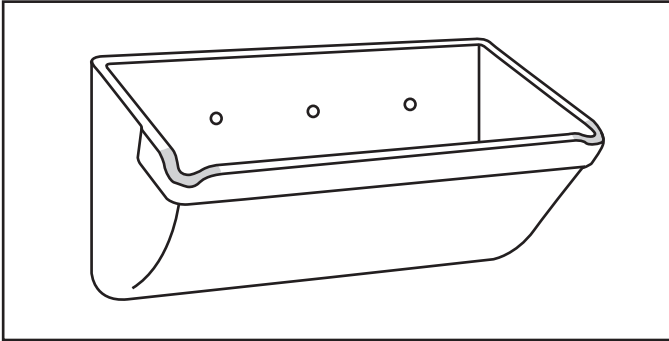
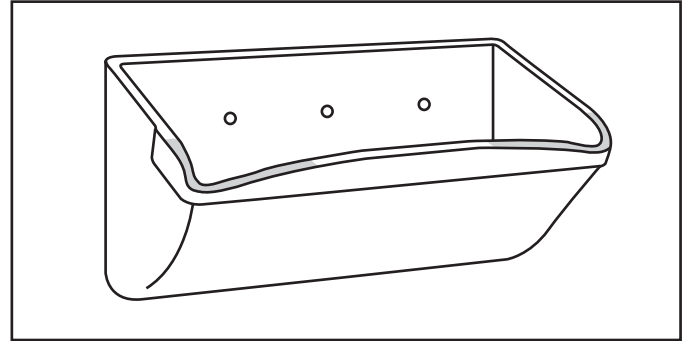


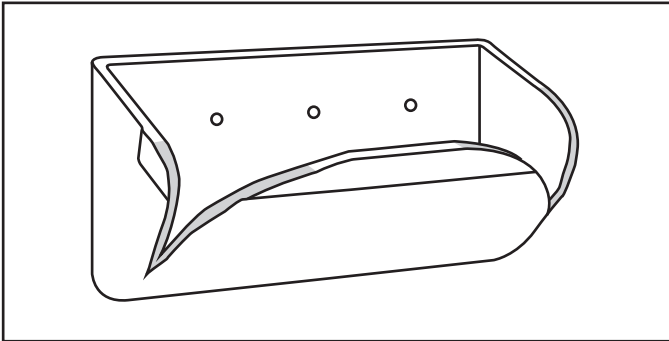
WEAR - Typical Patterns



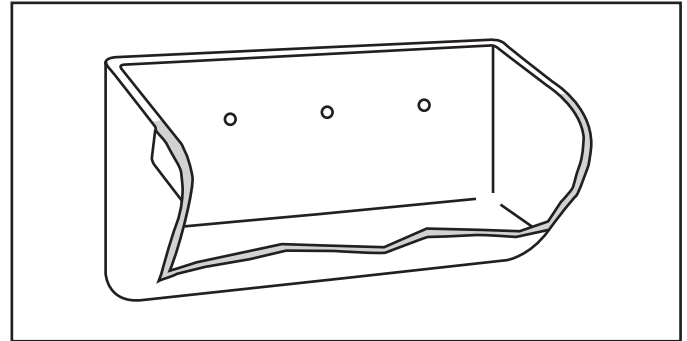
STAGE 1. Corners show minor wear, capacity close to 100%



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

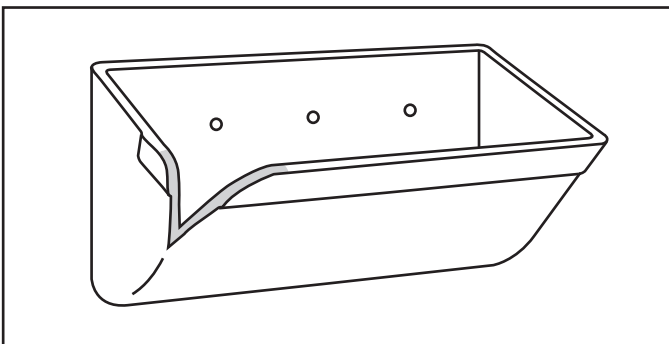


STAGE 3. Corners worn out, may discharge erratically, bucket losing significant capacity

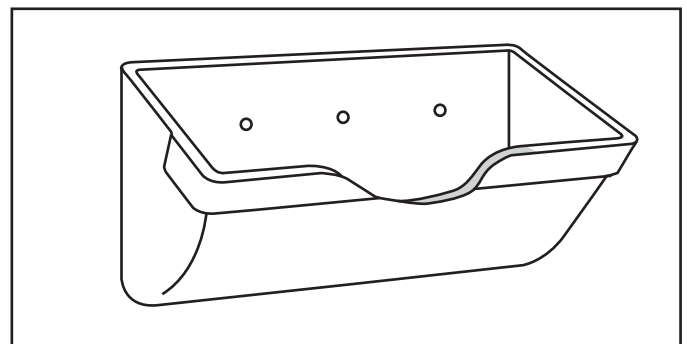


STAGE 4. Front of bucket has broken off

PREMATURE WEAR - Material Flow / Loading Issues



Uneven Wear - Corner



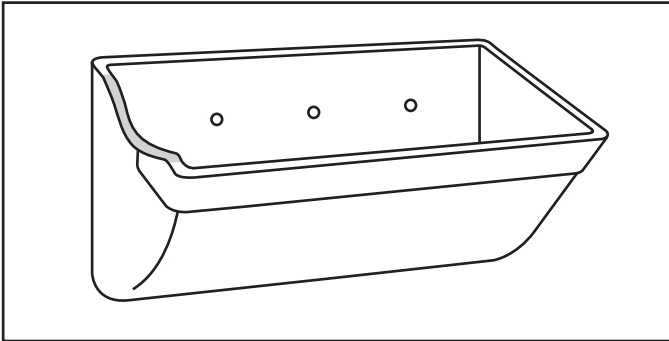
Uneven Wear - Middle

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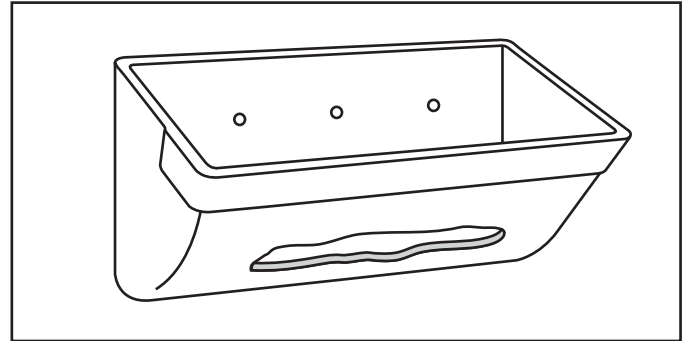
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PREMATURE WEAR (Cont.) - Material Flow / Loading Issues

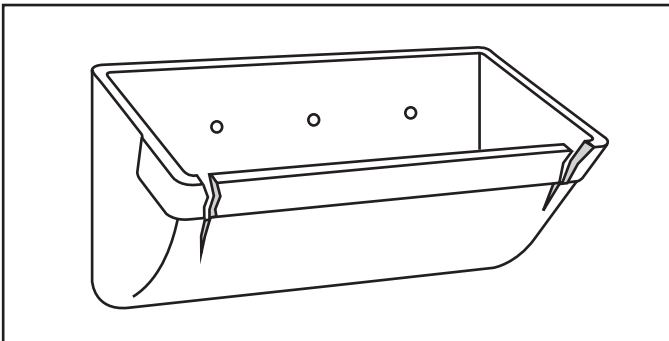


Uneven Wear - Side

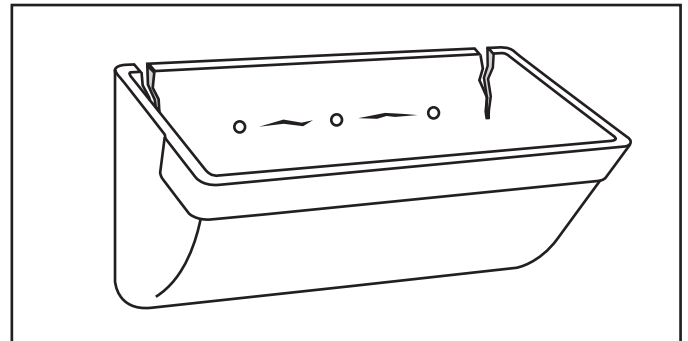


Bottom Wear - Hole in bottom of bucket,
loading at a poor angle

CRACKING

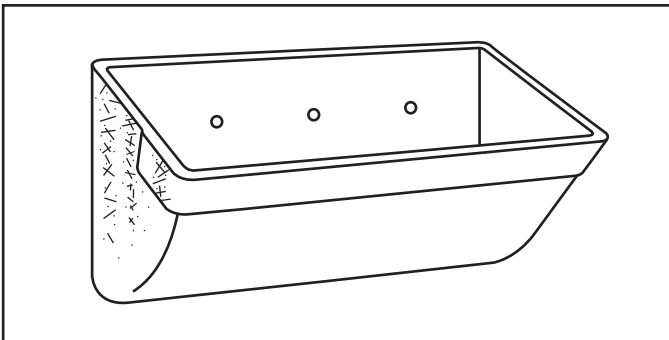


Front Corner Cracking - Excessive digging
impact

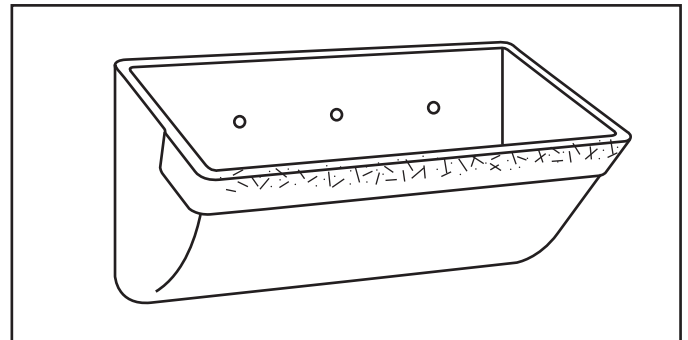


Back Corner Cracking - Excessive crown on
head pulley, impact on front lip,
or excessive torque on bolts

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

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