**RH-2534-230 ASSEMBLY**
Consist of:
1 - RH-2534 Box
1 - G-1023-23 Scarifier
1 - 230ST Star Tooth
1 - 23FP Flexpin
1 - .75” X 4” HTCS Hardware
1 - .75” X 2½” HTCS Safety Bolt

**RH-1857E-240 ASSEMBLY**
Consist of:
1 - RH-1857B Box
1 - G-839A-24 Scarifier
1 - 240ST Star Tooth
1 - 24FP Flexpin
1 - 1.00” X 5” HTCS Hardware
1 - 1.00” X 3” HTCS Safety Bolt

**RH-1857L-252 ASSEMBLY**
Consist of:
1 - RH-1857C Box
1 - G-839F-25 Scarifier
1 - 252ST Star Tooth
1 – 25-26FP Flexpin
1 - 1.00” X 6” HTCS Hardware
1 - 1.00” X 3½” HTCS Safety Bolt

**RH-2628-18 ASSEMBLY**
Consist of:
1 - RH-2628 Box
1 - G-1040-18 Scarifier
1 - 18 Ripping Tooth
1 – 18FP Flexpin
1 - 1.00” X 7” HTCS Hardware
1 - 1.00” X 4” HTCS Safety Bolt

**RH-2034G-19 ASSEMBLY**
Consist of:
1 - RH-2034A Box
1 - G-910F-19 Scarifier
1 – 19 Star Tooth
1 – 19-36FP Flexpin
1 - 1.25” X 8” HTCS Hardware
1 - 1.25” X 5” HTCS Safety Bolt
INSTRUCTIONS for Attaching Backhoe Ripper Boxes

A. Place centerline of the “Dipper Stick” in vertical position.
B. Rotate bucket from full “Open Position 1” to full “Closed Position 3” to determine your “Bucket Arc”.
C. Open bucket 1/3 distance on the bucket arc, “Mounting Position 2”. This establishes the proper location for box mounting.
D. Mount Ripper Box Assembly to the rear of the bucket with Scarifier shank in vertical alignment with dipper stick centerline.
E. It may become necessary to trim the ripper box to match the contour of your bucket.

Welding Guide Lines:
Preheat the weld areas 400 - 600°F (204 – 315°C). Use ¼” diameter A.W.S. grade 7018 low hydrogen welding rod.