

## PRO-LINK HYDRAULIC THUMB (2<sup>ND</sup> GEN)

### INSTALLATION:

1. Fold stick until bottom faces upward as much as possible.
2. Remove main pin from bucket.
3. With retaining bolt installed, place thumb and front baseplate assembly on stick.
4. Align thumb and front baseplate to centerline of bucket and install *supplied* main pin. Include any spacers or washers needed to center thumb side to side on bucket. Place lock collar on end of pin and attach lock collar bolt and nut.
5. Curl bucket and check for proper fit and alignment.
6. With retaining bolt installed, *tack* front baseplate to stick. Do NOT remove retaining bolt.
7. Center the rear (cylinder) baseplate assembly on stick. Position so ¼" to ½" of rod is visible when thumb is fully retracted.
8. Extend the cylinder rod until cylinder hitch pin hole aligns with cylinder end bearing hole and install 2 ½" cylinder hitch pin.
9. Center the cylinder baseplate and tack in place. Prior to engaging the thumb rotation ensure there are adequate tacks to prevent baseplates from moving.
10. Connect hydraulic hoses. **NOTE: Hoses or hydraulic kits are NOT included with purchase of thumb.** Ensure grease fittings are placed upward or away from stick for easy access. The hydraulic fitting for the cylinder is a Code 61 four bolt flange.
11. Before operating the thumb it is important to ensure that the hydraulic pressure coming to the cylinder is set at no more than 2500 PSI. If pressure is set higher than 2500 PSI the warranty will be VOID.
12. Make sure that the pressure relief valves are set to relieve anything over 2500 PSI. Not all machines have these so you may have to install them on your machine.
13. Remove the retaining bolt from the front baseplate and rotate thumb toward bucket until cylinder rod is fully extended. Then rotate bucket toward thumb until thumb and bucket meet. Ensure that bucket does not touch the thumb except at tooth/cutting edge. Visually inspect all components to ensure there is no interference and smooth rotation.
14. If all components are correctly positioned, weld both baseplates with a 5/8" weld using a low hydrogen E-7018 welding rod or equivalent. Weld 3" and skip 3" on all sides of *both* plates. **Do NOT weld across stick!**
15. Grease all fittings before operation!
16. Weld pin block to bucket. You may need to trim locking collar on thumb to fit with bucket. **FALURE TO WELD PIN BLOCK TO BUCKET WILL VOID ALL WARRANTIES!**

