



DURA-TUFF®

Wear Products, LLC



Wear Products
CATALOG

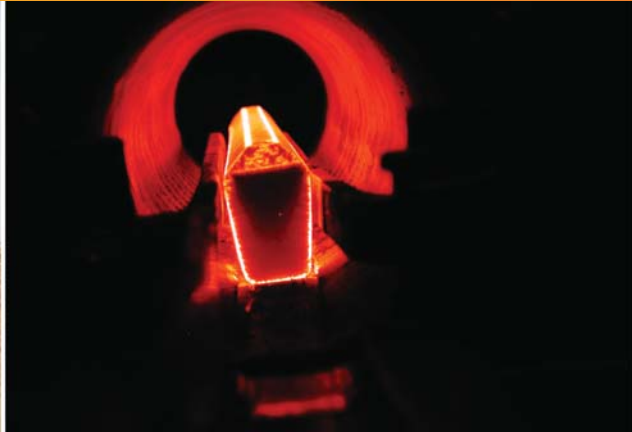




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To request a supplementary dealer pricing guide, please call, 801.973.8900.
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Dura-Tuff Business Overview

Dura-Tuff® Wear Products

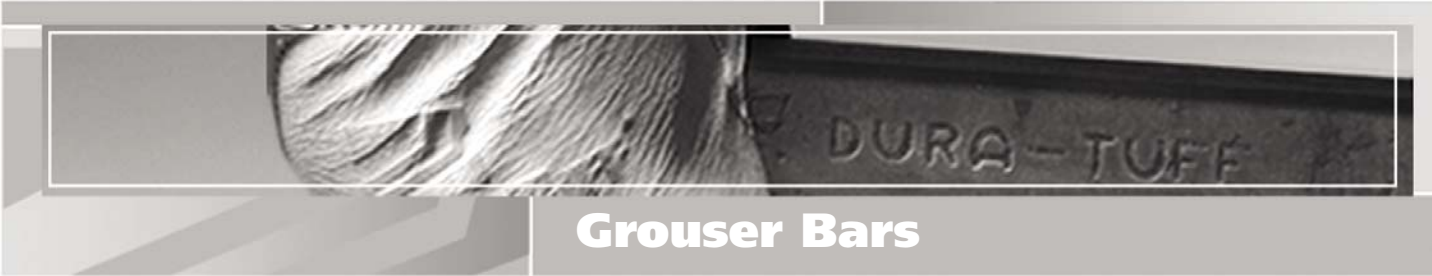
Dura-Tuff® Wear Products™, LLC formerly WC Manufacturing, was founded in 1986 by the owners of Wheeler Machinery. On June 19, 2002, WC Manufacturing became Dura-Tuff® Wear Products and part of a family of companies owned by GH Peterson Holdings, a company highly committed to value based growth.

The company developed its own metallurgical composite for grouser bars. Dura-Tuff® grouser bars, manufactured from some of the world's premium materials including boron, manganese, and titanium are used to replace the grouser treads on tracked vehicles when they have worn down. These grouser bars are thru-hardened to exacting standards for even and predictable wear. Dura-Tuff® grouser bars are produced in three grades or hardness levels including: General Service, Extreme Service, and Super Extreme Service grades. Dura-Tuff's Super Extreme Service grouser bar is the hardest and most durable grouser bar available on the market!

In addition to their extensive line of premium grade grouser bar Dura-Tuff® has also expanded their products to include their newly patented (US & International) Bolt on Finishing Edge System™. This edge is an efficient time saving device for those who wish to create a clean trench floor or a straight edge finish to any project. This reusable edge is composed of hardened steel which is attached to the bucket of a backhoe or excavator utilizing the bucket's teeth and adapters. It can be installed as easily as replacing bucket teeth. The primary feature of the Bolt-on Finishing Edge System™ is that no welding is required, thus it can be installed onto the backhoe or excavator bucket in minutes.

For 18 years, the company has manufactured and distributed its products to heavy equipment dealers all over the world including North and South America, Australia, Africa, Indonesia, China, and Europe. Because of strong customer loyalty teamed with outstanding service, the company continues to grow at a steady pace.

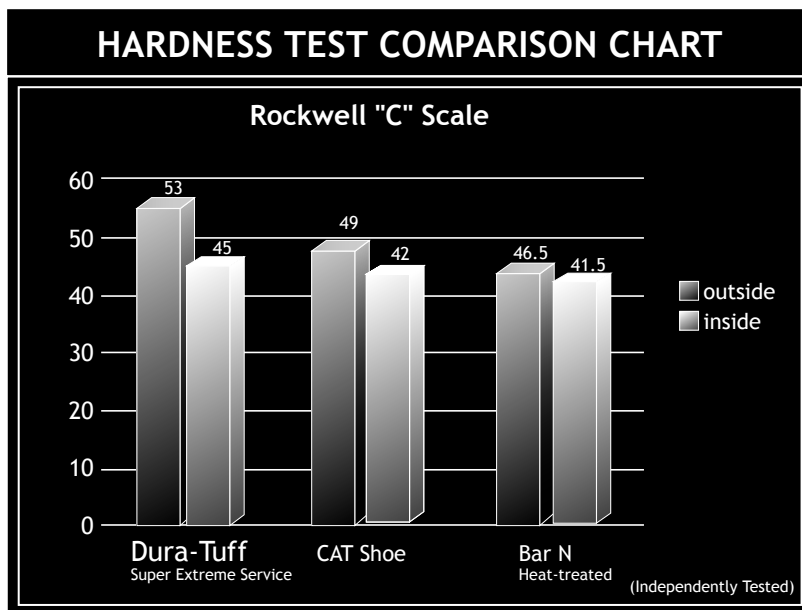




Grouser Bars

Dura-Tuff® Grouser Bars

Dura-Tuff® grouser bars are manufactured from a premium steel alloy. This alloy allows their grouser bar to be the strongest and longest lasting grouser bar on the market! These grouser bars have been proven in hard rock mining, construction, and tar sands to be the ultimate solution. Dura-Tuff® Wear Products is committed to the highest standard in quality. Their grouser bars are heat treated to the core and are thru-hardened to an average Rockwell-C hardness of up to 53.



Dura-Tuff® Wear Products, LLC has more than 800 tons of grouser bar inventory on-site. This enables them to ship their grouser bar orders with very quick turn times. Many orders are out the door within 24 hours. This enormous advantage over their competitors allows them to service you promptly, minimizing your downtime.

The competitive edge that Dura-Tuff® has retained for over 17 years is due to their technologically advanced forging process that is unlike any other in the world. This process has allowed them to deliver a superior grouser bar that is second to none and allows them to meet even customer specific requirements.

The Dura-Tuff® Grouser Bars are available in eleven sizes, straight, curved, beveled, and forged to fit virtually every make and model of tracked machinery. Custom sizes are also available upon request.

Benefits of Using a Dura-Tuff® Bar

- > The toughest and most durable bar in the industry (Call to learn about Independent Metallurgical Analysis)
- > Even harder than a new shoe
- > Extends the life of the track shoe by up to 5 times
- > Thru-hardened to a Rockwell hardness of up to 53
- > Up to 8 points harder on the Rockwell C scale than competitive bar
- > Curved or forged bar can even be welded on at the job site with very little trimming

Available Grades

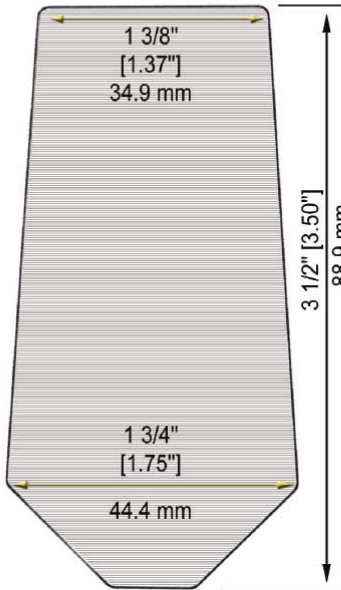
Dura-Tuff® offers three grades of grouser bars in order to meet the varying needs of our customers.

Grouser Grade	Hardness
General Service: <ul style="list-style-type: none"> > Economy bar > Non-heat treated > For machines that see little to medium use > For soft surface applications > Example applications: Forestry and agriculture 	Rc 20 Brinell (BHN) 240
Extreme Service: <ul style="list-style-type: none"> > Medium grade bar > Thru-heat treated > For moderately hard or moderately abrasive surfaces > For cost conscious customers > Harder than all non-heat treated and high carbon bars (the competitive option)! > Example application: Construction 	Rc 38-42 Brinell (BHN) 353-390
Super Extreme Service: <ul style="list-style-type: none"> > Premium grade bar > Specially heat treated for the toughest thru-hardness possible > Best value and best performance > The longest lasting grouser bar on the market! (The closest competitive offering is Rc 40-47.) > Example applications: Most mining, hard rock surfaces, tar sands, and any abrasive surface. 	Rc 45-53 Brinell (BHN) 421-535

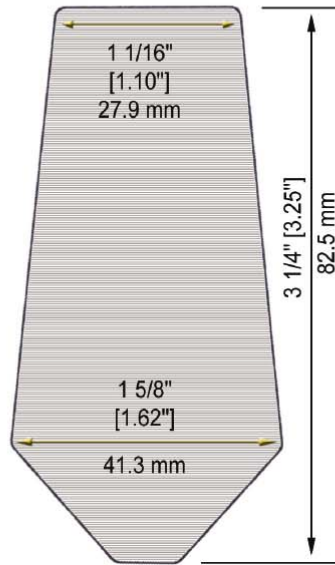


Thru-hardened for consistent and longer wear.

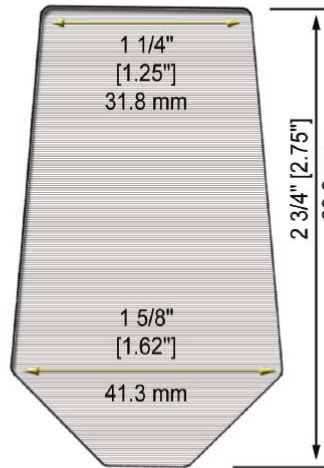
Grouser Profile Chart



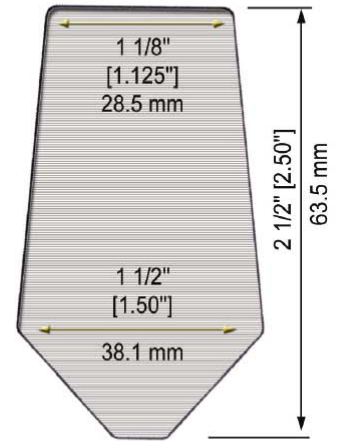
13 bar (G, E, S)
18.0 LB/FT



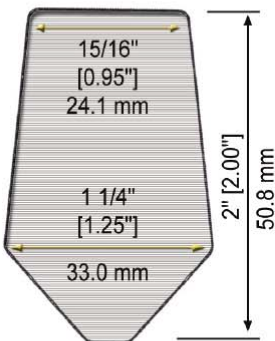
11 bar (G, E, S)
14.1 LB/FT



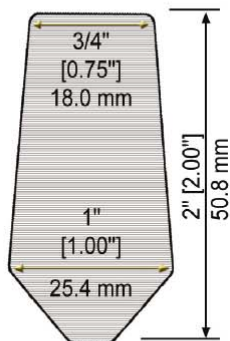
12 bar (G,E,S)
13.2 LB/FT



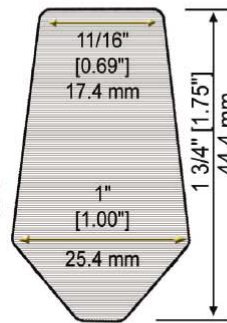
10 bar (G,E,S)
10.6 LB/FT



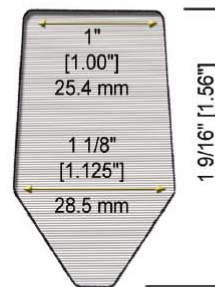
9 bar (G,E,S)
6.9 LB/FT



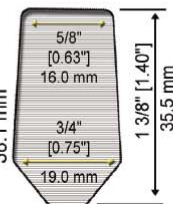
8 bar (G,E,S)
5.6 LB/FT



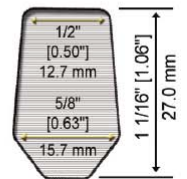
87 bar (G,E,S)
4.8 LB/FT



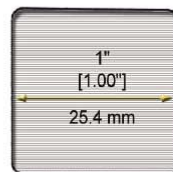
19 bar (G,E,S)
4.9 LB/FT



7 bar (G,E,S)
3.2 LB/FT



6 bar (G&E)
1.9 LB/FT



5 Bar (G&E)
3.41 LB/FT



4 Bar (G&E)
1.92 LB/FT



3 Bar (G)
1.33 LB/FT

Items listed above are available in any length from 2" (5.08 cm) to 120" (304.8 cm)
 Product available in the following configurations: Straight, Curved, Forged & Beveled.
 G = General Service, E = Extreme Service, S = Super Extreme Service
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Straight Bar



Dura-Tuff® straight bar is used when the gruffer on the shoe is worn evenly (as opposed to more wear on the ends of each shoe). Straight bars are easy to weld on and work well with automated welders or when shoes are trimmed straight.

Part #	Part #	Part #	L	Weight
6 Bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G0614	E0614	Not Available	14	2.10
G0616	E0616		16	2.40
G0618	E0618		18	2.70
G0620	E0620		20	3.00
G0622	E0622		22	3.30
G0624	E0624		24	3.60
G0628	E0628		28	4.20
G0630	E0630		30	4.50
G0624	E0634		34	5.10

7 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G0712	E0718	S0718	12	3.02
G0718	E0718	S0718	18	4.53
G0720	E0720	S0720	20	5.03
G0722	E0722	S0722	22	5.54
G0724	E0724	S0724	24	6.04
G0726	E0726	S0726	26	6.54
G0728	E0728	S0728	28	7.05
G0730	E0730	S0730	30	7.55

8 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G0820	E0820	S0820	20	8.92
G0822	E0822	S0822	22	9.81
G0824	E0824	S0824	24	10.70
G0826	E0826	S0826	26	11.59
G0828	E0828	S0828	28	12.48
G0830	E0830	S0830	30	13.38
G0836	E0836	S0836	36	16.05

87 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G8712	E8712	S8712	12	4.60
G8720	E8720	S8720	20	7.67
G8722	E8722	S8722	22	8.43
G8724	E8724	S8724	24	9.20
G8726	E8726	S8726	26	9.97
G8728	E8728	S8728	28	10.73

9 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G0922	E0922	S0922	22	12.93
G0924	E0924	S0924	24	14.10
G0926	E0926	S0926	26	15.28
G0927	E0927	S0927	27	15.86
G0928	E0928	S0928	28	16.45
G0932	E0932	S0932	32	18.80
G0936	E0936	S0936	36	21.15
G0938	E0938	S0938	38	22.33

10 Bar General Service	Extreme Service	Super Extreme Service	L	Weight
(in)	(lbs)	(in)	(lbs)	(lbs)
G1015	E1015	S1015	15	13.19
G1022	E1022	S1022	22	19.34
G1024	E1024	S1024	24	21.10
G1026	E1026	S1026	26	22.86
G1027	E1027	S1027	27	23.74
G1028	E1028	S1028	28	24.62
G1032	E1032	S1032	32	28.13
G1036	E1036	S1036	36	31.65

11 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G1124	Available upon request	S1124	24	28.34
G1128		S1128	28	33.06
G1130		S1130	30	35.43
G1132		S1132	32	37.79
G1135		S1135	35	41.33
G1136		S1136	36	42.51

12 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G1224	Available upon request	S1224	24	25.24
G1227		S1227	27	28.40
G1228		S1228	28	29.45
G1232		S1232	32	31.55
G1236		S1236	36	37.86

13 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G1327	Available upon request	S1327	27	39.44
G1328		S1328	28	40.90
G1334		S1334	34	49.67
G1336		S1336	36	52.59

(BHN) 240
Rc - 20

(BHN)
353 - 390
Rc 38 - 42

(BHN)
421 - 535
Rc 45 - 53

Straight Bar (Half Inch Short)

Dura-Tuff® half-size bar is a 1/2" shorter than the original grouser bar. Sometimes shoes have extra wear on the ends. Using the 1/2" bar saves time and money by eliminating the need to fill in the ends and this bar is close enough to the original length to give the necessary support.



Part #	Part #	Part #	L	Weight
6 Bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G0613.5	E0613.5	Not Available	13.5	2.03
G0615.5	E0615.5		15.5	2.33
G0617.5	E0617.5		17.5	2.63
G0619.5	E0619.5		19.5	2.93
G0621.5	E0621.5		21.5	3.23
G0623.5	E0623.5		23.5	3.53

Part #	Part #	Part #	L	Weight
10 Bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G1021.5	E1021.5	S1021.5	21.5	18.90
G1023.5	E1023.5	S1023.5	23.5	20.66
G1025.5	E1025.5	S1025.5	25.5	22.42
G1026.5	E1026.5	S1026.5	26.5	23.30
G1027.5	E1027.5	S1027.5	27.5	24.18
G1031.5	E1031.5	S1031.5	31.5	27.69
G1035.5	E1035.5	S1035.5	35.5	31.21

7 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G0717.5	E0717.5	S0717.5	17.5	4.40
G0719.5	E0719.5	S0719.5	19.5	4.91
G0721.5	E0721.5	S0721.5	21.5	5.41
G0723.5	E0723.5	S0723.5	23.5	5.91

11 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G1123.5	Available upon request	S1123.5	23.5	27.75
G1127.5		S1127.5	27.5	32.47
G1129.5		S1129.5	29.5	34.83
G1131.5		S1131.5	31.5	37.20
G1135.5		S1135.5	35.5	41.92

8 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G0819.5	E0819.5	S0819.5	19.5	8.69
G0821.5	E0821.5	S0821.5	21.5	9.59
G0823.5	E0823.5	S0823.5	23.5	10.48
G0825.5	E0825.5	S0825.5	25.5	11.37

12 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G1223.5	Available upon request	S1223.5	23.5	24.71
G1226.5		S1226.5	26.5	27.87
G1227.5		S1227.5	27.5	28.92

87 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G8719.5	E8719.5	S8719.5	19.5	7.48
G8721.5	E8721.5	S8721.5	21.5	8.24
G8723.5	E8723.5	S8723.5	23.5	9.01

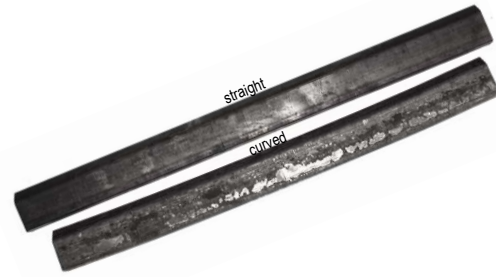
13 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G1326.5	Available on request.	S1326.5	26.5	38.71
G1327.5		S1327.5	27.5	40.17

9 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G0921.5	E0921.5	S0921.5	21.5	12.63
G0923.5	E0923.5	S0923.5	23.5	13.81
G0925.5	E0925.5	S0925.5	25.5	14.98
G0926.5	E0926.5	S0926.5	26.5	15.57
G0927.5	E0927.5	S0927.5	27.5	16.16
G0931.5	E0931.5	S0927.5	31.5	18.51

Brinell (BHN) 240 Rc - 20
 Brinell (BHN) 353 - 390 Rc 38 - 42
 Brinell (BHN) 421 - 535 Rc 45 - 53

Curved Bar

Dura-Tuff® curved bar is used when the grouser on the shoe is not worn evenly and is a great alternative to forged bar. The curved bar can even be welded on at field locations and does not leave open ends that need extra weld or fill. Little to no trimming required.



Part #	Part #	Part #	L	Weight
7 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	E0720C	S0720C	20	5.03
	E0722C	S0722C	22	5.54
	E0724C	S0724C	24	6.04
8 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	E0822C	S0822C	22	9.81
	E0824C	S0824C	24	10.70
87 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	E8722C	S8722C	22	8.43
	E8724C	S8724C	24	9.20

Part #	Part #	Part #	L	Weight
9 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	E0922C	S0922C	22	12.93
	E0924C	S0924C	24	14.10
	E0926C	S0926C	26	15.28
	E0927C	S0927C	27	15.86
	E0928C	S0928C	28	16.45

Part #	Part #	Part #	L	Weight
10 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	E1022C	S1022C	22	19.34
	E1024C	S1024C	24	21.10
	E1027C	S1027C	27	23.74
	E1028C	S1028C	28	24.62

Part #	Part #	Part #	L	Weight
11 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	Available/req. No returns.	S1124C	24	28.34
		S1128C	28	33.06

Part #	Part #	Part #	L	Weight
12 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	Available upon request	S1224C	24	25.24
		S1226C	26	27.34
	No returns.	S1228C	28	29.45

**Brinell
(BHN) 240
Rc - 20**

**Brinell
(BHN)
353 - 390
Rc 38 - 42**

**Brinell (BHN)
421 - 535
Rc 45 - 53**

Curved Bar (Half Inch Short)

Dura-Tuff® half-size curved bar are a ½ in. shorter than the original curved grouser bar. Similar to the straight half inch bar, this bar is used when there is extra wear on the ends of each shoe. It also helps eliminate the need to fill weld the ends.



Part #	Part #	Part #	L	Weight
7 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	E0719.5C	S0719.5C	19.5	4.91
	E0721.5C	S0721.5C	21.5	5.41
	E0723.5C	S0723.5C	23.5	5.91

Part #	Part #	Part #	L	Weight
12 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	Available upon request	S1223.5C	23.5	24.71
		S1225.5C	25.5	26.82
	No returns.	S1227.5C	27.5	28.92

Part #	Part #	Part #	L	Weight
8 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	E0821.5C	S0821.5C	21.5	9.59
	E0823.5C	S0823.5C	23.5	10.48

**Brinell
(BHN) 240
Rc - 20**

**Brinell
(BHN)
353 - 390
Rc 38 - 42**

**Brinell (BHN)
421 - 535
Rc 45 - 53**

Part #	Part #	Part #	L	Weight
87 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	E8721.5C	S8721.5C	21.5	8.24
	E8723.5C	S8723.5C	23.5	9.01

Part #	Part #	Part #	L	Weight
9 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	E0921.5C	S0921.5C	21.5	12.63
	E0923.5C	S0923.5C	23.5	13.81
	E0925.5C	S0925.5C	25.5	14.98
	E0926.5C	S0926.5C	26.5	15.57
	E0927.5C	S0927.5C	27.5	16.16

Part #	Part #	Part #	L	Weight
10 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	E1021.5C	S1021.5C	21.5	18.90
	E1023.5C	S1023.5C	23.5	20.66
	E1026.5C	S1026.5C	26.5	23.30
	E1027.5C	S1027.5C	27.5	24.18

Part #	Part #	Part #	L	Weight
11 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	Available/req. No returns.	S1123.5C	23.5	27.75
		S1127.5C	27.5	32.47

Forged Bar

Dura-Tuff® Forged Bar is used to help customers keep labor costs down on regrousering. The forged bar eliminates the need to trim the shoe grouser to a straight edge before regrousering and forms to the wear of the shoe. The forged ends fit down over the ends of a worn shoe to restore it most closely to original specs.



Part #	Part #	Part #	L	Weight
7 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	Available upon request	S0720F	20	5.45
		S0722F	22	6.00
	No returns.	S0724F	24	6.54

8 bar	Extreme Service	Super Extreme Service	(in)	(lbs)
General Service				
Not Available	Available/req. No returns.	S0822F	22	10.63
		S0824F	24	11.59

87 bar	Extreme Service	Super Extreme Service	(in)	(lbs)
General Service				
Not Available	Available/req. No returns.	S8722F	22	9.14
		S8724F	24	9.97

9 bar	Extreme Service	Super Extreme Service	(in)	(lbs)
General Service				
Not Available	Available upon request	S0922F	22	14.00
		S0924F	24	15.28
	No returns.	S0926F	26	16.55
		S0927F	27	17.18
		S0928F	28	17.82

10 bar	Extreme Service	Super Extreme Service	(in)	(lbs)
General Service				
Not Available	Available upon request	S1022F	22	20.95
		S1024F	24	22.86
	No returns.	S1027F	27	25.72
		S1028F	28	26.67

Part #	Part #	Part #	L	Weight
11 bar General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
Not Available	Available/req. No returns.	S1124F	24	30.70
		S1128F	28	35.82

12 bar	Extreme Service	Super Extreme Service	(in)	(lbs)
General Service				
Not Available	Available upon request	S1224F	24	27.34
		S1226F	26	29.62
	No returns.	S1228F	28	31.90

Brinell
(BHN) 240
Rc - 20

Brinell
(BHN)
353 - 390
Rc 38 - 42

Brinell (BHN)
421 - 535
Rc 45 - 53

10 Foot Length Bars

Dura-Tuff's 10 foot lengths make it easy to inventory grouser bar, because they can be cut to size as needed. 10 foot bars are also occasionally welded onto scraper flights, rock crusher liners, grizzlies, grader edges and used for other applications for strength and exceptional wear.



Dura-Tuff can fulfill requests for custom sizes and shapes. For example, beveled bar is available upon request.

Part #	Part #	Part #	L	Weight
<u>10 ft bar</u> General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G03120	E03120	Not Available	120	13.30
G04120	E04120		120	19.40
G05120	E05120		120	34.00
G06120	E06120		120	18.00
G07120	E07120	S07120	120	30.20
G08120	E08120	S08120	120	53.50
G87120	E87120	S87120	120	46.00

Minimum Order - 15

<u>10 ft bar</u> General Service	Extreme Service	Super Extreme Service	(in)	(lbs)
G09120	E09120	S09120	120	70.50
G10120	E10120	S10120	120	105.50
G11120	Available upon request	S11120	120	141.70
G12120		S12120	120	126.20
G13120	No returns.	S13120	120	175.30

Minimum Order - 10

Brinell (BHN) 240	Brinell (BHN) 353 - 390	Brinell (BHN) 421 - 535
Rc - 20	Rc 38 - 42	Rc 45 - 53

Specialty Bar

<u>11 ft bar</u> General Service	Extreme Service - No Returns	Super Extreme Service	(in)	(lbs)
G10132	E10132	S10132	132	116.05
G11140	Available/req.	S11140	140	165.32

Minimum Order - 10

Brinell (BHN) 240	Brinell (BHN) 353 - 390	Brinell (BHN) 421 - 535
Rc - 20	Rc 38 - 42	Rc 45 - 53

Policies and Procedures

Mission Statement

It is our mission to provide the toughest and most durable wear products on the market. We are committed to responding to your needs with the utmost care and consideration.

Statement of Quality

At Dura-Tuff® Wear Products, LLC, we are committed to providing quality checked Dura-Tuff® products. Our numerous quality assurance tests ensure that exact standards are met and you the customer are receiving only the highest quality products and materials available.

Shipping Policy

For domestic and international land shipments, we are pleased to arrange for pickup and delivery from our dock to yours. International ocean shipments will be made from our dock to the customer's port. Unless otherwise negotiated, all orders are FOB Dura-Tuff® Wear Products, LLC plant located at 5079 West 2100 South West Valley City, Utah USA 84120. In all cases freight charges are due and payable to Dura-Tuff Wear Products, LLC no later than 30 days after pickup from our shipping dock.

Dura-Tuff® Wear Products is committed to offering great products and services at fair and competitive prices. As a customer you are free to arrange for pickup with your own truck or carrier. Otherwise we will take it upon ourselves to see that your shipping needs are met.

Lost or Damaged Freight Claims

Any freight claims for lost or damaged product must be noted on the original bill of lading upon receipt of shipment. Both the freight carrier and Dura-Tuff® Wear Products, LLC are to be made aware of loss or damage to ordered contents. Failure to advise carrier at time of delivery and to obtain a statement in writing from delivering carrier of possible loss or damage will result in claim being denied. To notify Dura-Tuff® Wear Products, LLC representatives for reordering and replacement of loss or damaged product, please call (801) 973-8900.

Return Policy

Dura-Tuff® Wear Products stands behind the quality of each of its products. Grouser Bars and Bolt-on Finish Edge Systems may be returned, providing they have not been damaged by incorrect care, including improper storage and/or installation practices. (See product warranties on pages 16 & 30). All returns are subject to a 20% repackaging and restocking fee. If the returned product is rusted, an additional 15% refurbishing charge will be added to the restocking charge. **Bar in 10 foot or longer lengths and ice lugs are not eligible for return credit. No product returns accepted after 90 days from purchase date.**

Ice Lugs

Dura-Tuff® ice lugs offer extra traction where conditions are snowy, icy, wet or swampy. The 3-5" small pieces of bar are welded right on top of the grouser bar to add additional traction in severe conditions.



Part #	Part #	L	Weight
6 bar General Service	Extreme Service	(in)	(lbs)
G0603	E0603	3	0.45
G0604	E0604	4	0.60

7 bar	Extreme Service	(in)	(lbs)
General Service			
G0703	E0703	3	0.76
G0704	E0704	4	1.01

8 bar	Extreme Service	(in)	(lbs)
General Service			
G0803	E0803	3	1.34
G0804	E0804	4	1.78

9 bar	Extreme Service	(in)	(lbs)
General Service			
G0903	E0903	3	1.76
G0904	E0904	4	2.35

10 bar	Extreme Service	(in)	(lbs)
General Service			
G1003	E1003	3	2.64
G1004	E1004	4	3.52
G1005	E1005	5	4.40

11 bar	Extreme Service	(in)	(lbs)
General Service			
G1103	E1103	3	3.54
G1104	E1104	4	4.72
G1105	E1105	5	5.90

Brinell (BHN) 240
Rc - 20

Brinell (BHN) 353-390
Rc 38 -42

Regrousering Instructions

Precautions

Proper Temperature

- > Cold metals should not be welded. Grouser bars and track shoes should be a uniform room temperature before welding.
- > Preheating can reduce cooling rates and residual stress required for weld deposit. Trimming grouser shoes provides preheat for the pad. Do not preheat grouser over 300 degrees.
- > Preheating can also be achieved by first running a 1/4 to 3/8" weld pass. This is called a heat pass where the weld will heat up both the grouser and the shoe. In cold welding conditions the heat pass should be closely followed by the fill or final weld pass.
- > Cracking can occur, if the current is too high, if the current travels too fast, if the voltage is too high, or if the grouser bar is welded on when it is too cold.
- > In order to retain the hardness of the grouser bar it is recommended that an effort be made to keep the maximum temperature reached in welding as low as possible.



Clean Surface

The track shoe must be clean and free from dirt and contaminants before any welding can take place. Rust and dirt can be a source of hydrogen and cause a weld to crack. Often the surface can be cleaned with a metal brush or metal conditioning disk.

Weld Depth

Use a full penetration weld to make get the maximum strength hold.

Proper Electrode or Wire Welding Rod

Proper Electrode is critical to the success and strength of the weld. Both the track shoes and the grouser bars are made of hardened materials which require appropriate weld strength. Consult your welding supplier for recommendations on welding hardened steel. The steel you will be welding is approximately a BHN of 443 to 543.

Preparation

Mechanized Welding (Shoes removed) Preparation

Follow the directions given by the manufacturer.

In the Field Welding (Shoes on Link Assembly) Preparation

Most welding done in the field is done manually with a stick welder. Usually, the grouser is not trimmed. During the field fabrication, the worn grouser bar should be cleaned and a pre-formed bar should be welded to it. With manual welding you will need to leave a 1/32" in gap for expansion and contraction of metals and penetration.



Welding Procedure

Position grouser bar. Place new grouser bar vertically over worn surface. Be sure to tack each end of the grouser bar to hold it in position of the weld. You will want to bead each corner of the bar to help hold it in position and avoid distortion.

The Weld

To begin welding, place the bar in a horizontal position. Start the weld in the middle and move to the outside edge. Then go to the other edge and move towards the center. This will help to reduce the overall heating. Turn the bar over and repeat this process on the opposite side.

Clean off the weld slag and finish the welding job. It may take several passes over the stringer beads. The weld should completely fill the groove between the grouser bar and the shoe, particularly near the ends. Be sure to fill all weld craters. Repeat this process on both sides of the bar.

Sources:

- 1) Undercarriage Reconditioning Bulletin, Bulletin No. MP-20, 1991 Caterpillar Inc.
- 2) Allied Construction Products web site, http://www.alliedcp.com/support/faq_griplug2.asp
- 3) Dura-Tuff® welders

DURA-TUFF® WEAR PRODUCTS, L.L.C.
GROUSER BAR LIMITED WARRANTY
TO FILE A WARRANTY CLAIM, CALL 1-801-973-8900

LIMITED WARRANTY

Dura-Tuff® Wear Products, L.L.C. warrants the Grouser Bar to be free from defects in workmanship and materials, excluding finish or cosmetic conditions or surface erosion, for a period of 90 days from date of purchase.

The above warranty shall be void if the product is (i) altered, modified, disassembled, stored improperly, abused, or not used or maintained in accordance with the instructions printed in Dura-Tuff® Wear Products, L.L.C.'s Grouser Bar Brochure and Installation Guide, (ii) not properly installed or assembled in accordance with the instructions printed in Dura-Tuff® Wear Products, L.L.C.'s Grouser Bar Brochure and Installation Guide, or (iii) used in excess of those uses set forth in current Dura-Tuff® Wear Products, L.L.C.'s Grouser Bar Brochure and Installation Guide. The above warranty also does not cover (a) defects resulting from corrosion, other components or accessories not manufactured or sold by Dura-Tuff® Wear Products, L.L.C., accident, or other abnormal, abusive, or severe operating conditions or (b) damage to the Grouser Bar caused by the welding of "ice lugs" to and subsequent separation of such ice lugs from the Grouser Bar. You, and not Dura-Tuff® Wear Products, L.L.C., are solely responsible for ensuring that all track shoes to which the Grouser Bar is attached conform with all minimum thickness and other operating requirements of the equipment manufacturer. Dura-Tuff® Wear Products, L.L.C. makes no warranty with respect to the Grouser Bar's ability to protect track shoes that do not conform with all minimum thickness and other operating requirements of the equipment manufacturer against wearing, cracking and other damage. Dura-Tuff® Wear Products, L.L.C. makes no recommendation as to height limitations for replacement of the Grouser Bars and does not endorse any such recommendations made by equipment manufacturers or other persons.

Dura-Tuff® Wear Products, L.L.C.'s obligation under this warranty is limited to the replacement of any Grouser Bar that is determined to be defective by Dura-Tuff® Wear Products, L.L.C., F.O.B. Dura-Tuff® Wear Products, L.L.C.'s production plant, freight collect. Claims shall be made under this warranty by mailing, at your expense, the Grouser Bar to Dura-Tuff® Wear Products, L.L.C., 5079 West 2100 South, Salt Lake City, Utah 84120.

Dura-Tuff® Wear Products, L.L.C. reserves the right to inspect each part for which warranty claims are filed, and if necessary, associated equipment used with the part submitted for warranty claims and their maintenance records. Parts for which warranty claims are filed must, upon request, be returned to Dura-Tuff® Wear Products, L.L.C., with transportation charges pre-paid.

The warranty is only extended to the original owner of the Grouser Bar. This warranty cannot be transferred to subsequent purchasers or owners.

The 90 day warranty period begins on the date the Grouser Bar is sold to you. However, the warranty shall become effective only after our receipt of your proof of purchase and a completed Warranty Registration Card. The Warranty Registration Card must be completed and returned to Dura-Tuff® Wear Products, L.L.C. within fourteen (14) days of your purchase. Please retain your original proof of purchase and a copy of your Warranty Registration Card for your records.

THE ABOVE WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES EXPRESSED OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, WHICH EXTENDS BEYOND THE WARRANTY SPECIFIED ABOVE, AND IN NO EVENT SHALL THIS WARRANTY BE DEEMED TO COVER INCIDENTAL OR CONSEQUENTIAL DAMAGES OF ANY PERSON.

IMPORTANT NOTICE

Included with this package is the Dura-Tuff® Wear Products, L.L.C.'s Grouser Bar Brochure and Installation Guide. Warranty registration cards can be obtained from the packaging materials, your dealer, or by calling Dura-Tuff® Wear Products, LLC at (801) 973-8900.

If you do not have these documents, or want additional copies, please contact Dura-Tuff® Wear Products, L.L.C., P.O. Box 70035, West Valley City, UT 84170 or call (801) 973-8900.



WARRANTY AND REGISTRATION CARD

Grouser Bar

Dura-Tuff® Wear Products, LLC

P.O. Box 70035

West Valley City, UT 84170

Company Name: _____

Address: _____

City: _____ State: _____ Zip Code: _____

Mailing address if different than address above:

Address: _____

City: _____ State: _____ Zip Code: _____

Telephone: () _____ - _____ Ext: _____

Cell Phone: () _____ - _____

Email Address: _____

Date of purchase: ____/____/____

Invoice number: _____

Where purchased: _____

Grouser Part #: _____

Print name

Date

Signature

Please photocopy as needed.



Bolt on Finishing Edge System

Dura-Tuff® Bolt on Finishing Edge System

Dura-Tuff® Wear Products has developed an efficient time saving device for those who wish to create a clean trench floor or a straight edge finish to any project. Their **patented** product is a reusable edge that is composed of durable hardened steel, which is attached to the bucket of a backhoe or excavator utilizing the bucket's teeth and adapters. It is installed as simply as replacing bucket teeth. The primary feature of the Bolt-On Edge system is that **no welding is required**, thus it can be installed in minutes.

The Bolt-On Edge system is available for all Excavator and Back-hoe Loaders for all makes and models.

Benefits

- > Installed or removed in less than 10 minutes
- > **No welding required** (Therefore, it is not necessary to have a welder on site)
- > Custom fit to bucket and teeth
- > Uses hardened steel for long life and durable use
- > Maintains a right angled edge
- > Reversible for double the life (most edges)
- > Eliminates the need for manual shoveling
- > Interchangeable with receiver tips (no tip waste)
- > System can be used on multiple machines

Applications

- > Smoothing trench floors for pipe laying
- > Preparing a sidewalk or driveway
- > Trenching & digging
- > Grooming hillsides, grading, and grass striping
- > Moving fines, road base, gravel
- > Adding final grading for footings and floor



Traditional weld-on edge vs. the Bolt on Finishing Edge System



Bolt on Finishing Edge System

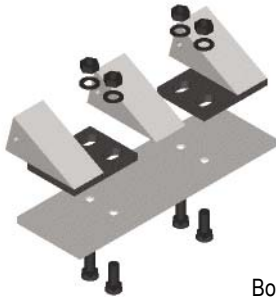


traditional weld-on finishing edge

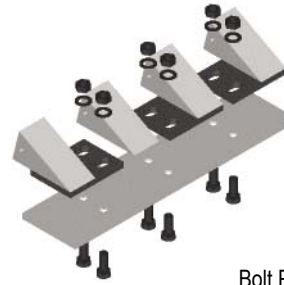
What it takes	Bolt on Finishing Edge System	Traditional
Welding required	No	Yes.
Can be installed or removed in less than 10 minutes	Yes	No, 1 st you'll need to cut & fit an edge and 2 nd weld the edge. (Could be as long as 2 hours.)
Ties up the bucket	No	Yes, but removal is not a simple process and can even be impossible.
Reversible for double the life	Yes	No, you'll need to start from scratch.
Custom fit to bucket and tooth (allows for bent or misplaced adapters)	Yes	No, if you take off the edge and your adapters bend, the edge will no longer fit.
Eliminates the need for manual shoveling	Yes	Yes, but cannot be easily removed when digging is required.
Uses hardened steel (Rockwell C hardness 42-45)	Yes	Depends, on what is available in the scrap pile.
Maintains a right angle edge	Yes	Probably not, because most scrap metal is often a soft mild steel and will wear quickly.
Removeable and then Re-useable again and again	Yes	No, a weld-on edge is not intended to be removed. You must pay a welder to have it removed or haul the torche to the job site to cut it off.

Patterns for Installation

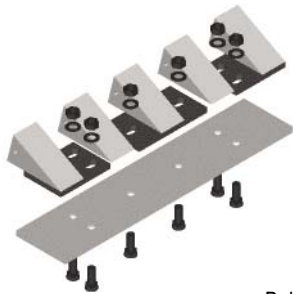
Ground Engaging Tools - Bolt on Finishing Edge System



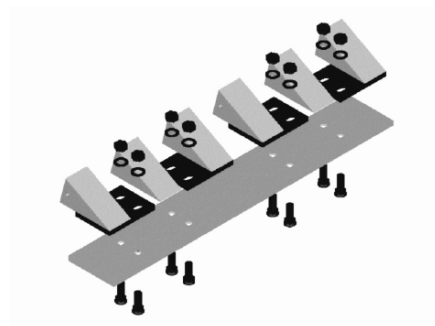
Bolt Pattern "A"
1 Left & 1 Right Receiver



Bolt Pattern "B"
2 Lefts & 1 Right Receiver



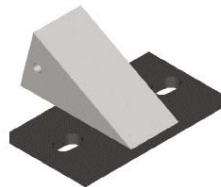
Bolt Pattern "C"
1 Left, 1 Center, & 1 Right Receiver



Bolt Pattern "D"
2 Lefts & 2 Right Receivers



Left Receiver



Center Receiver



Right Receiver

Instructions	3 items are critical for proper edge selection. *
	(1) Bucket width. (Bucket width is measured from outside edges of the teeth)
	(2) Number of teeth on the bucket
	(3) Tooth part number

* See page 28 for measuring guide.

Backhoe Loaders	Customer Information			Kit	Finish Edge	Left Receiver	Center Receiver	Right Receiver	Bolt Pattern	Bolt Size	**
	Bucket Width (*) (Inches)	Number of Teeth	Tooth Part #	Part #	Part #	Part #	Part #	Part #			No. of Bolts
MODEL											
416/416B/416C 416C IT/420 426/426B/426C 426C IT/ 428/428B 428B/428C IT 436B/436C/436C IT	12	3	1U-3202	K112	1230	1U-3202L	N/A	1U-3202R	A	3/4"	4
	16	3	1U-3202	K113	1630	1U-3202L	N/A	1U-3202R	A	3/4"	4
	16	4	1U-3202	K114	1640	1U-3202L	N/A	1U-3202R	A	3/4"	4
	18	4	1U-3202	K115	1840	1U-3202L	N/A	1U-3202R	A	3/4"	4
	24	5	1UD-3202	K116	2450	1U-3202L	1U-3202C	1U-3202R	C	3/4"	6
	30	5	1U-3202	K117	3050	1U-3202L	1U-3202C	1U-3202R	C	3/4"	6
	36	6	1U-3202	K118	3660	1U-3202L	1U-3202L	1U-3202R	B	3/4"	6
416D/420D/430D	12	3	1957206	K100	1230	1957206L	N/A	1957206R	A	3/4"	4
	16	3	1957206	K101	1630	1957206L	N/A	1957206R	A	3/4"	4
	18	4	1957206	K102	1840	1957206L	N/A	1957206R	A	3/4"	4
	24	5	1957206	K103	2450	1957206L	1957206C	1957206R	C	3/4"	6
	30	5	1957206	K104	3050	1957206L	1957206C	1957206R	C	3/4"	6
	36	6	1957206	K105	3660	1957206L	1957206L	1957206R	B	3/4"	6
	12	3	2085235	K106	1230	2085235L	N/A	2085235R	A	3/4"	4
	16	3	2085235	K107	1630	2085235L	N/A	2085235R	A	3/4"	4
	18	4	2085235	K108	1840	2085235L	N/A	2085235R	A	3/4"	4
	24	5	2085235	K109	2450	2085235L	2085235C	2085235R	C	3/4"	6
	30	5	2085235	K110	3050	2085235L	2085235C	2085235R	C	3/4"	6
	36	6	2085235	K111	3660	2085235L	2085235L	2085235R	B	3/4"	6
446/446B-446D	12	3	6Y-3222	K174	1230	6Y-3222L	N/A	6Y-3222R	A	3/4"	4
	16	3	6Y-3222	K175	1630	6Y-3222L	N/A	6Y-3222R	A	3/4"	4
	18	3	6Y-3222	K176	1830	6Y-3222L	N/A	6Y-3222R	A	3/4"	4
	18	4	6Y-3222	K177	1840	6Y-3222L	N/A	6Y-3222R	A	3/4"	4
	24	5	6Y-3222	K179	2450	6Y-3222L	6Y-3222C	6Y-3222R	C	3/4"	6
	30	5	6Y-3222	K183	3050	6Y-3222L	6Y-3222C	6Y-3222R	C	3/4"	6
	36	6	6Y-3222	K185	3660	6Y-3222L	6Y-3222L	6Y-3222R	B	3/4"	6
	12	3	2085235	K106	1230	2085235L	N/A	2085235R	A	3/4"	4
	16	3	2085235	K107	1630	2085235L	N/A	2085235R	A	3/4"	4
	18	4	2085235	K108	1840	2085235L	N/A	2085235R	A	3/4"	4
	24	5	2085235	K109	2450	2085235L	2085235C	2085235R	C	3/4"	6
	30	5	2085235	K110	3050	2085235L	2085235C	2085235R	C	3/4"	6
	36	6	2085235	K111	3660	2085235L	2085235L	2085235R	B	3/4"	6

* See page 28 for measuring guide.

** See page 23 for bolt packages.

Mini Excavator	Customer Information			Kit	Finish Edge	Left Receiver	Center Receiver	Right Receiver	Bolt Pattern	Bolt Size	** No. of Bolts
	Bucket Width (*) (Inches)	Number of Teeth	Tooth Part #	Part #	Part #	Part #	Part #	Part #			
MODEL											
307	12	3	6Y-3222	K174	1230	6Y-3222L	N/A	6Y-3222R	A	3/4"	4
	16	3	6Y-3222	K175	1630	6Y-3222L	N/A	6Y-3222R	A	3/4"	4
	20	3	6Y-3222	K178	2030	6Y-3222L	N/A	6Y-3222R	A	3-4"	4
	24	4	6Y-3222	K180	2440	6Y-3222L	N/A	6Y-3222R	A	3/4"	4
	25	4	6Y-3222	K181	2540	6Y-3222L	N/A	6Y-3222R	C	3/4"	6
	28	4	6Y-3222	K182	2840	6Y-3222L	6Y-3222L	6Y-3222R	B	3/4"	6
	30	5	6Y-3222	K183	3140	6Y-3222L	6Y-3222C	6Y-3222R	B	3/4"	6
	33	5	6Y-3222	K184	3350	6Y-3222L	6Y-3222C	6Y-3222R	C	3/4"	6
	36	6	6Y-3222	K185	3660	6Y-3222L	6Y-3222L	6Y-3222R	B	3/4"	6

* See page 28 for measuring guide.

** See chart below for bolt packages.

(**) Bolt Packages	Loader Backhoe's / Mini Excavators	Bolt	Bolt	Nut	Washer	4 Bolt PKG	6 Bolt PKG	8 Bolt PKG
		Size	Part #	Part #	Part #	Part #	Part #	Part #
		3/4"	5J4773	2J3506	5P8248	B-754	B-756	B-758
	Excavators	1"	3J2801	2J3507	5P8250	B-104	B-106	B-108

> 4 bolt pkg includes 4 bolts, 4 nuts, 4 washers

> 6 bolt pkg includes 6 bolts, 6 nuts, 6 washers

> 8 bolt pkg includes 8 bolts, 8 nuts, 8 washers

Excavator	Customer Information			Kit	Finish Edge	Left Receiver	Center Receiver	Right Receiver	Bolt Pattern	Bolt Size	** No. of Bolts	
	Bucket Width (*) (Inches)	Number of Teeth	Tooth Part #	Part #	Part #	Part #	Part #	Part #				
MODEL												
311/312/314	24	3	1U-3252	K120	2431	1U-3252L	N/A	1U-3252R	A	1"	4	
	30	4	1U-3252	K122	3041	1U-3252L	1U-3252L	1U-3252R	B	1"	6	
	36	5	1U-3252	K125	3651	1U-3252L	1U-3252C	1U-3252R	C	1"	6	
	42	5	1U-3252	K128	4251	1U-3252L	1U-3252C	1U-3252R	C	1"	6	
	48	5	1U-3252	K130	4851	1U-3252L	1U-3252C	1U-3252R	C	1"	6	
315/318	24	3	1U-3302	K134	2431	1U-3302L	N/A	1U-3302R	A	1"	4	
	30	4	1U-3302	K136	3041	1U-3302L	1U-3302L	1U-3302R	B	1"	6	
	36	5	1U-3302	K139	3651	1U-3302L	1U-3302C	1U-3302R	C	1"	6	
	42	5	1U-3302	K143	4251	1U-3302L	1U-3302C	1U-3302R	C	1"	6	
	48	6	1U-3302	K146	4861	1U-3302L	(1)	1U-3302R	D	1"	8	
	24	3	1U-3352	K148	2431	1U-3352L	N/A	1U-3352R	A	1"	4	
	30	4	1U-3352	K151	3041	1U-3352L	1U-3352L	1U-3352R	B	1"	6	
	36	4	1U-3352	K155	3641	1U-3352L	1U-3352L	1U-3352R	B	1"	6	
	36	5	1U-3352	K156	3651	1U-3352L	1U-3352C	1U-3352R	C	1"	6	
	42	5	1U-3352	K158	4251	1U-3352L	1U-3352C	1U-3352R	C	1"	6	
	48	6	1U-3352	K162	4861	1U-3352L	(1)	1U-3352R	D	1"	8	
	320 321	24	3	1U-3352	K148	2431	1U-3352L	N/A	1U-3352R	A	1"	4
		30	3	1U-3352	K152	3031	1U-3352L	1U-3352C	1U-3352R	C	1"	6
30		4	1U-3352	K151	3041	1U-3352L	1U-3352L	1U-3352R	B	1"	6	
36		5	1U-3352	K156	3651	1U-3352L	1U-3352C	1U-3352R	C	1"	6	
42		5	1U-3352	K158	4251	1U-3352L	1U-3352C	1U-3352R	C	1"	6	
43		5	1U-3352	K159	4351	1U-3352L	1U-3352C	1U-3352R	C	1"	6	
48		6	1U-3352	K162	4861	1U-3352L	(1)	1U-3352R	D	1"	8	
54		7	1U-3352	K164	5471	1U-3352L	(1)	1U-3352R	D	1"	8	
30		3	7T-3402	K186	3031	7T-3402L	7T-3402C	7T-3402R	C	1"	6	
36		4	7T-3402	K187	3641	7T-3402L	7T-3402L	7T-3402R	B	1"	6	
42		5	7T-3402	K188	4251	7T-3402L	7T-3402C	7T-3402R	C	1"	6	
48		5	7T-3402	K190	4851	7T-3402L	7T-3402C	7T-3402R	C	1"	6	
54		6	7T-3402	K191	5461	7T-3402L	(1)	7T-3402R	D	1"	8	
60		7	7T-3402	K194	6071	7T-3402L	(1)	7T-3402R	D	1"	8	
66		7	7T-3402	K196	6671	7T-3402L	(1)	7T-3402R	D	1"	8	

Note: (1) Requires an additional (Left) and (Right) receiver. Warranty void if not used.

* See page 28 for measuring guide.

** See page 23 for bolt packages.

Excavator	Customer Information			Kit	Finish Edge	Left Receiver	Center Receiver	Right Receiver	Bolt Pattern	Bolt Size	** No. of Bolts
	Bucket Width (*) (Inches)	Number of Teeth	Tooth Part #	Part #	Part #	Part #	Part #	Part #			
MODEL											
322	24	3	1U-3352	K148	2431	1U-3352L	N/A	1U-3352R	A	1"	4
	30	4	1U-3352	K151	3041	1U-3352L	1U-3352L	1U-3352R	B	1"	6
	36	5	1U-3352	K156	3651	1U-3352L	1U-3352C	1U-3352R	C	1"	6
	42	5	1U-3352	K158	4251	1U-3352L	1U-3352C	1U-3352R	C	1"	6
	43	5	1U-3352	K159	4351	1U-3352L	1U-3352C	1U-3352R	C	1"	6
	48	6	1U-3352	K162	4861	1U-3352L	(1)	1U-3352R	D	1"	8
	54	7	1U-3352	K164	5471	1U-3352L	(1)	1U-3352R	D	1"	8
	30	3	7T-3402	K186	3031	7T-3402L	7T-3402C	7T-3402R	C	1"	6
	36	4	7T-3402	K187	3641	7T-3402L	7T-3402L	7T-3402R	B	1"	6
	42	5	1U-3352	K188	4251	1U-3352L	1U-3352C	1U-3352R	C	1"	6
	48	5	7T-3402	K190	4851	7T-3402L	7T-3402C	7T-3402R	C	1"	6
	54	6	7T-3402	K191	5461	7T-3402L	(1)	7T-3402R	D	1"	8
	60	6	7T-3402	K195	6061	7T-3402L	(1)	7T-3402R	D	1"	8
	60	7	7T-3402	K194	6071	7T-3402L	(1)	7T-3402R	D	1"	8
	55	5	9W-8452	K205	5552	9W-8452L	9W-8452C	9W-8452R	C	1"	6
	60	6	9W-8452	K206	6062	9W-8452L	(1)	9W-8452R	D	1"	8
	64	6	9W-8452	K208	6462	9W-8452L	(1)	9W-8452R	D	1"	8
	325 330	36	5	1U-3352	K156*	3651	1U-3352L	1U-3352C	1U-3352R	C	1"
42		5	1U-3352	K158	4251	1U-3352L	1U-3352C	1U-3352R	C	1"	6
48		6	1U-3352	K162	4861	1U-3352L	(1)	1U-3352R	D	1"	8
54		7	1U-3352	K164	5471	1U-3352L	(1)	1U-3352R	D	1"	8
30		3	7T-3402	K186	3031	7T-3402L	7T-3402C	7T-3402R	C	1"	6
36		4	7T-3402	K187	3641	7T-3402L	7T-3402L	7T-3402R	B	1"	6
42		5	7T-3402	K188	4251	7T-3402L	7T-3402C	7T-3402R	C	1"	6
48		5	7T-3402	K190	4851	7T-3402L	7T-3402C	7T-3402R	C	1"	6
54		5	7T-3402	K192	5451	7T-3402L	7T-3402C	7T-3402R	C	1"	6
54		6	7T-3402	K191	5461	7T-3402L	(1)	7T-3402R	D	1"	8
60		6	7T-3402	K195	6061	7T-3402L	(1)	7T-3402R	D	1"	8
60		7	7T-3402	K194	6071	7T-3402L	(1)	7T-3402R	D	1"	8
66		7	7T-3402	K196	6671	7T-3402L	(1)	7T-3402R	D	1"	8
72		7	7T-3402	K197	7271	7T-3402L	(1)	7T-3402R	D	1"	8
30		3	9W-8452	K198	3032	9W-8452L	N/A	9W-8452R	A	1"	4
36		3	9W-8452	K199	3632	9W-8452L	9W-8452C	9W-8452R	C	1"	6
42		4	9W-8452	K201	4242	9W-8452L	9W-8452L	9W-8452R	B	1"	6
42		5	9W-8452	K202	4252	9W-8452L	9W-8452C	9W-8452R	C	1"	6
48		5	9W-8452	K203	4852	9W-8452L	9W-8452C	9W-8452R	C	1"	6
54		5	9W-8452	K204	5452	9W-8452L	9W-8452C	9W-8452R	C	1"	6
55	5	9W-8452	K205	5552	9W-8452L	9W-8452C	9W-8452R	C	1"	6	
60	6	9W-8452	K206	6062	9W-8452L	(1)	9W-8452R	D	1"	8	
66	6	9W-8452	K209	6662	9W-8452L	(1)	9W-8452R	D	1"	8	
72	7	9W-8452	K211	7272	9W-8452L	(1)	9W-8452R	D	1"	8	

Note: (1) Requires an additional (Left) and (Right) receiver. Warranty void if not used.

* See page 28 for measuring guide.

** See page 23 for bolt packages.

Excavator	Customer Information			Kit	Finish Edge	Left Receiver	Center Receiver	Right Receiver	Bolt Pattern	Bolt Size	** No. of Bolts
	Bucket Width (*) (Inches)	Number of Teeth	Tooth Part #								
MODEL											
345	48	5	7T-3402	K10	4851	7T-3402L	7T-3402C	7T-3402R	C	1"	6
	30	3	9W-8452	K198	3032	9W-8452L	N/A	9W-8452R	A	1"	4
	36	3	9W-8452	K199	3632	9W-8452L	9W-8452C	9W-8452R	C	1"	6
	36	4	9W-8452	K200	3642	9W-8452L	9W-8452L	9W-8452R	B	1"	6
	42	4	9W-8452	K201	4242	9W-8452L	9W-8452L	9W-8452R	B	1"	6
	48	5	9W-8452	K203	4852	9W-8452L	9W-8452C	9W-8452R	C	1"	6
	54	5	9W-8452	K204	5452	9W-8452L	9W-8452C	9W-8452R	C	1"	6
	60	6	9W-8452	K206	6062	9W-8452L	(1)	9W-8452R	D	1"	8
	62	6	9W-8452	K207	6262	9W-8452L	(1)	9W-8452R	D	1"	8
	66	6	9W-8452	K209	6662	9W-8452L	(1)	9W-8452R	D	1"	8
	68	7	9W-8452	K210	6872	9W-8452L	(1)	9W-8452R	D	1"	8
	72	7	9W-8452	K211	7272	9W-8452L	(1)	9W-8452R	D	1"	8
	36	3	9W-8552	K212	3632	9W-8552L	9W-8552C	9W-8552R	C	1"	6
	48	4	9W-8552	K214	4842	9W-8552L	9W-8552L	9W-8552R	B	1"	6
	54	4	9W-8552	K215	5442	9W-8552L	9W-8552L	9W-8552R	B	1"	6
	60	5	9W-8552	K216	6052	9W-8552L	9W-8552C	9W-8552R	C	1"	6
	75	6	9W-8552	K219	7562	9W-8552L	(1)	9W-8552R	D	1"	8
365	40	3	9W-8552	K213	4032	9W-8552L	9W-8552C	9W-8552R	C	1"	6
	48	4	9W-8552	K214	4842	9W-8552L	9W-8552L	9W-8552R	B	1"	6
	60	5	9W-8552	K216	6052	9W-8552L	9W-8552C	9W-8552R	C	1"	6
	66	5	9W-8552	K217	6652	9W-8552L	(1)	9W-8552R	D	1"	8
	75	6	9W-8552	K219	7562	9W-8552L	(1)	9W-8552R	D	1"	8
	79	4	6I-6602	K172	7943	6I-6602L	(1)	6I-6602R	D	1"	8
	89	5	6I-6602	K173	8953	6I-6602L	(1)	6I-6602R	C	1"	6
385	42	3	6I-6602	K167	4233	6I-6602L	6I-6602C	6I-6602R	C	1"	6
	54	4	6I-6602	K168	5443	6I-6602L	(1)	6I-6602R	D	1"	8
	66	4	6I-6602	K170	6643	6I-6602L	(1)	6I-6602R	D	1"	8
	78	5	6I-6602	K171	7853	6I-6602L	(1)	6I-6602R	C	1"	6

Note: (1) Requires an additional (Left) and (Right) receiver. Warranty void if not used.

* See page 28 for measuring guide.

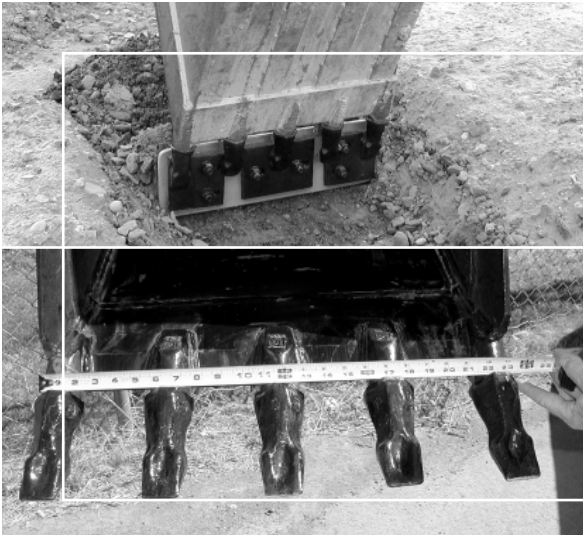
** See page 23 for bolt packages.

Excavator	Customer Information			Kit	Finish Edge	Left Receiver	Center Receiver	Right Receiver	Bolt Pattern	Bolt Size	** No. of Bolts
	MODEL	Bucket Width (*) (Inches)	Number of Teeth	Tooth Part #	Part #	Part #	Part #	Part #			
This Section is for Older Bucket Configurations	20	3	1U-3252	K119	2031	1U-3252L	N/A	1U-3252R	A	1"	4
	28	4	1U-3252	K121	2841	1U-3252L	N/A	1U-3252R	A	1"	4
	32	4	1U-3252	K123	3241	1U-3252L	1U-3252L	1U-3252R	B	1"	6
	35	5	1U-3252	K124	3551	1U-3252L	1U-3252C	1U-3252R	C	1"	6
	39	5	1U-3252	K126	3951	1U-3252L	1U-3252C	1U-3252R	C	1"	6
	40	5	1U-3252	K127	4051	1U-3252L	1U-3252C	1U-3252R	C	1"	6
	43	5	1U-3252	K129	4351	1U-3252L	1U-3252C	1U-3252R	C	1"	6
	52	6	1U-3252	K131	5261	1U-3252L	(1)	1U-3252R	D	1"	8
	56	6	1U-3252	K132	5661	1U-3252L	(1)	1U-3252R	D	1"	8
	20	3	1U-3302	K133	2031	1U-3302L	N/A	1U-3302R	A	1"	4
	28	3	1U-3302	K135	2831	1U-3302L	N/A	1U-3302R	A	1"	4
	32	4	1U-3302	K137	3241	1U-3302L	1U-3302L	1U-3302R	B	1"	6
	35	5	1U-3302	K138	3551	1U-3302L	1U-3302C	1U-3302R	C	1"	6
	36	4	1U-3302	K140	3641	1U-3302L	1U-3302L	1U-3302R	B	1"	6
	39	5	1U-3302	K141	3951	1U-3302L	1U-3302C	1U-3302R	C	1"	6
	40	4	1U-3302	K142	4041	1U-3302L	1U-3302L	1U-3302R	B	1"	6
	42	6	1U-3302	K144	4261	1U-3302L	1U-3302L	1U-3302R	B	1"	6
	44	5	1U-3302	K145	4451	1U-3302L	1U-3302C	1U-3302R	C	1"	6
	48	5	1U-3302	K147	4851	1U-3302L	1U-3302C	1U-3302R	C	1"	6
	27	3	1U-3352	K149	2731	1U-3352L	N/A	1U-3352R	A	1"	4
	28	4	1U-3352	K150	2841	1U-3352L	N/A	1U-3352R	A	1"	4
	31	4	1U-3352	K153	3141	1U-3352L	1U-3352L	1U-3352R	B	1"	6
	32	4	1U-3352	K154	3241	1U-3352L	1U-3352L	1U-3352R	B	1"	6
	40	5	1U-3352	K157	4051	1U-3352L	1U-3352C	1U-3352R	C	1"	6
	44	5	1U-3352	K161	4451	1U-3352L	1U-3352C	1U-3352R	C	1"	6
	48	5	1U-3352	K163	4851	1U-3352L	1U-3352C	1U-3352R	C	1"	6
	54	6	1U-3352	K165	5461	1U-3352L	(1)	1U-3352R	D	1"	8
	60	7	1U-3352	K166	6071	1U-3352L	(1)	1U-3352R	D	1"	8
	55	5	7T-3402	K193	5551	7T-3402L	7T-3402C	7T-3402R	C	1"	6
	67	6	9W-8552	K218	6762	9W-8552L	(1)	9W-8552R	D	1"	8
78	6	9W-8552	K220	7862	9W-8552L	(1)	9W-8552R	D	1"	8	
60	5	6I-6602	K169	6053	6I-6602L	6I-6602C	6I-6602R	C	1"	6	

Note: (1) Requires an additional (Left) and (Right) receiver. Warranty void if not used.

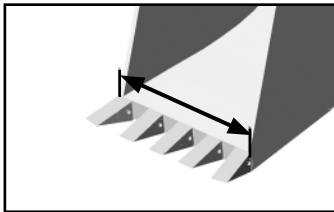
* See page 28 for measuring guide.

** See page 23 for bolt packages.



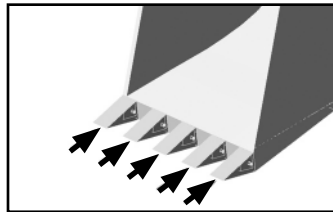
* Fax in Measuring Guide Bolt on Finishing Edge System

All Buckets



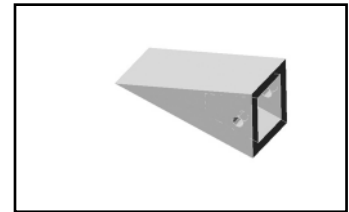
- 1** Measure the bucket width from the outer edge of the left tooth to the outer edge of the right tooth.

_____ inches (i.e. 42")



- 2** Count the number of teeth on your bucket.

_____ teeth (i.e. 5 teeth)



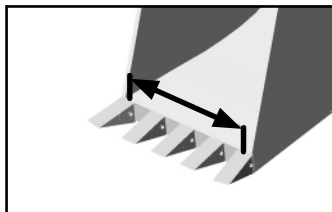
- 3** Find out what tooth part number you are using.

_____ tip size (i.e. 1U-3202)

Additional Information Needed for Non-Cat Buckets

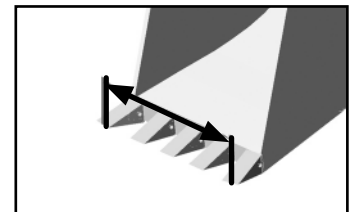
Many non-CAT buckets have different angles on their outside teeth.

If your bucket is not manufactured by CAT please proceed to measurements #4 and #5.



- 4** Help us measure the tooth angle by first measuring from the top middle of the far left tooth to the top middle of the far right tooth.

_____ inches (i.e. 40")



- 5** Then measure from the bottom middle of the far left tooth to the bottom middle of the far right tooth.

_____ inches (i.e. 42")

PO # _____

Signature _____

Date ____/____/____

Please Fax this form back to 801.973.4884.

Bolt on Finishing Edge System

Installation Guide



1 Remove the two outside teeth. (A middle tooth is also required for larger buckets.)



2 Replace bucket teeth with the Bolt on Finishing Edge System receivers.

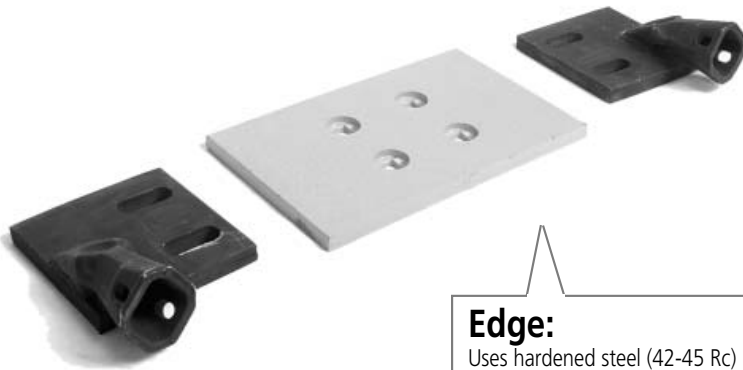


3 Use the Torque wrench to tighten the plow bolts and hold the Edge in place.

Three things are critical to proper Edge selection.

1. Bucket Width, 2. Number of Teeth on bucket, 3. Tooth Size

(Consult the pattern guide on page 21 for proper receiver and Edge placement. Larger buckets require a larger Edge, more receivers, and more bolts.)



Receivers:

Allows for quick on/off changes
Custom fit to bucket and tooth system

Edge:

Uses hardened steel (42-45 Rc)
Reversible for double the wear
Maintains a right angle while operating

Hardware:

Consists of plow bolts, nuts & washers
Fast easy change outs

Tools Needed

- Torque wrench
- 1.125 socket for a backhoe
- 1.5 socket for an excavator
- Hammer
- Pin Master -Talk to your dealer to find out which size you need.

DURA-TUFF® WEAR PRODUCTS, L.L.C.
BOLT-ON EDGE SYSTEM LIMITED WARRANTY
TO FILE A WARRANTY CLAIM, CALL 1-801-973-8900

LIMITED WARRANTY

Dura-Tuff® Wear Products, L.L.C. warrants the following products to be free from defects in workmanship and materials, excluding finish or cosmetic conditions or surface erosion, for a period of ninety (90) days from date of manufacture:

- Bolt-On Edge System Finishing Edge; and
- Bolt-On Edge System Receiver.

The above warranty shall be void if the product is (i) altered, modified, disassembled, stored improperly, abused, or not used or maintained in accordance with the instructions printed in Dura-Tuff® Wear Products, L.L.C.'s Bolt-On Finish Edge System Installation Brochure, (ii) used for any earth-moving activity other than final grade finishing or loose material handling, (iii) not properly installed or assembled, or (iv) used in excess of those uses set forth in current Dura-Tuff Wear Products, L.L.C. literature. The above warranty also does not cover defects resulting from corrosion, other components or accessories not manufactured or sold by Dura-Tuff® Wear Products, L.L.C., accident, or other abnormal, abusive, or severe operating conditions, ie: breaking up concrete or asphalt during demolition or construction.

Dura-Tuff® Wear Products, L.L.C.'s obligation under this warranty is limited to the replacement of any product that proves to be defective with a Bolt-On Finish Edge System product of like size and type, F.O.B. Dura-Tuff® Wear Products, L.L.C.'s production plant, freight collect. Claims shall be made under this warranty by shipping, at your expense, the Bolt-On Finish Edge System and/or Bolt-On Edge Finish Edge System Receiver to Dura-Tuff Wear Products, L.L.C., 5079 West 2100 South, Salt Lake City, Utah 84120.

Dura-Tuff® Wear Products, L.L.C. reserves the right to inspect each part for which warranty claims are filed, and if necessary, associated equipment used with the party submitted for warranty claims and their maintenance records. Parts for which warranty claims are filed must, upon request, be returned to Dura-Tuff® Wear Products, L.L.C., with transportation charges pre-paid.

The warranty is only extended to the original owner of the Bolt-On Finish Edge System and/or Bolt-On Finish Edge System Receiver. This warranty cannot be transferred to subsequent purchasers or owners.

The 90-day warranty period begins on the date the Bolt-On Finish Edge System and/or Bolt-On Finish Edge System Receiver is sold to you. However, the warranty shall become effective only after our receipt of your proof of purchase and a completed Warranty Registration Card. The Warranty Registration Card must be completed and returned to Dura-Tuff® Wear Products, L.L.C., P.O. Box 708273, Sandy, UT 84070-8273 within 14 days of your purchase. Please retain your original proof of purchase and a copy of your Warranty Registration Card for your records.

THE ABOVE WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES EXPRESSED OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, WHICH EXTENDS BEYOND THE WARRANTY SPECIFIED ABOVE, AND IN NO EVENT SHALL THIS WARRANTY BE DEEMED TO COVER INCIDENTAL OR CONSEQUENTIAL DAMAGES OF ANY PERSON.

IMPORTANT NOTICE

Included with this package is the Dura-Tuff® Wear Products, L.L.C.'s Bolt-On Finish Edge System Installation Brochure and Warranty Registration Card.

If you do not have these documents, or want additional copies, please contact Dura-Tuff® Wear Products, L.L.C., P.O. Box 70035, West Valley City, UT 84170 or call (801) 973-8900.



WARRANTY AND REGISTRATION CARD

Bolt on Finishing Edge System

Dura-Tuff® Wear Products, LLC

P.O. Box 70035

West Valley City, UT 84170

Company Name: _____

Address: _____

City: _____ State: _____ Zip Code: _____

Mailing address if different than address above:

Address: _____

City: _____ State: _____ Zip Code: _____

Telephone: () _____ - _____ Ext: _____

Cell Phone: () _____ - _____

Email Address: _____

Date of purchase: _____ / _____ / _____

Invoice number: _____

Where purchased: _____

Receiver Part #:

Left _____ Left _____ Right _____ Right _____ Center _____

Print name

Date

Signature

Please photocopy as needed.



DURA-TUFF®

Wear Products, LLC

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