The bucket’s tooth system is exposed to extreme stresses when it encounters a combination of hard materials, shocks and high breakout forces. In that environment it’s impossible to eliminate wear – but it is possible to reduce the effect it has on the tooth system. The great challenge is designing a tooth system that is optimized for the forces and wear to which it is exposed. Such a tooth system gives optimum service life with maintained performance. Volvo has faced that challenge and succeeded. Discover the difference.

**Success is built from the ground up**
It is important that the tooth system is engineered correctly and that it has the right design to give optimized efficiency and the longest possible wear life. Volvo tooth system is another result of Volvo’s commitment to innovation and development. The tooth system has undergone extensive field testing in various types of materials and applications to analyze and to ensure its high quality and good characteristics. It has shown several advantages, for example:

- The teeth have a self-sharpening design which gives them long-lasting good penetration capability and high productivity.
- Strategically placed wear material in the tooth design provides maximum wear life.
- The correct fit between the tooth and adapter, as well as large stabilizing surfaces, provides a very strong unit which can withstand high tolerance from forces and stresses.
- High-quality steel alloy increases wear resistance.
- A vertical patented locking device makes mounting and removing fast and easy.

**High quality**
When choosing steel, there is no compromising. Volvo’s teeth have the right balance between hardness and high tension steel, which is the key to quality and long wear life. The teeth consist of a specifically designed steel alloy, with a hardness of approx. 500 Brinell, dependant on the type and size of the tooth. From the selection of raw materials for the molten steel to blasting and heat treatment of the finished teeth, continuous checks and measurements are performed to avoid any deviations with regards to steel quality, technical specifications and the fit of the tooth and adapter.

**Wide product range**
In the Volvo Tooth System range, there are teeth and adapters for all types of applications, from handling easily broken bank materials to breaking out hard and rocky materials, such as shot rock. The adapters are developed to fit new Volvo buckets, as well as accommodate bucket rebuilds for older machines from Volvo Construction Equipment. For instructions about welding on different types of adapters on buckets, contact your nearest Volvo Construction Equipment dealer.

**Total operating economy is the key**
Design and material selection make Volvo tooth system the obvious choice for all applications.

**Better penetration capability gives:**
- better and faster bucket filling
- less wear of bucket, machine and tires
- lower fuel consumption

**Long service life due to:**
- strategically placed wear material
- High-quality steel alloy
- self-sharpening design
- correct fit between adapter and tooth

**Shorter downtime when changing gives:**
- lower maintenance costs
- increased productivity

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**VOLVO TOOTH SYSTEM – DISCOVER THE DIFFERENCE**
The powerful patented tooth system from Volvo

Distribution of forces
Volvo tooth system has a longer distance between A and B compared to other systems. When the tooth is exposed to shocks and forces from the side or vertically (F), the reactive forces (R1 and R2) are lower compared to other systems in identical working conditions. The “tooth box”, meaning the connection between the tooth and the adapter, provides optimal absorption of the stresses to which it is exposed.

Better resistance to forces
The edge of the adapters and teeth have an acute angle, less than 90 degrees. This gives better resistance to frontal forces and reduces the risk of the “tooth box” opening.

Self-sharpening teeth
Due to their profile, the teeth have a small penetration area, which gives reduced penetration force. This provides better bucket fill factor, lower fuel consumption as well as reduced wear on bucket, machine and tires. The self-sharpening design and strategically placed wear material give maximum wear life with maintained performance.
The powerful PATENTED tooth system from Volvo

Segments between teeth (for wheel loaders)

You get a number of advantages with segments between the teeth. They give:

• Up to five times longer service life for the cutting edge than without protection between the teeth.
• Protection of the bucket floor.
• Longer adapter service life.
• Prevent uneven wear of the cutting edge.

Robust design

Reinforced area that protects the adapter and the tooth’s guide lugs from early wear.

Locking device

The unique positive locking device integrates the locking pin completely in the adapter body. Position and design give complete protection. The locking device consists of two components: one reusable steel pin as well as an elastic and flexible lock retainer. The design of the tooth and adapter gives a smooth transfer of forces, without the locking device having to absorb the stresses, resulting in a locking device with significantly longer service life.

Two parts, one unit

A perfect fit between the tooth and adapter, together with large stabilizing surfaces, provides a very strong unit with minimal internal wear. Stresses are reduced due to minimum movement between the tooth and adapter.
## Guide tables Volvo tooth system for skidsteer loaders

<table>
<thead>
<tr>
<th>Machine model</th>
<th>Volvo Part No</th>
<th>Description</th>
<th>Designation</th>
<th>Type/application</th>
<th>Weight kg</th>
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<tbody>
<tr>
<td>Volvo MC60/B-110/B</td>
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## Guide tables Volvo tooth system for compact wheel loaders

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## Guide tables Volvo tooth system for backhoe loaders

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*) Locking device complete consists of pin and retainer.

Note: Volvo Tooth System will also fit older machines from Volvo Construction Equipment.
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*) Locking device complete consists of pin and retainer

Note: Volvo Tooth System will also fit older machines from Volvo Construction Equipment.
## Guide tables Volvo tooth system for wheel loaders

<table>
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<tr>
<th>Machine model</th>
<th>Volvo Part No</th>
<th>Description</th>
<th>Designation</th>
<th>Type/application</th>
<th>Weight kg</th>
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Note: Volvo Tooth System will also fit older machines from Volvo Construction Equipment.
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*) Locking device complete consists of pin and standard retainer. Note: Volvo Tooth System will also fit older machines from Volvo Construction Equipment.
Teeth and adapters for loader buckets

**GPC/GPL** General purpose tooth that gives the bottom of the bucket a smooth and clean profile. Self-sharpening.

**AML** Tooth for abrasive material handling and where extra penetration is required. Undercuts slightly to give the cutting edge optimum protection. Self-sharpening.

**AMXL** Tooth for abrasive material handling with extra large bottom surface on the wear shoe. Provides good penetration capacity in combination with long service life. Undercuts slightly to give the cutting edge optimum protection. Self-sharpening.

**AMRL** Tooth for highly abrasive material and rock handling with a focus on long service life. Undercuts slightly to give the cutting edge optimum protection. Self-sharpening.

**FC** Flush-mounted weld-on adapter for loader and planing (leveling) buckets. Gives the bottom of the bucket a smooth and clean profile. Commonly combined with GPC/GPL tooth and NOT in combination with segments.

**TL** 1½ top leg adapter (long top leg), for welding to both sides of the cutting edge. Should be used in heavy duty applications.

**BN** Two leg adapter bolted to the bucket edge. Gives the cutting edge optimum protection. Should NOT be used in heavy duty applications.

**CR** Bolt-on corner adapters protect the bucket corners.

**FCB** One leg adapter bolted to the bucket edge. Gives the bottom of the bucket a smooth and clean profile.

**MB** Monoblock tooth. Tooth and adapter in one piece.

**BPL** Bolt-on cast segments protect the bucket edge between the points. **IMPORTANT:** We recommend using segments together with 1½ leg adapters or bolt-on adapters, but **NEVER** with flush-mounted adapters.

**T** Tool for easy mounting and removal of locking devices.

**P** Locking device for tooth and adapter consists of a lock retainer and a reusable steel pin. When it’s time to change adapter, it’s also suitable to change the complete locking device.

**MR** Heavy duty retainer in steel/polyurethane for work in very wet fine-grained clay and coal handling.

**PHS** Steel locking for hot slag applications. Consists of a reusable steel pin, a steel retainer and two springs.

### DESIGNATIONS

**Example: tooth for a wheel loader.**

15 GP L

15 = size of tooth.  
GP = type of tooth. In this case, General Purpose.  
L = Loader.

**Example: adapter for a wheel loader.**

LA 20 FC 40

LA = Loader adapter.  
20 = size of adapter.  
FC = type of adapter. In this case, flush-mounted.  
40 = thickness of bucket cutting edge.

**IMPORTANT:** If the machine operates in varying conditions, it is important to size the teeth for the heaviest applications. In extremely demanding applications, it may be appropriate to select a larger point size than that which is specified. Contact your Volvo dealer for further information.
# Teeth and adapters for loader buckets

## GPC/GPL Teeth

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## AML Teeth

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## BN Bolt-On Adapters

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# Teeth and adapters for loader buckets

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*) Locking device complete consists of pin and standard retainer.

## Locking Devices, Hot Slag

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*) Locking device complete consists of pin, retainer and two springs.

**) Retainer complete consists of retainer and two springs.

## Segments

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## Tools for Mounting and Removal

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## MB Monoblock Tooth

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Dimensions and weights are approximate.
Teeth and adapters for excavator buckets

**GPC/GPE** General purpose tooth with good penetration and long service life. Self-sharpening.

**AMRE** Tooth with extra wear metal and longer service life intended for rock and abrasive material. Self-sharpening.

**PPC/PPE** Pick point tooth for work in extremely compact material. Maximum penetration capability in hard clay, frozen ground etc. Can be used in combination with TPC/TPE.

**TPC/TPE** Twin pick point tooth for work in extremely compact material. Maximum penetration capability in hard clay, frozen ground etc. Can be used in combination with PPC/PPE.

**SNC/SNE** Spade nose tooth for levelling, cleaning, grading and backfilling.

**BL** 1 ½ bottom leg adapter (long bottom leg), for welding to both sides of the cutting edge.

**BLX** Bottom leg adapter with extra long top leg for welding to both sides of the cutting edge. Long bottom leg.

**BLW** Bottom leg adapter for wear cap with extra long top leg for welding to both sides of the cutting edge. Long bottom leg.

**BLU** Weld-on bottom leg universal adapter.

**W** Wear cap protects the adapter from unnecessary wear.

**MB** Monoblock tooth. Tooth and adapter in one piece.

**P** Locking device for tooth and adapter consists of a lock retainer and a reusable steel pin. When it’s time to change adapter, it’s also suitable to change the complete locking device.

**MR** Heavy duty retainer in steel/polyurethane for work in very wet fine-grained clay and coal handling.

**PHS** Steel locking for hot slag applications. Consists of a reusable steel pin, a steel retainer and two springs.

**DESIGNATIONS**

**Example: tooth for an excavator.**

15 GP E

15 = size of tooth.

GP = type of tooth. In this case, General Purpose.

E = excavator.

**Example: adapter for an excavator.**

EA 20 BL 40

EA = excavator adapter.

20 = size of adapter.

BL = type of adapter. In this case, bottom leg 1 ½ (long bottom leg).

40 = thickness of bucket cutting edge.

**IMPORTANT!** If the machine operates in varying conditions, it is important to size the teeth for the heaviest applications. In extremely demanding applications it may be appropriate to select a larger point size than that which is specified. Contact your Volvo dealer for further information.
# Teeth and adapters for excavator buckets

## GPC/GPE Teeth

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<thead>
<tr>
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## AMRE Teeth

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## PPC/PPE Teeth

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## SNC/SNE Teeth

<table>
<thead>
<tr>
<th>Designation</th>
<th>Volvo Part No</th>
<th>A mm</th>
<th>B mm</th>
<th>C mm</th>
<th>D mm</th>
<th>Weight kg</th>
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<tr>
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## BL Bottom Leg 1 1/2 (Long Bottom Leg) Adapters

<table>
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<tr>
<th>Designation</th>
<th>Volvo Part No</th>
<th>Cutting Edge Thickness mm</th>
<th>Cutting Edge Angle °</th>
<th>A mm</th>
<th>B mm</th>
<th>Weight kg</th>
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<td>393</td>
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<td>EA55BLX50</td>
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# Teeth and adapters for excavator buckets

## BLU BOTTOM LEG UNIVERSAL ADAPTERS

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<thead>
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<th>Designation</th>
<th>Volvo Part No</th>
<th>Cutting Edge Thickness mm</th>
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<th>Weight kg</th>
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## BLX EXTRA LONG TOP LEG ADAPTERS

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<th>Volvo Part No</th>
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<th>B mm</th>
<th>Weight kg</th>
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<tbody>
<tr>
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## BLW EXTRA LONG TOP LEG ADAPTERS FOR WEAR CAP

<table>
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<th>Volvo Part No</th>
<th>Cutting Edge Thickness mm</th>
<th>Cutting Edge Angle °</th>
<th>A mm</th>
<th>B mm</th>
<th>Weight kg</th>
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## W WEAR CAPS

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## LOCKING DEVICES

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<tr>
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<th>Length (L) mm</th>
<th>Weight kg</th>
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<tbody>
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<td>VOE 15603422</td>
<td>Locking device, complete*)</td>
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<tr>
<td>5/8R</td>
<td>VOE 15603429</td>
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<td>VOE 11417145</td>
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<td>15/20MR</td>
<td>VOE 11716119</td>
<td>Retainer, heavy duty</td>
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<tr>
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<td>VOE 11417146</td>
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<td>20/20MR</td>
<td>VOE 11716119</td>
<td>Retainer, heavy duty</td>
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<td>–</td>
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<td>VOE 11417147</td>
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<td>Retainer, standard</td>
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<td>Retainer, heavy duty</td>
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<td>Retainer, standard</td>
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<td>55/65MR</td>
<td>VOE 11716121</td>
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<td>77</td>
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<td>20MR</td>
<td>VOE 11716122</td>
<td>Retainer, heavy duty</td>
<td>77</td>
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</table>

*) Locking device complete consists of pin and standard retainer.
### Teeth and adapters for excavator buckets

#### Locking Devices, Hot Slag

<table>
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<tr>
<th>Designation</th>
<th>Volvo Part No</th>
<th>Description</th>
<th>Length (L) mm</th>
<th>Weight kg</th>
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</thead>
<tbody>
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<td>Locking device, complete*)</td>
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<td>30/40MRS</td>
<td>VOE 15002854</td>
<td>Retainer, complete, hot slag**)</td>
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<td>0.03</td>
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<td>55PHS</td>
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<td>VOE 15002939</td>
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<td>55/65MRS</td>
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</table>

*) Locking device complete consists of pin, retainer and two springs.

**) Retainer complete consists of retainer and two springs.

#### Tools for Mounting and Removal

<table>
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<tr>
<th>Designation</th>
<th>Volvo Part No</th>
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<th>Weight kg</th>
<th>For tooth size</th>
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<td>VOE 15120568</td>
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<td>65/125T</td>
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</table>

#### MB Monoblock Tooth

<table>
<thead>
<tr>
<th>Designation</th>
<th>Volvo Part No</th>
<th>Cutting Edge Thickness mm</th>
<th>Cutting Edge Angle °</th>
<th>A mm</th>
<th>B mm</th>
<th>Weight kg</th>
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<tbody>
<tr>
<td>MB8</td>
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<td>250</td>
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<td>2.4</td>
</tr>
</tbody>
</table>

Dimensions and weights are approximate.
Changing Volvo teeth

1. Before you start

1. Use a hammer, weight approx. 1 kilo, and protective gear: a hard hat, protective glasses, gloves and work shoes.

2. To make work easier, Volvo has developed a special tool. It consists of a handle and a head. The head consists of two pins, one shorter and one longer, as well as a striking surface for each pin. The tool is available in different sizes, depending on tooth size.

3. To make tooth mounting easier, angle back the bucket a bit so that the adapters face slightly upwards.

4. Place the tool’s longer pin in the opening for the lock pin. Drive out the lock pin using a hammer, so that the lock retainer is removed from its seat. Drive out the lock pin so that it comes out on the underside. Remove the tooth.

2. Dismantling of teeth

4. Clean the opening for the adapter’s lock pin.

3. Mounting of teeth

6. Thoroughly clean the adapter’s nose and the hole for the lock pin, so that the tooth and lock pin can be fitted in the correct position.

7. Fit the tooth on the adapter’s nose, so that the tooth’s guide lugs fit in the adapter’s slots.

8. Fit the lock pin in the adapter’s nose, so that the arrow on the lock pin faces down and the lock retainer faces forward toward the tip of the tooth. Always use a new lock retainer in the correct size.

9. Check manually that the lock pin has been mounted correctly.

10. Drive down the lock pin using a hammer so that the lock pin is flush with the top of the adapter body.

11. Drive down the lock pin to the correct position with a hammer and the shorter pin on the tool. Use a correctly sized tool.

12. The lock pin is mounted correctly when the mark in the hole is visible just above the lock pin.
Always use genuine Volvo parts. They are the surest way to high machine availability and good operating economy.

Every genuine part is developed and manufactured together with all other machine components. It is a complete system where each separate part works in perfect harmony with the others. Only by using genuine Volvo parts can you be completely sure of keeping the system intact and maintaining the qualities and features Volvo intended from the beginning.

By choosing genuine Volvo parts, you know that your machine will function as intended in the future as well. Down to the smallest detail.

More care. Built in.