BUCKETS

ARE YOU DIGGING FOR A NEW BUCKET? GET A TOUGHER & STRONGER WEST-TRAK BUCKET ON THE BUSINESS END OF YOUR MACHINES

Call 0800 654 323 for your Bucket needs!



Issue Date: June 2023



BUCKETS

Boost productivity with a stronger & tougher Bucket on the business end of your machines

"Guaranteed quality & full backup support"

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OVERVIEW

Buckets



Digging for a new Rock Bucket?

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

We import \mathcal{S} stock a large range of high quality, heavy-duty Rock \mathcal{S} Bulk Buckets that survive the toughest quarry \mathcal{S} mining environments in the world.

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

Productivity & performance is a key part of our design process to ensure you get the best Bucket for your needs, with good penetration & fill factor, structural integrity, safe & 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.

On-going 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 onsite 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.

Buckets 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







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 Buckets



What makes a good Bucket?

ITS 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 & fuel burn.

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





PENETRATION

You need the right shape cutting edge & correct tooth configuration, size & 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 & wear resistance.

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

G.E.T & WEAR PACKAGE

Get a safe & reliable tooth system on your Bucket. The MTG Hammerless StarMet system guarantees no loss of teeth, fast & safe change overs and the longest wear rates.

A good Rock Bucket needs a full wear package inside & outside to protect it from wear & tear. Wear is the main cause of cracks and failure of the Bucket parts & 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 & provide trusted advice when things go wrong. West-Trak stand by what we sell & provide exceptional service & 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 & conditions for more details.

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

Buckets 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.

EXCAVATOR ROCK BUCKETS



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 & outside

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



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 | Α | 1210mm | 1320mm | |
| Bucket Height | В | 1405mm | 1555mm | |
| Bucket Depth | С | 1592mm | 1734mm | |
| Pin Centers | D | 475mm | 475mm | |
| Dipper Width (front) | Е | 307mm | 410mm | |
| Power Link Width (rear) | F | 307mm | 410mm | |
| Front Pin Diameter | G | 80mm | 90mm | |
| Rear Pin Diameter | н | 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 & 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 & pin sizes can be modified to suit various machine models.





Buckets

EXCAVATOR BULK BUCKETS



EXCAVATOR BULK BUCKETS

<image>

Want to move mountains?

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

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

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

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

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



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Buckets

Buckets 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



EXCAVATOR BULK BUCKETS



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 on for extra penetration



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 | В | 1154mm | 1267mm | 1417mm | 1580mm |
| Bucket Depth | с | 1191mm | 1253mm | 1392mm | 1555mm |
| Pin Centres | D | 475mm | 475mm | 585mm | 575mm |
| Dipper Width (front) | Е | 307mm | 410mm | 418mm | 474mm |
| Power Link Width (rear) | F | 307mm | 410mm | 418mm | 474mm |
| Front Pin Diameter | G | 80mm | 90mm | 100mm | 110mm |
| Rear Pin Diameter | н | 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 & pin sizes can be modified to suit various machine models.









Buckets QUALITY ASSURANCE

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

- 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 & cracks in the weld joints, propagating into the welded material include;

- Welding of cold, not 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:

- Pre-heat 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 ensure.

- Correct welding sequence, direction and termination of weld joints to minimize 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 on 0800 654 323



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Visit our Website www.west-trak.co.nz



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Call 0800 654 323 for your Bucket needs!

