

Cat[®] Ground Engaging Tools

Caterpillar. The difference counts.™

NEW LEVEL EDGE TIPS FOR K SERIES™ BUCKETS

This IRM introduces K80, K90 and K100 Level Edge bucket tips to allow dealer or customer attached weld-on “leveling” or “smoothing” edges for 315 thru 325 excavator buckets and certain 938 thru 980 loader buckets. These tips supplement the line of K Series™ parts previously released for these products and provide extended versatility to customers using K Series buckets. The new part numbers are listed in Attachment 1.



This picture shows a level edge attached to a K Series bucket. Level edge tips are utilized at positions 2 and 4. The other positions are using regular K Series tips.

Level Edge Tips

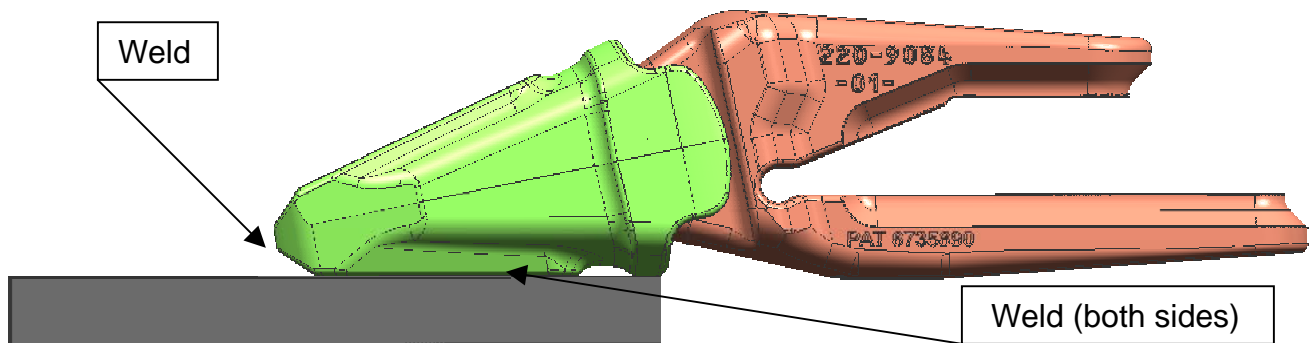
Level edge tips are designed to allow the installation of a level edge assembly on a bucket in lieu of standard bucket tips. This is generally accomplished by welding a length of straight edge material to several bucket tips so the resultant level edge assembly can be attached to the bucket adapters. This provides a system that can be used for leveling the finish cut, cleaning excess material from flat surfaces, or other work where a flat bucket edge is occasionally required. The “twist-on” feature of K Series tips requires a special, no-twist tip to meet this application requirement.

For Dealer Sales Personnel

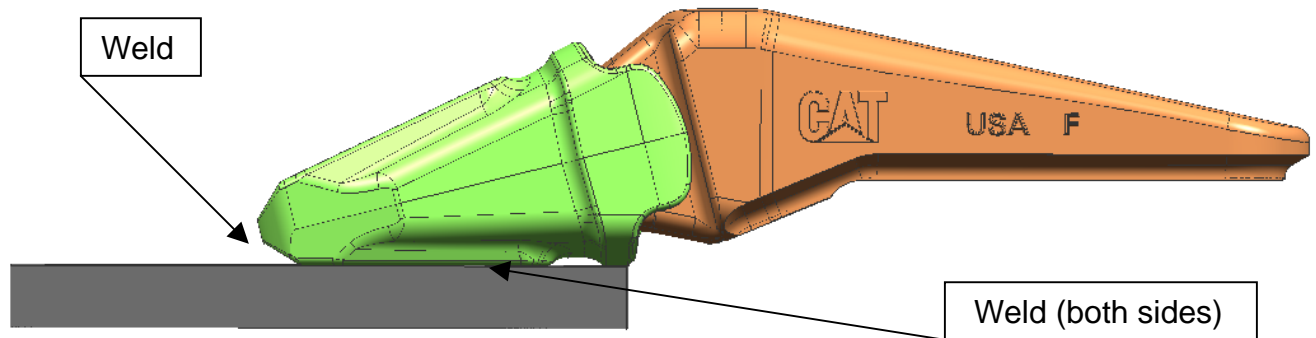
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Features of K Series™ Level Edge Tips

The new level edge tips are designed for easy fabrication of a bucket leveling edge assembly. They have flat surfaces with weld grooves on the top and bottom to allow use on either K Series™ excavator buckets with 2-strap adapters or straight edge loader buckets made with weld-on adapters. The tip can be reversed to provide an edge assembly parallel to the bucket base edge in either a loader or excavator application.



Typical excavator bottom-side installation of edge to tip



Typical installation of edge to tip (opposite side) bottom-side with flushmount adapter

The edge can also be welded to the top surface of the tips if desired. Level edge tips are cast from DH-2™ alloy steel, similar to weld-on adapters. Adapter welding procedures, pre-heat, etc. should be followed. See REHS0597 for welding parameters. They are not as hard as regular K Series tips and there is no substantial amount of wears material. They should not be used as digging tips, since wear life and performance will not be acceptable.

Installation

Generally, the flat edge is welded to at least two level edge tips and the assembly installed on the two adapters next to the corner adapters. Additional interior tips/adapters can be used if desired. The outward angle of the corner adapters in most Caterpillar® buckets with K Series™ tools prevents the use of level edge tips in the corner positions. Testing has proven a K Series level edge assembly can successfully function in this configuration or when installed on the single center adapter of a three-tooth bucket.

Regular K Series bucket tips can be used in the other adapter positions, although level edge tips are not compatible with Heavy Penetration or Heavy Abrasion tips.

When welding on the flat edge, it is recommended to have all the level edge tips assembled on their respective adapters with retainer assemblies correctly installed prior to welding. Follow adapter-welding procedure. Alternate welds to minimize distortion. This will help keep the assembly aligned during the welding process for better assurance of the ability to remove and install the level edge assembly.

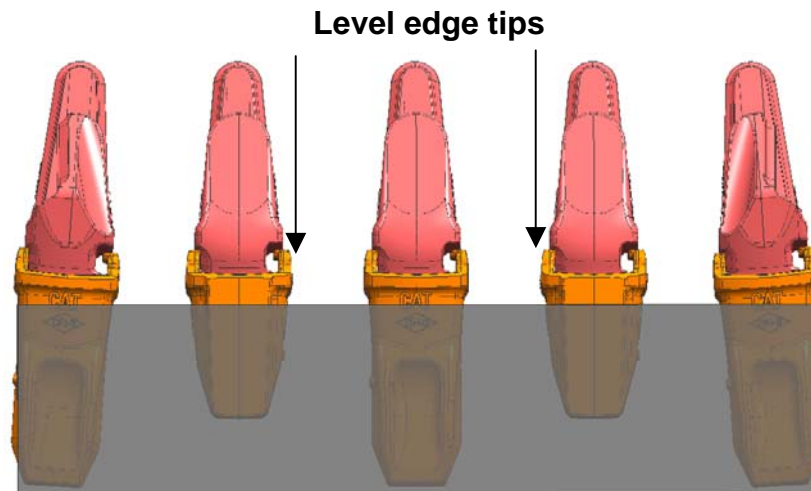


Illustration of top-installed level edge assembly on 5-tooth K Series excavator bucket and General Duty tips

Warranty

Caterpillar level edge tips are warranted against breakage during normal operation for the useful life of the part. Failures resulting from improper welding process are not warranty.

Summary

- DH-2™ steel castings slide straight onto adapters
- Excavator or loader applications
- Flat top and bottom surfaces with weld groove to accept leveling edge
- Can be configured parallel to bucket base edge
- Enhance bucket versatility
- Use standard drive-thru retainer
- Compatible with all styles Caterpillar K Series™ tips except Heavy Penetration and Heavy Abrasion
- Not for use on angled corner adapters

| <u>Part No.</u> | <u>Adapter Size</u> | <u>Retainer</u> |
|------------------------|----------------------------|------------------------|
| 232-0082 | K80 | 220-9090 |
| 232-0092 | K90 | 220-9090 |
| 232-0102 | K100 | 220-9090 |

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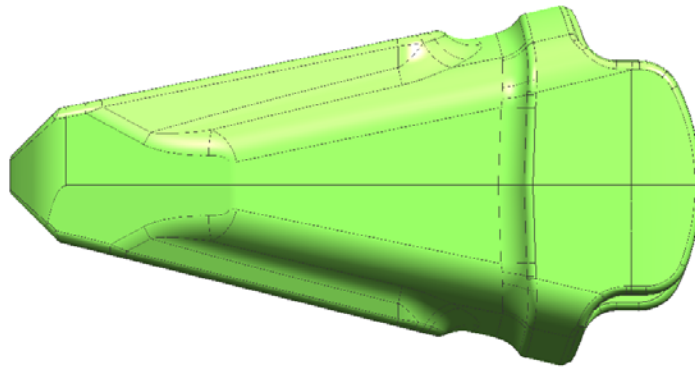
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Attachment 1

Level Edge Tip Part Numbers



| <u>Adapter Size</u> | <u>Part Number</u> | <u>Retainer</u> |
|---------------------|--------------------|-----------------|
| K80 | 232-0082 | 220-9090 |
| K90 | 232-0092 | 220-9090 |
| K100 | 232-0102 | 220-9090 |