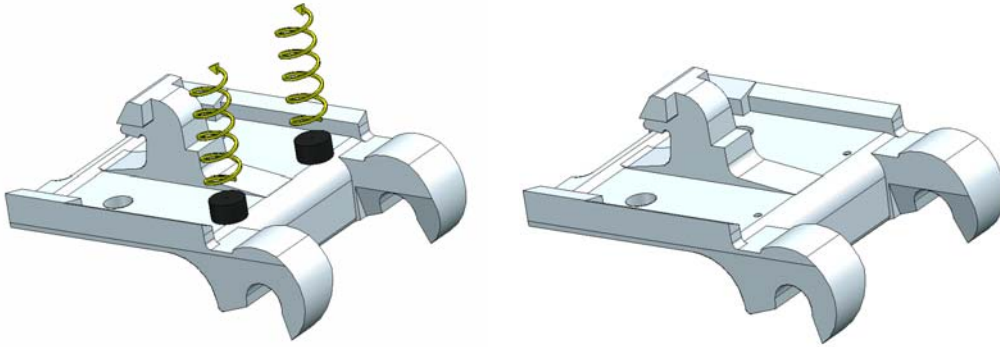
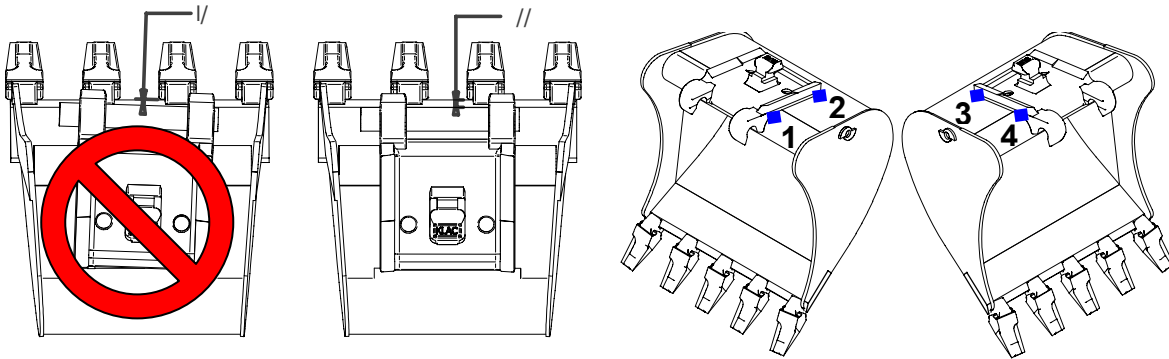


INSTRUCTIONS FOR WELDING OF KLAC TOP PLATES

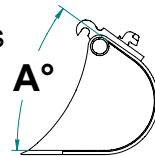
1- Remove the silent-blocs



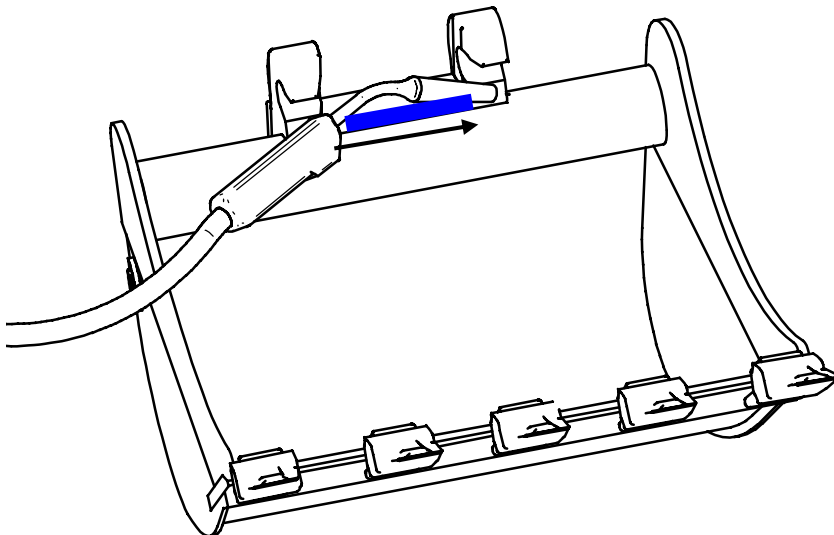
2- Install the top-plate by aligning the axle on the blade and weld at the 4 indicated points :



The Klac system's top-plates have to be welded with an angle :
 (A°) of $40^\circ \pm 2$ for the buckets equipped with C, D and F top-plates models
 (A°) of $37^\circ \pm 2$ for the buckets equipped with F top-plate model!

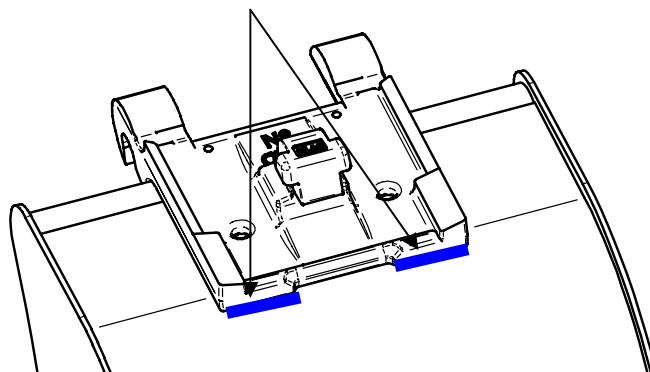


3- Weld the front part :

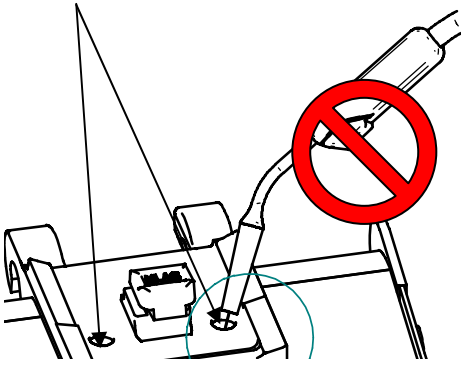


Welding :
 $x \times x$ mm
 6*6 model C
 7*7 model D
 8*8 model E
 10*10 model F

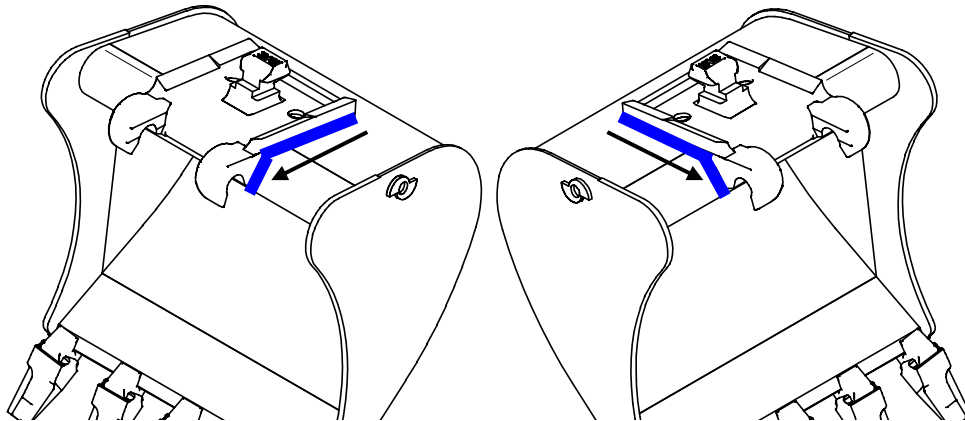
4- Only weld the back part all along the side parts :



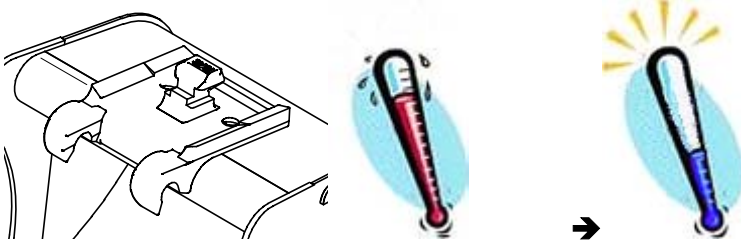
DO NOT WELD THE HOLES



5- Weld all along the side parts in the shafts' direction :
From back to ahead



6- Allow the bucket to sufficiently cool!



7- Replace the silent-blocs after painting

