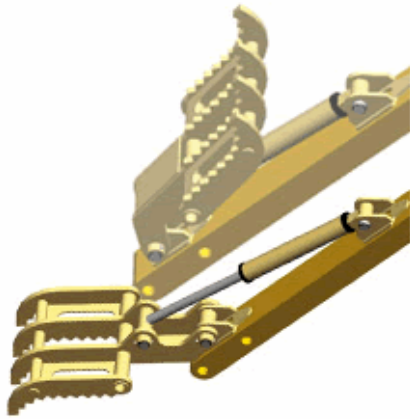


# HYDRAULIC THUMB MOUNTING INSTRUCTIONS



## Installing the Cylinder Base Bracket

- Step1.** Install the cylinder bracket to the dimension shown and tack weld in place. The tack weld to be sufficient to hold the bracket, thumb and cylinder.
- Step2.** Move the thumb to the minimum and maximum cylinder stroke; check that the cylinder is free and that it has no contact that would damage the cylinder.
- Step3.** Finish welding the brackets to the boom using 70-18 electrode.
- Step4.** The thumb is now ready for use.

## Installing the Front Bracket

- Step1.** Position the bucket in full curl and locate the bracket as shown in **Figure A**. Allow 1/2" clearance between the bracket and the bucket. Then clamp or tack weld the bracket in place. The tack weld or clamp to be sufficient to hold the bracket and thumb.
- Step2.** Install the thumb to the bracket.
- Step3.** Check the bracket and thumb position as shown in **Figure B**. The thumb to be Positioned 90° to the flat part of the stick as shown. Bring the bucket and thumb together as shown in **Figure B2**. The thumb must contact the bucket cutting edge or bucket teeth. The bucket must contact the thumb only in this area. When the thumb contacts the bucket in another area the bracket position is to be moved back on the stick to remove the contact area.

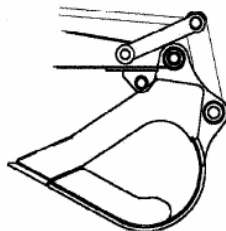
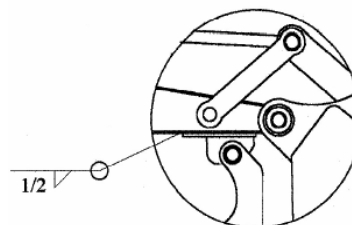


Figure A  
Full Curl



B1 Front Bracket Installation

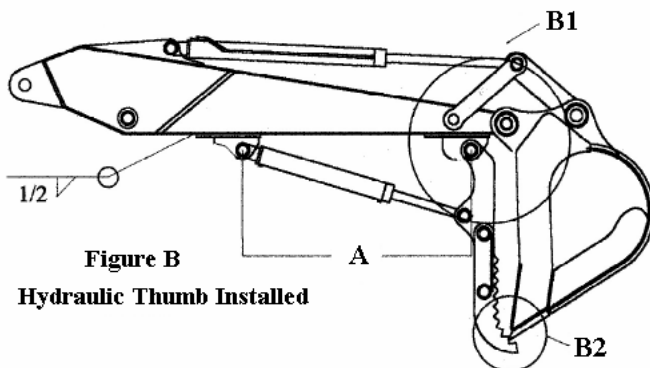


Figure B  
Hydraulic Thumb Installed

Thumb	A Dimension
8x28	29 1/4
8x34	29 1/4
12x35	38 15/16
12x40	38 15/16
12x42	38 15/16
18x46	52 3/4
18x50	52 3/16
18x56	52 3/16
24x53	59 11/16
24x58	59 3/8
30x62	59 3/8
30x67	59 3/8
32x58	59 11/16
32x67	59 11/16
34x63	82 1/4
34x75	82 1/4

Note: If problems occur installing the thumb contact the manufacturer to resolve the problem.



\* Operating pressure **MUST** not exceed 2,500 psi or warranty will be void.