



GENERAL PURPOSE and LIGHT MATERIAL BUCKET



PALADIN HEAVY CONSTRUCTION

REPAIR AND PREVENTATIVE MAINTENANCE GUIDE



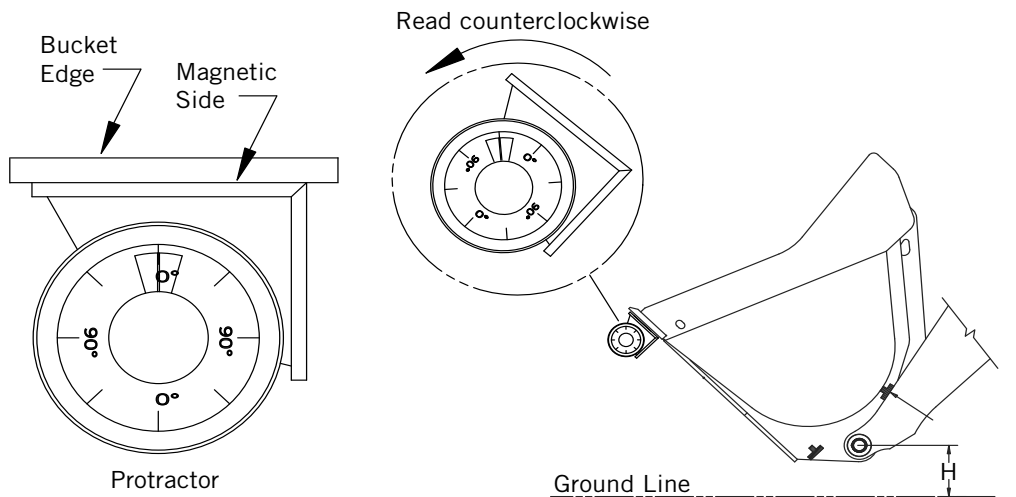
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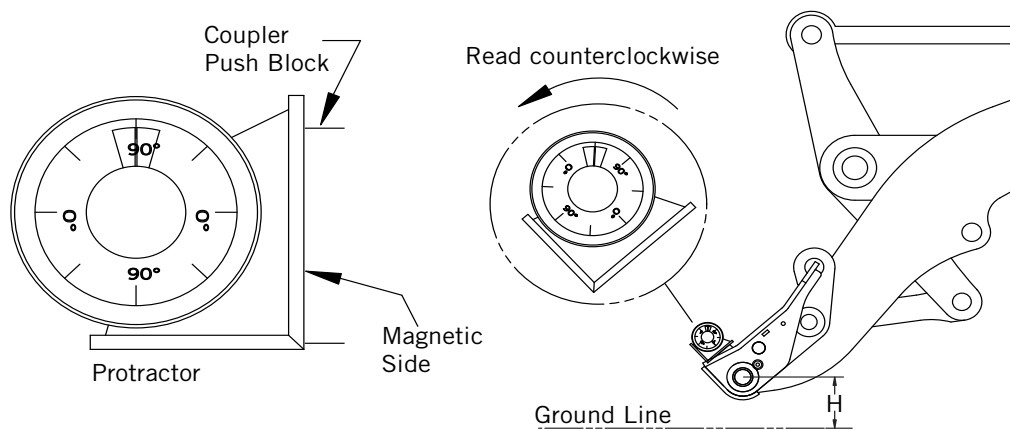
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ROLL BACK STOPS



Bucket Rollback



Coupler Rollback

Set attachment in the carry position, check the vertical measurement to the center of the boom attaching pins (dimension H). Refer to OEM specifications for correct dimension.

With the machine on level ground, roll the attachment back until the rollback stops contact both arms evenly.

Place a magnetic protractor on the attachment as shown and read the protractor in a counterclockwise direction to get the angle. Refer to OEM specifications for correct angle.

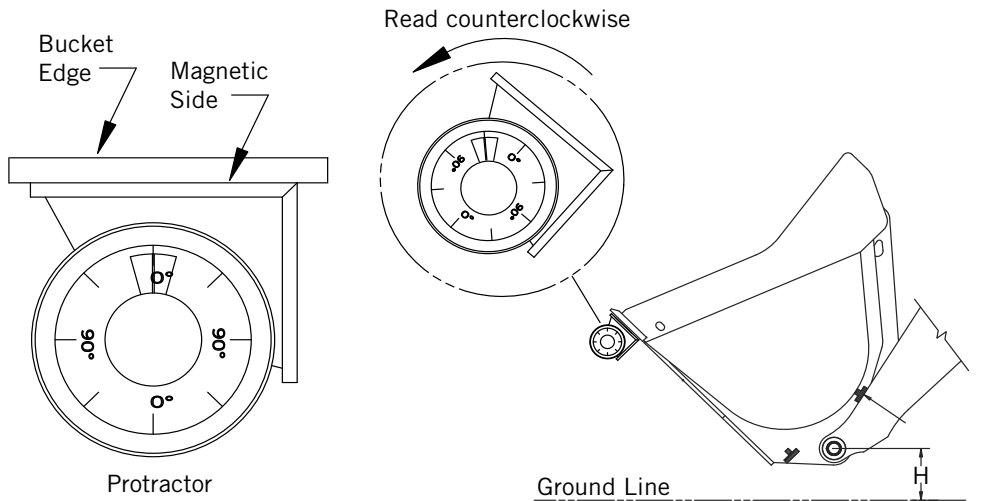
If attachment angle is off perform the following steps:

To add stop material use a low hydrogen 7018 rod to build up the stop surface of the machine. Grind smooth. This may require more than one adjustment until the stop is the correct thickness to obtain the OEM specified degree of rollback.

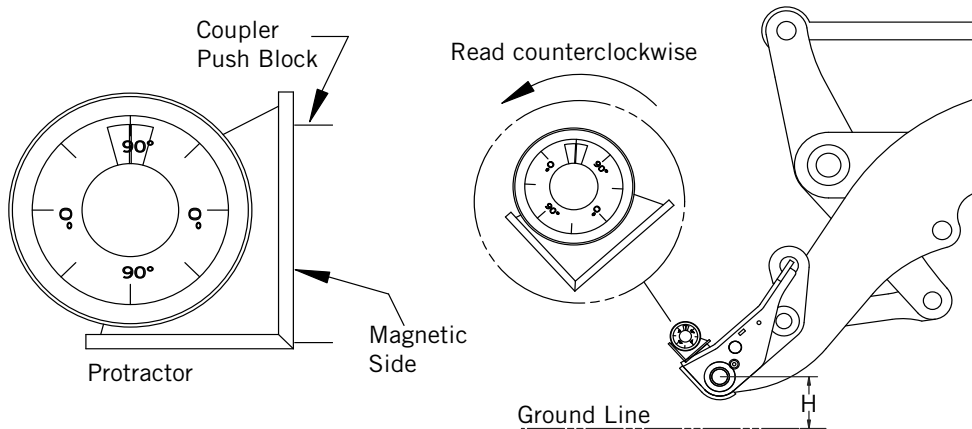
To remove stop material, grind the stop surface of the machine until it is the correct thickness to obtain the OEM specified degree of rollback.

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ROLL BACK STOPS ADJUSTABLE CHECKING ADJUSTABLE ROLLBACK STOPS



Bucket Rollback



Coupler Rollback

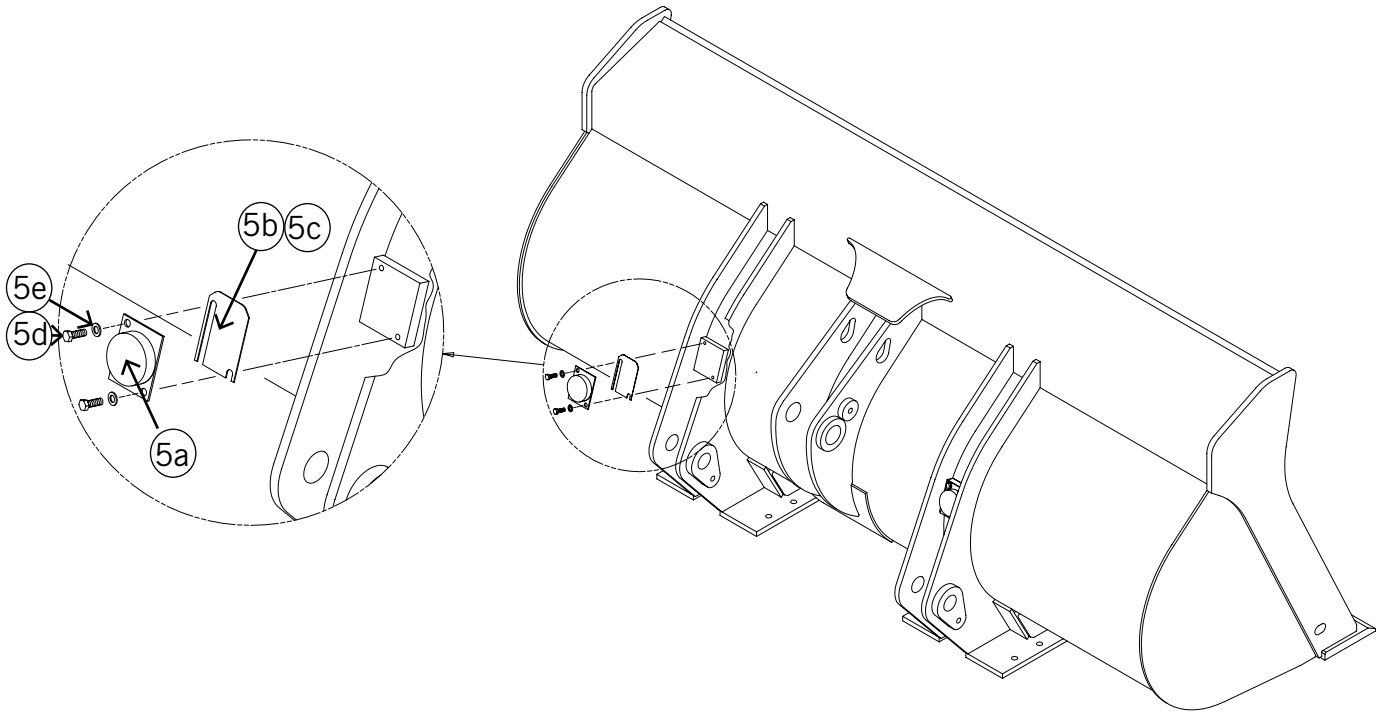
Set attachment in the carry position, check the vertical measurement to the center of the boom attaching pins (dimension H). Refer to OEM specifications for correct dimension.

With the machine on level ground, roll the attachment back until the rollback stops contact both arms evenly. For polyurethane stops, slight deformation of stop material is normal.

Place a magnetic protractor on the attachment as shown and read the protractor in a counterclockwise direction to get the angle. Refer to OEM specifications for correct angle.

If attachment angle is off refer to next page for stop adjustment.

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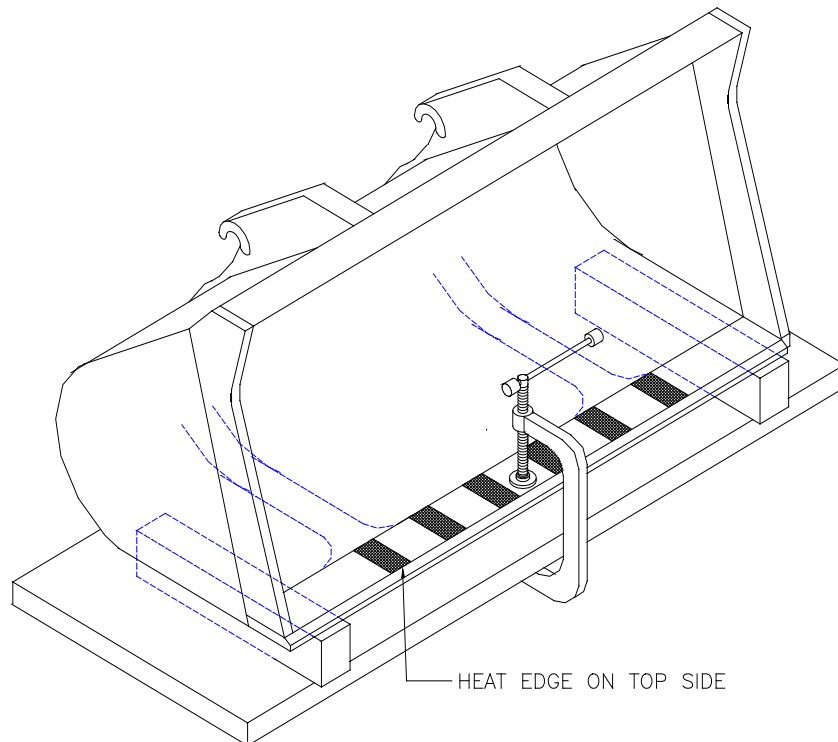


ITEM	QTY	PART NUMBER	DESCRIPTION
5	1		Adjustable Stop Kit (consists of items 4a thru 4e)
5a	2		Stop, Rollback (Poly)
5b	4		Shim, RB, Stop, 11 Ga
5c	4		Shim, RB, Stop, 16 Ga
5d	4		Bolt, HHCS, 3/8-16 x 3/4, Gr 8
5d	4		Washer, 3/8 Regular Lock

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CUTTING EDGE STRAIGHTENING PROCEDURE

- 1) Set bucket on flat work table blocking each corner with 8" to 12" blocks.
- 2) Using a heavy clamp in the center, clamp bucket to table. Tighten clamp so bow begins to decrease.
- 3) Begin heating on the top surface of the edge, using 1" strips spaced approx. 6" apart. See the figure below.
- 4) Continue to increase clamp pressure while heating until the bucket edge is approx. 0.38" below flat.
- 5) Allow to air cool in clamped position.
- 6) Once cooled remove clamp.



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CUTTING EDGE - CRACK REPAIR PROCEDURE

- 1) Remove bolt-on cutting edges or teeth.
- 2) Clean area adjacent to crack on both sides of edge.
- 3) Air-arc crack three quarters of the way through the edge from one side.
- 4) Preheat to 350 degrees and reweld. Make sure to remove slag in between each pass.

Note: All welding must be done with 7018 or equivalent weld process.

NOTICE

Heat from welding may cause edge to bow.

In order to keep edge from bowing during welding process, install a 1.5" dia. bar or rod between the center of the edge and the spill sheet of the bucket. Keep rod in place until welded area has cooled.

- 5) Air-arc crack from opposite side until crack is removed.
- 6) Maintain preheat and weld while making sure to remove slag between passes.
- 7) Grind weld reinforcement only as necessary to reinstall teeth or edges.
- 8) Post heat to ambient temperature (gradually).

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MAINTENANCE

The following maintenance procedures should be performed in order to maintain proper operation of the general purpose bucket.

PROCEDURE	INTERVAL	NOTES
Check for cracks	daily	Primarily around bucket mounting bosses and hinges
Check bolts tightness	daily	Refer to torque table for specifications
Check edges and wear pads	weekly	Replace if thinning
Check stops for excessive wear	weekly	Build up with weld as needed
		gpmtrnc

Service, maintenance and repair on these products are infrequent and the time involved will vary greatly. Contact JRB Customer Service at 1-800-428-2538 for assistance in determining the time you should allot for repair.