



ATI Corporation
New Holland, PA 17557 (717) 354-8721

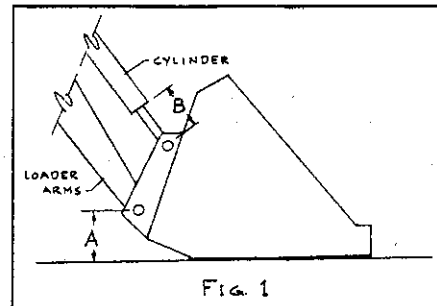
INSTRUCTIONS: INSTALLATION OF A WELD-ON ATTACHMENT PLATE

Tools Needed To Complete Job: Electric Welder
Standard welding rod
Torch
Hand-held electric grinder
Touch-up paint

CAUTION: Weld in a well-ventilated area. Burning paint may create toxic fumes that should not be inhaled.

1. **Plan Ahead.** Welding an attachment plate onto an attachment should not be rushed. A few minutes of planning will make installation easier and a better finished product.

2. **Establish the Proper Height and Back Angle.** First, before removing attachment, drive loader onto a flat surface. Lower attachment and position flat on the floor. Measure hinge pin distance from floor "A" and measure cylinder rod extension "B" (See Figure 1). Mount the weld-on attachment plate onto the loader's mountings. Next, drive the loader to a flat surface and place the attachment that is to be converted in front of the loader. Position the loader height and dump cylinders to the "A" and "B" dimensions that you measured earlier. The new position should be equal to that of the bucket to keep the height, rollback and dump angles the same. Please note: Any variance in this position will cause the height, rollback and dump angles to be changed. This variance in position may allow the attachment to interfere with the loader frame, cylinders, or hoses.



3. **Mark the angle at which the attachment plate is to be welded.** A steel marking pen works very well on both bare or painted steel.

4. **Create a flat, weldable surface.** A flat, weldable surface will be needed to weld the new attachment plate onto the attachment.

5. **Position the attachment plate on the back of the attachment with the loader.** Center the attachment side to side. Double check attachment height and angle.

6. **Tack weld the attachment plate in position while it is mounted on the loader.** Unhook the loader from the attachment plate to do final bracing and welding.

7. **Weld around the attachment plate.** Be sure to weld short beads of no more than 3" at a time to prevent warping. Skip to various places on the attachment plate to keep the heat level low.

8. **The top and bottom of the attachment plate are critical stress areas.** Fasten attachment plate solidly to prevent flexing.