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Frame B Hoist Gearcase Bolt-tightening Pattern Technical Bulletin November 2003

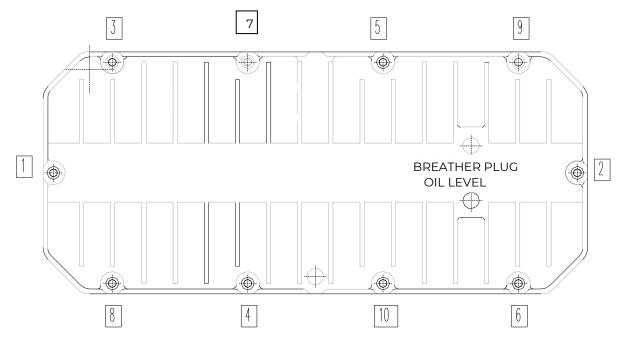


Figure 1 – Frame B Bolt-tightening Sequence

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

<u>Step 2:</u> 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.

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

<u>Step 4:</u> Retighten the cover bolts to a torque of 19 ft-lbs in same sequence as previous. <u>Step 5:</u> 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 four 5" long studs (without bolt heads) into positions 3, 4, 5 and 6. This will help hold the cover during removal and align the cover during installation.