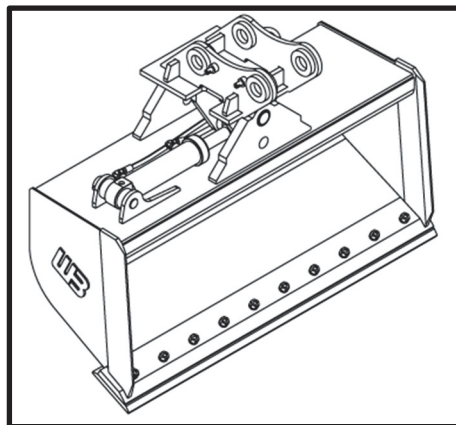


PRODUCT MANUAL AND INSTALLATION KIT

Hydraulic Tilting Grade Bucket



Serial No: _____

Model No: _____

Date Manufactured: _____



Werk-Brau Co., Inc.
P.O. Box 545 Findlay, Ohio 45839-0545 U.S.A.
Phone 1-800-537-9561
Fax (419)422-7207
Visit Werk-Brau at: www.werk-brau.com

Safety Statement Guide



→ Danger tags are used in major hazard situations where an immediate hazard presents a threat of death or serious injury to operator and anyone about.



→ Warning tags are used to represent a hazard level between “Caution” and “Danger”, instead of the required “Caution” tag, provided that they have a signal word of “Warning,” an appropriate major message.



→ Caution tags are used in minor hazard situations where a non-immediate or potential hazard or unsafe practice presents a lesser threat of injury.



→ A notice label is used where equipment or property damage could result if the instructions are not followed properly.



→ This symbol by itself or used with a safety signal word throughout this manual is used to call your attention to instructions involving your personal safety or the safety of others. Failure to follow these instructions can result in injury or death.

General Safety Precautions



READ MANUAL PRIOR TO INSTALLATION

Improper installation, operation, or maintenance of this equipment could result in serious injury or death. Operators and maintenance personnel should read this manual as well as all manuals related to this equipment and the operating machine thoroughly before beginning installation, operation, or maintenance. FOLLOW ALL SAFETY INSTRUCTIONS IN THIS MANUAL AND THE OPERATING MACHINES MANUAL.



READ AND UNDERSTAND ALL SAFETY STATEMENTS

Read all safety decals and safety statements in all manuals prior to operating or working on this equipment. Know and obey all OSHA regulations, local laws and other professional guidelines for your operation. Know and follow good work practices when assembling, maintaining, repairing, mounting, removing or operating this equipment.



KNOW YOUR EQUIPMENT



Know your equipment’s capabilities, dimensions and operations before operating. Visually inspect your equipment before you start, and never operate equipment that is not in proper working order with all safety devices intact. Check all hardware to assure it is tight. Make certain that all locking pins, latches, and connection devices are properly installed and secured. Remove and replace any damaged, fatigued or excessively worn parts. Make certain all safety decals are in place and are legible. Keep decals clean, and replace them if they become worn and hard to read.



PROTECT AGAINST FLYING DEBRIS

Always wear proper safety glasses, goggles with a face shield when driving pins in or out or when any operation causes dust, flying debris, or any other hazardous material.



LOWER OR SUPPORT RAISED EQUIPMENT

Do not work under raised booms without supporting them. Do not use support material made of concrete blocks, logs, buckets, barrels or any other material that could suddenly collapse or shift positions. Make sure support material is solid, not decayed, warped, twisted, or tapered. Lower the boom(s) to ground level or onto block(s). Lower the boom(s) and attachment(s) to the ground before leaving the cab or operator’s station.



General Safety Precautions - Continued



USE CARE WITH HYDRAULIC FLUID PRESSURE

Hydraulic fluid under pressure can penetrate the skin and cause serious injury or death. Hydraulic leaks under pressure may not be visible. Before connecting or disconnecting hydraulic hoses, read your operating machines operator's manual for detailed instructions on connecting and disconnecting hydraulic hoses or fittings.

- Keep unprotected body parts, such as face, eyes, and arms as far away as possible from a suspected leak. Flesh injected with hydraulic fluid may develop gangrene or other permanent disabilities. Wear safety glasses, protective clothing, and use a sound piece of cardboard or wood when searching for hydraulic leaks. **DO NOT USE YOUR HANDS!**
- If injured by injected fluid, see a doctor at once. If your Doctor is not familiar with this type of injury, ask him to research immediately to determine proper treatment.



DO NOT MODIFY MACHINE OR ATTACHMENTS

Modifications may weaken the integrity of the attachment and may impair the function, safety, life and performance of the attachment. When making repairs, use only the manufacturer's genuine parts, following authorized instructions. Other parts may be substandard in fit and quality. For loaders, never modify any ROPS (Roll Over Protection System) equipment or device.

!!!Any modifications must be authorized in writing by the Werk-Brau or the manufacturer!!!

SAFELY OPERATE THE EQUIPMENT



Do not operate equipment until you are completely trained by a qualified operator in how to use the controls, know its capabilities, dimensions, and all safety requirements. See your operating machines manual for these instructions.



- Keep all step plates, grab bars, pedals, and controls free of dirt, grease, debris, and oil.
- Be sure that all bystanders are out of harms way when operating.
- Do not allow riders on the attachment or operating machine
- Do not operate the equipment from anywhere other than the correct operators position.
- Never leave equipment unattended with the engine running or with this attachment in a raised position.
- Do not alter or remove any safety feature from the operating machine or this attachment.
- Know your work site safety rules as well as traffic rules and flow. When in doubt on any safety issue, contact your supervisor or safety coordinator for an explanation.

SAFELY MAINTAIN AND REPAIR EQUIPMENT

- Do not wear loose clothing, or any accessories that can catch in moving parts. If you have long hair, cover or secure it so that it does not become entangled in the equipment.
- Work on a level surface in a well-lit area.
- Use properly grounded electrical outlets and tools.
- Use the correct tool for the job at hand. Make sure tools are in good condition.
- Wear all protective equipment specified by the tool manufacturer.



OPERATING PRECAUTIONS

⚠ WARNING **DO NOT IMPROPERLY USE THIS TILT BUCKET**
This attachment is designed to grade at a slope.

⚠ DANGER **BE AWARE OF SURROUNDING UTILITIES**
Operator must be aware of all utility line and overhead electrical lines. Operations must be able to clear all lines safely.

NOTICE

⚠ DANGER **BE AWARE OF OVERHEAD DANGER**
Operator must be aware of all possible overhead dangers that are within the range of motion of the operating machine.

⚠ WARNING **DO NOT OPERATE WITH A LOOSE ATTACHMENT**
Visually check the coupler to verify attachments are secure and lock is fully engaged and that the center to center of the attachment matches the up with the coupler.

⚠ WARNING **PINCH POINTS**
Personal injury could result from the careless misuse of this coupler. Keep hands and body parts clear of the coupler when it's in the process of hooking up to an attachment. Be sure the machine is off and the attachment is on the ground prior to making adjustments.

Torque Specs

Please observed these approved specs. Failure to observe these specs can result in damage and other undesirable results.

Dash Size	Tube O.D. (Ref)	Thread Size	Torque Values Ft. Lbs.			
			37° Flare		Straight Thread	
			Ft. Lbs	Nm.	Ft. Lbs.	Nm.
4	1/4	7/16-20	10-12	14-16	15-19	20-25
5	5/16	1/2-20	13-16	18-21	20-25	27-33
6	3/8	9/16-18	20-25	27-33	32-40	43-54
8	1/2	3/4-16	34-42	46-56	54-67	73-90
10	5/8	7/8-14	46-58	62-78	74-92	100-124
12	3/4	1-1/16-12	64-80	87-108	102-128	138-173
14	7/8	1-3/16-12	80-100	109-135	128-160	173-216
16	1	1-5/16-12	97-117	131-158	150-187	203-253
20	1 1/4	1-5/8-12	145-165	197-223	227-264	308-357
24	1 1/2	1-7/8-12	230-250	312-338	363-400	492-542

*Apply enough pipe sealer to contact all threads.

** Do not use that excess will squeeze into the hydraulic lines.



Hydraulics

NOTICE

PRESSURE SETTING
3500 MAX PSI

FLOW – start around and adjust so bucket works at a nice pace and is not slamming

Jumper hoses will need to be run from the manifold to Auxiliary ports. We recommend matching the hose size on the tilt bucket or being the next size hose up. Make sure that the hose you are using is rated for the pressure you will be operating at.

**Werk-Brau Co. INC.,
2800 Fostoria Rd
P.O. Box 545
Findlay, Ohio
45839**

For replacement parts, questions, and other matters please call your local dealer. If you can not reach a local dealer please call us and we will be happy to find a dealer for you and answer any questions.

**PHONE:
1-800-537-9561**

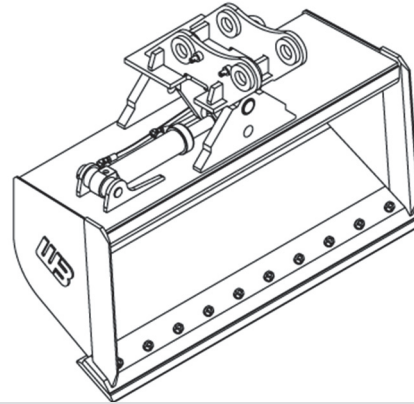
**FAX:
(419) 422-7207**

**WEBSITE:
www.werk-brau.com**

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Record of Revisions

Revision	Date	Notes
A	6/24/08	Document Created.
B	8/24/12	Edited layout, added cover, added back cover.
C	7/31/14	Updated

ABOUT WERK-BRAU

Since 1947, Werk-Brau has manufactured the highest quality and most innovative specialty products for the heavy equipment industry. Werk-Brau is respected internationally for providing outstanding customer service and being dedicated to excellence in all aspects of our business. Duke Werkheiser and Dutch Brautigan, for whom the company is named after, first opened their blacksmith shop in Findlay Ohio. Still today Werk-Brau manufactures and produces in Findlay Ohio, in a state of the art facility.

Over the decades Werk-Brau has grown and become so much more than a simple blacksmith operation. Today Werk-Brau proudly employs an industry leading team of professionals who work hard to follow the vision set by the founders of Werk-Brau to "Provide Excellence in Customer Service". As a modern company Werk-Brau is efficient, high-tech, dedicated to its customers, and deeply proud of the quality of products manufactured.

Werk-Brau manufactures a complete line of O.E.M. and replacement attachments for excavators, mini excavators, backhoes, skid steers, mini and full size loaders and crawler loaders. All over the world Werk-Brau attachments can be found hard at work in the toughest of conditions.

**THANK YOU FOR YOUR
PURCHASE!**

Tough Jobs Demand Tough Attachments

WB[®] WERK-BRAU CO., INC.
2800 FOSTORIA AVE. • P.O. BOX 545 • FINDLAY, OH 45839-0545
www.Werk-Brau.com
1-800-537-9561

W A R R A N T Y

To read the complete and most current version of Werk-Brau's Warranty Policy, and or to file a claim at any time please visit the Werk-Brau website.

Policy Online: <http://www.Werk-Brau.com/warranty-claims>

Claim Form Online: <http://www.Werk-Brau.com/warranty-claims/form>

Additionally you may directly contact Werk-Brau Company, Inc. @ 800-537-9561, Monday – Friday, 8:00am – 5:00pm, eastern standard time, and request a Werk-Brau customer service representative in the Warranty Claims department.

All returns must have prior authorization from a Werk-Brau customer service representative and must have a Return Authorization number (RA) assigned to the claim. This number must be referenced through all proceeding transactions.

Werk-Brau Company warrants buckets and non-hydraulic components against defaults in materials, faulty design and workmanship for a period of twelve months from the date of delivery or 2000 hours, whichever comes first. Hydraulic components and couplers are warranted for 12 months or 1000 hours, whichever comes first. Werk-Brau's warranty policy does not apply to purchased subassemblies including, teeth assemblies, tines (forks), cylinders, auxiliary edges and etc. Such items are subject to OEM's Warranty of their respective manufacturer.

Warranty Procedures

Prior to notifying Werk-Brau Company, Inc., please compile the following :

1. Serial Number of the bucket or attachment.
2. Description of specific failure and conditions prior to failure.
3. Name of reliable contact with regards to claim.
4. Number of hours on machine and attachment.
5. Comments from end-user and/or operator.

Return Policy

All items must have prior approval of Werk-Brau Company, Inc. and be assigned a Return Authorization Number.

Items ordered in error, can be returned with a 20% restocking fee and freight prepaid. Item(s) that have been placed in the ground or show any signs of use, will not be considered for return.

Werk-Brau Company, Inc. has the final "say so" in determining if a custom product or a product manufactured for a non-current machine can be returned with accordance to the Return Policy.

Cancellation Policy

Orders canceled are subject to a cancellation charge of 3% of the retail amount of the order. Items manufactured by the Werk-Brau Company have varied manufacturing times; therefore, this policy is at the discretion of Werk-Brau Company, Inc.

If order is complete and awaiting shipment or pickup by customer, cancellation, at that time, will have a penalty of 100% of the net invoice and will be charged to the purchasing customer.



American Made Since 1947



Tough Jobs Demand Tough Attachments



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