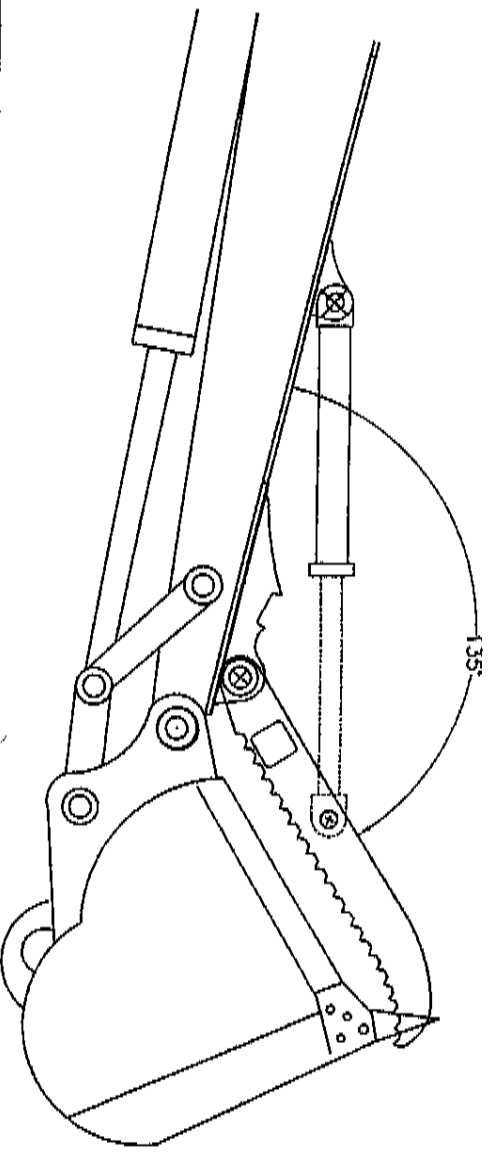
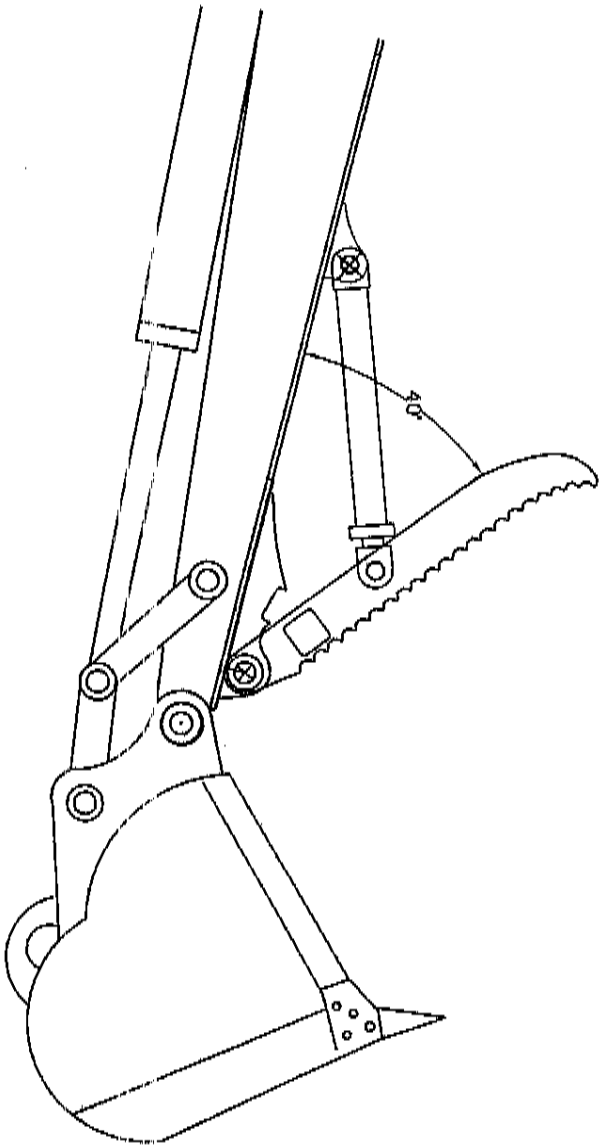


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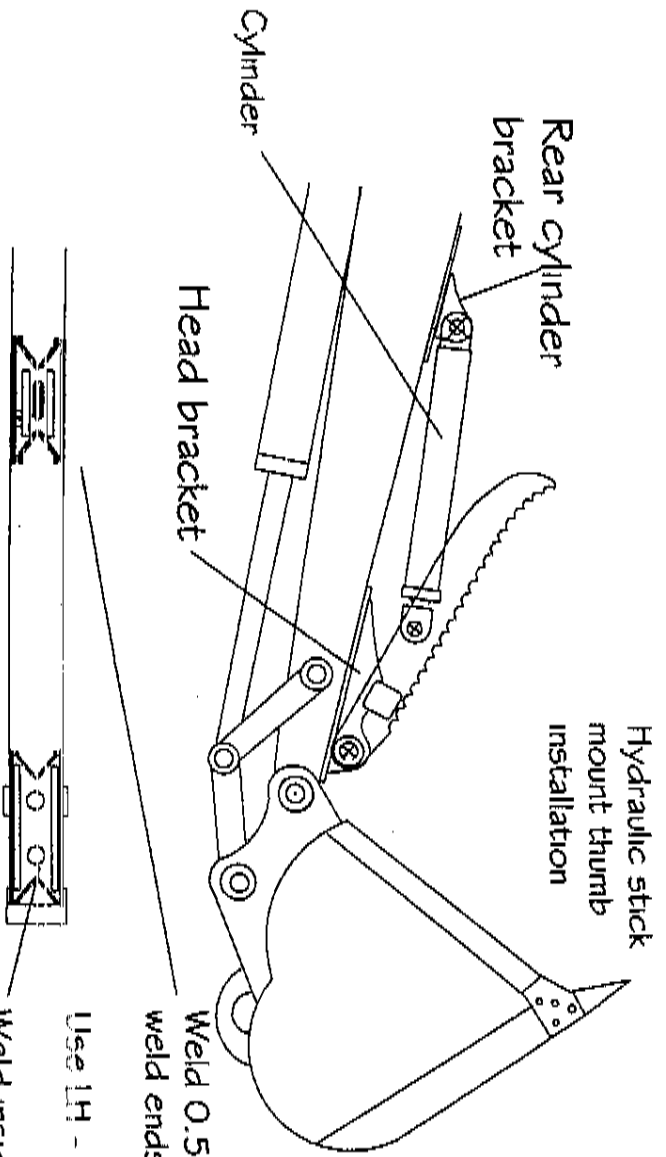
4150 Fairburn Rd.
Douglasville, GA 30135

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Weld 0.50" stringers as indicated and do not weld ends of brackets

Use LH - 7018 or equivalent
Weld inside slots as well as outside area

Fold stick under toward cab until bottom side of stick is as close to level as possible.

Take pins out of thumb and brackets.

Weld all pins from bottom and sides of brackets and surfaces to be welded to on stick with sawtooth.

Place thumb head-bracket on bottom side of stick with pin hole as close to bucket as possible, leaving plate completely flush all round to stick. Make sure the plate is centered and square to stick.

Tack plate in several places. Then pin thumb to bracket as per drawing with back of thumb resting in cradle of bracket.

Rotate bucket toward thumb making sure that it does not touch thumb.

Pin rod end of cylinder to back side of thumb. Now pin rear cylinder bracket to rear of cylinder, center and square bracket to stick making sure cylinder is fully retracted and grease fittings are reachable for grease gun.

Tack the rear cylinder bracket in place.

Hook up hydraulics and check rotation of thumb and bucket making sure that thumb only touches bucket at the edge or tooth area.

When thumb rotation is suitable and unit is working properly with bucket, finish welding brackets to arm.

Set hydraulic cylinder pressure to yield to bucket cylinder pressure. NEVER SET PRESSURE ON THUMB CYLINDER HIGH ENOUGH TO ALLOW THUMB TO PUSH BUCKET CYLINDER BACK. IF PRESSURE IS SET THIS HIGH ARRANGING IS VOID.