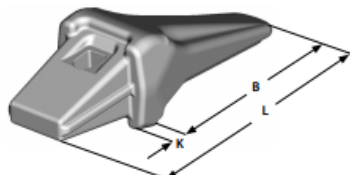
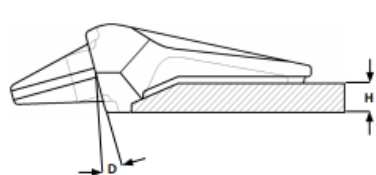




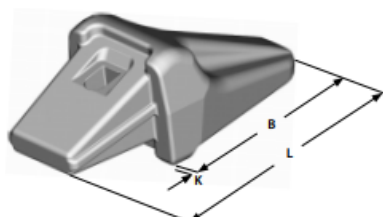
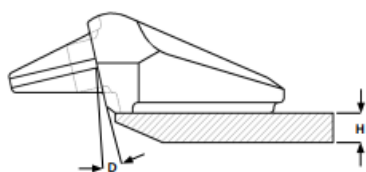
TABLEAU DES ACCOUPLEMENTS PAR TAILLE

| Classe |  |  |  |  |  |  |  |  |
|------------|---|---|---|---|---|--|---|---|
| K1 | M761 | M701 | | M781 | M721L | M721R | M721PE | M741 |
| K3 | M763 | M703 | | M783 | M723L | M723R | M723PE | M741 |
| K5 | M765 | M705 | | M785 | M725L | M725R | M725PE | M745 |
| K6 | | | M706 | | | M726R | M726PE | M746 |
| K7 | M767 | M707 | | | M727L | M727R | M727PE | M747 |
| K8 | | | M708 | | | M728R | M728PE | M748 |
| K9 | M769 | | | | M729L | M729R | M729PE | M747 |
| K11 | | | M711 | M791 | | M731R | M731PE | M751 |
| K13 | | | M713 | | | M733R | M733PE | M753 |
| K15 | | | M715 | | | M735R | M735PE | M755 |

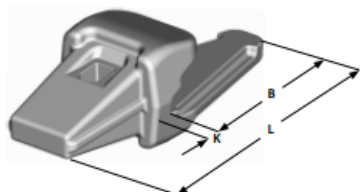
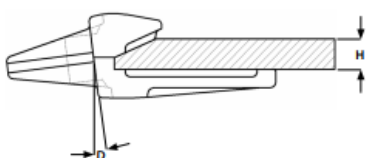
Les porte-dents



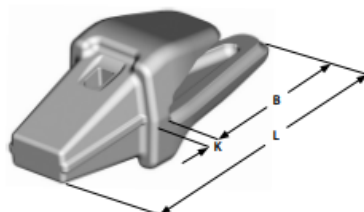
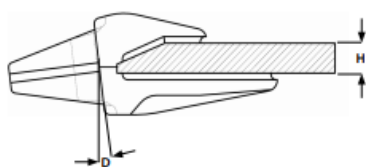
Type 1



Type 2



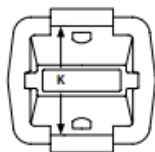
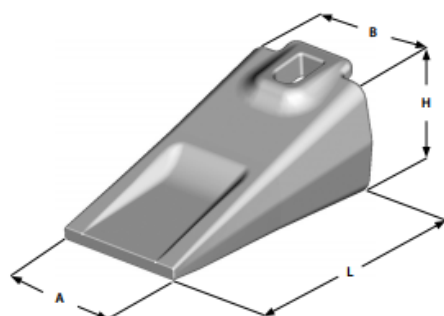
Type 3



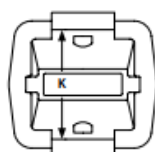
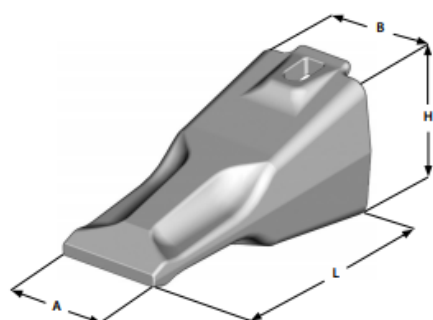
Type 4

| Classe | Réf. | Type | Dimensions | | | | | Poids | Force d'arrachement en kg | Pointe |
|------------|------|------|------------|-----|----|-------|-----|-------|---------------------------|----------|
| | | | L | B | K | H | D | | | |
| K1 | M761 | 1 | 163 | 100 | 13 | 12-16 | 14° | 0,85 | 2 400 | M721L-R |
| | M781 | 2 | 146 | 91 | 5 | 12-16 | 12° | 1,1 | 2 400 | M721R |
| | M701 | 3 | 143 | 86 | 11 | 16 | 7° | 0,75 | 2 400 | M721L-R |
| K3 | M763 | 1 | 181 | 111 | 13 | 16 | 14° | 1,25 | 3 500 | M723L-R |
| | M783 | 2 | 170 | 104 | 6 | 12-16 | 12° | 1,45 | 3 700 | M723L-R |
| | M703 | 3 | 156 | 91 | 12 | 16-20 | 7° | 1,1 | 3 500 | M723L-R |
| K5 | M765 | 1 | 212 | 127 | 18 | 20 | 14° | 2,1 | 5 000 | M725L-R |
| | M785 | 2 | 188 | 116 | 4 | 20 | 13° | 2,6 | 5 500 | M725L-R |
| | M705 | 3 | 173 | 100 | 12 | 20 | 7° | 1,65 | 4 700 | M725L-R |
| K6 | M706 | 4 | 179 | 105 | 12 | 20 | 7° | 2 | 6 400 | M726R-PE |
| K7 | M767 | 1 | 268 | 164 | 18 | 25 | 15° | 3,2 | 7 000 | M727L-R |
| | M707 | 3 | 223 | 130 | 16 | 25 | 7° | 2,75 | 7 000 | M727L-R |
| K8 | M708 | 4 | 227 | 131 | 15 | 25 | 7° | 3,1 | 8 300 | M728R-PE |
| K9 | M769 | 1 | 318 | 208 | 20 | 25 | 15° | 4,4 | 9 000 | M729L-R |
| K11 | M791 | 2 | 265 | 160 | 9 | 25-30 | 14° | 6,4 | 10 500 | M731R |
| | M711 | 4 | 250 | 149 | 16 | 25 | 7° | 4,4 | 10 200 | M731R-PE |
| K13 | M713 | 4 | 300 | 180 | 23 | 30 | 7° | 7,6 | 13 500 | M733R-PE |
| K15 | M715 | 4 | 340 | 204 | 26 | 40 | 7° | 9,5 | 16 600 | M735R-PE |

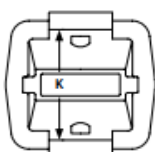
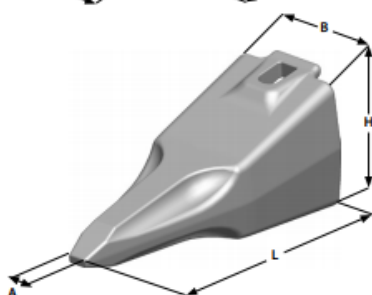
Les dents



Série L



Série R



Série PE

| Classe | Réf. | Dimensions | | | | | Poids | Porte-dent | Clavette |
|--------|--------|------------|----|-----|-----|----|-------|----------------|----------|
| | | L | A | B | H | K | | | |
| K1 | M721L | 100 | 44 | 50 | 41 | 33 | 0,6 | M701-M761 | M741 |
| | M721R | 98 | 42 | 50 | 41 | 33 | 0,55 | M701-M761-M781 | M741 |
| K3 | M723L | 117 | 52 | 57 | 45 | 37 | 0,9 | M703-M763-M783 | M741 |
| | M723R | 115 | 50 | 57 | 45 | 37 | 0,85 | M703-M763-M783 | M741 |
| K5 | M725L | 143 | 56 | 67 | 56 | 45 | 1,45 | M705-M765-M785 | M745 |
| | M725R | 138 | 54 | 67 | 56 | 45 | 1,3 | M705-M765-M785 | M745 |
| K6 | M726R | 138 | 53 | 67 | 65 | 54 | 1,45 | M706 | M746 |
| | M726PE | 148 | 11 | 67 | 65 | 54 | 1,4 | M706 | M746 |
| K7 | M727L | 160 | 61 | 73 | 62 | 49 | 1,9 | M707-M767 | M747 |
| | M727R | 155 | 59 | 73 | 62 | 49 | 1,65 | M707-M767 | M747 |
| K8 | M728R | 155 | 58 | 73 | 73 | 60 | 1,8 | M708 | M748 |
| | M728PE | 165 | 12 | 73 | 73 | 60 | 1,8 | M708 | M748 |
| K9 | M729L | 178 | 68 | 79 | 67 | 54 | 2,55 | M769 | M747 |
| | M729R | 173 | 65 | 79 | 67 | 54 | 2,3 | M769 | M747 |
| K11 | M731R | 191 | 64 | 79 | 85 | 72 | 3,2 | M711-M791 | M751 |
| | M731PE | 206 | 14 | 79 | 85 | 72 | 3 | M711 | M751 |
| K13 | M733R | 220 | 74 | 95 | 100 | 86 | 5 | M713 | M753 |
| | M733PE | 238 | 16 | 95 | 100 | 86 | 4,7 | M713 | M753 |
| K15 | M735R | 247 | 86 | 103 | 109 | 92 | 6,6 | M715 | M755 |
| | M735PE | 265 | 18 | 103 | 109 | 92 | 6,3 | M715 | M755 |

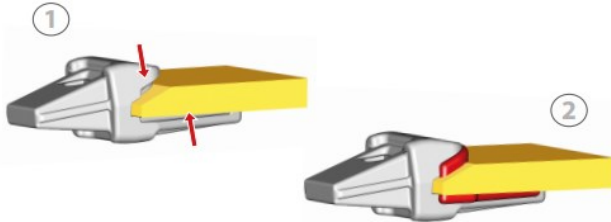
Les clavettes



| Classe | Dimensions | | | Poids | Porte-dent | Dent |
|--------------|------------|-------|------|-------|----------------------------------|--------------------|
| | Réf. | L | H | | | |
| K1-K3 | M741 | 43 | 8 | 0,02 | M701-M761-M781 M703-M763-M783 | M721L-R M723L-R |
| K5 | M745 | 56 | 10 | 0,05 | M705-M765-M785 | M725L-R |
| K6 | M746 | 64 | 10 | 0,06 | M706 | M726R-PE |
| K7 | M747 | 65 | 12 | 0,07 | M707-M767-M769 | M727L-R M729L-R |
| K8 | M748 | 75 | 12 | 0,08 | M708 | M728R-PE |
| K11 | M751 | 84 | 12 | 0,1 | M711-M791 | M731R-PE |
| K13 | M753 | 102 | 13,5 | 0,15 | M713 | M733R-PE |
| K15 | M755 | 108,5 | 13,5 | 0,2 | M715 | M735R-PE |

Instructions

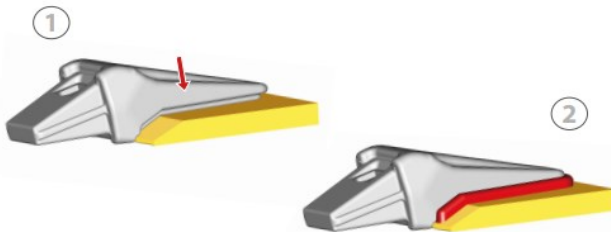
Soudage



1- Les surfaces à souder doivent être propres et sèches. Un bon nettoyage évite la formation des fissures pendant le soudage.



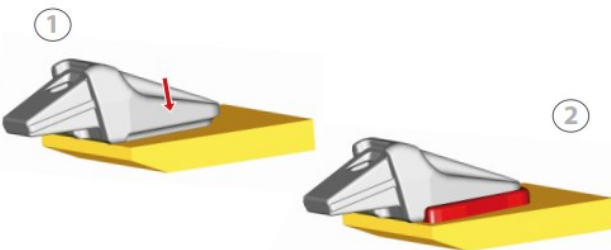
2- Positionner le porte-dents en s'assurant que le couplage avec la lame soit correct, puis fixer le porte-dents avec quelques points de soudure.



3- Il est conseillé d'effectuer le préchauffage des parties à souder. Cette opération favorise la fuite d'hydrogène du métal et ainsi réduit le risque de fissure.



4- Utiliser un électrode basique donnant la plus faible teneur possible en hydrogène.

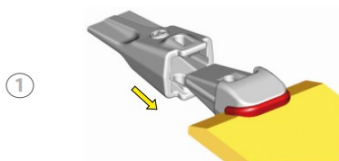


5- Positionner la soudure dans les espaces spéciaux indiqués par les flèches .

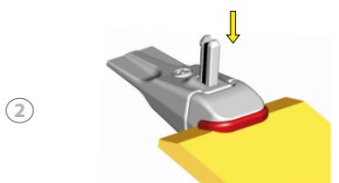


6- La largeur de la soudure doit être proportionnelles aux dimensions du porte-dents.

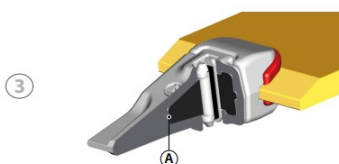
Assemblage



1- Assembler la dent au porte-dents déjà soudé sur la lame. Les deux surfaces indiquées au point A doivent être en contact.



2- Positionner la clavette. La partie métallique antérieure a une surface arrondie avec deux saillies, la partie métallique postérieure a une surface plate.



3- Positionner la clavette sur toute la longueur.