ROCK & BULK BUCKETS

BOOST PRODUCTIVITY WITH A STRONGER, MORE DURABLE BUCKET ON YOUR MACHINE. DESIGNED & BUILT TO SUIT YOUR NEEDS

West-Trak
UNRIVALLED STRENGTH

ROCK & BULK BUCKETS

“Guaranteed quality & full backup support”

Digging for a new Rock Bucket?

YOU'LL NEED A TOUGH, RELIABLE WEST-TRAK BUCKET TO GET THE JOB DONE

We import and stock a large range of high quality, heavy-duty Rock and Bulk Buckets that survive the toughest Quarry and Mining environments in the world.

Our Buckets are manufactured from the highest quality structural and abrasion-resistant wear steels, providing unrivalled strength and durability.

Productivity and performance is a key part of our design process to ensure you get the best Bucket for your needs, with good penetration and fill factor, structural integrity, safe and reliable G.E.T systems and a solid wear protection package.

Our expertise in big Bucket engineering for more than 20 years, gives you the confidence we know what works best. You'll get proven, tried and trusted Bucket advice you can rely on.

Ongoing back-up support is part of the West-Trak Bucket solution. All replacement wear parts are readily available ex-stock, for fast delivery to keep your machine in action. Regular Bucket assessments can be carried out on-site to ensure optimum performance and customer satisfaction.

Maximise your productivity today with a West-Trak Bucket on your Excavators. Available for 20 - 100 tonne size machines.

DESIGN FEATURES & BENEFITS

Get more bang for your buck!

BOOST PRODUCTIVITY WITH A STRONGER, MORE DURABLE ROCK BUCKET ON THE BUSINESS END OF YOUR MACHINE

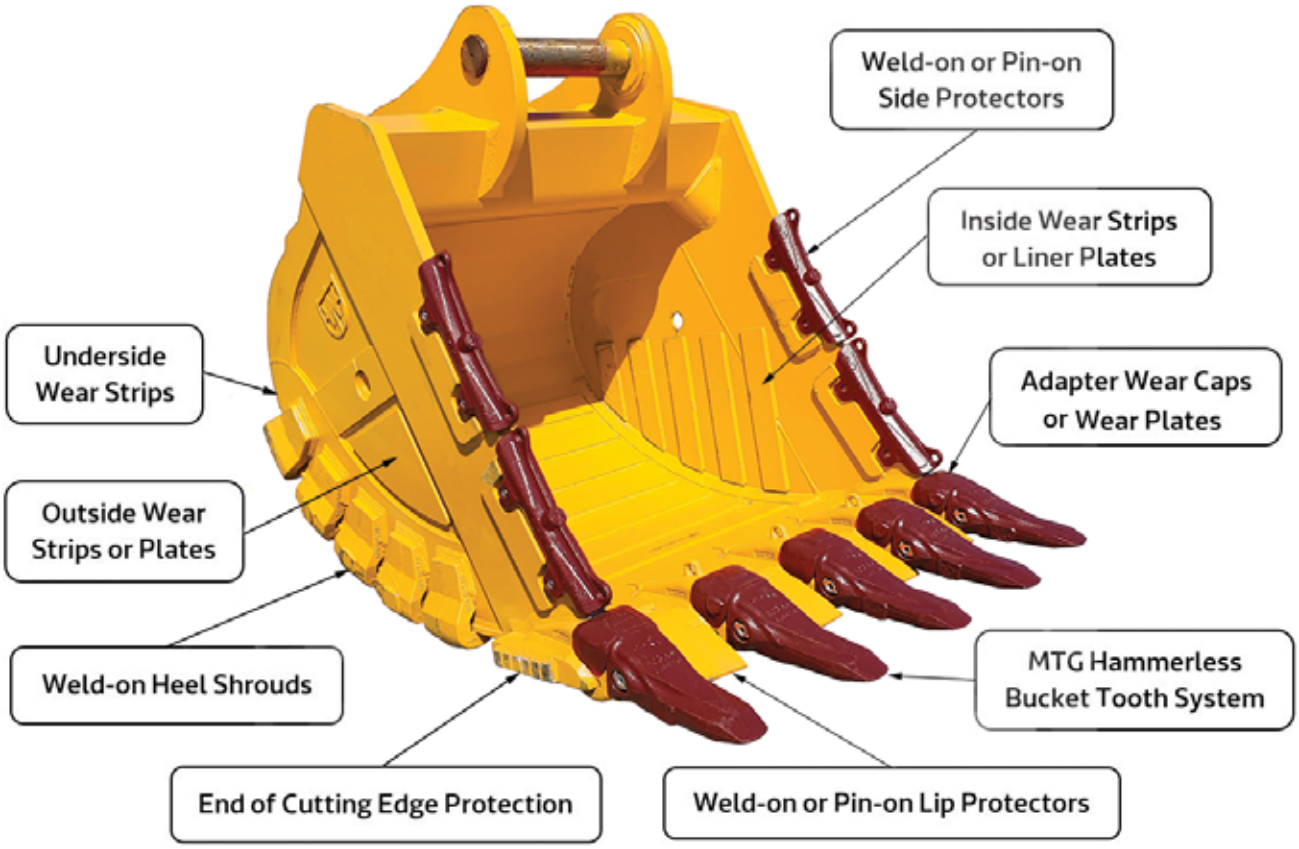
- **Built from High Tensile & Abrasion-resistant steels for maximum strength and wear life**
- **Improved design and performance benefits to enhance your machines productivity**
- **Fully hammerless G.E.T wear protection system for ultimate safety and reliability**
- **Guaranteed quality and full back-up support with replacement wear parts in stock**
- **Buckets are available to suit any brand of Excavator from 20-100 tonne size**

Medium or High Tensile, high strength steel is used on the top bridge, skin & lip areas

G400-G450 Abrasion Resistant wear steel is used on the Bucket sides, lip & wear strips

G500 Abrasion Resistant wear steel is used for wear strips & wear protection plates

THE BUCKET WEAR PROTECTION PACKAGE IS FUNDAMENTAL FOR ACHIEVING LONG SERVICE LIFE & PROTECTING THE STRUCTURAL AREAS OF THE BUCKET FROM WEAR & TEAR



DESIGN FEATURES & BENEFITS

What makes a good Bucket?

IT'S IMPORTANT TO KNOW THE KEY FEATURES & BENEFITS OF A GOOD BUCKET TO MAXIMISE YOUR MACHINE PRODUCTIVITY & SERVICE LIFE

CAPACITY

Choose a Bucket with the most capacity possible to suit your truck size and digging application. You'll increase your extraction capacity with more material in every scoop, also reducing cycle times and fuel burn.

Having a stepped spade edge and using Lip and Side Protectors will also help to add extra capacity to your Bucket.

PENETRATION

You need the right shape Cutting Edge and correct tooth configuration, size and style to maximise your Bucket penetration.

A spade shape Cutting Edge with the centre teeth set forward, combined with the MTG hammerless, self-sharpening tooth system, will enhance your digging power significantly. A narrow Bucket will improve penetration.

DESIGN FEATURES & BENEFITS

DESIGN & QUALITY

A good Bucket design has the right steel grades and thicknesses in the right areas for structural toughness and wear resistance.

All our Bucket designs are FEA stress-tested to eliminate any weak areas prior to production and ensure reliable performance. The correct weld preps, welding procedures and heat-treatment are also important quality factors for achieving good structural strength and durability.

G.E.T & WEAR PACKAGE

Get a safe and reliable tooth system on your Bucket. The MTG hammerless Starmet system guarantees no loss of teeth, fast and safe changeovers and the longest wear rates.

A good Rock Bucket needs a full wear package inside and out to protect it from wear and tear. Wear is the main cause of cracks and failure of the Bucket parts and structure, so it's important to keep your asset armoured up.

BACK-UP & SUPPORT

You'll need a fast, reliable supplier for your replacement wear parts, who can supply from stock and provide trusted advice when things go wrong. West-Trak stand by what we sell and provide exceptional service and support to keep your machines moving.

All West-Trak Buckets have a 12 month/2000 hour structural warranty for your peace of mind. See our Terms and Conditions for more details.

Choose a West-Trak Bucket today & get these benefits!
Call 0800 654 323 to discuss your needs now

EXCAVATOR ROCK BUCKETS

A large range of Rock Buckets are available to suit most makes & models of Excavators.

Images shown are indicative only & may not represent the final design.

16-23 Tonne Standard Rock Bucket

- 1.0m³ SAE heaped capacity
- 1200mm wide
- 80mm pins fitted
- J350 teeth fitted
- Wear strips fitted on underside
- Part No. HD-21.12-J35

Pins can be modified to suit different fitments.

24-30 Tonne Standard Rock Bucket

- 1.4m³ SAE heaped capacity
- 1300mm wide
- 90mm pins fitted
- J400 teeth fitted
- Wear strips fitted on underside
- Part No. HD-31.13-J40

Pins can be modified to suit different fitments.

33-40 Tonne Heavy Duty Rock Bucket

- 1.7m³ SAE heaped capacity
- 1450mm wide
- 100mm pins fitted
- MTG teeth & protectors fitted
- Weld-on wear protection inside & outside
- Part No. RDH-41.14WT-NSF1

Pins can be modified to suit different fitments.

45-55 Tonne Heavy Duty Rock Bucket

- 2.1m³ - 2.6m³ SAE heaped capacity
- 1590mm-1890mm wide
- 110mm pins fitted
- MTG teeth & protectors fitted
- Weld-on wear protection inside & outside
- Part No. RDH-51.15WT-NSF2 (2.1m³)
- Part No. RDH-51.18WT-NSF1 (2.6m³)

Pins can be modified to suit different fitments.

60-90 Tonne Heavy Duty Rock Bucket

- 3.5m³ - 5.0m³ SAE heaped capacity
- 2050mm-2300mm wide
- Fixed or floating pins fitted
- MTG teeth & protectors fitted
- Weld-on wear protection inside & outside

Available on indent order or custom built to suit your needs.

100-120 Tonne Heavy Duty Rock Bucket

- 5.2m³ - 7.0m³ SAE heaped capacity
- 2250mm-2400mm wide
- Fixed or floating pins fitted
- MTG teeth & protectors fitted
- Weld-on wear protection inside & out

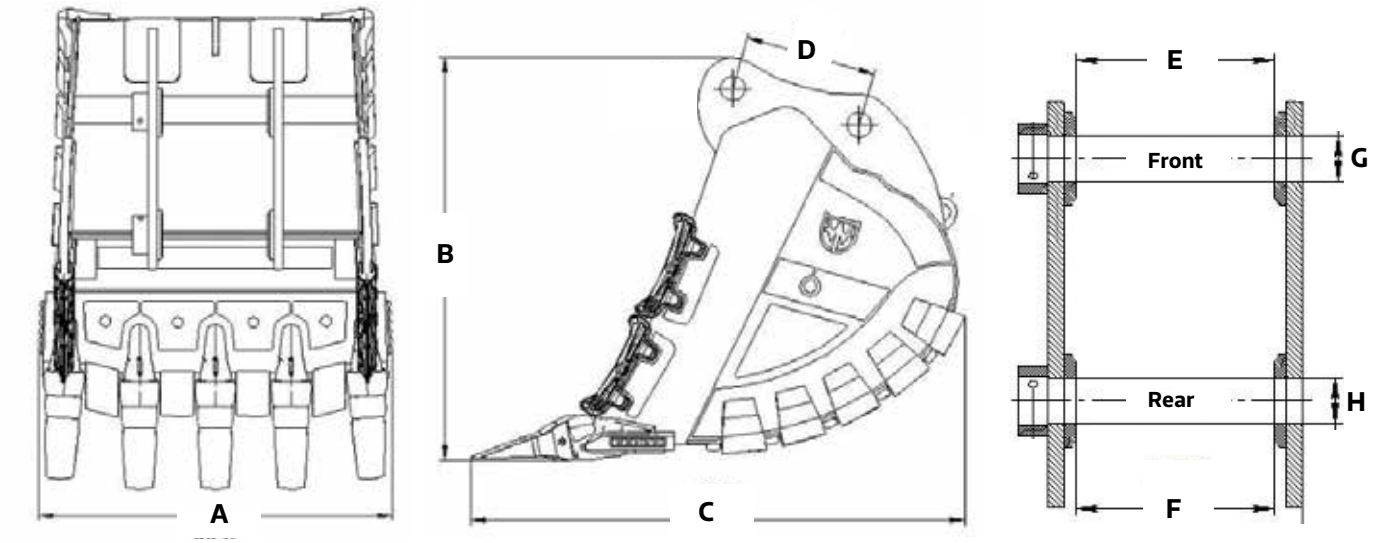
Available on indent order or custom built to suit your needs.

EXCAVATOR ROCK BUCKETS

Size chart for stock Buckets

Excavator Size		16-23 tonne	24-30 tonne
Bucket Part No		HD-21.12-J35	HD-31.13-J40
Bucket Type		Standard	Standard
Bucket Capacity (SAE)		1.0m3	1.4m3
Bucket Width	A	1210mm	1320mm
Bucket Height	B	1405mm	1555mm
Bucket Depth	C	1592mm	1734mm
Pin Centres	D	475mm	475mm
Dipper Width (front)	E	307mm	410mm
Power Link Width (rear)	F	307mm	410mm
Front Pin Diameter	G	80mm	90mm
Rear Pin Diameter	H	80mm	90mm
Cutting Edge Thickness		40mm	45mm
Cutting Edge Shape		Straight	Straight
Bucket Teeth		J350 (x5)	J400 (x5)
Side Protectors		Yes	Yes
Lip Protectors		No	No
Heel Shrouds		No	No
Wear Strips Inside		No	No
Wear Strips Underside		Yes	Yes
Mounting Pins fitted		Yes	Yes
Bucket Weight (approx)		870kg	1200kg

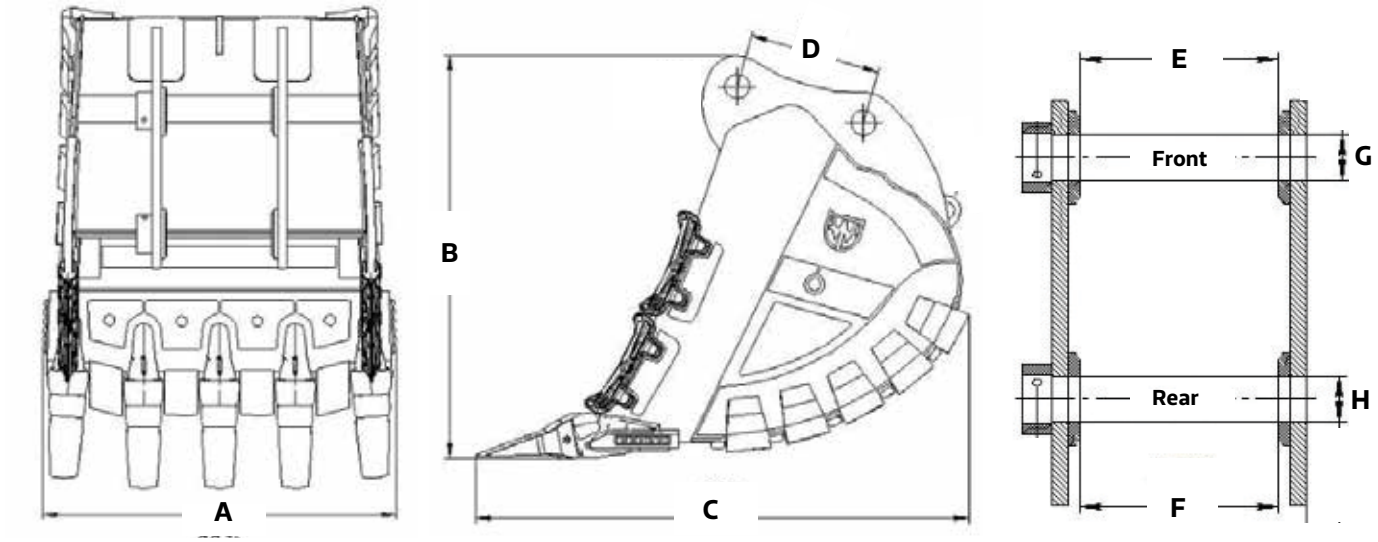
The Bucket fitment specifications and pin sizes can be modified to suit various machine models.



Size chart for stock Buckets

Excavator Size		33-40 tonne	45-55 tonne	45-55 tonne
Bucket Part No		RDH-41.14WT-NSF1	RDH-51.15WT-NSF2	RDH-51.18WT-NSF1
Bucket Type		Heavy Duty	Heavy Duty	Heavy Duty
Bucket Capacity (SAE)		1.7m3	2.1m3	2.6m3
Bucket Width	A	1470mm	1588mm	1888mm
Bucket Height	B	1637mm	1755mm	1763mm
Bucket Depth	C	1958mm	2128mm	2147mm
Pin Centres	D	585mm	575mm	570mm
Dipper Width (front)	E	418mm	472mm	470mm
Power Link Width (rear)	F	418mm	472mm	430mm
Front Pin Diameter	G	100mm	110mm	110mm
Rear Pin Diameter	H	100mm	110mm	100mm
Cutting Edge Thickness		50mm	60mm	60mm
Cutting Edge Shape		Stepped	Stepped	Stepped
Bucket Teeth		MTG MA50 (x5)	MTG MA60 (x5)	MTG MA60 (x5)
Side Protectors		Yes	Yes	Yes
Lip Protectors		Yes	Yes	Yes
Heel Shrouds		Yes	Yes	Yes
Wear Strips Inside		Yes	Yes	Yes
Wear Strips Underside		Yes	Yes	Yes
Mounting Pins fitted		Yes	Yes	Yes
Bucket Weight (approx)		1500kg	2500kg	2700kg

The Bucket fitment specifications and pin sizes can be modified to suit various machine models.



Want to move mountains?

GET A HEAVY DUTY, HIGH QUALITY WEST-TRAK BULK BUCKET ON YOUR EXCAVATORS & SHIFT MORE SOIL!

We import and stock a large range of Bulk Cleaning Buckets in a range of widths and capacities to suit most makes and models of Excavators from 20-50 tonne size.

Our Bulk Buckets are designed to withstand the most extreme digging conditions and built with the hardest and toughest wear steels. Our Buckets are fitted with a G500 reversible bolt-on Cutting Edge, G450 underside wear strips and 2x mild steel pins.

We can fit teeth and extra wear protection to them if required. All Buckets have a 12 month/2000hr structural warranty for your peace of mind.

Get more done and move more mountains with a stronger West-Trak Bulk Bucket on your machine today!

EXCAVATOR BULK BUCKETS

A large range of Bulk Cleaning Buckets are available to suit most makes & models of Excavators. Images shown are indicative only & may not represent the final design.

16-23 Tonne Bulk Cleaning Bucket

- 1.2m³ SAE heaped capacity
- 2000mm wide
- 80mm pins fitted
- Bolt-on Cutting Edge fitted
- Underside wear strips fitted
- Part No. TBA-21.20N-NSF1

Pins can be modified to suit different fitments.

24-30 Tonne Bulk Cleaning Bucket

- 1.7m³ SAE heaped capacity
- 2100mm wide
- 90mm pins fitted
- Bolt-on Cutting Edge fitted
- Underside wear strips fitted
- Part No. TBA-21.21N-NSF1

Pins can be modified to suit different fitments.

33-40 Tonne Bulk Cleaning Bucket

- 2.2m³ SAE heaped capacity
- 2300mm wide
- 100mm pins fitted
- Bolt-on Cutting Edge fitted
- Underside wear strips fitted
- Part No. TBA-31.23WT-NSF1

Pins can be modified to suit different fitments.

45-55 Tonne Bulk Cleaning Bucket

- 3.0m³ SAE heaped capacity
- 2500mm wide
- 110mm pins fitted
- Bolt-on Cutting Edge fitted
- Underside wear strips fitted
- Part No. TBA-51.25-SEV2

Pins can be modified to suit different fitments.

Half-arrow bolt-on Cutting Edge option for longer wear life

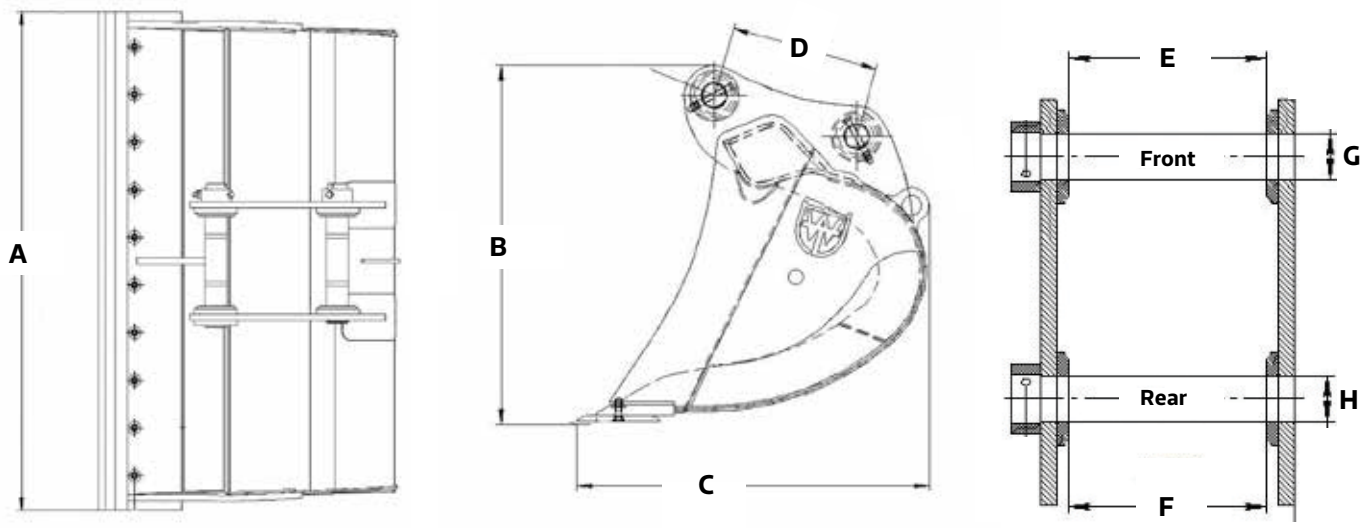
Adapters & teeth can be fitted for extra penetration

EXCAVATOR BULK BUCKETS

Size chart for stock Buckets

Excavator Size		16-23 tonne	24-30 tonne	33-40 tonne	45-55 tonne
Bucket Part No		TBA-21.20N-NSF1	TBA-21.21N-NSF1	TBA-31.23N-NSF1	TBA-51.25-SEV2
Bucket Capacity (SAE)		1.2m3	1.7m3	2.2m3	3.0m3
Bucket Width	A	2000mm	2100mm	2300mm	2500mm
Bucket Height	B	1154mm	1267mm	1417mm	1580mm
Bucket Depth	C	1191mm	1253mm	1392mm	1555mm
Pin Centres	D	475mm	475mm	585mm	575mm
Dipper Width (front)	E	307mm	410mm	418mm	474mm
Power Link Width (rear)	F	307mm	410mm	418mm	474mm
Front Pin Diameter	G	80mm	90mm	100mm	110mm
Rear Pin Diameter	H	80mm	90mm	100mm	110mm
Bolt-on Cutting Edge fitted		Yes	Yes	Yes	Yes
Wear Strips on Underside		Yes	Yes	Yes	Yes
Mounting Pins fitted		Yes	Yes	Yes	Yes
Bucket Weight (approx)		750kg	840kg	1600kg	2600kg

The Bucket fitment specifications and pin sizes can be modified to suit various machine models.



QUALITY ASSURANCE

Bucket quality and structural strength depends not only on the materials and components used, but also on the correct Bucket manufacturing processes. The through-hardened and high tensile steels used for Bucket manufacturing are very sensitive to the welding process. The key points of a proper welding process include:

- **Proper preheating & welding temperature controls**
- **Correct post heating to relieve residual stresses in the steel & welds**
- **Slow, controlled cooling techniques**
- **Proper weld preps on the joining areas**
- **Correct welding wire & weld application techniques**
- **Correct weld finishing in high stress areas**

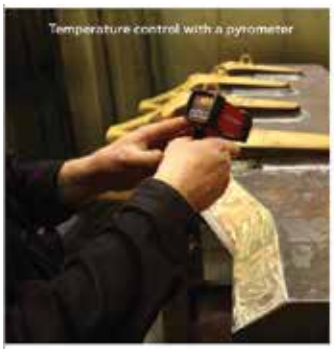
Proper welding temperature control is very important for retention of wear-resisting properties of the steel and strength of the welds. The main reasons that cause loss of wear-resistant properties in the steel and cracks in the weld joints, propagating into the welded material include;

- **Welding of cold, non pre-heated steel**
- **Fast cooling of the steel in the weld joint area**
- **Violation of recommended welding procedures**
- **Incorrect weld preps on the joining areas**
- **Incorrect or no weld toe finishing**

To avoid such situations when welding high tensile, wear-resistant steels, it is necessary to observe the following rules:

- **Preheat welding area to optimal work temperatures, considering the steel grade and thickness (check the temperature with a tempilstik or pyrometer)**
- **Maintain the recommended optimum temperature in the weld pool when welding different material integrated in the Bucket**
- **Arrange enclosed warm zone in the welding space to avoid draughts and low ambient air temperatures causing shock cooling of metal in the weld joint area**
- **Use of thick welding blankets to allow slow cooling after welding**

The steel welding process is very arduous, because it is difficult to control the welding temperature. It is necessary to heat the steel, to control the process, and to check the result practically at the same time. All welders should be qualified and have proper certificates permitting them to work with the different steel grades.



Relieving residual stresses in the metal
The Bucket is a complex welded structure made from materials having different thickness, different chemical composition, and physical properties. The more welding operations that are performed, the more stressed the finished product is and the higher probability of cracking in the metal and weld joints. Below are some important tips to consider:

- **Correct welding sequence, direction and termination of weld joints to minimise residual stresses**
- **Mandatory relieving of residual stresses in the weld joints and in the weld adjacent zones through heat-treatment after welding, machining of the weld toe, peening with a pneumatic needle gun, and shot blasting**

Welding materials and equipment
The quality of weld joints depends largely on advanced equipment and welding materials used. Welding shall be performed with a high quality wire (e.g. ESAB) in an atmosphere of shielding gas (argon 82% and carbon dioxide 18%). Welding performed with such equipment and using properly selected welding materials and conditions will significantly improve the weld joint quality and benefits as below;

- **Better filling of the weld**
- **Lower porosity and non-metallic inclusions**
- **Provision of high surface tension and minimum stresses in the weld**
- **Higher stability of the welding process**
- **No crater forming on completion of the weld**
- **Smaller heat-affected zone so there is little workpiece deformation, if any at all**

Warranty
All Buckets are covered by a 12 month/2000 hour structural warranty - refer to our terms and conditions for more details.

Delivering the solutions you need to stay productive

Phone us
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