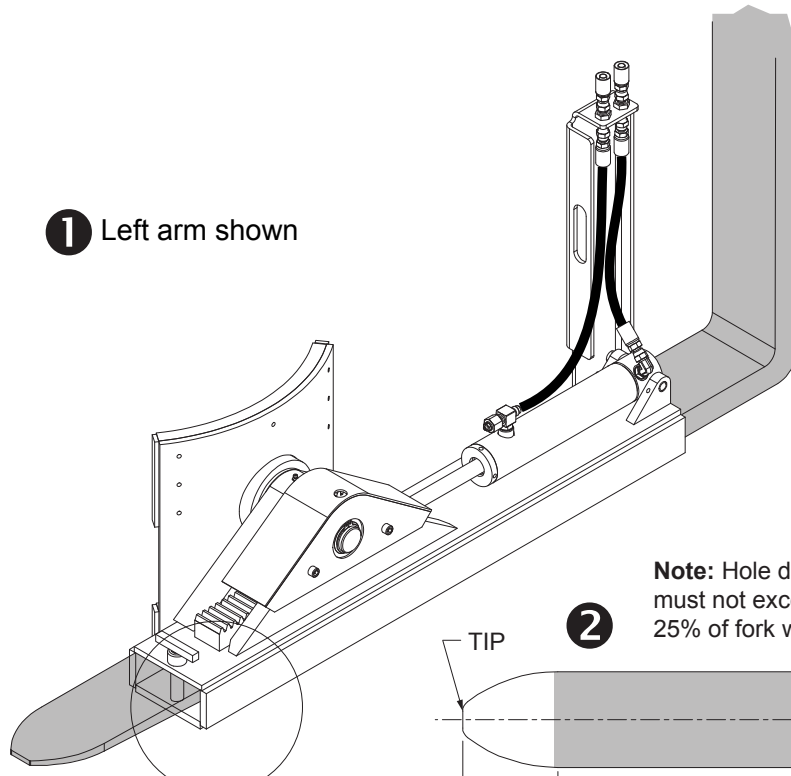
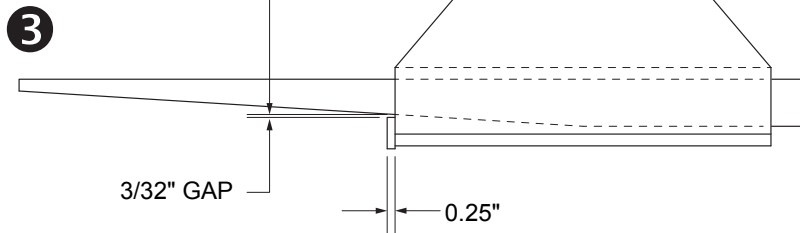
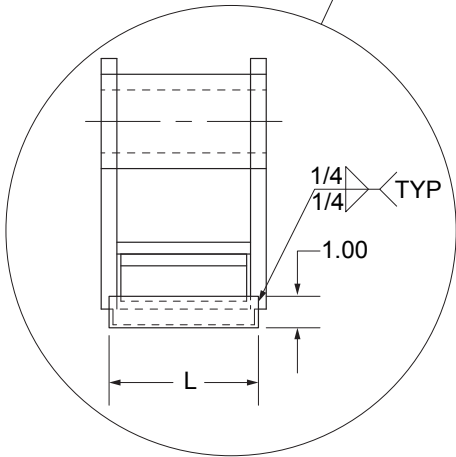
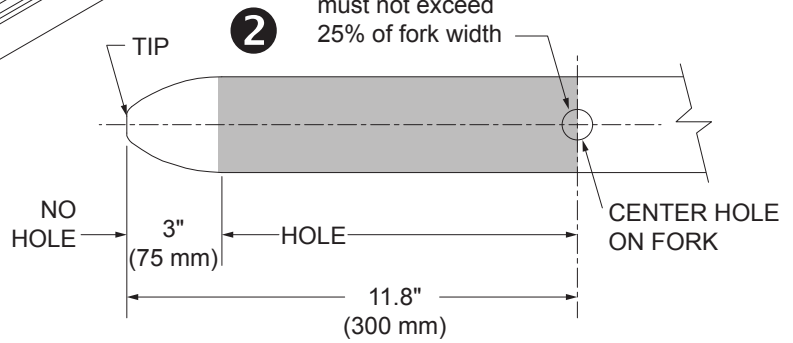


Installation Instructions Forward Drum Dumper Kit

1 Left arm shown



Note: Hole diameter must not exceed 25% of fork width



Forward Drum Dumper Installation instructions:

1. Drum arm weldment should sit fully in front of radius at fork bend and flat on top of fork blade, as in ❶.
2. Drill a clearance hole for the 3/4" locking bolt, approximately 13/16" diameter, centered on fork width, and at least 39.75" from the face of the fork shank. Position the hole in the center of the fork blade, between 3.0" (75 mm) and 11.8" (300 mm) from the tip, as in ❷. Hole diameter must not exceed 25% of the fork width.

Note

The fork is an attachment that is designed for lifting and lowering only. Do not use for pushing, pulling, or side loading. Never load or pry with the tip.

3. Install both drum arms.
4. Match plate to fork size, see table and illustration.

Fork Size	Plate Length	Plate Height
1.5" x 4"	4.75"	1.0"
1.5" x 5"	5.75"	1.0"
2" x 5"	5.75"	1.0"

5. Follow field weld instructions and weld plate to dumper arm as shown at ❸, to prevent arm movement on the fork.
6. Attach hoses.

Field welding instructions:

Original equipment material: A572

ASC supplied component material: A572

1. Park truck on a level surface, set brake and disconnect battery cables.
2. Remove all paint and foreign material from area to be welded. Be sure area is thoroughly clean before welding begins. Weld indoors if possible. If not, be sure to shield weld area from wind and debris.
3. Preheat and interpass temperature is recommended at 250°F.
4. Use low-hydrogen electrodes only. For example, the last digit of the electrode number will end in a 5, 6, or 8 (E7028, E7018, E9016). Unsure if electrodes or wire are low hydrogen? Consult manufacturer or supplier.
5. For FCAW process use 100% CO2 shielding gas and E70t-1 wire per AWS spec A5.20.
6. For SMAW process use E7018 electrodes per AWS spec A5.5.
7. Determine proper welding parameters for material thickness and rod/wire diameter (voltage, amps, feed, travel speed, etc.).
8. Thoroughly clean all tacks and root passes and remove all slag and cracks prior to additional welding.
9. Inspect finished weld for gaps and cracks.
10. When weld has cooled to ambient temperature, paint the repair area to protect against corrosion.