WELD ON THUMB BRACKET KIT INSTRUCTIONS

NOTE: READ MANUAL PRIOR TO START OF WORK

DISCONNECT BATTERY BEFORE WELDING
WELD ON THUMB BRACKET KIT INSTRUCTIONS

Step 1. Prep stick by removing paint by grinding as to have a clean weld area for the bracket weldment.

Step 2. Tack weld support stop at 5" above main bucket pivot. This is a reference starting point and may need to be adjusted.

Step 3. Center bracket weldment onto stick as is rests on the support stop. Ensure that the bracket weldment is flat on the stick plate (may have to use some type of clamping device).

Step 4. Tack weld bracket weldment (secure the bracket weldment but keep in mind it may have to be repositioned). Caution: Tack weld sufficiently as to keep bracket in place when attaching thumb and cylinder.

Step 5. Attach bucket, thumb, thumb cylinder. (no hydraulics)

Step 6. Move stick to cause thumb to be vertical (cylinder fully extended).

Step 7. Curl bucket until it slightly contacts thumb with the bucket's cutting edge.

Step 8. Ensure that the bucket comes into contact with at least one tooth of the thumb to be below the bucket's cutting edge.


Step 10. Swing thumb into stored position to verify clearance with boom.

Step 11. If the bracket weldment is in proper position, remove components and proceed to fully weld the bracket to the stick. If not, cut bracket weldment loose and repeat from step 1 but adjusting the bracket weldment along the stick for proper location. Position lockback rib into slot and weld.

Step 12. Attach the bucket, thumb, thumb cylinder, hoses to establish proper operation of the attachments. At this time it is necessary to adjust Thumb circuit pressure. See thumb manual for specs.

Step 13. Position and install the pin lock plate if necessary.
PREP STICK ON MACHINE AS TO HAVE A CLEAN WELD AREA FOR THE BRACKET WELDMENT
TACK SUPPORT STOP AT SOME POINT ABOVE MAIN PIVOT. STOP SHOULD BE SQUARE TO THE STICK.
Bracket weldment should be centered on the stick and should be as parallel as possible to the stick.

Ensure that the bracket weldment is flat on the stick plate (may have to use some type of clamping devices(s)).
TACK WELD ALONG THIS EDGE ONLY BOTH SIDES

DO NOT WELD ACROSS EITHER END
ATTACH BUCKET, THUMB AND THUMB CYLINDER
MOVE BOOM TO CAUSE THUMB TO BE VERTICAL (FREE SWING)
CURL BUCKET UNTIL IT SLIGHTLY CONTACTS THUMB WITH THE BUCKET'S CUTTING EDGE
STEP 11

IF THE BRACKET WELDMENT IS IN PROPER POSITION PROCEED TO FULLY WELD THE BRACKET ON BOTH SIDES TO THE STICK. IF NOT, CUT THE BRACKET WELDMENT LOOSE AND REPEAT FROM STEP 1 BUT ADJUSTING THE BRACKET WELDMENT ALONG THE STICK FOR PROPER LOCATION.
STEP 12

ATTACH BUCKET, THUMB, THUMB CYLINDER AND HOSES TO ESTABLISH PROPER OPERATION OF THE MACHINE
LOCATE AND INSTALL THE PIN LOCK PLATE