



**Figure 1** – Frame A Bolt-tightening Sequence

Step 1: Make sure mating surfaces of cover and case do not have any nicks or dings

Step 2: Use 5/16-18 socket head cap screws with internal tooth lock washers to bolt the cover to the gear case. Do not use plated bolts.

Step 3: Tighten the cover bolts to a torque of 10 ft-lbs in the sequence 1 through 8 as indicated in Figure 1.

Step 4: Retighten the cover bolts to a torque of 19 ft-lbs in same sequence as previous. Step 5:

Fill the gearcase with oil to the proper oil level.

Step 6: Test the hoist without load and with load.

Step 7: Check the tightness of the bolts at a torque of 19 ft-lbs.

Before removing the cover from the hoist-mounted gearcase, screw three 5" long studs (without bolt heads) into positions 4, 5 and 7. This will help hold the cover during removal and align the cover during installation.