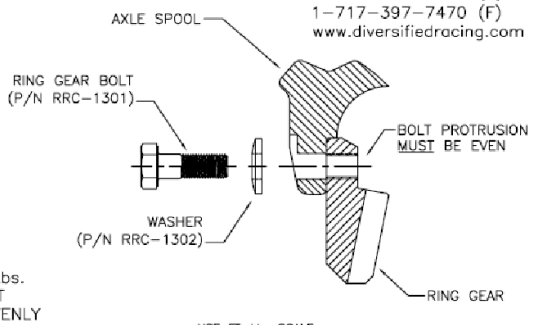
THREADED RING GEAR BOLT INSTALLATION

DIVERSIFIED MACHINE INC.
430 NORTH FRANKLIN STREET
LANCASTER, PA 17602
1-717-397-5347 (P)
1-717-397-7470 (F)
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- BE SURE THAT RING GEAR BOLTS AND TAPPED HOLES IN RING GEAR ARE CLEAN AND FREE FROM OIL
- USE RED LOCTITE® ON BOLT THREADS
- MOUNT RING GEAR AND ALIGN HOLES
- INSTALL BOLT THRU BELLEVILLE WASHER AND THREAD INTO RING GEAR. MAKE SURE THAT WASHER IS INSTALLED AS SHOWN
- TORQUE RING GEAR BOLTS IN CRISS-CROSS PATTERN TO 35-40 FT-Lbs. THEN FINAL TORQUE TO 60 FT-Lbs.
- VISUALLY INSPECT BELLEVILLE WASHERS. WASHERS MUST BE COMPLETELY FLATTENED OUT. BOLTS SHOULD EVENLY PROTRUDE OUT OF THE TOOTH SIDE OF THE RING GEAR

- ** IF ANY PERCEPTIBLE VARIATION - BOLTS MUST BE RE-TORQUED. **

USE FT-Lbs SCALE ONLY. DO NOT USE M-KGS OR NEWTONS