



TAG MANUFACTURING INC.

P.O. BOX 23667

6989 DISCOVERY DRIVE

CHATTANOOGA, TN 37422

PHONE: 1-423-893-3345 FAX: 1-423-893-3385

**QUICK LINK HYDRAULIC THUMB
INSTRUCTIONS - GENERIC**

SAFETY

LIVE WITH IT!

READ - Read the installation manual prior to the start of any work. Improper installation could potentially lead to personal injury or property damage.

WEAR - Wear approved and appropriate clothing and eye protection when performing this installation.

SUPPORT - Support any components - of the thumb or base machine - if this installation procedure requires working under them. Use of a crane or other approved support equipment must be used.

RELIEVE - Relieve hydraulic circuit pressure prior to disconnecting any hydraulic lines, hoses, fittings, etc. Escaping high pressure fluids can penetrate the skin causing serious injury. Make sure all hydraulic connections are tight before applying hydraulic pressure.

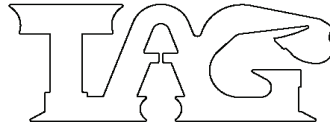
DISCONNECT - Disconnect the battery prior to the start of any work once the machine is in the required position for work to begin. This is especially important before any welding is performed. When disconnecting the battery remove the ground terminal first.

PROTECT - Protect any exposed glass, hydraulic cylinder rods, etc. from weld spatter or sparks by covering with appropriate material.

VERIFY - Verify the accuracy of the installation for fit and function once completed.

REMEMBER - THINK SAFETY FIRST

- Read and understand the installation instructions.
- Wear proper clothing and protective gear.
- Support overhead equipment.
- Relieve high pressure circuits.
- Disconnect the battery.
- Protect vulnerable components.
- Verify fit and function.



QUICK LINK HYDRAULIC THUMB INSTALLATION INSTRUCTIONS

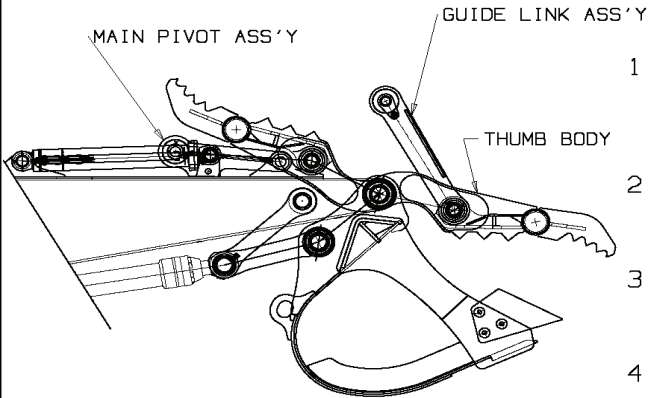


FIGURE 1

1. Look over your parts guide to assure that all the parts are there to properly install your Quick Link Thumb.
2. Install Quick Link Thumb to bucket with your new main pin, align and center thumb with bucket
3. Center the thumb Base Link Assembly onto the underside of the stick with the Main Pivot Link Ass'y in the locked position.
4. With the thumb attached to stick attach Guide Link Ass'y to thumb body and swing thumb back and attach to Main Pivot Ass'y to properly align and to maintain the correct distance for Base Link Ass'y on stick as shown in figure 1.
5. Tack weld Base Link Ass'y as shown in figure 1.
6. Check the alignment of the bucket and thumb by extending the thumb cylinder and curling the bucket into the thumb - Figure 2.
7. After verification of the location of the thumb finish welding the Base Link Ass'y to the stick. Make sure to extend the weld past the end of the bracket by 1"-2" for stress relief. Figure 3.
DO NOT WELD ACROSS THE STICK!

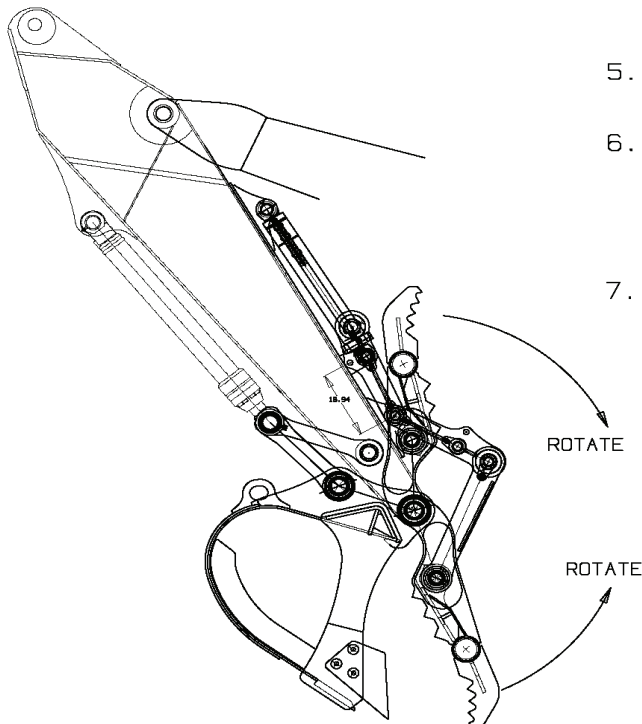


FIGURE 2

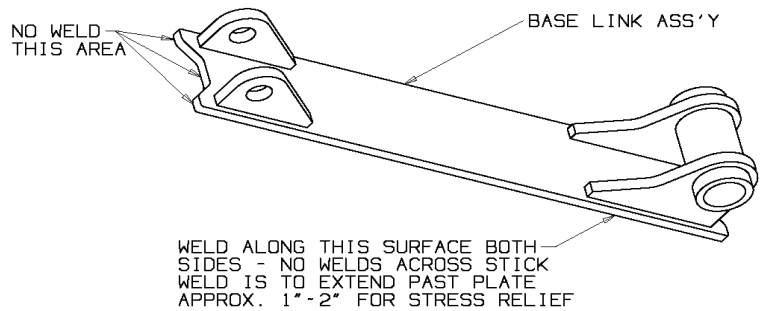


FIGURE 3

Hydraulic Installation Instructions

- Prior to installing the hydraulic components the auxiliary circuit relief pressure needs to be set at approximately **1700psi to 2300psi**. This can be checked with an appropriate rated pressure gauge and changed by adjusting the circuit's pressure relief valve. Consult the operating/maintenance manual for specifics to this procedure.

! Warning Bucket should override thumb so that there isn't any damage to thumb components.

- Prior to removing the plugs from the auxiliary circuit valve blocks located on either side of the stick, make sure that the valve is closed so as not to spill hydraulic fluid.
- Use Teflon tape or other appropriate thread sealant on pipe thread fittings only. No thread sealant is required on any other style threaded connection.
- Install the hydraulic fittings in both cylinder ports and in both valve blocks.
- Connect one end of each jump hose (furnished separately) to the fitting located in each of the valve blocks. Tighten with open end wrench.
- Connect the other end of each hose to the fitting located in the cylinder ports. Use a second open end wrench to hold the crimp fitting on the end of the hose from turning when tightening the hose. This will prevent the hose from twisting.
- With all connections tight start the machine and cycle the thumb slowly to ensure proper hose routing/movement. The hoses should move smoothly and not be in or near any pinch points. Correct hose routing as necessary.