



Lip Thickness (mm)	Leading Edge (mm)	Ramp Angle (deg)	Boss Setback (mm)	Bucket Spade Angle (deg)
A	B	C	D	

Wing Shroud

50	50	90	40	0
80	80	90	40	0

Surface & Underground Shroud

50 (All Shroud)	30	25	60	10
70 (All Shroud)	25	30	100	10
70	19	30	110	10
90	22	30	145	14
100	25	30	150	10
120	42	30	160	14
140	45	30	190	11.5

Lip profile must be relatively smooth and free of debris, such as weld spatter, metal deformation, cutting dags or other irregularities

Tolerances

Lip Thickness	Standard Lip Plate Tolerance
Leading Edge	± 2mm
Ramp Angle	+ 0 deg / -2 deg
Boss Set Back	± 1mm