



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

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

**Step 2:** Use ½-13 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 25 ft-lbs in the sequence 1 through 12 as indicated in Figure 1.

**Step 4:** Retighten the cover bolts to a torque of 50 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 50 ft-lbs.

Before removing the cover from the hoist-mounted gearcase, screw four 5” long studs (without bolt heads) into positions 9, 10, 11 and 12. This will help hold the cover during removal and align the cover during installation.