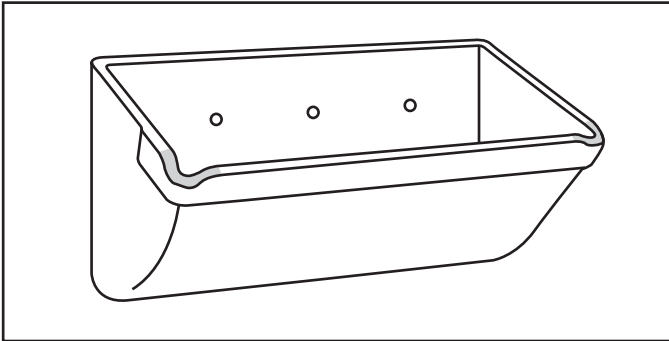
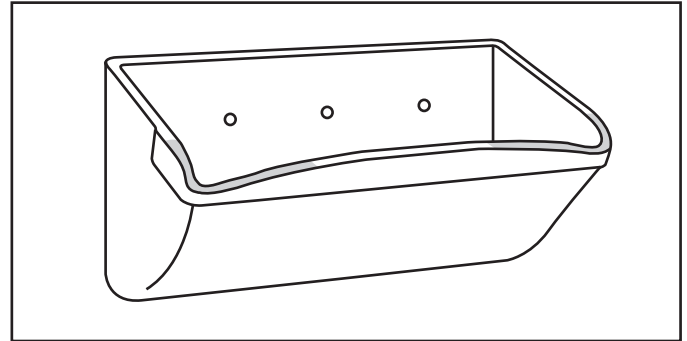


ELEVATOR BUCKET INSPECTION GUIDELINES

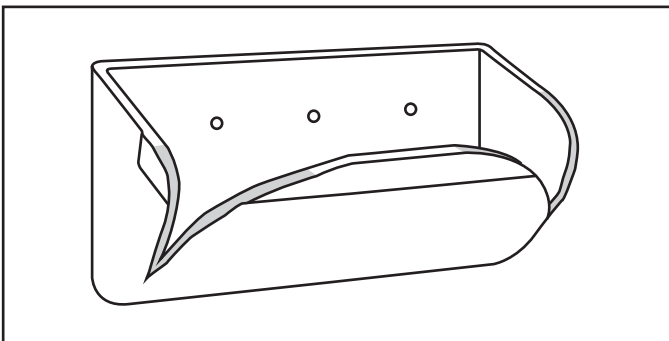
WEAR - Typical Patterns



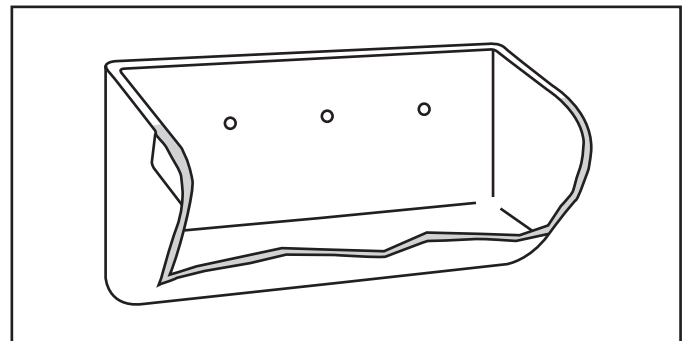
STAGE 1. Corners show minor wear, capacity close to 100%



STAGE 2. Corners show more wear, capacity reduced to 90-95%

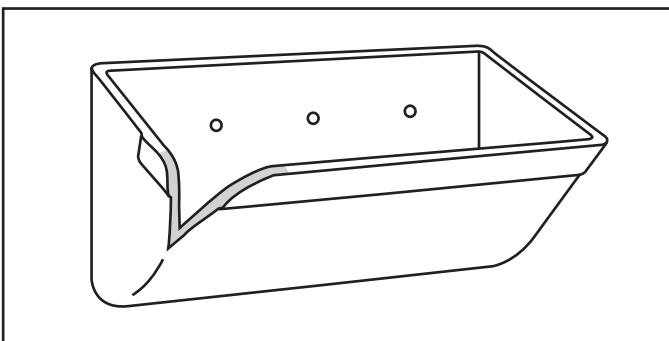


STAGE 3. Corners worn out, may discharge erratically, bucket losing significant capacity

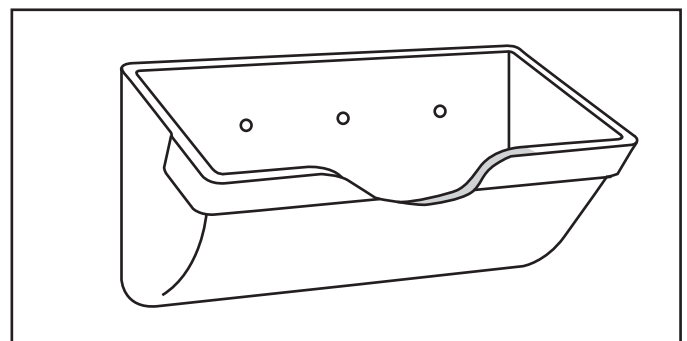


STAGE 4. Front of bucket has broken off

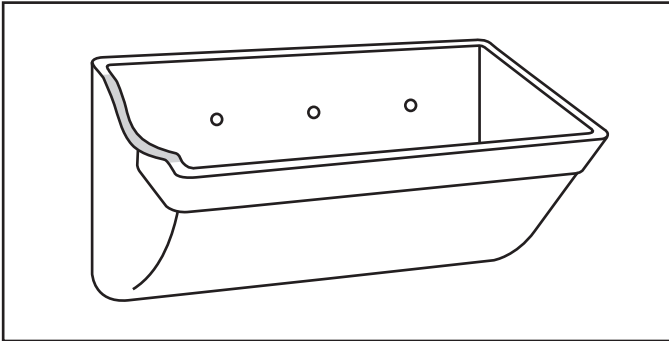
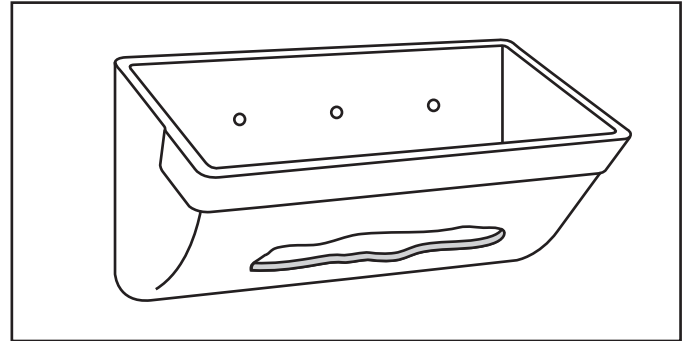
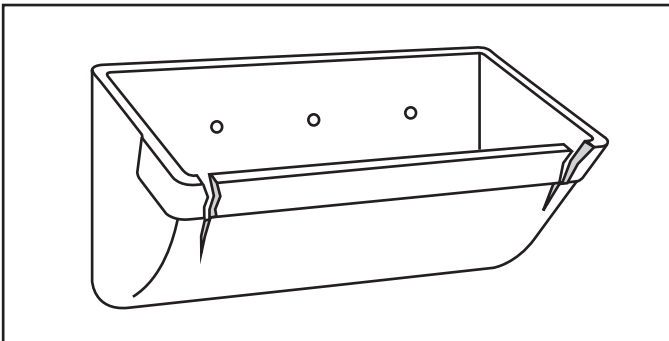
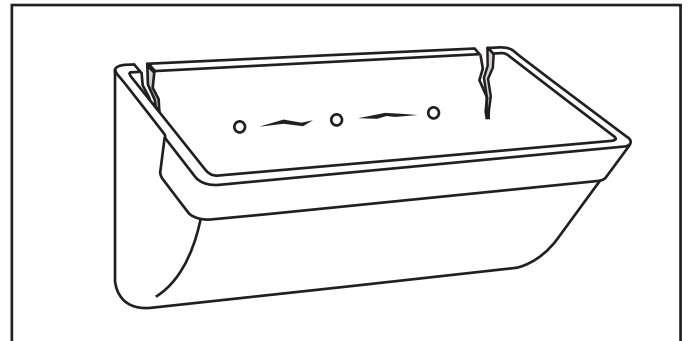
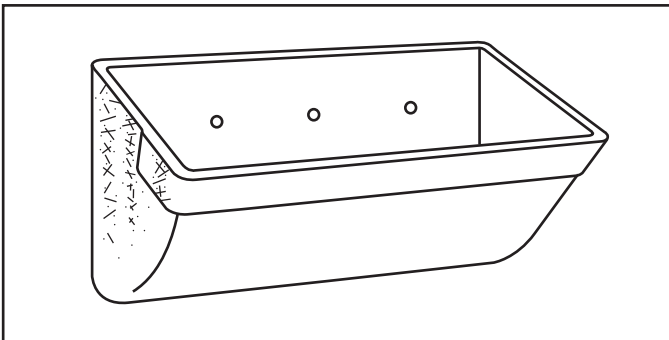
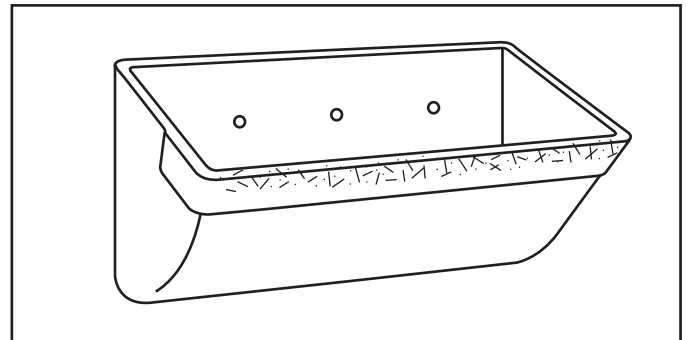
PREMATURE WEAR - Material Flow / Loading Issues



Uneven Wear - Corner



Uneven Wear - Middle

PREMATURE WEAR (Cont.) - Material Flow / Loading Issues**Uneven Wear - Side****Bottom Wear - Hole in bottom of bucket,
loading at a poor angle****CRACKING****Front Corner Cracking - Excessive digging
impact****Back Corner Cracking - Excessive crown on
head pulley, impact on front lip,
or excessive torque on bolts****RUBBING - Tracking / Take-up Issues****Bucket rubbing on casing of elevator
causing marks on side of bucket****Bucket rubbing on casing or bottom of
boot causing marks on front of bucket**