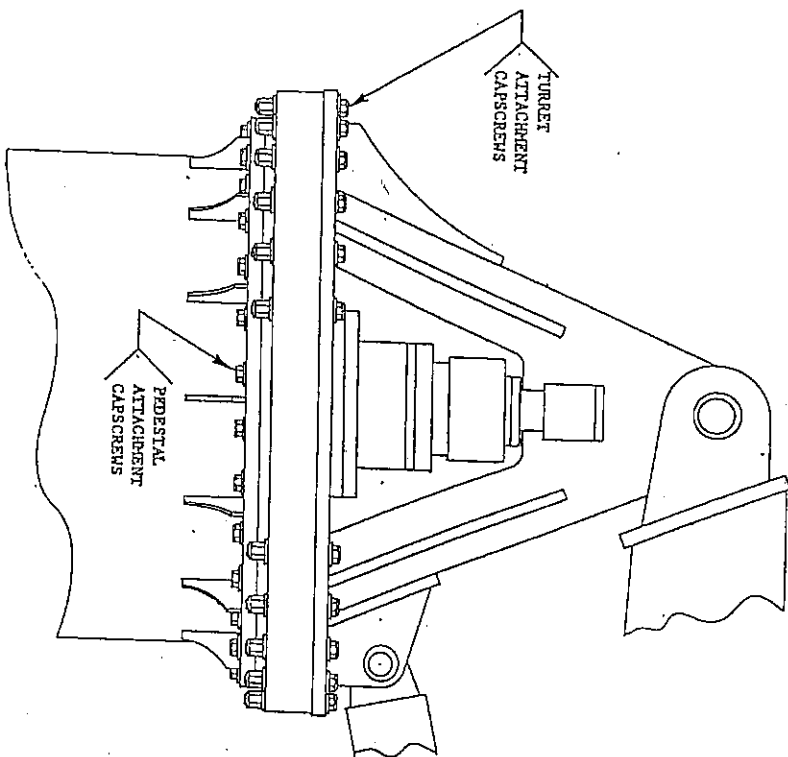




ORIGINAL INSTALLATION TURRET TO SWING BEARING

TORQUE THE TURRET TO SWING BEARING ATTACHMENT CAPSCREWS AS FOLLOWS.

- (1) GO AROUND THE TURRET AND TORQUE ALL CAPSCREWS TO 500 FT. LBS. TORQUE.
- (2) GO AROUND THE TURRET AND TORQUE ALL CAPSCREWS TO 750 FT. LBS. TORQUE.
- (3) GO AROUND THE TURRET AND TORQUE ALL CAPSCREWS TO 1000 FT. LBS. TORQUE. GO AROUND ONCE MORE TO BE SURE NO CAPSCREWS WERE MISSED.

AFTER 20 TO 30 HOURS OF OPERATION

TORQUE TURRET TO SWING BEARING ATTACHMENT CAPSCREWS AS FOLLOWS.

- (1) GO AROUND TURRET AND TORQUE ALL CAPSCREWS TO 1000 FT. LBS. TORQUE.
- (2) REPEAT STEP (1) TO BE SURE NO CAPSCREWS WERE MISSED.

EVERY (6) MONTHS OF OPERATION

AFTER TURRET TO SWING BEARING ATTACHMENT CAPSCREWS HAVE BEEN PROPERLY TORQUED, THEY WILL NOT BREAK LOOSE AND TURN AT THE SPECIFIED TORQUE, SO PROCEED AS FOLLOWS.

- (1) GO AROUND THE TURRET AND TORQUE ALL CAPSCREWS TO 1000 FT. LBS. TORQUE. IF THE CAPSCREWS DID NOT BREAK LOOSE AND TURN AT 1000 FT. LBS. OF TORQUE, YOU DO NOT NEED TO PROCEED TO STEP (2).
- (2) IF THE CAPSCREWS BROKE LOOSE AND TURNED AT 1000 FT. LBS. OF TORQUE OR LESS, IT IS AN INDICATION THAT THE CRANE HAS BEEN OVERLOADED, AND THE CAPSCREWS HAVE BEEN STRETCHED. IF THIS CONDITION EXISTS, REPLACE THE CAPSCREWS IN THE FOLLOWING MANNER. REPLACE ONE CAPSCREW AT A TIME, AND TORQUE TO 1000 FT. LBS. TORQUE. AFTER ALL CAPSCREWS HAVE BEEN REPLACED, GO AROUND TURRET ONE MORE TIME TO BE SURE NO CAPSCREWS WERE MISSED. BE SURE REPLACEMENT CAPSCREWS ARE GRADE "8" CAPSCREWS.

ORIGINAL INSTALLATION PEDESTAL TO SWING BEARING

TORQUE THE PEDESTAL TO SWING BEARING ATTACHMENT CAPSCREWS AS FOLLOWS.

- (1) GO AROUND THE PEDESTAL AND TORQUE ALL CAPSCREWS TO 500 FT. LBS. TORQUE.
- (2) GO AROUND THE PEDESTAL AND TORQUE ALL CAPSCREWS TO 700 FT. LBS. TORQUE.
- (3) GO AROUND THE PEDESTAL AND TORQUE ALL CAPSCREWS TO 900 FT. LBS. TORQUE. THEN GO AROUND ONCE MORE TO BE SURE NO CAPSCREWS WERE MISSED.

AFTER 20 TO 30 HOURS OF OPERATION

TORQUE THE PEDESTAL TO SWING BEARING ATTACHMENT CAPSCREWS AS FOLLOWS.

- (1) GO AROUND THE PEDESTAL AND TORQUE ALL CAPSCREWS TO 900 FT. LBS. TORQUE.
- (2) REPEAT STEP (1) TO BE SURE NO CAPSCREWS WERE MISSED.

EVERY (6) MONTHS OF OPERATION

AFTER PEDESTAL TO SWING BEARING CAPSCREWS HAVE BEEN PROPERLY TORQUED, THEY WILL NOT BREAK LOOSE AND TURN AT THE SPECIFIED TORQUE, THEREFORE PROCEED AS FOLLOWS.

- (1) GO AROUND THE PEDESTAL AND TORQUE ALL CAPSCREWS TO 900 FT. LBS. TORQUE. IF CAPSCREWS DID NOT BREAK LOOSE AND TURN AT 900 FT. LBS. TORQUE, YOU DO NOT NEED TO PROCEED TO STEP (2).

ALASKA MARINE CRANE

SCALE: N.T.S.	APPROVED BY:	DRAWN BY: RON C.
DATE:		REVISED:
TURRET TO SWING BEARING AND PEDESTAL TO SWING BEARING TORQUE SPECIFICATIONS: FOR ALL 12 THRU 25 TON CRANES		

DRAWING NUMBER

- (2) IF CAPSCREWS BROKE LOOSE AND TURNED AT 900 FT. LBS. OR LESS, IT IS AN INDICATION THAT THE CRANE HAS BEEN OVERLOADED, AND THE CAPSCREWS HAVE BEEN STRETCHED. IF THIS CONDITION EXISTS, REPLACE THE CAPSCREWS IN THE FOLLOWING MANNER. REPLACE ONE CAPSCREW AT A TIME, AND TORQUE TO 900 FT. LBS. TORQUE. AFTER ALL CAPSCREWS HAVE BEEN REPLACED, GO AROUND PEDESTAL ONE MORE TIME TO BE SURE ALL CAPSCREWS ARE PROPERLY TORQUED. BE SURE REPLACEMENT CAPSCREWS ARE GRADE "8" CAPSCREWS.