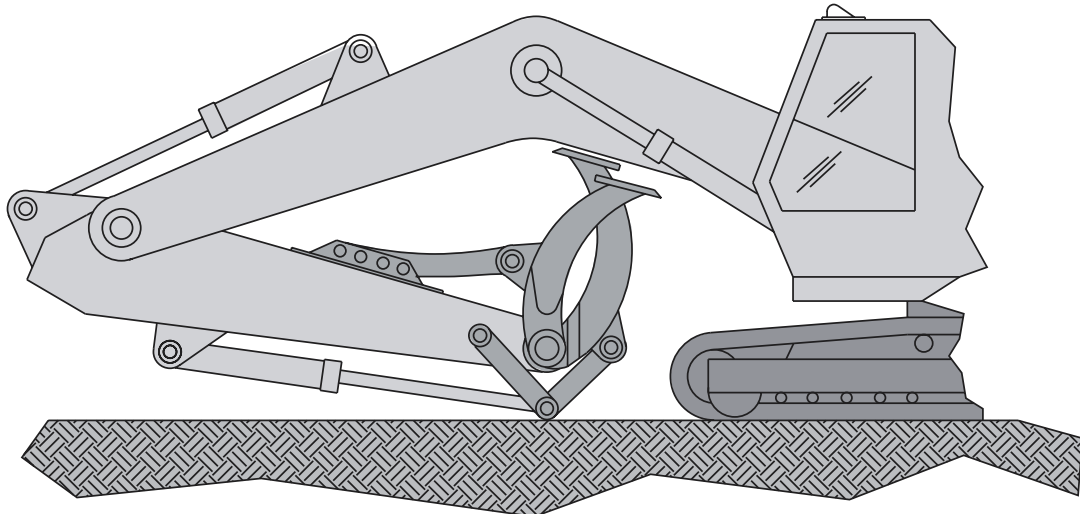
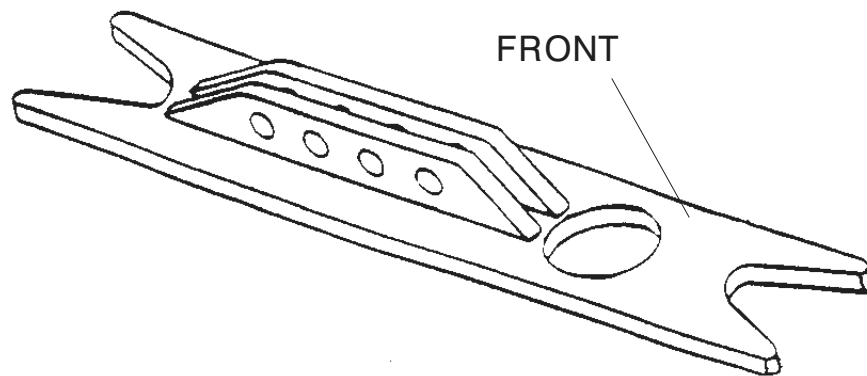


**INSTALLING THE MOUNTING PAD**

1. Position the carrier dipperstick so its back side is laying horizontal. Refer to figure 3-4.

**FIGURE 3-4****NOTE**

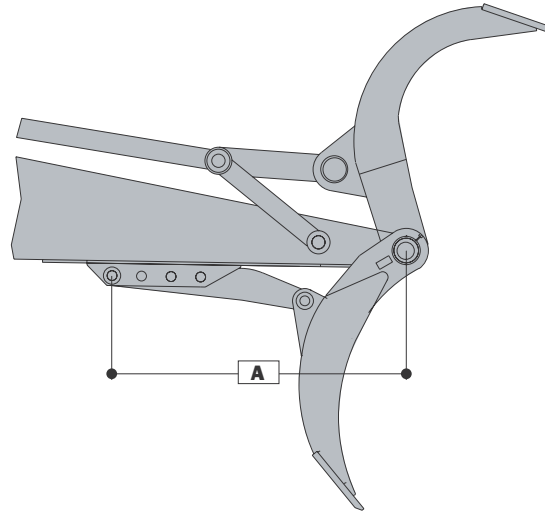
THE MOUNTING PLATE IS MARKED "FRONT." THE FRONT SIDE GOES TOWARD

**FIGURE 3-5**

THE STICKPIN. REFER TO FIGURE 3-5.

2. Thoroughly clean the area on the carrier dipperstick, where the mounting pad attaches, of all oil grease, rust, paint and scale.

- Set the mounting pad on the dipperstick the specified number of inches from the center of the stickpin hole to the center of the rear pin hole on the mounting pad. Refer to the chart below. Make sure the front side of the mounting pad is facing toward the stickpin.


**FIGURE 3-6**
**[ DIMENSION "A" ]**

ABG 30	46 in. [1168 mm]
ABG 40	50 in. [1270 mm]
ABG 50	60 in. [1524 mm]
ABG 70	60 in. [1524 mm]
ABG 90	65 in. [1676 mm]
ABG 140	76 in [1930 mm]

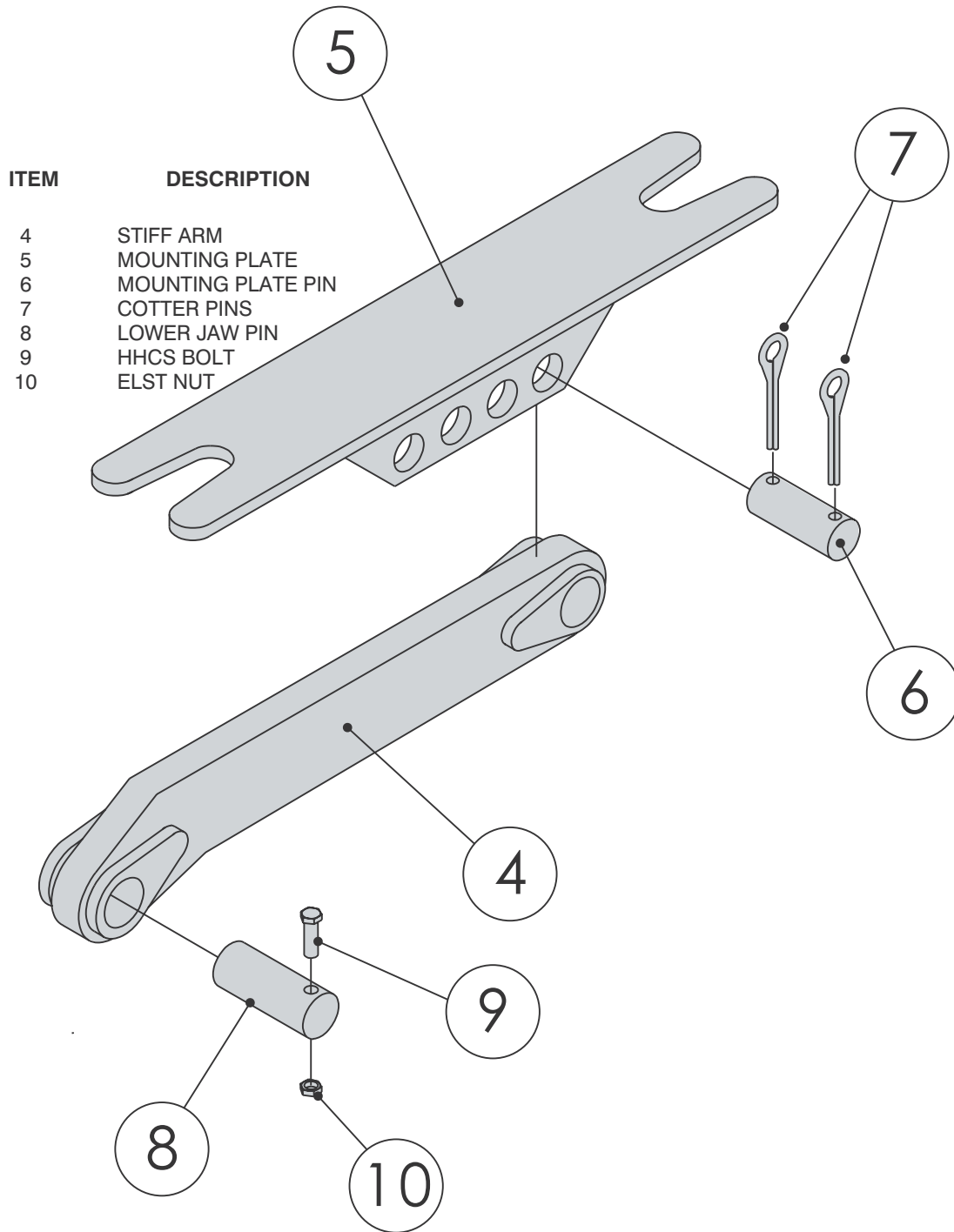
- Clamp the mounting pad in place temporarily. The mounting pad should be centered on the dipperstick from side to side.
- Before welding, make sure that the pins for the stiff arm go in and out of the lower jaw and the mounting plate.

**NOTE**

REFER TO FIGURE 3-7 FOR PROPER INSTALLATION OF THE STIFF ARM. NOTE THAT TOP OF BEND IN ARM GOES AGAINST MOUNTING PAD SIDE.

- Disconnect carrier electrical system by removing the ground wire from the battery.
- After final adjustments, the mounting pad should be spot tack welded in place and a final check made before permanently welding the pad to the dipperstick.

8. Heat the welding zone to remove moisture, to 200-300 degrees Fahrenheit [93-149C].
9. Using AWS E -7018 low hydrogen rod for stick welding, or AWS E-70T-1 for semi-automatic gas shielding, arc weld a 1/2" [1.27 mm] fillet all around the mounting pad, periodically alternating from side to side to control warpage and cracking.



**FIGURE 3-7**