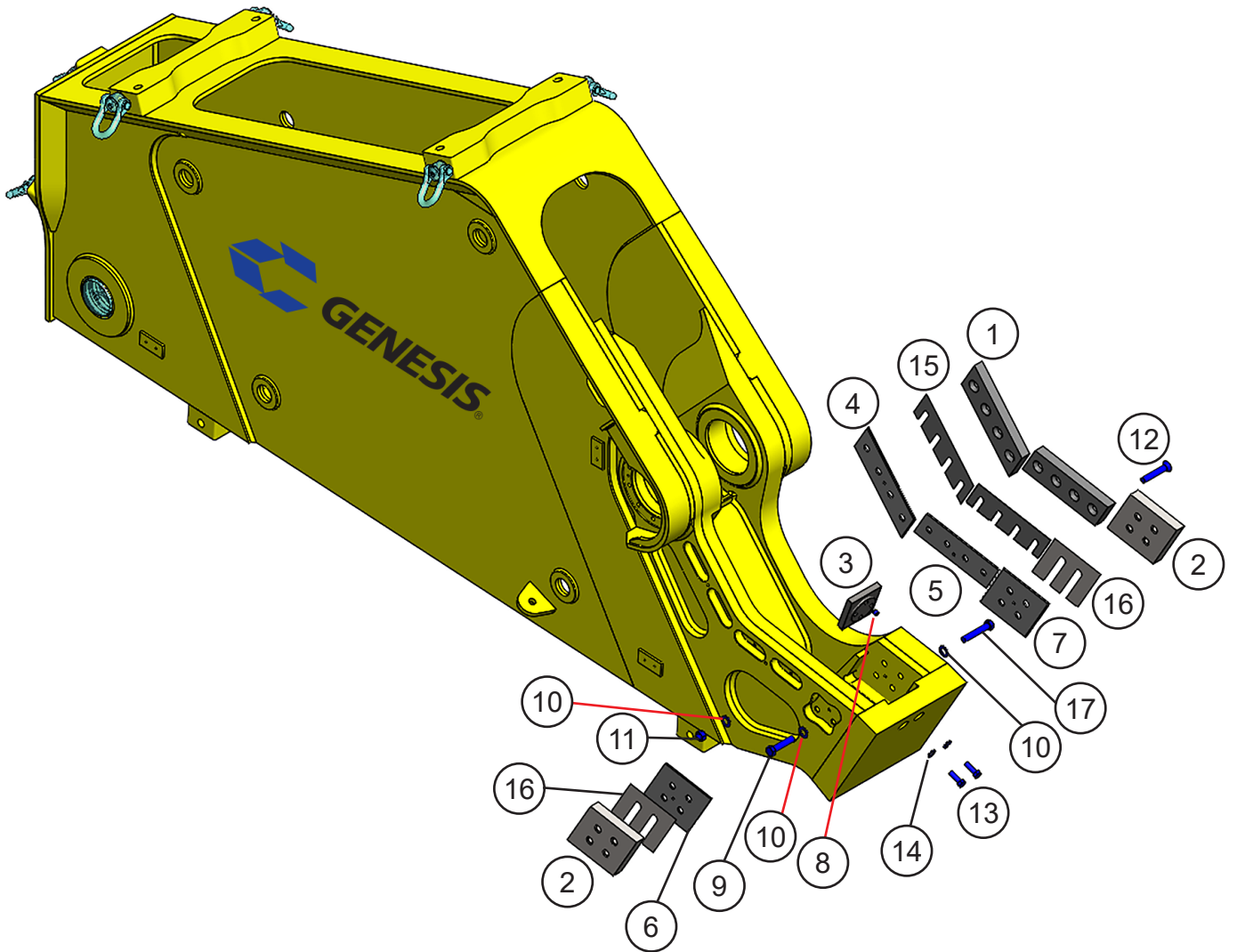
ASSEMBLY PIVOT GROUP - LEFT HAND SIDE



ASSEMBLY PIVOT GROUP - LEFT HAND SIDE

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1107663	Mach Main Shaft
2	1	1108330	Mach Bearing LH
3	1	FE0412035	Flat Head Capscrew M12 x 1.75 x 35 with EcoGuard
4	1	1104048	Mach Thrust Washer
5	1	1104049	Shim Set Thrust Washer
6	2	6200002	Grease Fitting
7	1	1108301	Mach End Cap
8	1	1108300	Mach Tie Rod Nut
9	1	S0190357	O-Ring
10	4	FE0616050	Socket Head Capscrew M16 x 2.00 x 50 with EcoGuard
11	4	FE1201630	Flat Washer M16 with EcoGuard
12	10	FE0624080	Socket Head Capscrew M24 x 3.00 x 80 with EcoGuard
13	10	FE1202444	Flat Washer M24 with EcoGuard
14	6	FE0612050	Socket Head Capscrew M12 x 1.75 x 50 with EcoGuard
15	6	FE1201224	Flat Washer M12 with EcoGuard

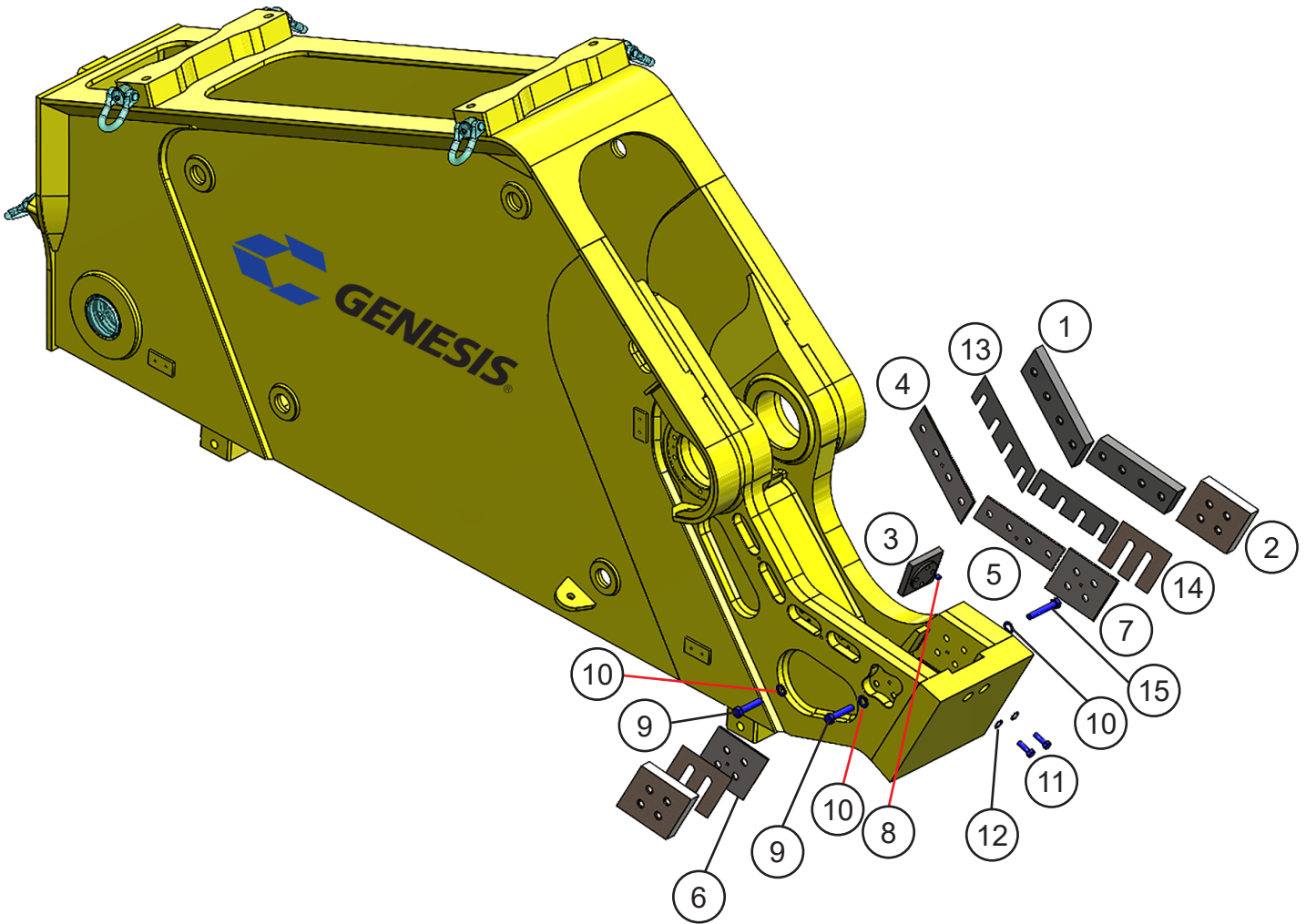
ASSEMBLY LOWER SHEAR BLADES - COUNTERSUNK BOLTS



ASSEMBLY LOWER SHEAR BLADES - COUNTERSUNK BOLTS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	1107967	Mach Blade Countersunk Bolts
2	2	1107629	Mach Blade Guide
3	1	1107630	Mach Blade Razor
4	1	1107860	Mach Adjustment Plt Primary
5	1	1107862	Mach Adjustment Plt Secondary
6	1	1107744	Mach Adjustment Plt GB
7	1	1107742	Mach Adjustment Plt Guide
8	2	FE2510100	Set Screw Socket Head 1 - 8 x 1 with EcoGuard
9	4	FE0213575	Hex Head Capscrew 1¼ - 7 x 5¾ with EcoGuard
10	16	FE1300125	Flat Washer 1¼ with EcoGuard
11	8	FE0912507	Hex Nut 1¼ - 7 with EcoGuard
12	8	FE0513700	Flat Head Capscrew 1¼ - 7 x 7 with EcoGuard
13	2	FE0210300	Hex Head Capscrew 1 - 8 x 3 with EcoGuard
14	2	FE1300100	Flat Washer 1" with EcoGuard
15	2	1107858	Blade Shim Set
16	2	1107660	Guide Shim Set, Blade Side
17	4	FE0213700	Hex Head Capscrew 1¼ - 7 x 7 with EcoGuard

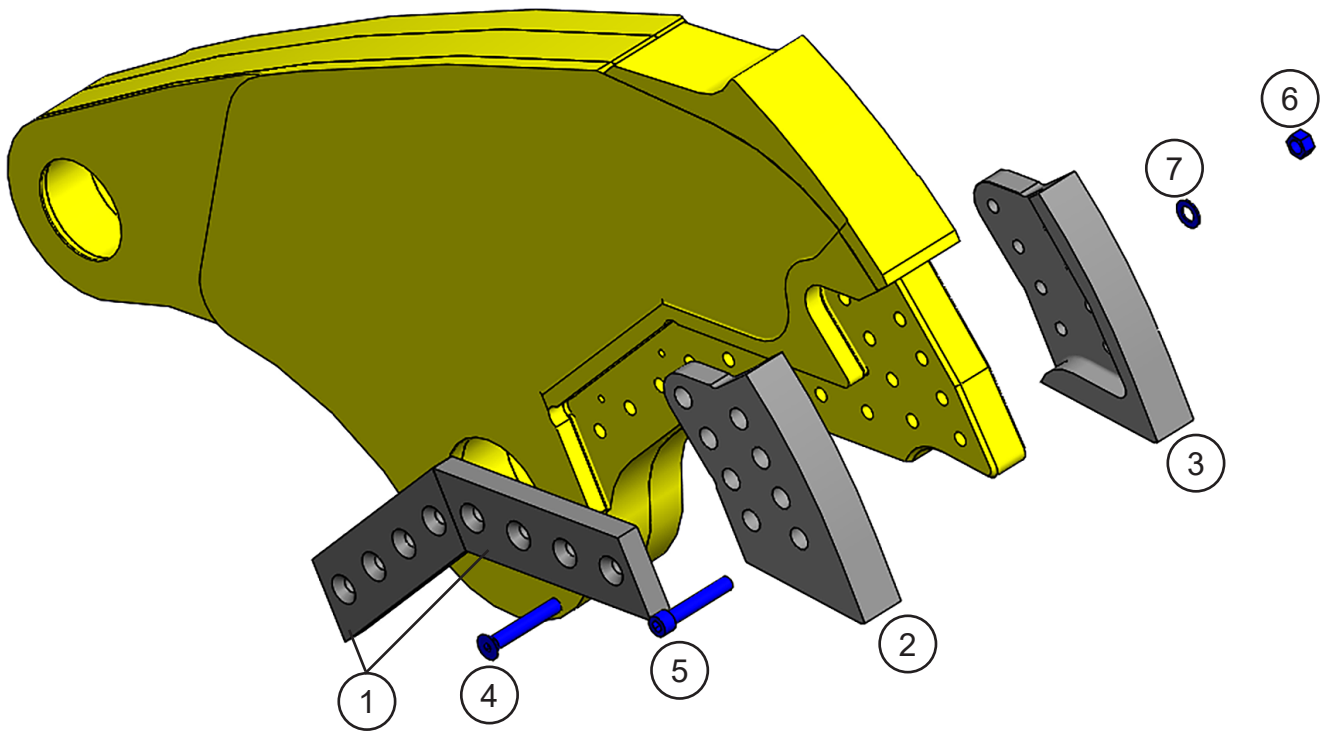
ASSEMBLY LOWER SHEAR BLADES - TAPPED BLADES



ASSEMBLY LOWER SHEAR BLADES - TAPPED BLADES

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	1107874	Mach Blade Tapped Blade
2	2	1107629	Mach Blade Guide
3	1	1107630	Mach Blade Razor
4	1	1107860	Mach Adjustment Plt Primary
5	1	1107862	Mach Adjustment Plt Secondary
6	1	1107744	Mach Adjustment Plt GB
7	1	1107742	Mach Adjustment Plt Guide
8	2	FE2510100	Set Screw Socket Head 1 - 8 x 1 with EcoGuard
9	12	FE0213575	Hex Head Capscrew 1¼ - 7 x 5¾ with EcoGuard
10	16	FE1300125	Flat Washer 1¼ with EcoGuard
11	2	FE0210300	Hex Head Capscrew 1 - 8 x 3 with EcoGuard
12	2	FE1300100	Flat Washer 1" with EcoGuard
13	2	1107858	Blade Shim Set
14	2	1107660	Guide Shim Set, Blade Side
15	4	FE0213700	Hex Head Capscrew 1¼ - 7 x 7 with EcoGuard

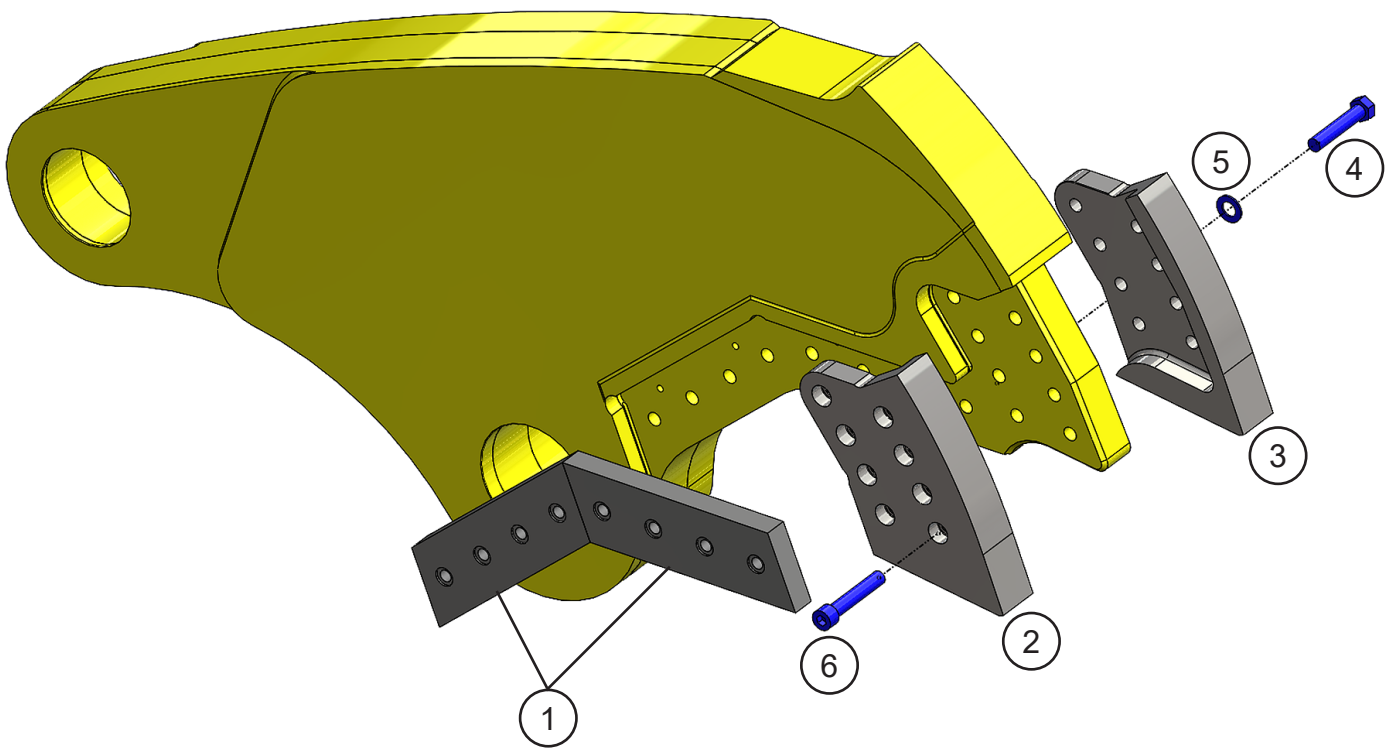
ASSEMBLY UPPER SHEAR BLADES - COUNTERSUNK BOLTS



ASSEMBLY UPPER SHEAR BLADES - COUNTERSUNK BOLTS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	1107967	Mach Blade Countersunk Bolts
2	1	1107624	Mach Blade Tip RH
3	1	1107625	Mach Blade Tip LH
4	8	FE0513800	Flat Head Capscrew 1¼ - 7 x 8 with EcoGuard
5	8	FE0712700	Socket Head Capscrew 1¼ - 7 x 7 with EcoGuard
6	8	FE0912507	Hex Nut 1¼ - 7 with EcoGuard
7	8	FE1300125	Flat Washer 1¼ with EcoGuard

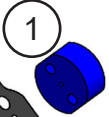
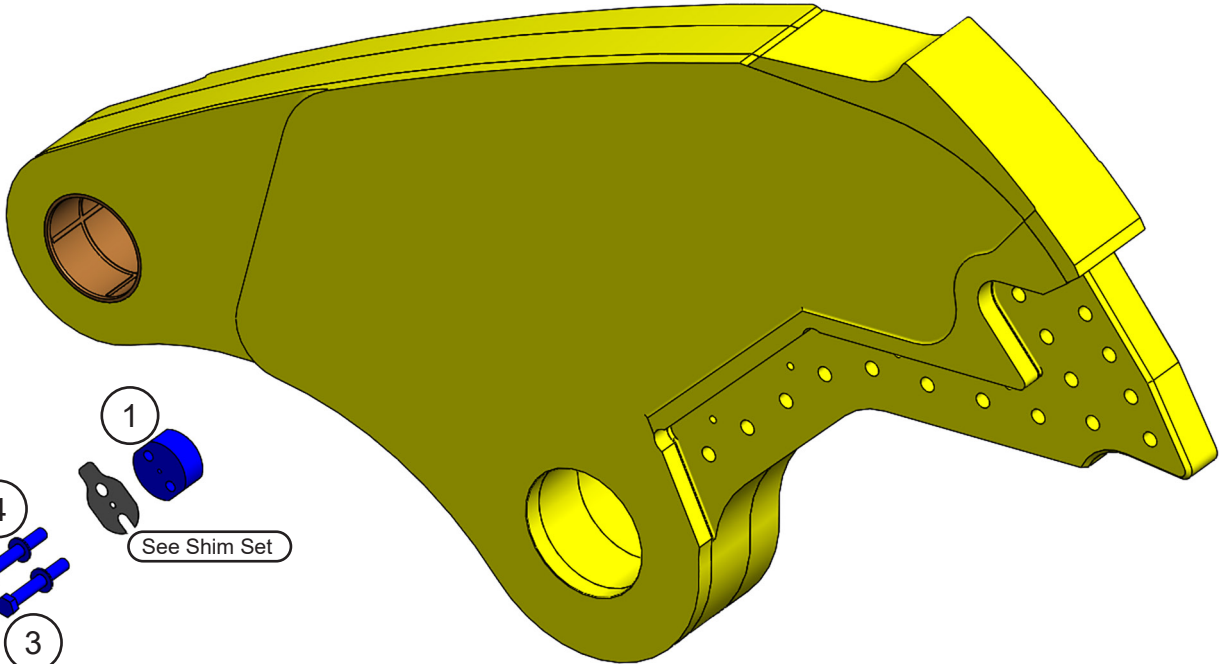
ASSEMBLY UPPER SHEAR BLADES - TAPPED BLADES



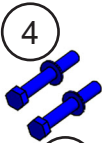
ASSEMBLY UPPER SHEAR BLADES - TAPPED BLADES

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	1107848	Mach Blade Tapped
2	1	1107624	Mach Blade Tip RH
3	1	1107625	Mach Blade Tip LH
4	8	FE0213650	Hex Head Capscrew 1¼ - 7 x 6½ with EcoGuard
5	8	FE1300125	Flat Washer 1¼ with EcoGuard
6	8	FE0712700	Socket Head Capscrew 1¼ - 7 x 7 with EcoGuard

ASSEMBLY AUTO GUIDE



See Shim Set

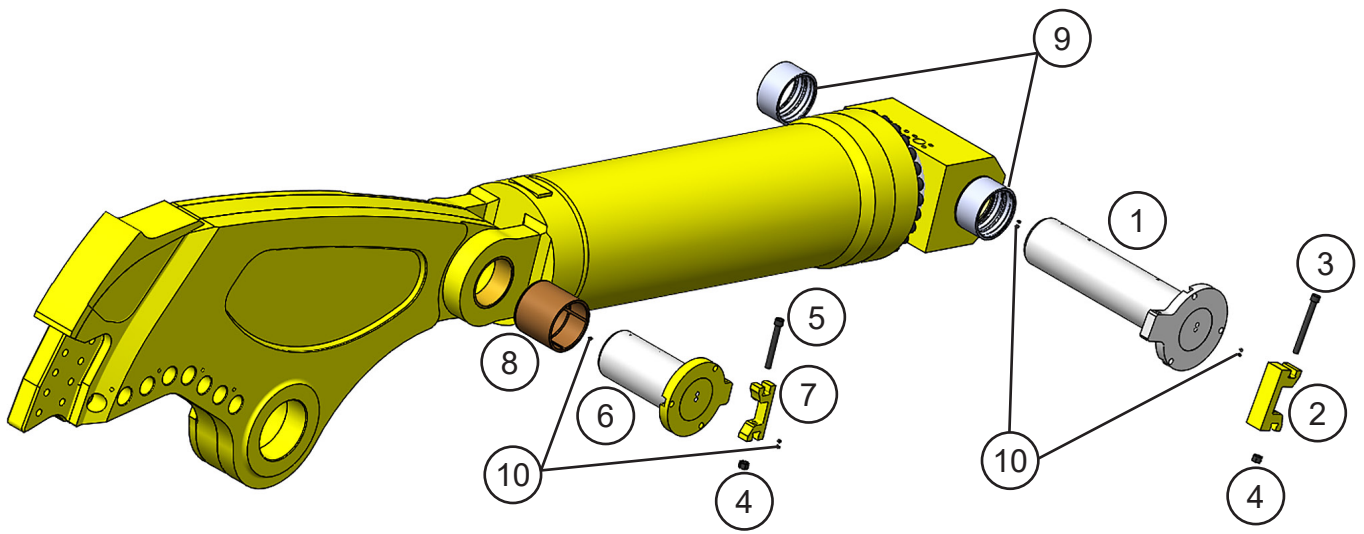


Maintenance Schedule
Lubricate every
8 hours

ASSEMBLY AUTO GUIDE

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1108302	Mach Auto Guide
2	1	6200002	Grease Fitting
3	2	FE0210700	Hex Head Capscrew 1 - 8 x 7 with EcoGuard
4	2	FE1300100	Flat Washer 1" with EcoGuard
SHIM SET			
		1106478	Shim Set, Auto Guide

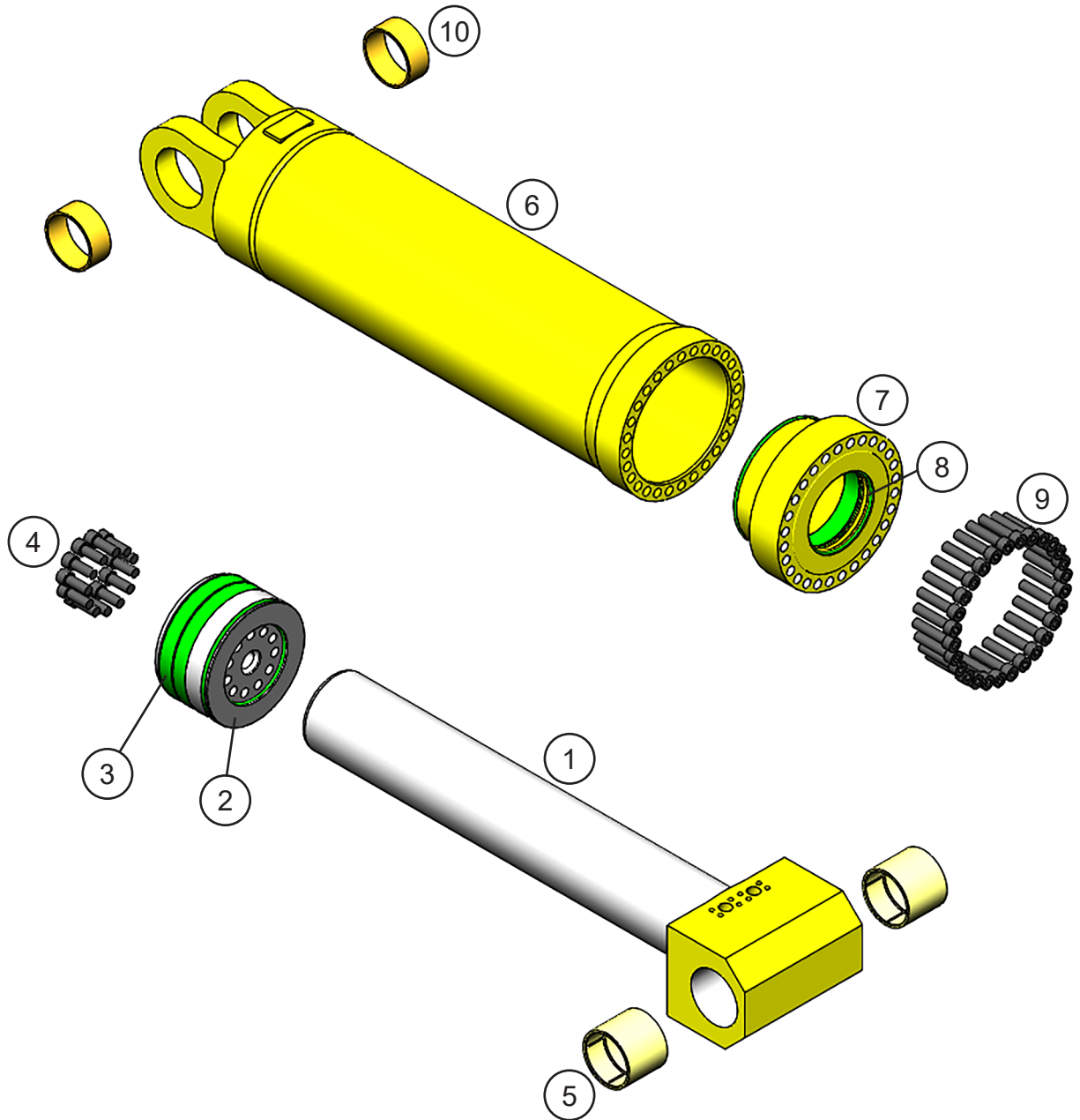
ASSEMBLY CYLINDER PINS



ASSEMBLY CYLINDER PINS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	1108355	Wldt Pin Rear
2	1	1108356	Mach Pin Keeper
3	1	F0624240	Socket Head Capscrew M24 x 3.00 x 240
4	2	F0824300	Hex Nut M24 x 3.00
5	1	F0624200	Socket Head Capscrew M24 x 3.00 x 200
6	1	1108362	Wldt Pin Front
7	1	1108365	Mach Pin Keeper
8	1	1107165	Mach Bearing Upper Cylinder Connection
9	2	1108358	Mach Bearing Lower Cylinder Connection
10	7	6200002	Grease Fitting

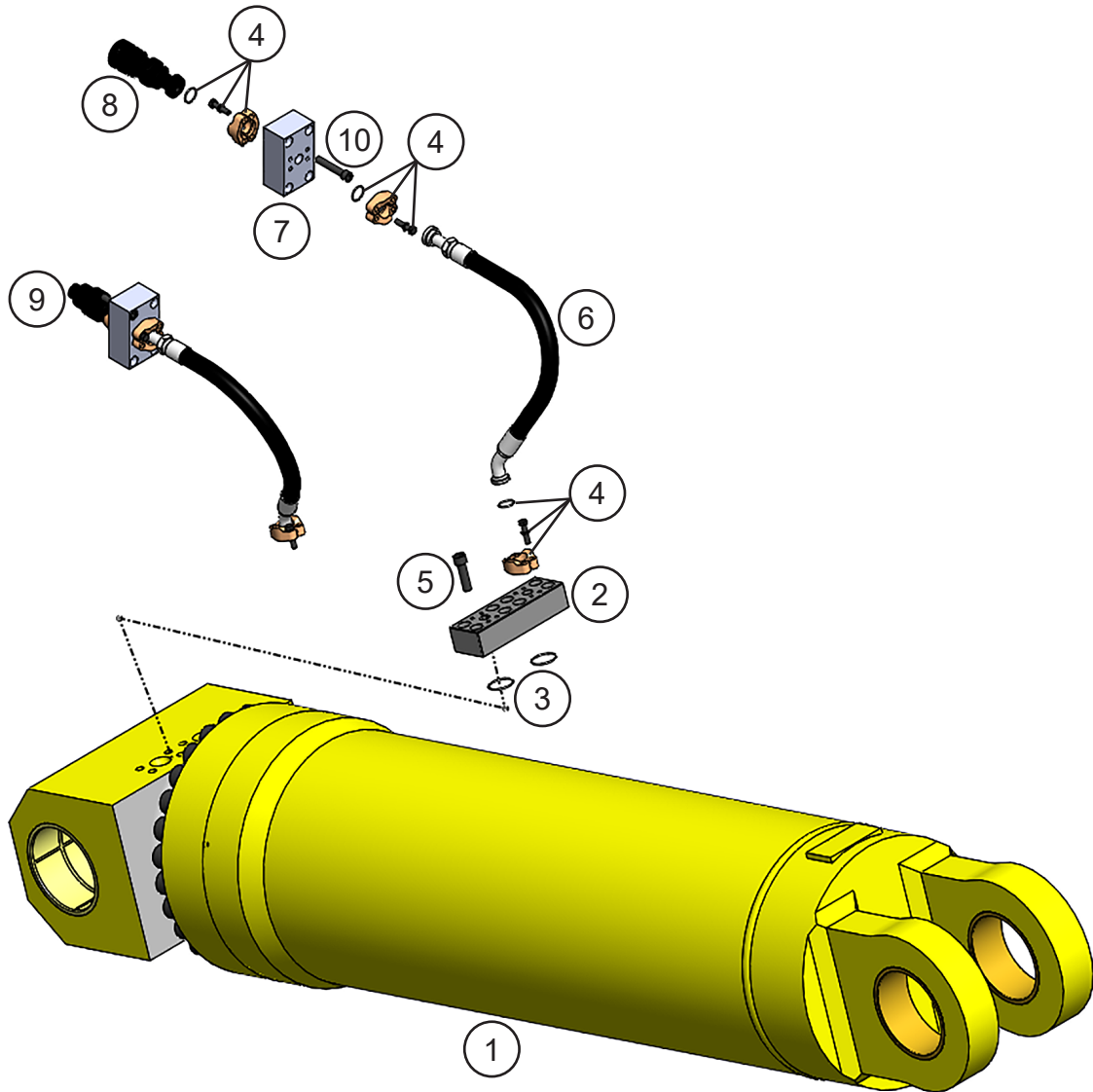
ASSEMBLY CYLINDER - 6350148



ASSEMBLY CYLINDER - 6350148

ITEM	QTY	PART NUMBER	DESCRIPTION
		6350148	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	6350148	Assy Cyl. B20.0 R13.0 S63.0
2	1	1108350	Mach Cylinder Manifold
3	2	S0190228	O-Ring
4	6	1" Split Flange Kit	
	2	HS262100	Split Flange Half 1.00 Code 62
	4	F0112050	Socket Head Capscrew M20 x 2.5 x 70
	4	F1402000	Lock Washer M20
	1	S0190219	O-Ring
5	8	F0620070	Socket Head Capscrew M20 x 2.50 x 70
6	2	1108373	Hose 16EFG5K - 16FL - 16FL45M - 37.145
7	2	1107783	Mach Adapter Block
8	1	6301210	Female Quick Connect
9	1	6301209	Male Quick Connect
10	8	F0616090	Socket Head Capscrew M16 x 2.00 x 90

BOLT TORQUE SPECIFICATIONS

Reference the product Thread Treatment Diagrams on page 27 to determine whether to use wet or dry torque values for specific bolts.

Reference Procedures on page 28 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.

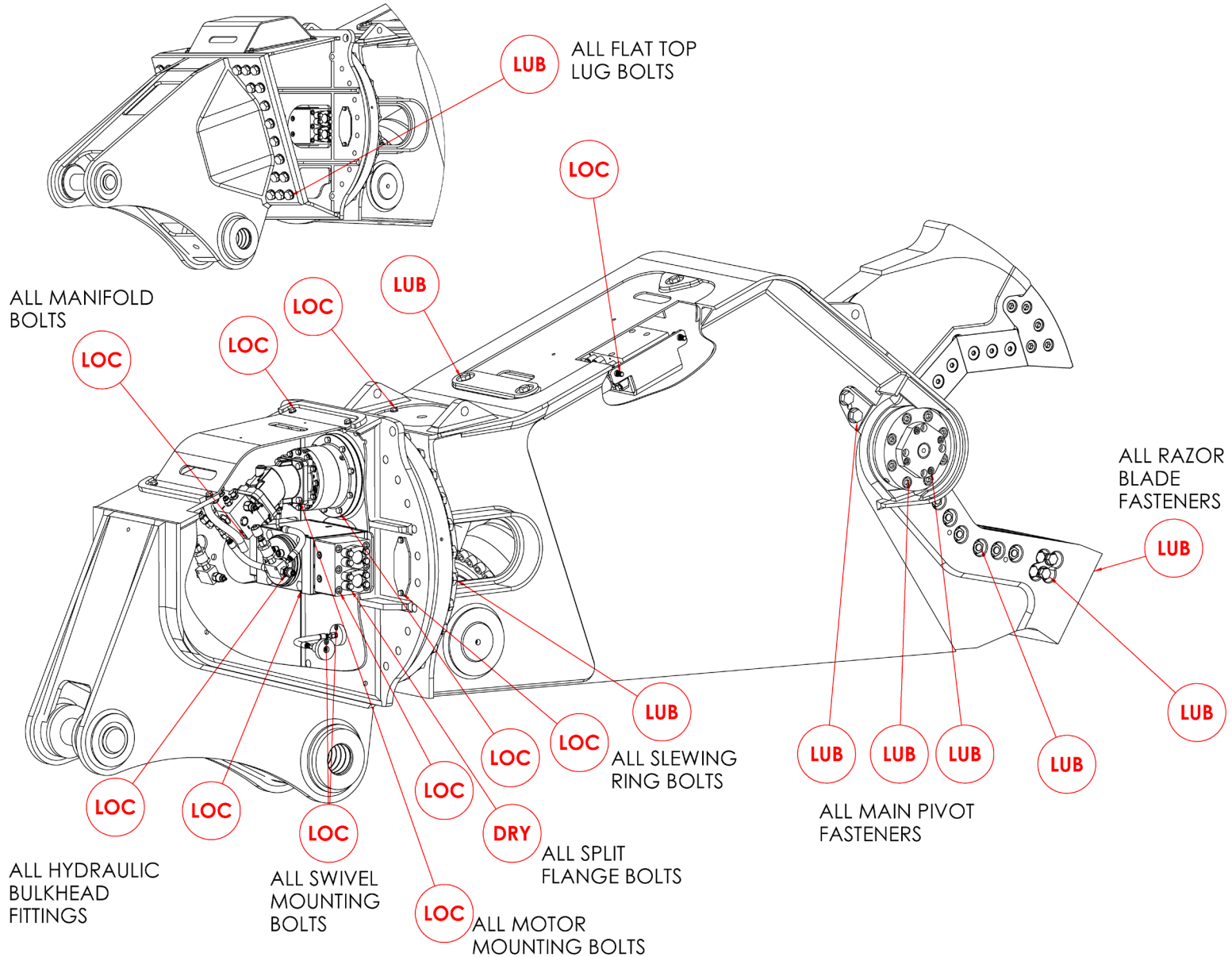
When using a torque multiplier with a torque wrench, incorrect settings will be multiplied by the ratio of the torque wrench.

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 28. For prescribed torque values, see page 30.



PROCEDURES

Reference the product Thread Treatment Diagrams on page 27 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

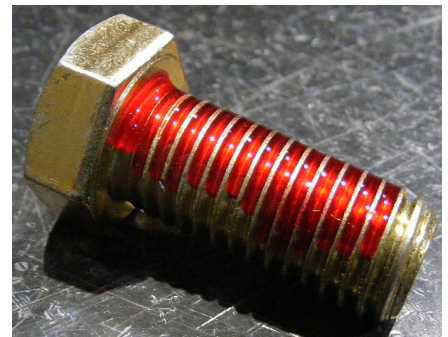
For bolted connections requiring threadlocker, use **Loctite 263** or equivalent applied using the following procedure:

- 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 30.

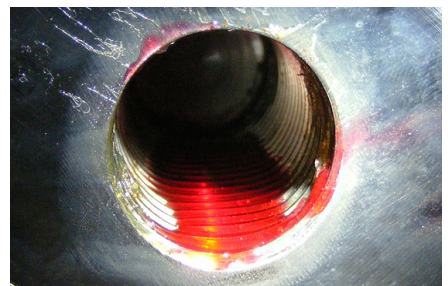
For threaded hydraulic fitting connections, use **Loctite 5452** or equivalent thread sealant in conjunction with **Loctite 7471** primer using the following procedure:

- 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 31.

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 30.

Anti-Seize





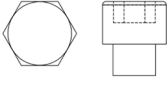

DRY

No Thread Treatment

- Clean and degrease all threads.
- Torque bolt to specified **Dry Torque Value**, see page 30.

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
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
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

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CONTACT INFORMATION

Genesis Attachments

1000 Genesis Drive
Superior, WI 54880 USA

Toll Free: 888-SHEAR-IT
(888-743-2748)

Phone: 715.395.5252

E-mail:
info@genesisattachments.com

Europe/Africa/Middle East Genesis GmbH

Teramostrasse 23
87700 Memmingen, Germany

Phone: +49 83 31 9 25 98 0
Fax: +49 83 31 9 25 98 80
genesis-europe.com

E-mail:
info@genesis-europe.com

Asia Pacific Representative Office

24 Upper Serangoon View #12-28
Singapore 534205

Phone: +65 9673 9730

E-mail:
tchoo@genesisattachments.com

Central America & Colombia

Cra 13A #89-38 / Ofi 613
Bogota, Colombia

Phone: +57 1 610 8160 / 795 8747

E-mail:
contact@themsagroup.com

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