



# TALON

## Document Version Control

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# LOCKJAW INSERT GUIDE AND INSTALLATION



Talon have developed easy to change Lock Cavity Inserts to improve the life in service of the Cast Corners and Bosses. Inserts are a simple "push fit" design requiring no welding.

Inserts come in two version:

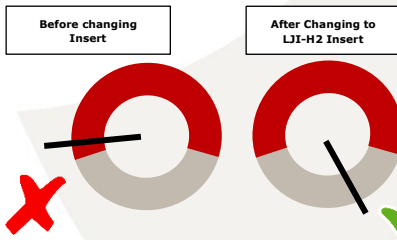
**LJH-I** – Standard Insert "H" Series (Gold)

**LJH-I2** – Oversize Insert "H" Series (Silver)



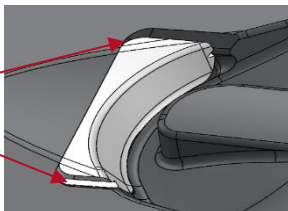
Locks rotating past the seven o'clock position should be changed with the Red **LJH-I2** Oversize Insert.

For normal replacement with locks in good position Standard **LJH-I** Inserts can be used



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CUT OUR GROOVES ON  
EITHER SIDE FOR LEVERAGE  
TO REMOVE



To remove the Insert use the lever points. Once removed Insert cavity should be cleaned and then new Insert can be installed. Correctly maintaining Inserts in your Cast Corners and Bosses will enable maximum life from these parts and reduce the requirement to change weld on components of the Talon Lockjaw Lip Assembly

### IMPORTANT NOTES PRIOR TO INSTALLATION OF BOSSES AND CAST CORNERS

1. Remove Lock Cavity Insert prior to commencing any welding processes.
2. Store Lock Cavity Insert in a safe location during Boss/Cast Corner welding installation.
3. Prior to any welding process pre-heat the Boss and Lip Plate to **150°C (300°F)**.
4. Following completion of Boss/Cast Corner welding must cool down **below 80°C (176°F)** before fitting the Lock Cavity Insert back in to the Boss.
5. If the Lock Cavity Insert is **NOT** a push fit. Use a Loctite or equivalent metal bonding product to retain the Insert within the Boss.
6. The Lock Cavity Insert is a replaceable item please contact your nearest Talon dealer for details.