



A Division of D&D Products, Inc.

Service Bulletin

Reference # 2012-003

Subject: BI-ANNUAL REPLACEMENT OF OUTBOARD SLEWING BEARING BOLTS:

*Normal operating use of an articulated loading conveyor can cause the Grade 8 bolts used to attach the outboard conveyor arm to the transition slewing bearing to harden and crack. As a result, for safety reasons, we strongly recommend replacing these bolts every 2 years. **Warning: Bolt failure could cause the loading arm to break free from the slewing bearing and fall resulting in damage or personal injury.***

INSTRUCTIONS FOR CHANGING OUTBOARD SLEW BEARING BOLTS:

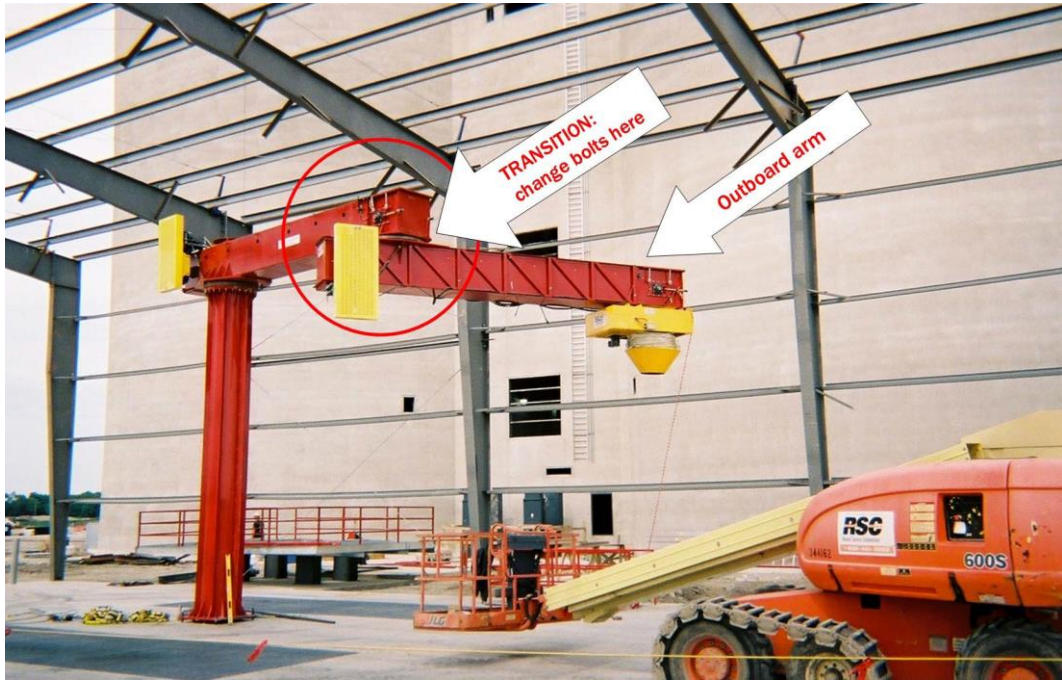
(Refer to the supplied photos)

Replacing the bolts requires that you to have good access to the transition area and slewing bearing mounted between the main conveyor arm and the outboard conveyor arm. This can be accomplished one of two ways:

- (A) Rotate the main arm so the transition area and slewing bearing between the two conveyor arms is centered over a railcar. Then perform the work using the railcar as a work platform.
- (B) Use a man-lift basket (or similar) to access the transition area and slewing bearing between the two conveyor arms.

Then follow these directions to change out the bolts:

- 1) Locate the (2) access holes on the transition between the main conveyor and the outboard conveyor. There is (1) access holes on each side of conveyor.
- 2) Rotate the outboard conveyor arm until the bolt head is in view in the access hole.
- 3) Use a $\frac{3}{4}$ " socket to remove the bolt.
- 4) Immediately replace the bolt with a new $\frac{1}{2}$ " diameter, 13 x 3" Grade 8 bolt.
- 5) Torque the bolt to 70 ft. lbs. if the bolt is pre-lubricated or 110 ft. lbs. if the bolt is dry.
- 6) Mark the bolt with a magic marker to indicate that it's been replaced.
- 7) Locate the access hole on the opposite side of the loading arm and move the loading arm until a bolt head is visible through that access hole.
Repeat steps 3 through 6.
- 8) Rotate the outboard arm to the next set of bolts and repeat steps 3 through 7 until all bolts have been changed out.





If you have questions on any aspect of this Service Bulletin or need further assistance of any kind, please contact Gary Kuehneman at:

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