



MANUAL & HYDRAULIC STICK MOUNT THUMB

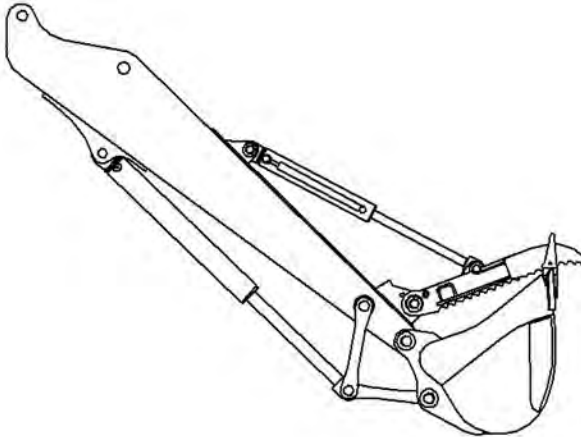


FIGURE 1

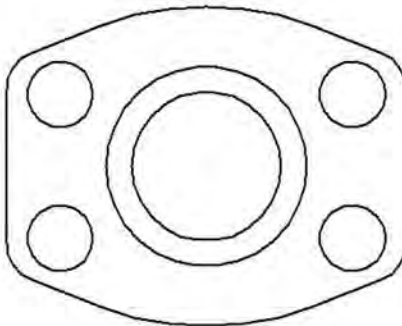


FIGURE 2

1. Fold stick under boom so the stick is flat as possible to ensure an easy work surface.
2. Curl bucket into the stick as the bucket would be positioned to use a thumb.
3. Prep surface of the stick. Remove paint to ensure a clean surface for welding.
4. Mark where the edges of the base plate should be placed. Long straight lines on each side work the best. This allows for a smoother install. Remember that the base plate will be centered on the stick.
5. Place assembled hydraulic stick mount thumb on the stick.
6. Extend the cylinder to its max extended length. Both ports on the cylinder can be loosened and the thumb can be rotated forward.
7. Thumb should touch the bucket as pictured in Figure 1. Normally the thumb tines will interlace with the bucket teeth.
8. Once positioned, slide the base plate up the stick to leave about a ½ inch gap between the curled buckets and the extended thumb. Tack base plate in place with several large tacks.
9. Double check the install to this point. The base plate should be center on the stick. The tines on the thumb should interlace with the teeth on the bucket. (In most applications.)
10. Install hydraulic lines to the cylinder. These are code 61 flange fittings for our cylinder with part number 319-063. See figure 2 for reference.
11. Check hydraulic pressure before operating the thumb. Max relief pressure should be 2500 PSI.
12. Rotate thumb to its fold up position as pictured in figured 3. Note that the thumb could hit the boom with the stick being folded up. You may have to give a little clearance to rotate thumb back. This is normal and why you pay your machine operators good money to not hit the boom with the thumb.
13. With thumb folded bring the stick to a max fold up position. Ensure the thumb does not hit the boom. Thumb should clear the boom in the folded-up position.



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NOTE: If there is a thin wearplate on stick, it must be removed.

14. Once satisfied with the thumb position of the thumb on the stick, weld the base plate to the stick. A minimum ½" fillet weld should be placed along the outside edges of the base plate, weld continuous. **MAKE SURE TO HAVE FULL PENETRATION ON STICK AND BASEPLATE.** Weld the inside slots also. See figure 4 for welding reference.

Pre-heat stick in cold weather. Use low hydrogen E7018 or equivalent wire.

15. Paint over weld and stick to ensure no bare metal is showing.

16. Check hydraulic relief pressures on machine. The bucket should be able to push the thumb backwards. The thumb should not be able to push the bucket backwards. This will void warranty.

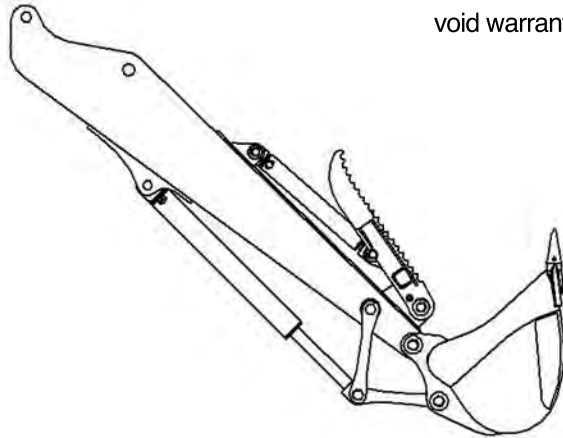


FIGURE 3

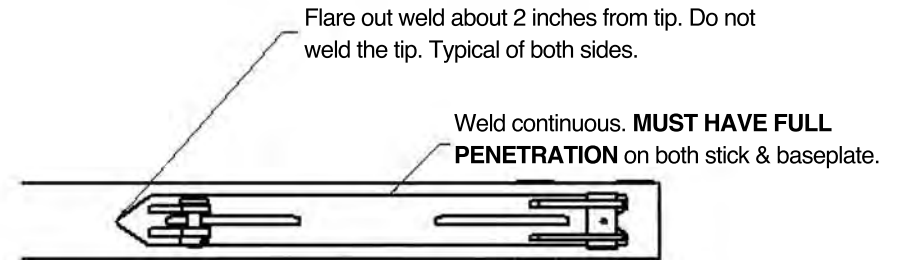


FIGURE 4