

# **TAG MANUFACTURING INC. INSTALLATION MANUAL**

## **WELD ON THUMB BRACKET KIT INSTRUCTIONS**

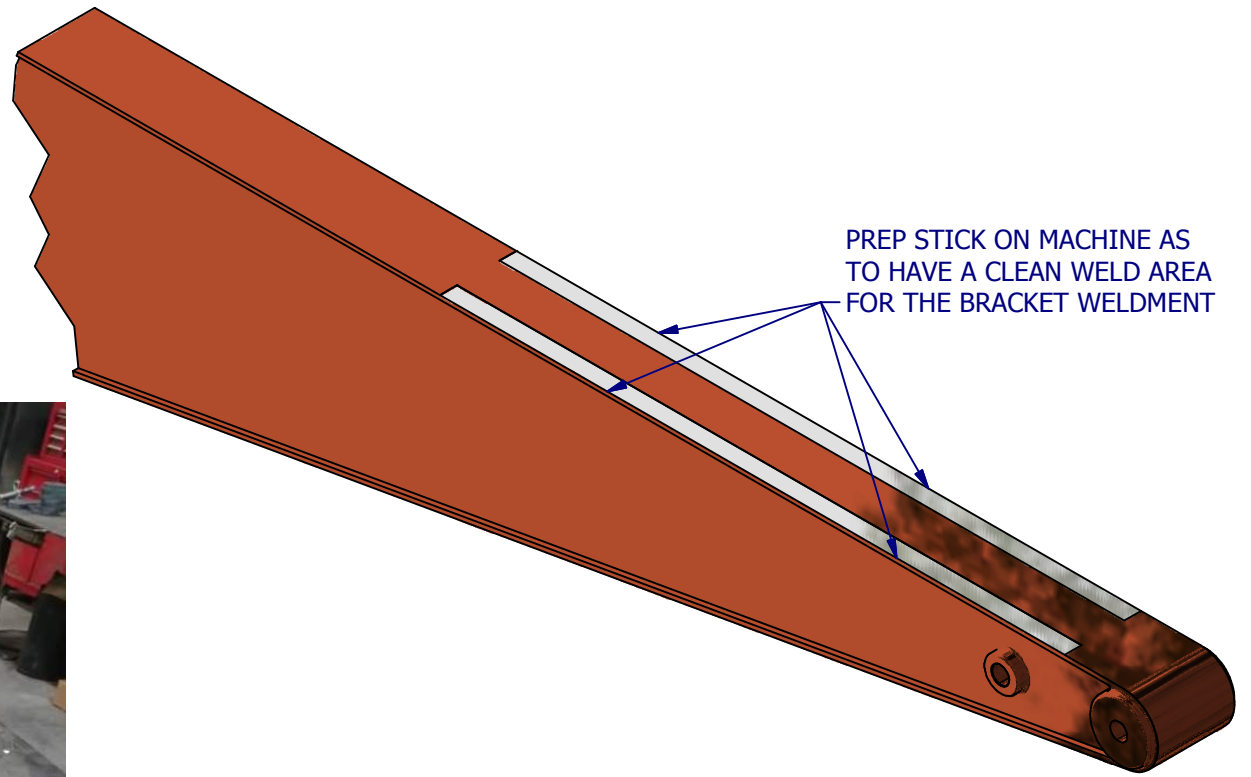
**NOTE: READ MANUAL PRIOR TO START OF WORK**



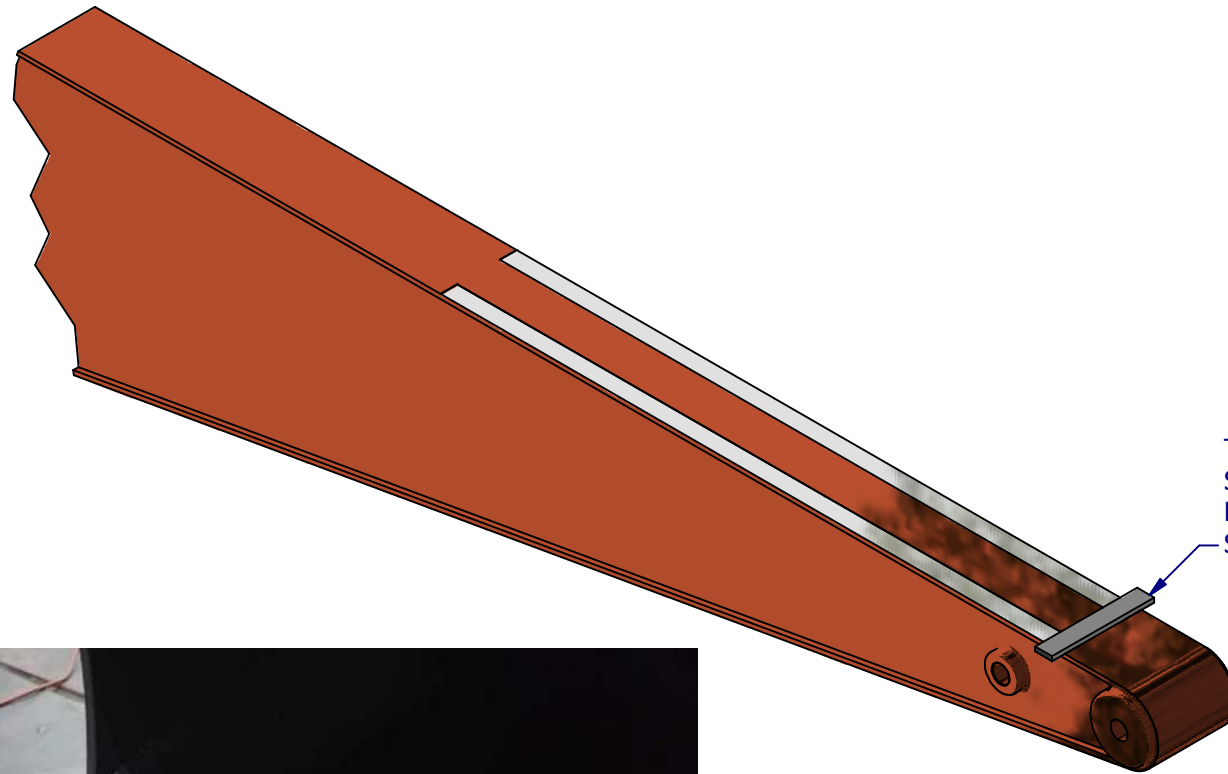
**DISCONNECT BATTERY BEFORE WELDING**

## 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 it 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 9. Pictures for Step 8.
- 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



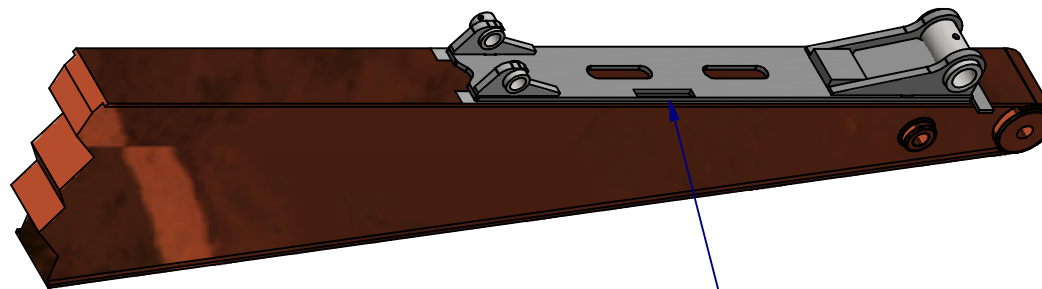
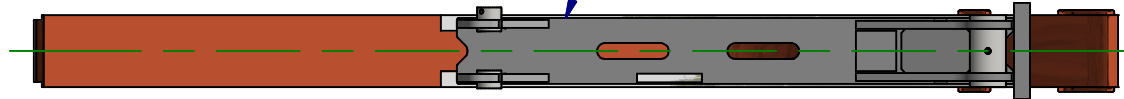
TACK SUPPORT STOP AT  
SOME POINT ABOVE MAIN  
PIVOT. STOP SHOULD BE  
SQUARE TO THE STICK



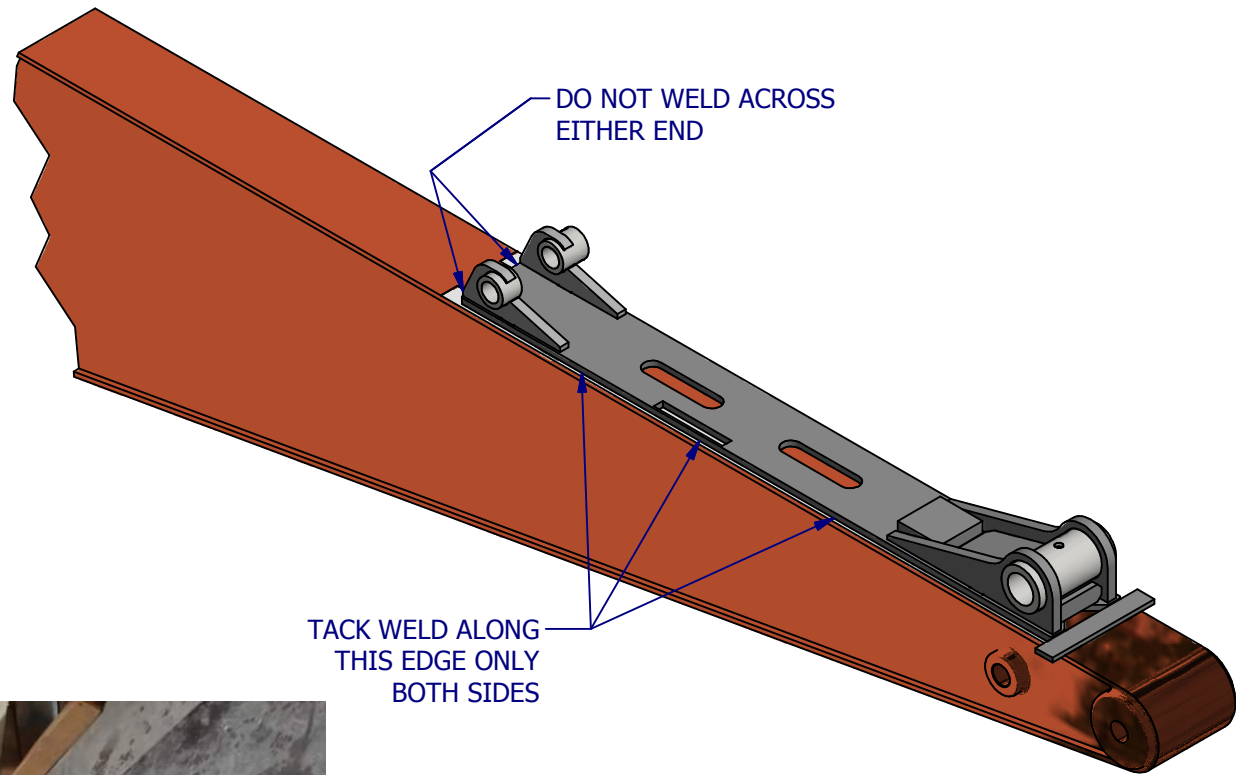
STEP 2

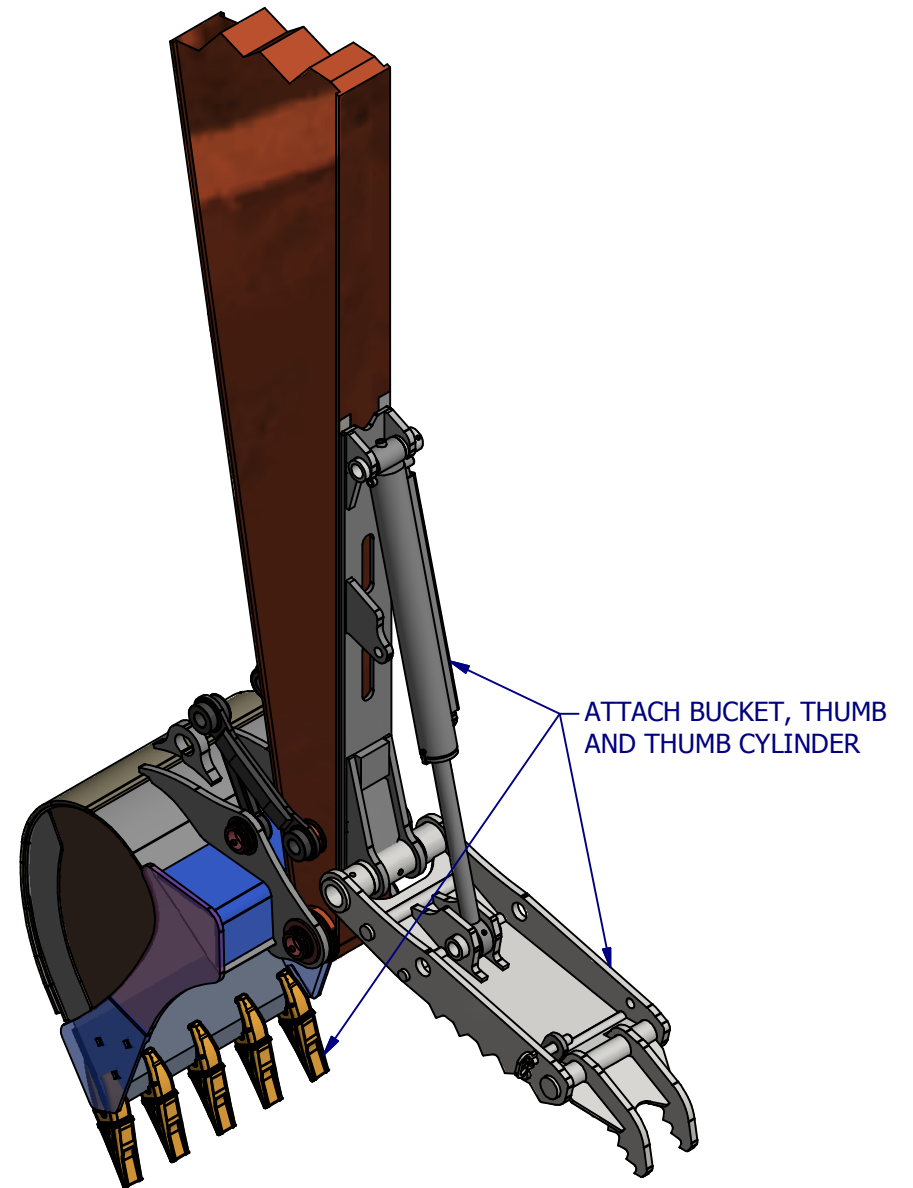


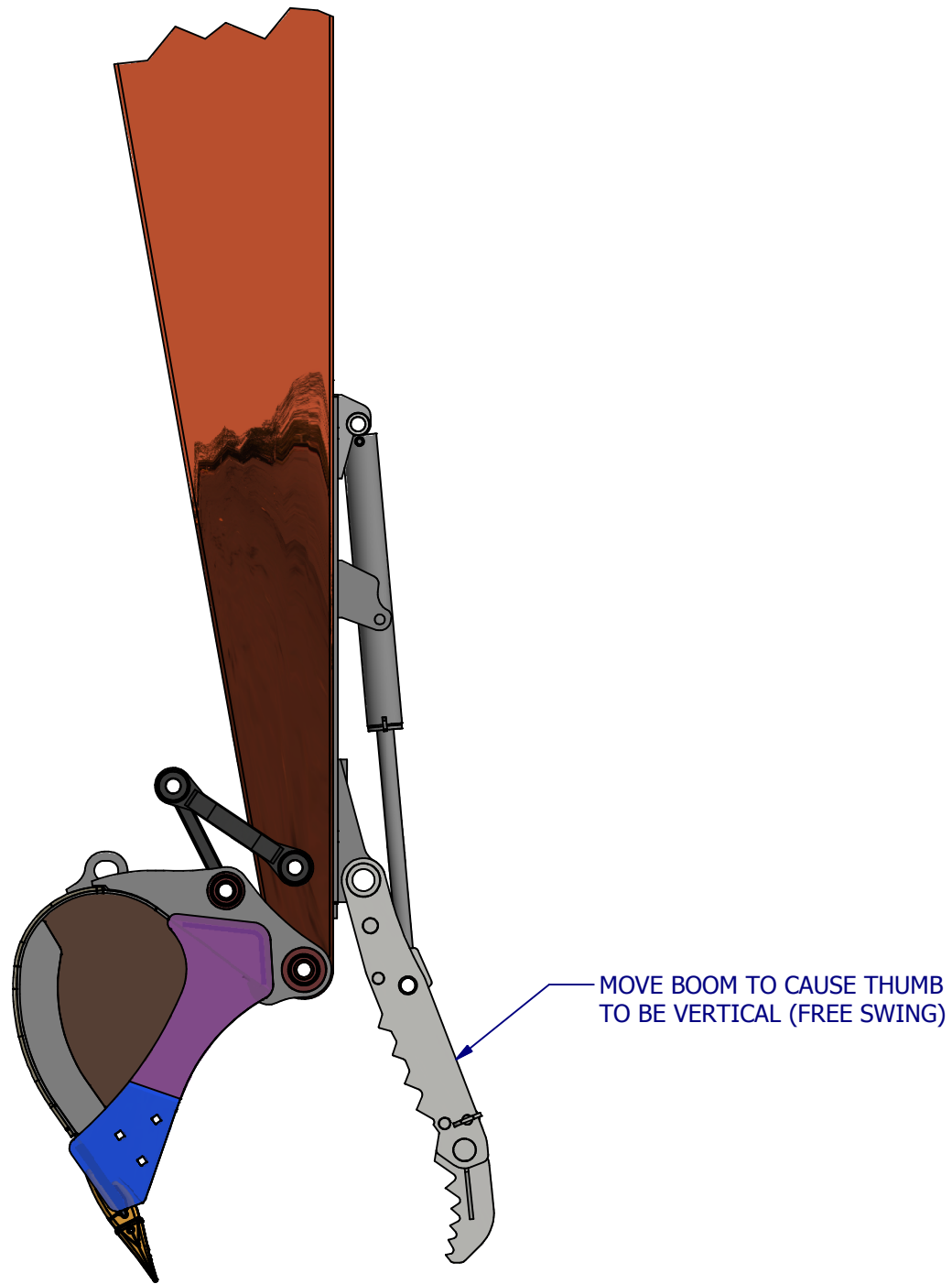
BRACKET WELDMENT SHOULD  
BE CENTERED ON THE STICK  
AND SHOULD BE AS PARALLEL  
AS POSSIBLE TO THE STICK



ENSURE THAT THE BRACKET WELDMENT  
IS FLAT ON THE STICK PLATE (MAY HAVE  
TO USE SOME TYPE OF CLAMPING DEVICES(S))



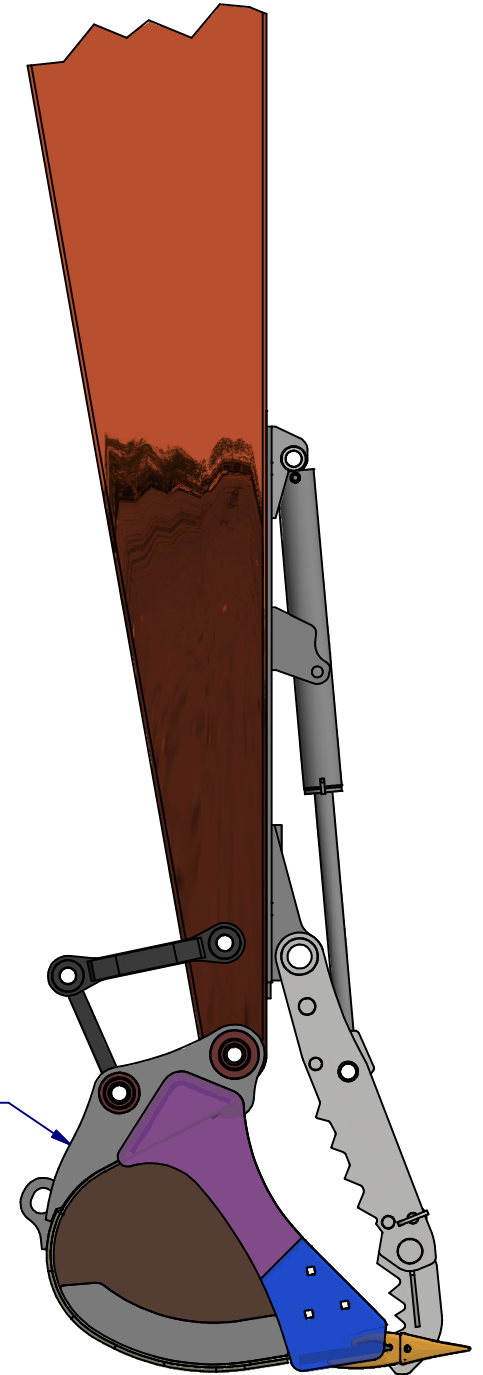


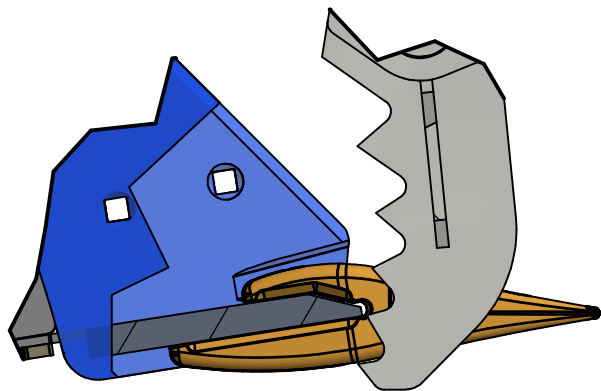






CURL BUCKET UNTIL IT SLIGHTLY  
CONTACTS THUMB WITH THE  
BUCKET'S CUTTING EDGE

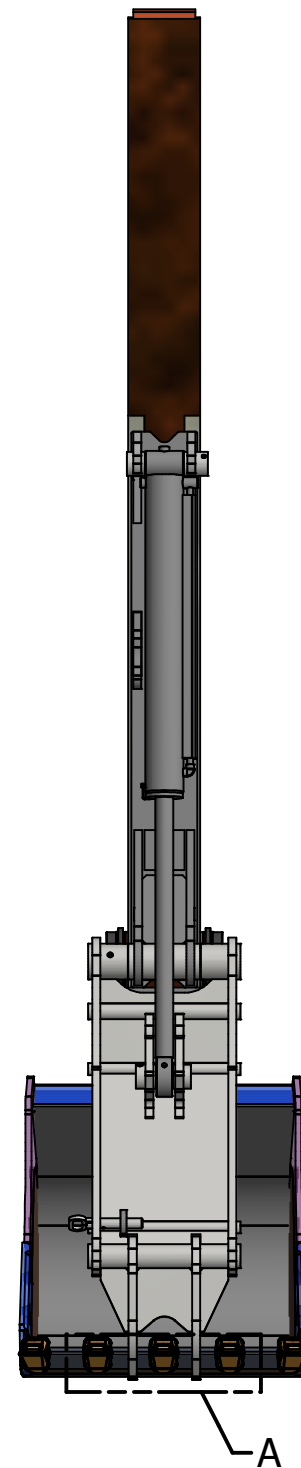
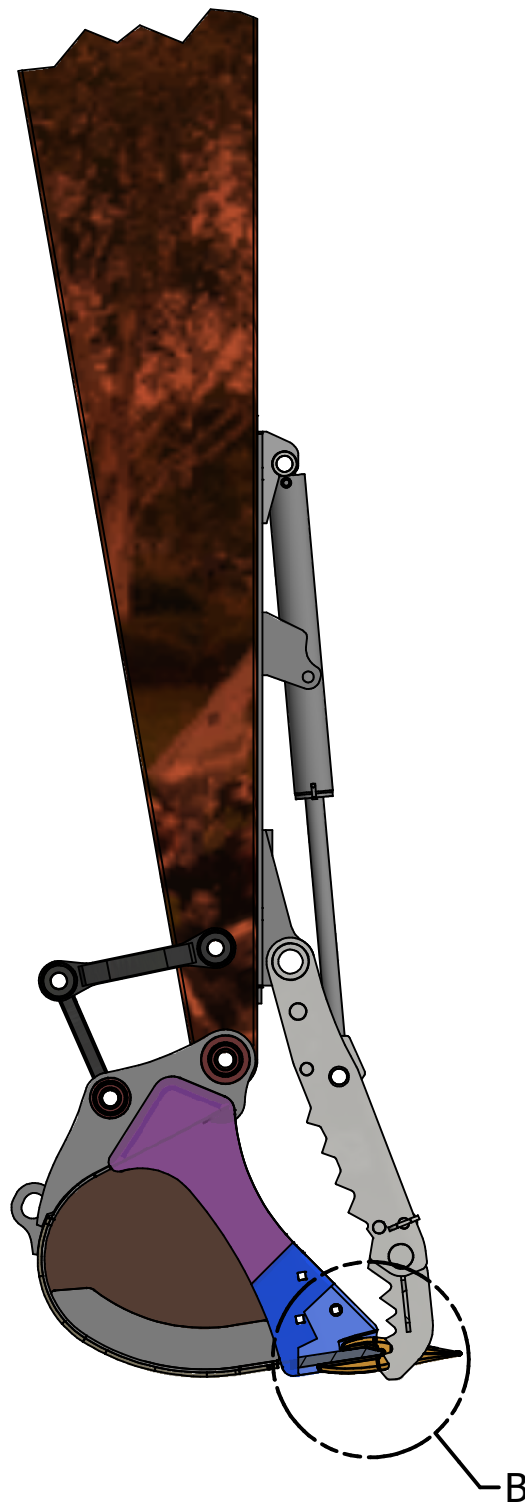




DETAIL B



DETAIL A







PICTURES FOR STEP 8

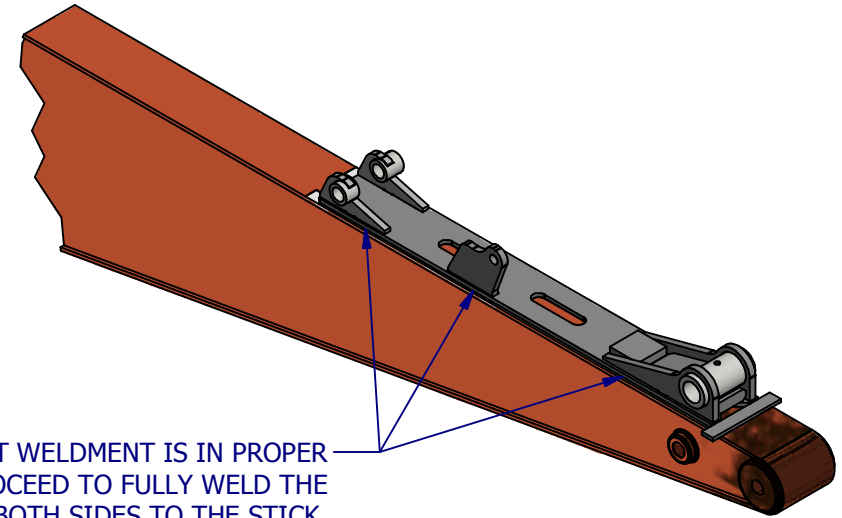


STEP 9

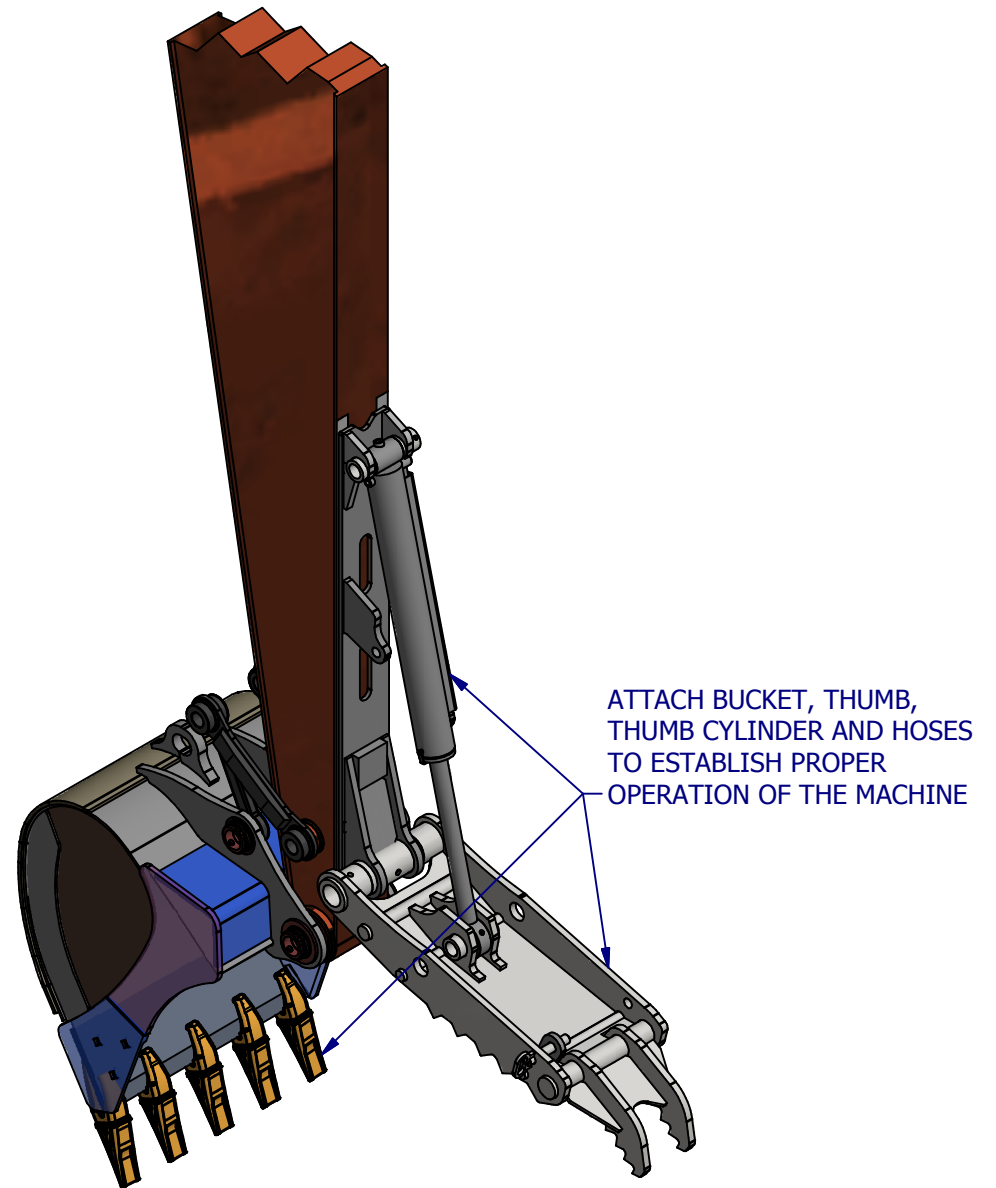








IF THE BRACKET WELDMENT IS IN PROPER POSITION PROCEED TO FULLY WELD THE BRACKET ON BOTH SIDES TO THE STICK. IF NOT, CUT THE BRACKET WELDMENT LOOSE AND REPEAT FROM STEP 1 BUT ADJUSTING THE BRACKET WELDMENT ALONG THE STICK FOR PROPER LOCATION.







LOCATE AND INSTALL  
THE PIN LOCK PLATE

STEP 13