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

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

**Step 2:** Use 3/8-16 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 10 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 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.