HTT

Harsco Track Technologies

Harsco

HR1500 SERIES B2

UNIVERSAL HY-RAIL®
GUIDE WHEEL EQUIPMENT
HYDRAULICALLY OPERATED

OPERATOR'S SERVICE AND PARTS MANUAL

ISSUED 3 - 2005

BULLETIN 1370B

■ **THIS MANUAL CONTAINS VITAL INFORMATION FOR THE SAFE USE AND EFFICIENT OPERATION OF THE VEHICLE EQUIPPED WITH HY-RAIL® GUIDE WHEEL EQUIPMENT. CAREFULLY READ THIS OPERATOR'S MANUAL BEFORE USING THE VEHICLE. FAILURE TO ADHERE TO THE INSTRUCTIONS COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.**

When this manual is received, record the rail pilot unit serial numbers in the spaces provided in the General Information and Parts Sections for future reference, in case the serial number tags ever become unreadable. A Manual must remain with the vehicle. Additional or replacement manuals may be obtained by calling or writing Harsco Track Technologies, Harsco Corporation.

All information, illustrations and specifications in this manual are based on the latest information available at the time of publication. Harsco Track Technologies, Harsco Corporation reserves the right to make changes at any time without notice.

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SECTION 1 - GENERAL INFORMATION
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1.1 Safety Information

**THIS SYMBOL MEANS: ATTENTION! BECOME ALERT!
YOUR SAFETY IS INVOLVED.**

SAFETY IS A CRITICAL FACTOR IN THE DESIGN OF HARSCO TRACK TECHNOLOGIES EQUIPMENT. THE BEST SAFETY PROGRAM STARTS WITH A SAFETY CONSCIOUS OPERATOR. THE SAFETY INFORMATION HIGHLIGHTED IN THIS BULLETIN DESCRIBES SAFE OPERATING PRACTICES FOR THE BENEFIT OF THE WORKERS WHO WILL USE OUR EQUIPMENT IN THEIR DAILY JOBS.

1.1.1 Hazard Seriousness

Signal Words: **DANGER**, **WARNING** and **CAUTION** are used to identify levels of hazard seriousness.

DANGER

DANGER - Immediate hazards which WILL result in severe bodily injury or death.

WARNING

WARNING - Hazards or unsafe practices which COULD result in severe bodily injury or death.

CAUTION

CAUTION - Hazards or unsafe practices which COULD result in minor bodily injury and / or product or property damage.

1.1 Safety Information

- **APPLY THE VEHICLE PARKING BRAKE AND STOP THE ENGINE WHEN PERFORMING MAINTENANCE, MAKING ADJUSTMENTS, WORKING UNDER THE VEHICLE OR GUIDE WHEEL EQUIPMENT OR WHENEVER UNINTENDED MOVEMENT OF THE VEHICLE COULD OCCUR, UNLESS OTHERWISE INSTRUCTED IN THIS MANUAL.**
- **MAKE SURE ALL PERSONS ARE CLEAR OF THE VEHICLE BEFORE PERFORMING ANY OPERATING FUNCTIONS.**
- **KEEP ALL PARTS OF THE BODY AND LOOSE CLOTHING CLEAR OF ALL MOVING PARTS OF THE VEHICLE OR GUIDE WHEEL EQUIPMENT.**
- **UNDERSTAND EQUIPMENT OPERATION AND BE AWARE OF ALL PINCH POINTS BEFORE OPERATING OR MAKING ADJUSTMENTS TO THE GUIDE WHEEL EQUIPMENT.**
- **IF A DERAILMENT SHOULD OCCUR WHILE THE VEHICLE IS OPERATING IN ELECTRIFIED 3RD-RAIL TERRITORY, THE VEHICLE OR GUIDE WHEEL EQUIPMENT MIGHT BE IN ELECTRICAL CONTACT WITH THE ELECTRIFIED RAIL. DO NOT ATTEMPT TO EXIT FROM THE VEHICLE UNTIL THE ELECTRICAL POWER TO THE 3RD-RAIL HAS BEEN TURNED OFF.**
- **IF THE HY-RAIL® EQUIPPED VEHICLE IS INVOLVED IN A DERAILMENT OR HIGHWAY ACCIDENT, IT MUST BE INSPECTED AND NECESSARY REPAIRS OR ADJUSTMENTS MADE TO THE VEHICLE AND / OR HY-RAIL® EQUIPMENT PRIOR TO ITS NEXT OPERATION ON THE RAILROAD TRACK.**
- **DO NOT EXCEED 45 MPH WHEN OPERATING VEHICLE ON TRACK. RAILROAD RULES GOVERNING SPEEDS SHOULD BE OBSERVED AT ALL TIMES. REDUCE SPEED WHEN PROPELLING THE VEHICLE THROUGH SWITCHES, CROSSINGS, BRANCH LINES AND ANY SPECIAL TRACK WORKS. OPERATING THE VEHICLE AT UNSAFE SPEEDS COULD RESULT IN DERAILMENT OF VEHICLE.**
- **CHECK AND CORRECT GUIDE WHEEL EQUIPMENT ALIGNMENT PROMPTLY IF MISALIGNMENT IS INDICATED.**

1

1.1 Safety Information

- **AT MAXIMUM LOADED GROSS VEHICLE WEIGHT ON TRACK (including driver, passengers, equipment, tools, payload, etc.) DO NOT EXCEED ANY OF THE FOLLOWING:**
  - **VEHICLE'S G.V.W.R. (Gross Vehicle Weight Rating)**
  - **VEHICLE'S FRONT G.A.W.R. (Gross Axle Weight Rating) OR THE SUM OF THE FRONT UNIT GUIDE WHEEL RATED LOAD CAPACITY PLUS (+) VEHICLE'S FRONT TIRE/WHEEL RATED LOAD CAPACITY, WHICHEVER IS LOWER.**
  - **VEHICLE'S REAR G.A.W.R. (Gross Axle Weight Rating) OR THE SUM OF THE REAR GUIDE WHEEL RATED LOAD CAPACITY PLUS (+) VEHICLE'S REAR TIRE/WHEEL RATED LOAD CAPACITY, WHICHEVER IS LOWER.**
  - **COMPONENTS RATED LOAD CAPACITY:**
    A. TIRE MANUFACTURER'S RATED LOAD CAPACITY.
    B. VEHICLE'S WHEEL RATED LOAD CAPACITY.
    C. GUIDE WHEEL UNIT RATED LOAD CAPACITY:
    3,000 lbs (1361 kg)
    1,500 lbs (680 kg) Maximum Per Guide Wheel

FAILURE TO HEED THESE WARNINGS COULD RESULT IN SEVERE BODILY INJURY.

- **OBSERVE AND FOLLOW ALL RAILROAD SAFETY RULES AND REGULATIONS.**
- **KNOW THE POSITIONS AND FUNCTIONS OF ALL CONTROLS BEFORE ATTEMPTING TO OPERATE THE VEHICLE.**
- **THIS GUIDE WHEEL EQUIPMENT IS DESIGNED WITH YOUR SAFETY IN MIND. NEVER DISCONNECT AND/OR ATTEMPT TO OVERRIDE SAFETY FEATURES.**

FAILURE TO HEED THESE PRECAUTIONS COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.

Note: To help ensure safe operation of this equipment, keep all safety decals clean and legible. Replace safety decals when necessary with new decals, listed in the Parts Section of this manual.

1.2 Identification View

FIGURE 1-1
HR1500 SERIES B2 HY-RAIL® GUIDE WHEEL EQUIPPED VEHICLE

1.3 Description

The HR1500 Series B2 HY-RAIL® guide wheel equipment can be applied to various standard utility vehicles, cab chassis and pickup trucks. The vehicles G.V.W.R. (gross vehicle weight rating) and/or G.A.W.R. (gross axle weight rating) must comply with the specified limits listed in the Harsco Track Technologies Vehicle Specifications manual. For information regarding special applications not listed in Harsco Track Technologies HY-RAIL® Vehicle Specifications Manual, contact Harsco Track Technologies, Harsco Corporation, Fairmont Minnesota.

The HY-RAIL® guide wheel units are lowered and raised hydraulically. Hydraulic power may be supplied from the vehicle system or from an optional power pack. The guide wheel are locked in both the highway and rail positions with manual locks. Optional electric actuated locks and hydraulic actuated locks are available. The guide wheel units are mounted onto the vehicle frame. Load bearing guide wheel assemblies guide the vehicle during on track operation. The HY-RAIL® equipped vehicle uses the vehicle propulsion and braking systems for propelling and braking on the track.

A steering wheel lock is manually actuated during on track operation. The steering lock holds the the vehicle's steering wheel in place to ensure alignment of the vehicle's front wheels with the rail.

1.4 Vehicle Orientation

Front - rear and left - right are determined from the vehicle driver's seat.

1

1.5 Serial Numbers

When this bulletin is received, complete the following record from the serial number tags on both the front and rear guide wheel units. Always provide these factory serial numbers when calling or writing about the units. The serial number tags are located on the mounting plates on both units.

FIGURE 1-2
FRONT GUIDE WHEEL UNIT SERIAL NUMBER TAG

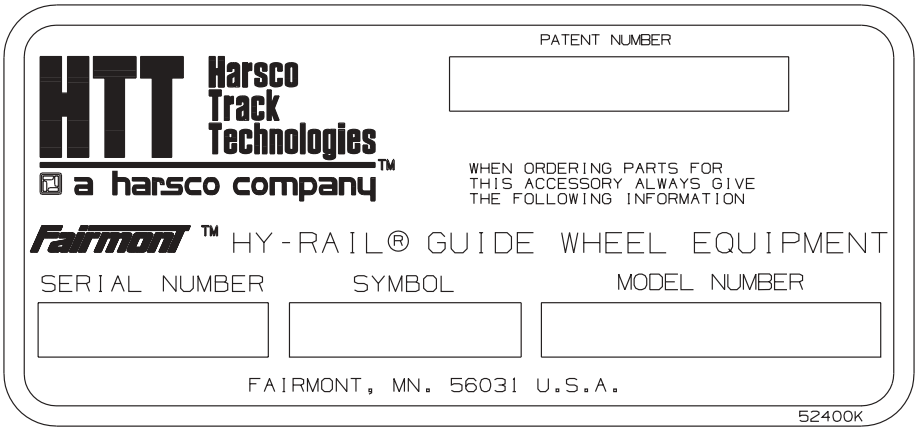
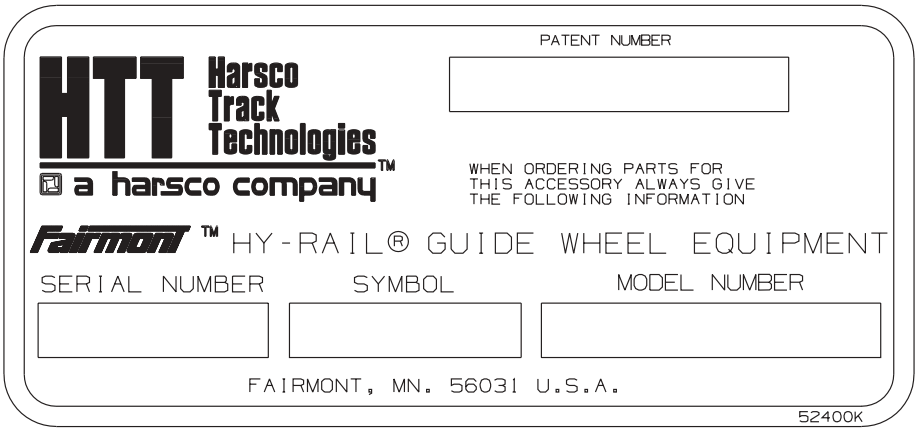


FIGURE 1-3
REAR GUIDE WHEEL UNIT SERIAL NUMBER TAG



1.6 Specifications

1.6.1 Vehicle

See the Harsco Track Technologies HY-RAIL® Vehicle Specifications Manual for vehicle specifications. For information regarding special applications not listed in the Harsco Track Technologies Vehicle Specifications Manual, contact Harsco Track Technologies, Harsco Corporation, Fairmont, Minnesota.

1.6.2 Guide Wheel Unit

Track Gauge	56-1/2 in	(1435 mm)
Guide Wheels - All Tread Types - Flange Diameter	12-1/4 in	(311 mm)
- Tread Diameter	10 in	(254 mm)
Weight - Front Unit	325 lbs	(147 kg)
- Rear Unit	320 lbs	(145 kg)
Recommended Load Per Guide Wheel - All Tread Types (with vehicle at curb weight)	500 ± 25 lbs	(227 ± 11 kg)
Maximum load per guide wheel - All Tread Types	1,500 lbs	(680 kg)

NOTES

SECTION 2 - OPERATION
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2.1 Speedometer

■ **WHEN WHEEL/TIRE MODIFICATIONS ARE APPLIED, CHECK AND CHANGE SPEEDOMETER DRIVE RATIO IF NECESSARY. THE SPEEDOMETER DRIVE RATIO WILL INFLUENCE THE OPERATION OF THE VEHICLE'S ANTI-LOCK BRAKE SYSTEMS, ELECTRONICALLY CONTROLLED TRANSMISSION SHIFT TIMING AND SPEEDOMETER DISPLAY OF THE TRUE VEHICLE SPEED. FAILURE TO MAINTAIN CORRECT SPEEDOMETER DRIVE RATIO COULD RESULT IN SEVERE BODILY INJURY.**

Some vehicles require special larger diameter wheels and/or wheel spacers to properly space the vehicle tires for on track operation. Use of these wheel modifications may effect the speedometer drive ratio calibration. The speedometer drive ratio will influence the operation of the vehicle's anti-lock brake systems, electronically controlled transmission shift timing and speedometer display of the true vehicle speed. The vehicle speedometer must be re-calibrated when wheel modifications are applied to the vehicle. See the vehicle manufacturer or dealer for speedometer calibration information.

2.2 Preparing Vehicle For Operation

Be sure vehicle is in operating condition by checking the following:

a. Engine oil level.
b. Radiator fluid level.
c. Fuel tank level.
d. Hydraulic reservoir level.
e. Brakes work properly.
f. Parking brake works properly.
g. Head, brake and signal lights work properly.
h. Tires properly inflated to tire manufacturer's recommended maximum pressure, printed on the sidewalls of the tires or wheel manufacturer's recommended maximum pressure, stamped on the wheel, whichever is lower.
I. Vehicle wheels: Lug nuts / bolts tightened to the proper torque, inspect vehicle wheels, lug bolts and lug nuts for wear or damage. For vehicle wheel, lug bolt and lug nut inspection information refer to the USER'S GUIDE TO WHEELS AND RIMS produced by THE MAINTENANCE COUNCIL. To obtain this guide, contact:

THE MAINTENANCE COUNCIL
AMERICAN TRUCKING ASSOCIATION
2200 MILL ROAD
ALEXANDRIA, VA. 22314
Phone: (703) 838-1763

j. Any other normal maintenance requirements.

2.3 Preparing Guide Wheel Equipment For Operation

Be sure the guide wheel equipment is in operating condition by checking the following:

a. Overall for damaged or worn parts.
b. Proper alignment and guide wheel loads.
c. Proper lubrication at recommended operating hourly intervals.
d. Hydraulic hoses and fittings damage, wear or leaks

2.4 Misalignment Indicators

■ **BEFORE OPERATING A VEHICLE WITH NEWLY INSTALLED GUIDE WHEEL EQUIPMENT ON TRACK, VERIFY THAT GUIDE WHEEL EQUIPMENT ALIGNMENT PROCEDURE HAS BEEN COMPLETED. CHECK AND CORRECT ALIGNMENT PROMPTLY IF MISALIGNMENT IS INDICATED. MISALIGNMENT OF GUIDE WHEEL EQUIPMENT COULD RESULT IN DERAILMENT OF VEHICLE AND SEVERE BODILY INJURY.**

The following conditions may indicate that minor adjustments to the guide wheel equipment alignment are necessary. If any of these conditions occur during operation, perform the Track Test, see Adjustment Section - Vehicle Track Test and/or complete the Alignment Procedure, see Adjustment Section - Guide Wheel Alignment Procedure.

1. Excessive flange or tread wear on any of the rail guide wheels.

2. Vehicle pulls noticeably to the left or right during track operation.

3. Vibration felt throughout the vehicle at various speeds during track operation.

2.5 Placing Vehicle on Track

- **PLACE VEHICLE AUTOMATIC TRANSMISSION IN "PARK" OR MANUAL TRANSMISSION IN "NEUTRAL". APPLY THE PARKING BRAKE.**
- **UNDERSTAND EQUIPMENT OPERATION AND BE AWARE OF ALL PINCH POINTS BEFORE OPERATING OR MAKING ADJUSTMENTS TO GUIDE WHEEL EQUIPMENT.**
- **BEFORE PROPELLING THE VEHICLE ON THE TRACK, MAKE SURE:**
  - **FRONT AND REAR GUIDE WHEELS ARE LOWERED AND LOCKED IN THE RAIL POSITION AND SECURED WITH THE LOCK PINS.**
  - **ALL GUIDE WHEEL FLANGES ARE ENGAGED ON THE INSIDE OF THE RAIL.**
  - **THE FRONT WHEELS ARE POINTED STRAIGHT AHEAD AND THE STEERING WHEEL LOCK IS ENGAGED.**

FAILURE TO HEED THESE WARNINGS COULD RESULT IN DERAILMENT OF THE VEHICLE AND SEVERE BODILY INJURY.

- **OBSERVE AND FOLLOW ALL RAILROAD SAFETY RULES AND REGULATIONS.**
- **IF THE VEHICLE IS EQUIPPED WITH A STROBE LIGHT (BEACON) AND RAILROAD RULES AND REGULATIONS REQUIRE ITS USE, THE STROBE LIGHT (BEACON) MUST BE ILLUMINATED WHEN PLACING THE VEHICLE ON TRACK AND WHEN OPERATING THE VEHICLE ON TRACK.**

FAILURE TO HEED THESE PRECAUTIONS COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.

2.5 Placing Vehicle on Track

1. Ensure that highway vehicles are not approaching the grade crossing while placing the vehicle on track. Flag the crossing per railroad rules and regulations to ensure safety.

2. At a road crossing, drive the vehicle about 25 feet (7.6 m) past the track. Back the vehicle onto the track so that the vehicle rear wheels are centered on rails. It may be necessary to move the vehicle back and forth several times to get the wheels centered on the rail properly.

3. Place automatic transmission in "PARK" or manual transmission in "NEUTRAL". Apply the parking brake.

4. Lower and lock the rear guide wheels first. The rear guide wheels should be lowered first so the vehicle front tires can be maneuvered to align the front guide wheels with the rails.

2.5.1 Lowering Rear Guide Wheels - See Figure 2-1

The location of the push / pull cable knob and the up / down switch will vary depending on the application.

2.5.1.1 Mechanical Lock or Hydraulic Lock

1. The hydraulic lock incorporates a pilot operated check valve to hold the hydraulic cylinder in the locked position. Even though the unit is equipped with the hydraulic lock, Harsco Track Technologies recommends that the manual locks also be engaged.

2. With the rear guide wheels centered over the rails, press the UP button (1) momentarily to relieve pressure from the lock pin. Pull the knob out on the push / pull cable to disengage the lock. Press the DOWN button (1) to activate the hydraulic pump and lower the guide wheels to the rail. As the guide wheels lower, ensure that the flanges of the guide wheels are on the gauge side (inside) of the rails.

3. Continue to hold the DOWN button (1) until the guide wheels are fully lowered to the "rail" position. Release the DOWN button (1). Push the knob in on the push / pull cable to engage the lock.

4. After the rear guide wheels are locked in the "rail" position, move the vehicle so that the front wheels are centered on the rail.

2.5 Placing Vehicle on Track

2.5.1 Lowering Rear Guide Wheels

2.5.1.2 Electric Lock

1. With the rear guide wheels centered over the rails, press the UP button (1) momentarily to relieve pressure from the lock pin and then press the DOWN button. The electric solenoid will energize and disengage the lock pin. The hydraulic pump will activate to lower the guide wheels to the rail. As the guide wheels lower, ensure that the flanges of the guide wheels are on the gauge side (inside) of the rails.

2. Continue to hold the DOWN button (1) until the guide wheels are fully lowered to the "rail" position. Release the down button. The electric solenoid will de-energize and engage the lock pin.

3. After the rear guide wheels are locked in the "rail" position, move the vehicle so that the front wheels are centered on the rail.

FIGURE 2-1
LOWERING REAR GUIDE WHEELS
ELECTRIC LOCK UNIT SHOWN

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2.5 Placing Vehicle on Track

2.5.2 Lowering Front Guide Wheels - See Figures 2-2, 2-3 and 2-4

The location of the up / down switch will vary depending on the application.

2.5.2.1 Mechanical Lock or Hydraulic Lock

1. The hydraulic lock incorporates a pilot operated check valve to hold the hydraulic cylinder in the locked position. Even though the unit is equipped with the hydraulic lock, Harsco Track Technologies recommends that the manual locks also be engaged.

2. Press the UP button (1) momentarily to relieve pressure from the lock pin. To disengage the lock, rotate lock handle (2) clockwise, pull out and then rotate the handle counter-clockwise to lock it in the disengaged position.

3. Press the DOWN button (1) to activate the hydraulic pump and lower the guide wheels to the rail. As the guide wheels lower, ensure that the flanges of the guide wheels are on the gauge side (inside) of the rails.

4. Continue to hold the DOWN button (1) until the guide wheels are fully lowered to the "rail" position. Release the DOWN button. To engage the lock, rotate lock handle (2) clockwise, push in and then rotate the handle counter-clockwise to lock it in the engaged position.

2.5.2.2 Electric Lock

1. Press the UP button (1) momentarily to relieve pressure from the lock pin and then press the DOWN button (1). The electric solenoid will energize and disengage the lock pin. The hydraulic pump will activate to lower the guide wheels to the rail. As the guide wheels lower, ensure that the flanges of the guide wheels are on the gauge side (inside) of the rails.

2. Continue to hold the DOWN button (1) until the guide wheels are fully lowered to the "rail" position. Release the DOWN button. The electric solenoid will de-energize and engage the lock pin.

2.5 Placing Vehicle on Track

2.5.2 Lowering Front Guide Wheels - See Figures 2-2, 2-3 and 2-4

FIGURE 2-2
TO DISENGAGE LOCK

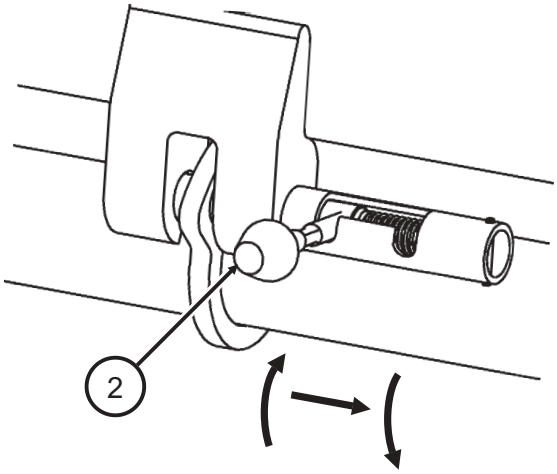

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FIGURE 2-3
TO ENGAGE LOCK

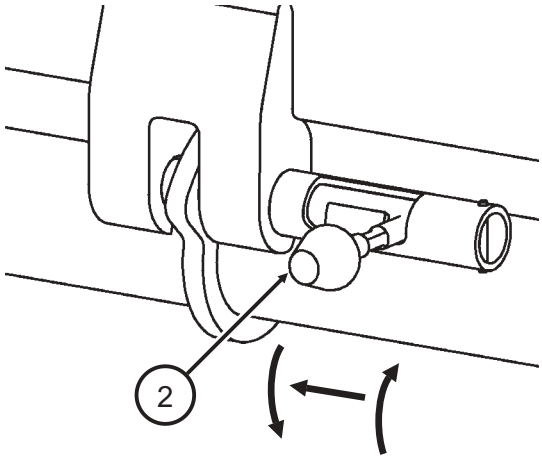

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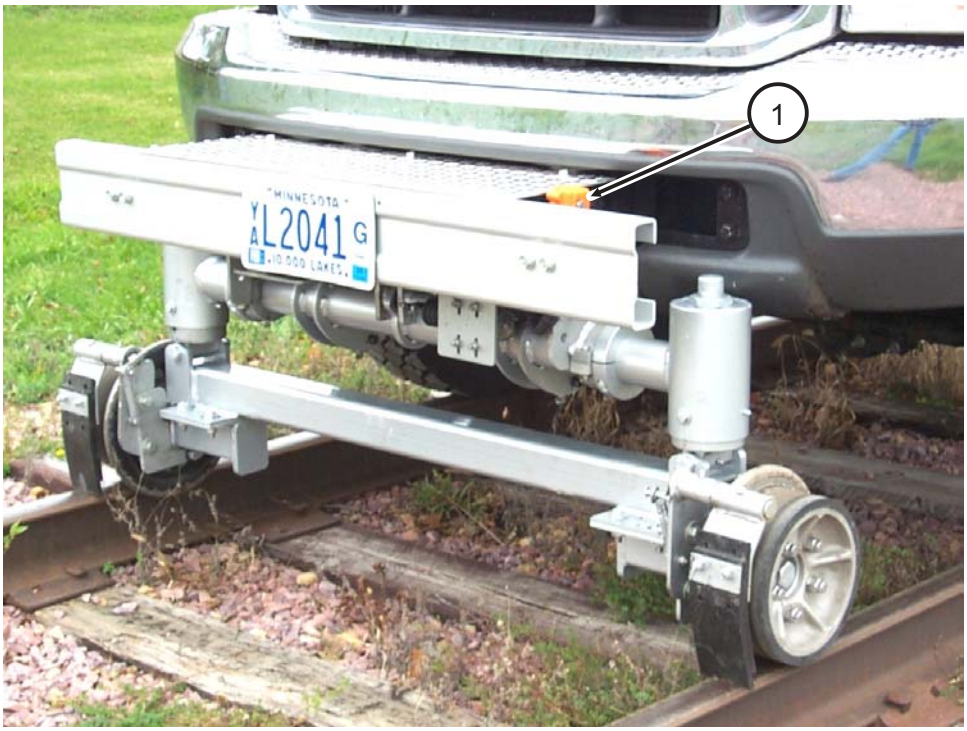
FIGURE 2-4
LOWERING FRONT GUIDE WHEELS
ELECTRIC LOCK UNIT SHOWN



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2.5 Placing Vehicle on Track

2.5.3 Steering Lock

1. See Figures 2-5, 2-6, 2-7 and 2-8. Turn the steering wheel to set the vehicle front wheels straight ahead. Secure the steering wheel in this position with the steering lock, located on the steering column. Steering locks may vary from vehicle to vehicle but will operate similarly.

   Note: Do not place any pressure on the steering wheel after the steering lock is engaged.

FIGURE 2-5
STEERING LOCK IN UNLOCKED POSITION

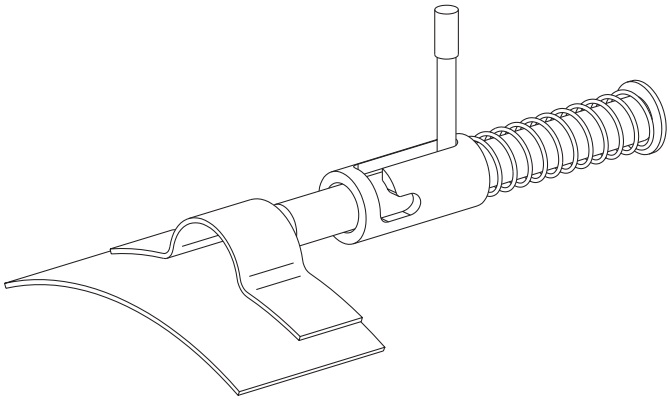

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FIGURE 2-6
STEERING LOCK IN LOCKED POSITION

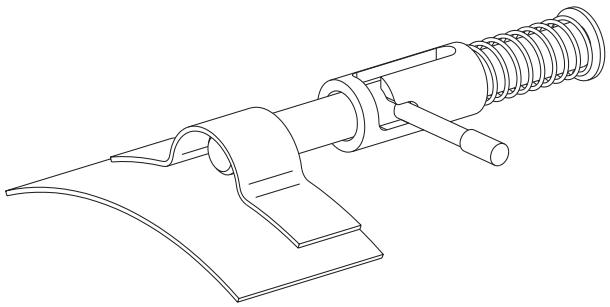

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FIGURE 2-7
VELCRO STEERING LOCK OFF

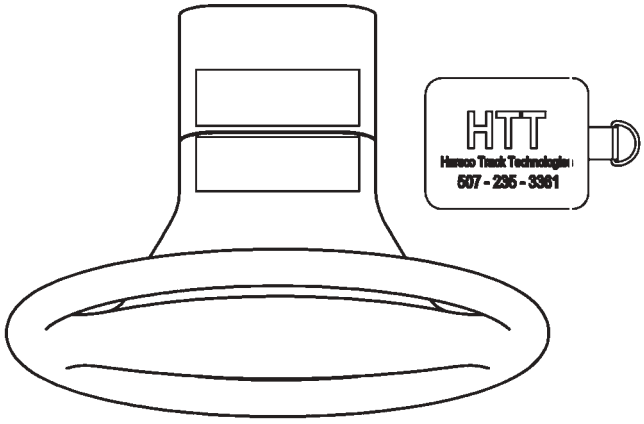
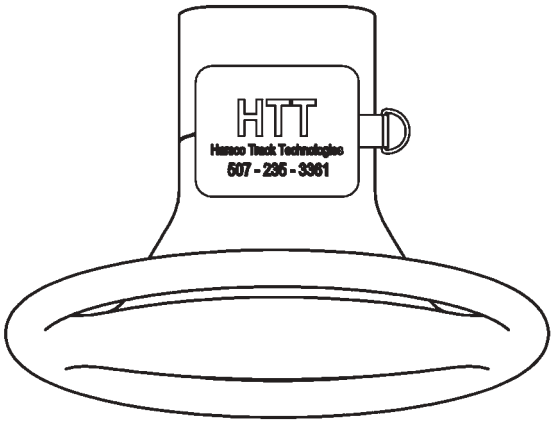


FIGURE 2-8
VELCRO STEERING LOCK ON



2.5 Placing Vehicle on Track

2.5.4 Rail Sweeps

1. The guide wheel units may be equipped with rail sweeps. The rail sweeps are positioned ahead of the front guide wheels and behind the rear guide wheels. The rail sweeps clear the rail of debris, lengthening the service life of the guide wheels.

2. One type of front rail sweeps are attached to the front axle and pivot up and down. After lowering the front guide wheels, pivot the front rail sweeps down. Before raising the front guide wheels, pivot the front rail sweeps up.

   The other type of front rail sweeps use a cable and spring arrangement that will pivot the rail sweeps down when the front guide wheels are lowered and pivot the rail sweeps up when the front guide wheels are raised.

3. The rear rail sweeps are attached to the axle and will lower when the guide wheels are lowered to the rail and will raise when the guide wheels are raised.

2.6 Guide Wheel Load on Track

- **IMPROPER LOADING OF GUIDE WHEEL EQUIPPED VEHICLE CAN CAUSE DERAILMENT OF VEHICLE.**
- **APPLY VEHICLE PARKING BRAKE AND STOP VEHICLE ENGINE BEFORE CHECKING GUIDE WHEEL LOAD.**
- **ALWAYS CHECK THE GUIDE WHEEL LOAD BEFORE OPERATING THE VEHICLE ON TRACK. NEVER OPERATE THE VEHICLE ON TRACK IF LOAD EXCEEDS THE MAXIMUM RATED LOAD ON THE FRONT AND/OR REAR GUIDE WHEEL UNITS. THE MAXIMUM LOAD ON THE FRONT OR REAR GUIDE WHEEL UNIT IS 3,000 LBS (1361 kg) OR 1,500 LBS (680 kg) MAXIMUM PER GUIDE WHEEL.**
- **DO NOT USE ANY OTHER JACK THEN THE HARSCO TRACK TECHNOLOGIES WHEEL WEIGHING JACK NO. 073527 TO CHECK THE GUIDE WHEEL LOAD. USE OF ANY OTHER JACK WILL RESULT IN INCORRECT GUIDE WHEEL LOAD INFORMATION.**
- **MISUSE OF THE WHEEL WEIGHING JACK MAY CAUSE GAUGE TO EXPLODE. READ ANSI B40.1 AND APPARATUS INSTALLATION / OPERATING INSTRUCTIONS BEFORE USE.**
- **DO NOT USE THE WHEEL WEIGHING JACK TO LIFT THE VEHICLE. EXCESSIVE WEIGHT MAY CAUSE THE JACK TO FAIL.**

FAILURE TO HEED THESE WARNINGS COULD RESULT IN DERAILMENT OF VEHICLE AND/OR SEVERE BODILY INJURY.

2.6.1 Checking Guide Wheel Load

2.6.1.1 Checking Guide Wheel Load Using The Guide Wheel Load Jack - See Figure 2-9

1. Apply the parking brake. Lower and lock the guide wheels in the rail position. Stop the vehicle's engine.

2. The guide wheel load can be checked using the HTT # 073527 Wheel Weighing Jack. Do not use any other jack to check the guide wheel load. The use of an other jack will result in incorrect guide wheel load information.

3. Place the jack under the square tube as close to the guide wheel as possible. Jack the guide wheel up until the guide wheel just clears the top of the rail. Note the gauge reading. The gauge reading indicates the pounds of load on the guide wheel.

   Note: An easy way to tell when the guide wheel just clears the top of rail is to jack the wheel up approximately 1/4" (6.4 mm) above the top of the rail. Place a piece of paper between the rail and the guide wheel. Lower the guide wheel onto the paper. Slowly jack the guide wheel up while applying a steady pulling force on the paper until the paper can be pulled out. Note the gauge reading when the paper can be removed.

2.6 Guide Wheel Load on Track

2.6.1 Checking Guide Wheel Load

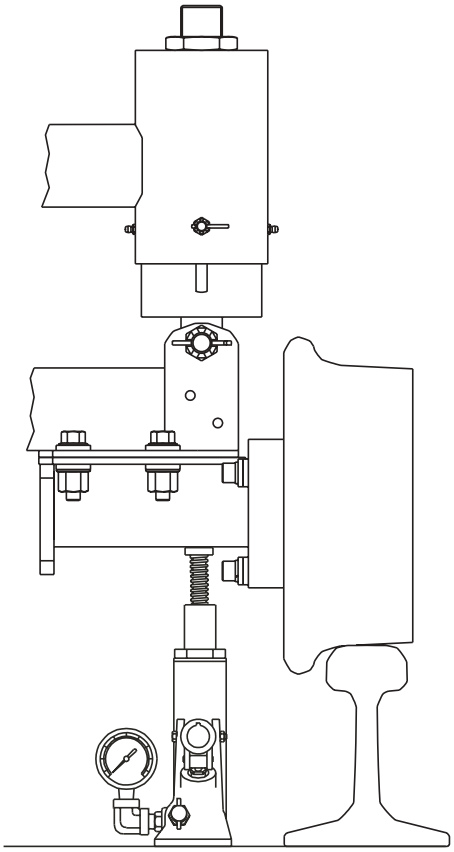
2.6.1.1 Checking Guide Wheel Load Using The Guide Wheel Load Jack - Continued

4. With the vehicle at curb weight, the recommended guide wheel load is 500 lbs ± 25 lbs (227 kg ± 11 kg) per guide wheel. The recommended guide wheel load must also be equal on the left and right sides of the front or rear guide wheel unit.

5. The maximum rated load on the front and / or rear guide wheel unit is 3,000 lbs (1361 kg) or 1,500 lbs (680 kg) maximum per guide wheel. The front and / or rear guide wheel unit spring cells are adjustable. See the Adjustments Section - Guide Wheel Load for the adjustment procedure.

6. If the load exceeds the maximum rated load capacity of the front and / or rear guide wheel unit or the maximum rated load capacity of any guide wheel, the load must be redistributed or some of the load removed. Never operate the vehicle on track if the load on the front and / or rear guide wheel unit exceeds the maximum rated load capacity.

FIGURE 2-9
WHEEL LOAD WEIGHING JACK



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2.6 Guide Wheel Load on Track

2.6.1 Checking Guide Wheel Load

2.6.1.2 Checking Guide Wheel Load By Measuring - See Figure 2-10 and Chart 2-11

1. Apply the parking brake. Lower and lock the guide wheels in the rail position. Stop the vehicle's engine.

2. Measure from the top of the adjusting stud (1) to the bottom of the inner spring cell tube (2). This measured dimension will be designated as Dimension "A".

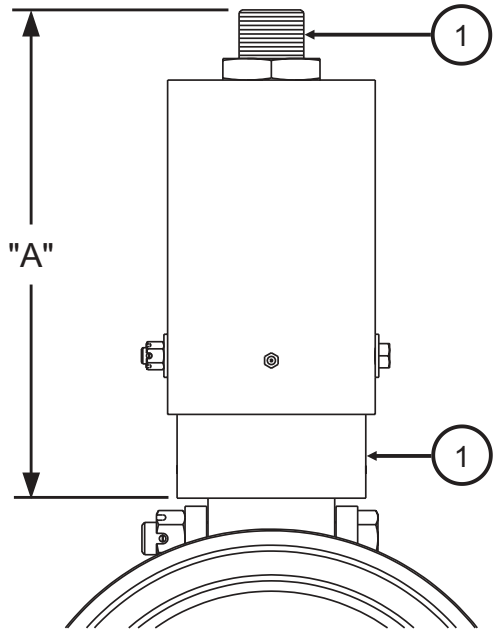
3. See Chart 2-11 to convert the measured Dimension "A" to the approximate load on the guide wheel.

4. With the vehicle at curb weight, the recommended guide wheel load is 500 lbs ± 25 lbs (227 kg ± 11 kg) per guide wheel. The recommended guide wheel load must also be equal on the left and right sides of the front or rear guide wheel unit.

5. The maximum rated load on the front and / or rear guide wheel unit is 3,000 lbs (1361 kg) or 1,500 lbs (680 kg) maximum per guide wheel. The front and / or rear guide wheel unit spring cells are adjustable. See the Adjustments Section - Guide Wheel Load for the adjustment procedure.

6. If the load exceeds the maximum rated load capacity of the front and / or rear guide wheel unit or the maximum rated load capacity of any guide wheel, the load must be redistributed or some of the load removed. Never operate the vehicle on track if the load on the front and / or rear guide wheel unit exceeds the maximum rated load capacity.

FIGURE 2-10
MEASURING SPRING CELL



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2.6 Guide Wheel Load on Track

2.6.1 Checking Guide Wheel Load

2.6.1.2 Checking Guide Wheel Load By Measuring

CHART 2-11
GUIDE WHEEL LOAD

	DIMENSION "A"		APPROXIMATE LOAD PER SIDE	
	11-1/4"	(285.8 mm).	25 lbs	(11 kg)
	11-1/8"	(282.6 mm).	100 lbs	(45 kg)
	11"	(279.4 mm).	150 lbs	(68 kg)
	10-7/8"	(276.2 mm).	225 lbs	(102 kg)
	10-3/4"	(273.0 mm).	275 lbs	(125 kg)
	10-5/8"	(269.9 mm	325 lbs	(147 kg)
	10-1/2"	(266.7 mm).	375 lbs	(170 kg)
	10-3/8"	(263.5 mm).	425 lbs	(193 kg)
	10-1/4"	(260.4 mm).	475 lbs	(216 kg)
	10-3/16"	(258.8 mm).	500 lbs	(227 kg)
	10-1/8"	(257.2 mm).	525 lbs	(238 kg)
	10"	(254.0 mm).	575 lbs	(261 kg)
	9-7/8"	(250.8 mm).	625 lbs	(284 kg)
	9-3/4"	(250.2 mm).	725 lbs	(329 kg)
	9-5/8"	(244.5 mm).	825 lbs	(374 kg)
	9-1/2"	(241.3 mm).	1000 lbs	(454 kg)
	9-3/8"	(238.1 mm).	1250 lbs	(567 kg)
	9-5/16"	(236.5 mm).	1500 lbs	(680 kg)
①	**9-1/4"**	**(235.0 mm). . . . . .**	**1800 lbs**	**(817 kg)**

① **GUIDE WHEEL IS OVERLOADED. REDISTRIBUTE OR REMOVE SOME OF THE LOAD. MAXIMUM LOAD ON GUIDE WHEEL UNIT MUST NOT EXCEED 3,000 LBS (1361 kg) OR 1,500 LBS (680 kg) MAXIMUM PER GUIDE WHEEL.**

2.7 Propelling on Track

- **IMPROPER LOADING OF THE GUIDE WHEEL EQUIPPED VEHICLE CAN CAUSE DERAILMENT OF VEHICLE.**

- **ALWAYS CHECK THE GUIDE WHEEL LOAD BEFORE OPERATING THE VEHICLE ON TRACK. NEVER OPERATE THE VEHICLE ON TRACK IF LOAD EXCEEDS THE MAXIMUM RATED LOAD ON THE FRONT AND/OR REAR GUIDE WHEEL UNITS. THE MAXIMUM LOAD ON THE FRONT OR REAR GUIDE WHEEL UNIT IS 3,000 LBS (1361 kg) OR 1,500 LBS (680 kg) MAXIMUM PER GUIDE WHEEL.**

FAILURE TO HEED THESE WARNINGS COULD RESULT IN DERAILMENT OF THE VEHICLE AND/OR SEVERE BODILY INJURY.

- **BEFORE OR WHEN PROPELLING ON TRACK:**
  - **OBSERVE AND FOLLOW ALL RAILROAD SAFETY RULES AND REGULATIONS.**
  - **OPERATOR MUST LOOK ALL DIRECTIONS FOR PERSONS OR OBJECTS ON OR ADJACENT TO THE TRACK.**
  - **DO NOT ACCELERATE SUDDENLY. TRACTION IS REDUCED ON TRACK, SPINNING VEHICLE TIRES COULD DAMAGE THEM.**
  - **DO NOT EXCEED 45 MPH (72 km/h) WHEN OPERATING VEHICLE ON TRACK. RAILROAD RULES GOVERNING SPEEDS SHOULD BE OBSERVED AT ALL TIMES. REDUCE SPEED WHEN PROPELLING THE VEHICLE THROUGH SWITCHES, CROSSINGS, BRANCH LINES AND ANY SPECIAL TRACK WORKS. OPERATING VEHICLE AT UNSAFE SPEEDS COULD RESULT IN DERAILMENT OF THE VEHICLE.**
  - **STEERING LOCK MUST BE ENGAGED AT ALL TIMES WHEN OPERATING VEHICLE ON THE TRACK.**

- **IF THE VEHICLE IS EQUIPPED WITH A STROBE LIGHT (BEACON) AND RAILROAD RULES AND REGULATIONS REQUIRE ITS USE, THE STROBE LIGHT (BEACON) MUST BE ILLUMINATED WHEN OPERATING THE VEHICLE ON TRACK.**

FAILURE TO HEED THESE PRECAUTIONS COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.

Vehicles equipped with HR1500 Series B2 HY-RAIL® Guide Wheel Equipment use the vehicle propulsion system for propelling on track. Do not accelerate suddenly. Traction is reduced on the track, and spinning the vehicle tires could damage them.

2.8 Braking on Track

- **PERSONS WHO OPERATE THE VEHICLE MUST BE FAMILIAR WITH TRACK AND WEATHER CONDITIONS THAT MAY AFFECT STOPPING DISTANCE. BE ALERT TO THESE CONDITIONS AND ALLOW ADEQUATE STOPPING DISTANCE.**

- **BE PREPARED TO BRAKE AT ALL HIGHWAY CROSSINGS. THIS VEHICLE WILL NOT OPERATE TRACK SIGNAL CIRCUITS, AND ONCOMING VEHICLES OR PEDESTRIANS MAY NOT YIELD THE RIGHT OF WAY.**

FAILURE TO HEED THESE PRECAUTIONS COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.

Vehicles equipped with HR1500 Series B2 HY-RAIL® Guide Wheel Equipment use the vehicle brake system for braking on track. Stopping distance may be greater on track than on typical road surfaces. Apply the brakes gradually to avoid sliding the tires.

2.9 Removing Vehicle from Track

- **PLACE VEHICLE AUTOMATIC TRANSMISSION IN "PARK" OR MANUAL TRANSMISSION IN "NEUTRAL". APPLY PARKING BRAKE.**

- **UNDERSTAND EQUIPMENT OPERATION AND BE AWARE OF ALL PINCH POINTS BEFORE OPERATING OR MAKING ADJUSTMENTS TO THE GUIDE WHEEL EQUIPMENT.**

- **BEFORE PROPELLING VEHICLE OFF TRACK, MAKE SURE:**
  - **FRONT AND REAR GUIDE WHEELS ARE RAISED, LOCKED IN THE HIGHWAY POSITION, AND SECURED WITH THE LOCKING PINS.**
  - **STEERING WHEEL LOCK IS DISENGAGED.**

FAILURE TO HEED THESE WARNINGS COULD RESULT IN SEVERE BODILY INJURY.

- **OBSERVE AND FOLLOW ALL RAILROAD SAFETY RULES AND REGULATIONS**

- **IF THE VEHICLE IS EQUIPPED WITH A STROBE LIGHT (BEACON) AND RAILROAD RULES AND REGULATIONS REQUIRE ITS USE, THE STROBE LIGHT (BEACON) MUST BE ILLUMINATED WHEN OPERATING THE VEHICLE ON TRACK AND WHEN REMOVING VEHICLE FROM TRACK.**

FAILURE TO HEED THESE PRECAUTIONS COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.

2.9 Removing Vehicle from Track

1. Ensure that highway vehicles are not approaching grade crossing while removing vehicle from track. To ensure safety, flag the crossing to per railroad rules and regulations.

2. Approach a road crossing and stop with the vehicle front wheels on the crossing.

3. Place automatic transmission in "PARK" or manual transmission in "NEUTRAL". Apply the parking brake.

4. See Figures 2-5, 2-6, 27 and 2-8. Disengage the steering lock. Steering locks may vary from vehicle to vehicle but will operate similarly.

5. Raise the front guide wheels first. Then the rear guide wheels.

6. Pivot the front rail sweeps up before raising the front guide wheels.

2.9.1 Raising Front Guide Wheels - See Figures 2-12, 2-13 and 2-14

The location of the up / down switch will vary depending on the application.

2.9.1.1 Mechanical Lock or Hydraulic Lock

1. The hydraulic lock incorporates a pilot operated check valve to hold the hydraulic cylinder in the locked position. Even though the unit is equipped with the hydraulic lock, Harsco Track Technologies recommends that the manual locks also be engaged.

2. Press the DOWN button (1) momentarily to relieve pressure from the lock pin. To disengage the lock, rotate lock handle (2) clockwise, pull out and then rotate the handle counter-clockwise to lock it in the disengaged position.

3. Press the UP button (1) to activate the hydraulic pump and raise the guide wheels from the rail.

4. Continue to hold the UP button (1) until the guide wheels are fully raised to the "highway" position. Release the UP button. To engage the lock, rotate lock handle (2) clockwise, push in and then rotate the handle counter-clockwise to lock it in the engaged position.

2.9.1.2 Electric Lock

1. Press the DOWN button (1) momentarily to relieve pressure from the lock pin then press the UP button (1). The electric solenoid will energize and disengage the lock pin. The hydraulic pump will activate to raise the guide wheels from the rail.

2. Continue to hold the UP button (1) until the guide wheels are fully raised to the "highway" position. Release the UP button. The electric solenoid will de-energize and engage the lock pin.

2.9 Removing Vehicle from Track

2.9.1 Raising Front Guide Wheels

FIGURE 2-12
TO DISENGAGE LOCK

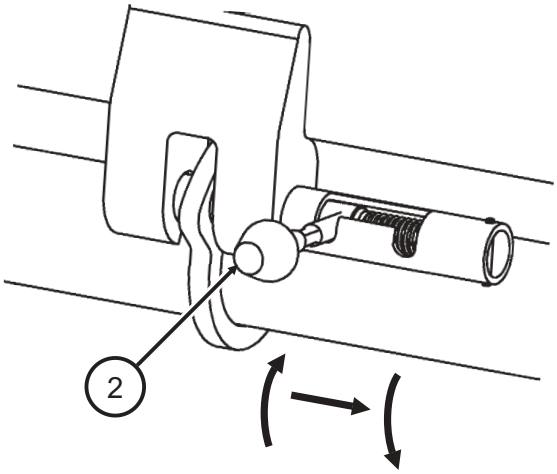

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FIGURE 2-13
TO ENGAGE LOCK

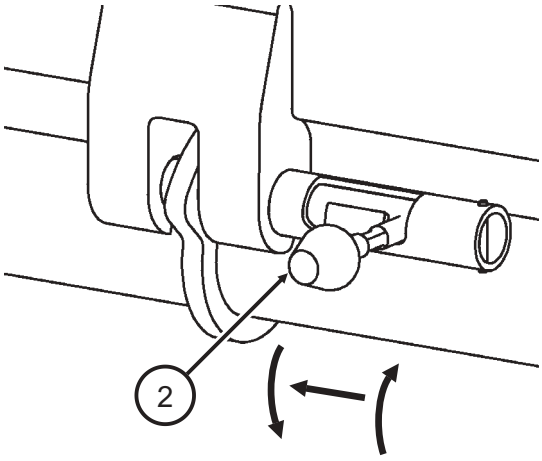

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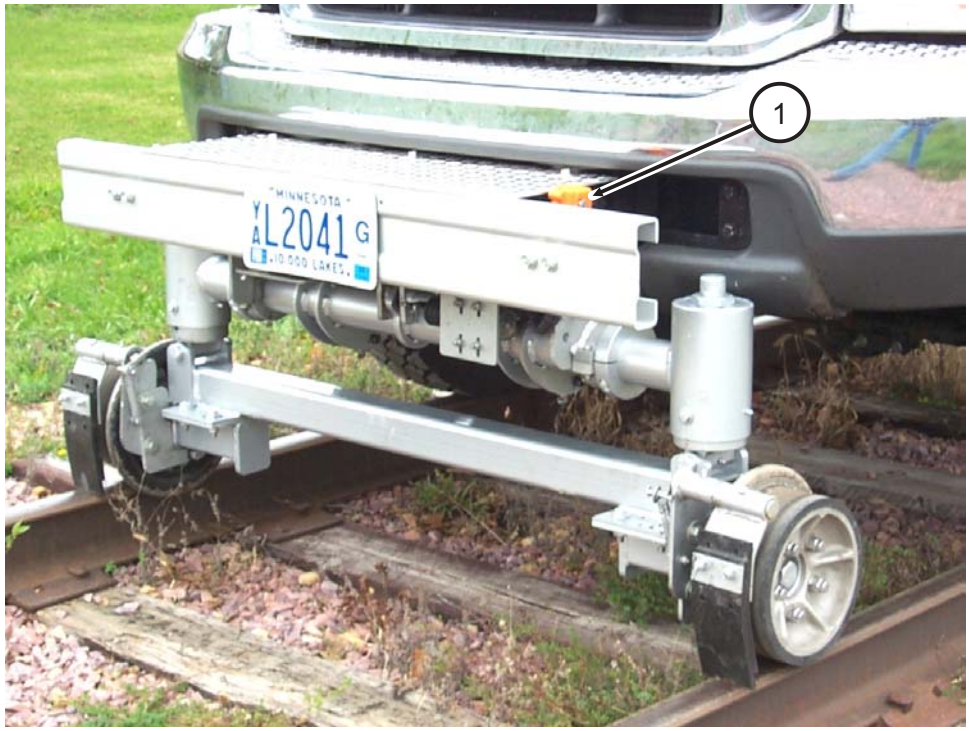
FIGURE 2-14
RAISING FRONT GUIDE WHEELS
ELECTRIC LOCK UNIT SHOWN



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2.9 Removing Vehicle from Track

2.9.2 Raising Rear Guide Wheels - See Figure 2-15

The location of the push / pull cable knob and the up / down switch will vary depending on the application.

2.9.2.1 Mechanical Lock or Hydraulic Lock

1. The hydraulic lock incorporates a pilot operated check valve to hold the hydraulic cylinder in the locked position. Even though the unit is equipped with the hydraulic lock, Harsco Track Technologies recommends that the manual locks also be engaged.

2. Press the DOWN button (1) momentarily to relieve pressure from the lock pin. Pull the knob out on the push / pull cable to disengage the lock. Press the UP button (1) to activate the hydraulic pump and raise the guide wheels from the rail.

3. Continue to hold the UP button (1) until the guide wheels are fully raised to the "highway" position. Release the UP button. Push the knob in on the push / pull cable to engage the lock.

2.9.2.2 Electric Lock

1. Press the DOWN button (1) momentarily to relieve pressure from the lock pin and then press the UP button (1). The electric solenoid will energize and disengage the lock pin. The hydraulic pump will activate to raise the guide wheels from the rail.

2. Continue to hold the UP button (1) until the guide wheels are fully raised to the "highway" position. Release the UP button. The electric solenoid will de-energize and engage the lock pin.

2.9 Removing Vehicle from Track

2.9.2 Raising Rear Guide Wheels

FIGURE 2-15
RAISING REAR GUIDE WHEELS
ELECTRIC LOCK UNIT SHOWN

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2.10 Highway Operation

CAUTION

■ **THIS MULTIPURPOSE VEHICLE HAS SPECIAL DESIGN AND EQUIPMENT FEATURES FOR OFF-ROAD USE. IT HANDLES DIFFERENTLY FROM AN ORDINARY PASSENGER CAR IN DRIVING CONDITIONS WHICH MAY OCCUR ON STREETS, HIGHWAYS AND OFF-ROAD. WEIGHT AND LOCATION OF AVAILABLE PAYLOAD MAY ALSO AFFECT THE HANDLING OF THIS VEHICLE. DRIVE WITH CARE AND WEAR SAFETY BELTS AT ALL TIMES. READ VEHICLE OWNER'S MANUAL FOR ADDITIONAL PRECAUTIONS.**

2.11 Towing Trailer / Equipment With Vehicle On Track

- **VEHICLE USED FOR TOWING MUST BE RATED BY VEHICLE MANUFACTURER FOR WEIGHT OF TRAILER / EQUIPMENT TO BE TOWED. DO NOT EXCEED VEHICLE MANUFACTURER'S MAXIMUM RATED TOWING CAPACITY.**
- **TOWING VEHICLE MUST WEIGH AS MUCH OR MORE THAN TRAILER / EQUIPMENT BEING TOWED.**
- **VEHICLE USED FOR TOWING MUST HAVE AN ADEQUATE BRAKE SYSTEM TO SAFELY DECELERATE AND STOP TOWING VEHICLE AND TRAILER / EQUIPMENT BEING TOWED.**
- **TOWING TRAILER / EQUIPMENT LENGTHENS STOPPING DISTANCES. ALLOW ADEQUATE DISTANCE FOR STOPPING. ANTICIPATE STOPS SO YOU CAN BRAKE GRADUALLY.**
- **STOPPING DISTANCE IS GREATER ON TRACK THAN ON TYPICAL ROAD SURFACES. APPLY BRAKES GRADUALLY TO AVOID SLIDING VEHICLE TIRES AND GUIDE WHEELS.**
- **TOW TRAILER / EQUIPMENT AT A REASONABLE SPEED, 20 MPH (32 km/h) MAXIMUM, TAKING INTO ACCOUNT TRACK CONDITIONS, TRACK GRADE, WEATHER, VISIBILITY AND STOPPING DISTANCE TO ASSURE SAFE OPERATION. RAILROAD RULES GOVERNING SPEEDS AND RIGHT OF WAY SHOULD BE OBSERVED AT ALL TIMES.**
- **TRAILER / EQUIPMENT BEING TOWED MUST BE IN A SAFE, USABLE CONDITION TO BE TOWED.**
- **MAKE SURE THAT VEHICLE HAS:**
  - **FRONT AND REAR GUIDE WHEELS LOWERED AND LOCKED IN RAIL POSITION.**
  - **ALL FRONT AND REAR GUIDE WHEEL FLANGES ENGAGED ON INSIDE OF RAILS.**
  - **STEERING WHEEL LOCK ENGAGED WITH FRONT WHEELS STRAIGHT AHEAD.**

FAILURE TO HEED THESE WARNINGS COULD RESULT IN SEVERE BODILY INJURY.

2.11 Towing Trailer / Equipment With Vehicle On Track

- **CAREFULLY AND THOROUGHLY PREPARE VEHICLE FOR TOWING, MAKING SURE TO USE THE RIGHT TOWING EQUIPMENT AND TO ATTACH IT PROPERLY.**
- **TOWING EQUIPMENT (HITCHES, TOW BARS, ETC.) MUST BE ATTACHED TO VEHICLE FRAME. DO NOT MOUNT OR ATTACH TOWING EQUIPMENT TO VEHICLE GUIDE WHEEL UNITS.**
- **TOWING EQUIPMENT (HITCHES, TOW BARS, ETC.) MUST HAVE A RATED TOWING CAPACITY EQUAL TO OR GREATER THAN WEIGHT OF TRAILER / EQUIPMENT BEING TOWED.**
- **USE A RIGID TYPE TOW BAR WITH SAFETY LOCKING COUPLERS. DO NOT USE CHAIN, WIRE ROPE ETC.**
- **OBSERVE AND FOLLOW ALL RAILROAD SAFETY RULES AND REGULATIONS.**
- **DO NOT ACCELERATE SUDDENLY. TRACTION IS REDUCED ON RAIL, SPINNING VEHICLE TIRES COULD DAMAGE THEM.**

FAILURE TO HEED THESE PRECAUTIONS COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.

2.11 Towing Trailer / Equipment With Vehicle On Track

1. See your vehicle operator's manual for towing information.

2. Use the vehicle manufacturer's recommendations to determine the maximum weight the towing vehicle can tow. Do not exceed the vehicle manufacturer's maximum rated towing capacity.

3. The towing vehicle must have an adequate brake system to safely decelerate and stop the towing vehicle and the trailer / equipment being towed. The towing vehicle must weigh as much or more than the trailer / equipment being towed.

4. Make sure that the vehicle has:
   a. Front and rear guide wheels lowered and locked in the rail position.
   b. All front and rear guide wheel flanges engaged on the inside of the rails.
   c. Front wheels are set straight ahead and the steering wheel lock is engaged on the steering column.

5. Make sure the towing vehicle and the trailer / equipment are in good working condition (tires, brakes, lights, etc.) and that current maintenance has been performed on the vehicle and trailer / equipment.

6. The towing equipment (hitches, tow bars, etc.) on the towing vehicle must have a rating equal to or greater than the weight of the trailer / equipment being towed.

7. The towing equipment (hitches, tow bars, etc.) must be attached to the towing vehicle frame. Do not mount or attach the towing equipment to the guide wheel units.

8. Observe and follow all railroad safety rules and regulations.

9. Do not accelerate suddenly. Traction is reduced on track. Spinning the vehicle tires could damage them.

10. Stopping distance is greater on track than on typical road surfaces. Apply the vehicle brakes gradually to avoid sliding the vehicle tires and the guide wheels. Towing trailer / equipment lengthens stopping distances. Allow adequate distance for stopping. Anticipate stops so that you can brake gradually.

11. Tow the trailer / equipment on the track at a reasonable speed, 20 MPH (32 km/h) maximum, taking into account track conditions, track grade, weather, visibility and stopping distance to assure safe operation. Railroad rules and regulations governing speed limits and right of way should be observed at all times.

12. Always chock the trailer wheels before unhooking the trailer from the towing vehicle.

2.12 Towing Trailer / Equipment With Vehicle On Road

- **VEHICLE USED FOR TOWING MUST BE RATED BY VEHICLE MANUFACTURER FOR WEIGHT OF TRAILER / EQUIPMENT TO BE TOWED. DO NOT EXCEED VEHICLE MANUFACTURER'S MAXIMUM RATED TOWING CAPACITY.**

- **VEHICLE USED FOR TOWING MUST HAVE AN ADEQUATE BRAKE SYSTEM TO SAFELY DECELERATE AND STOP TOWING VEHICLE AND TRAILER / EQUIPMENT BEING TOWED.**

- **TOWING TRAILER / EQUIPMENT LENGTHENS STOPPING DISTANCES. ALLOW ADEQUATE DISTANCE FOR STOPPING. ANTICIPATE STOPS SO YOU CAN BRAKE GRADUALLY.**

- **TOW TRAILER / EQUIPMENT AT A REASONABLE SPEED TAKING INTO ACCOUNT ROAD CONDITIONS, ROAD GRADE, WEATHER, VISIBILITY AND STOPPING DISTANCE TO ASSURE SAFE OPERATION. POSTED SPEED LIMITS SHOULD BE OBSERVED AT ALL TIMES.**

- **TRAILER / EQUIPMENT BEING TOWED MUST BE IN A SAFE, USABLE CONDITION TO BE TOWED.**

- **MAKE SURE THAT VEHICLE HAS:**
  - **FRONT AND REAR GUIDE WHEEL UNITS RAISED AND LOCKED IN HIGHWAY POSITION.**
  - **STEERING WHEEL LOCK DISENGAGED.**

FAILURE TO HEED THESE WARNINGS COULD RESULT IN SEVERE BODILY INJURY.

2.12 Towing Trailer / Equipment With Vehicle On Road

- **THIS MULTIPURPOSE VEHICLE HAS SPECIAL DESIGN AND EQUIPMENT FEATURES FOR OFF-ROAD USE. IT HANDLES DIFFERENTLY FROM AN ORDINARY PASSENGER CAR IN DRIVING CONDITIONS WHICH MAY OCCUR ON STREETS, HIGHWAYS AND OFF-ROAD. WEIGHT AND LOCATION OF AVAILABLE PAYLOAD MAY ALSO AFFECT THE HANDLING OF THIS VEHICLE. DRIVE WITH CARE AND WEAR SAFETY BELTS AT ALL TIMES. READ VEHICLE OWNER'S MANUAL FOR ADDITIONAL PRECAUTIONS.**

- **OBSERVE AND FOLLOW ALL FEDERAL, STATE AND LOCAL DRIVING RULES AND REGULATIONS.**

- **STATE LAWS MAY REQUIRE TOWING VEHICLE AND TRAILER / EQUIPMENT BEING TOWED TO BE EQUIPPED WITH SPECIAL SAFETY EQUIPMENT (MIRRORS ON BOTH SIDES OF TOWING VEHICLE, TRAILER BRAKES, TRAILER LIGHTS, ETC.).**

- **CAREFULLY AND THOROUGHLY PREPARE YOUR VEHICLE FOR TOWING, MAKING SURE TO USE THE RIGHT TOWING EQUIPMENT AND TO ATTACH IT PROPERLY.**

- **TOWING EQUIPMENT (HITCHES, TOW BARS, ETC.) MUST BE ATTACHED TO VEHICLE FRAME. DO NOT MOUNT OR ATTACH TOWING EQUIPMENT TO WHEEL UNITS.**

- **TOWING EQUIPMENT (HITCH, TOW BAR, ETC.) MUST HAVE A RATED TOWING CAPACITY EQUAL TO OR GREATER THAN WEIGHT OF TRAILER / EQUIPMENT BEING TOWED.**

FAILURE TO HEED THESE PRECAUTIONS COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.

2.12 Towing Trailer / Equipment With Vehicle On Road

1. See your vehicle operator's manual for towing information.

2. Use the vehicle manufacturer's recommendations to determine the maximum weight the towing vehicle can tow. Do not exceed the vehicle manufacturer's maximum rated towing capacity.

3. The towing vehicle must have an adequate brake system to safely decelerate and stop the towing vehicle and the trailer / equipment being towed. Towing trailer / equipment lengthens stopping distances. Allow adequate distance for stopping. Anticipate stops so that you can brake gradually.

4. Make sure that the vehicle has:
   a. Front and rear guide wheel units raised and locked in the highway position.
   b. Steering wheel lock is disengaged on the steering column.

5. Make sure the towing vehicle and the trailer / equipment are in good working condition (tires, brakes, lights, etc.) and that current maintenance has been performed on the vehicle and trailer / equipment.

6. The towing equipment (hitches, tow bars, etc.) on the towing vehicle must have a rating equal to or greater than the weight of the trailer / equipment being towed.

7. The towing equipment (hitches, tow bars, etc.) must be attached to the towing vehicle frame. Do not mount or attach the towing equipment to the guide wheel units.

8. Observe and follow all federal, state and local driving rules, regulations and laws.

9. State laws may require the towing vehicle and/or the trailer / equipment being towed to be equipped with special safety equipment (mirrors on both sides of the towing vehicle, trailer brakes, trailer lights, etc.).

10. Tow the trailer / equipment on the road at a reasonable speed taking into account road conditions, road grade, weather, visibility and stopping distance to assure safe operation. Always observe posted speed limits.

11. Always chock the trailer wheels before unhooking the trailer from the towing vehicle.

2.13 Towing Disabled Vehicle On Track

- **TOWING VEHICLE / MACHINE MUST WEIGH AS MUCH OR MORE THAN DISABLED VEHICLE BEING TOWED.**
- **VEHICLE / MACHINE USED FOR TOWING MUST HAVE AN ADEQUATE BRAKE SYSTEM TO SAFELY DECELERATE AND STOP TOWING VEHICLE / MACHINE AND DISABLED VEHICLE BEING TOWED.**
- **TOWING DISABLED VEHICLE LENGTHENS STOPPING DISTANCES. ALLOW ADEQUATE DISTANCE FOR STOPPING. ANTICIPATE STOPS SO YOU CAN BRAKE GRADUALLY.**
- **TOW DISABLED VEHICLE AT A REASONABLE SPEED, 10 MPH (16 km/h) MAXIMUM, TAKING INTO ACCOUNT TRACK CONDITIONS, TRACK GRADE, WEATHER, VISIBILITY AND STOPPING DISTANCE TO ASSURE SAFE OPERATION. RAILROAD RULES GOVERNING SPEED LIMITS AND RIGHT OF WAY SHOULD BE OBSERVED AT ALL TIMES.**
- **STOPPING DISTANCE IS GREATER ON TRACK THAN ON TYPICAL ROAD SURFACES. APPLY BRAKES GRADUALLY TO AVOID SLIDING TOWING VEHICLE / MACHINE WHEELS.**
- **MAKE SURE THAT DISABLED VEHICLE HAS:**
  - **FRONT AND REAR GUIDE WHEEL UNITS LOWERED AND LOCKED IN RAIL POSITION.**
  - **ALL FRONT AND REAR GUIDE WHEEL FLANGES ENGAGED ON INSIDE OF RAILS.**
  - **STEERING WHEEL LOCK ENGAGED WITH FRONT WHEELS STRAIGHT AHEAD.**

FAILURE TO HEED THESE WARNINGS COULD RESULT IN SEVERE BODILY INJURY.

2.13 Towing Disabled Vehicle On Track

- **TOW BAR MUST BE ATTACHED TO DISABLED VEHICLE FRAME. DO NOT MOUNT OR ATTACH TOW BAR TO DISABLED VEHICLE GUIDE WHEEL UNITS.**
- **TOW BAR MUST HAVE A RATED TOWING CAPACITY EQUAL TO OR GREATER THAN WEIGHT OF DISABLED VEHICLE BEING TOWED.**
- **USE A RIGID TYPE TOW BAR WITH SAFETY LOCKING COUPLERS. DO NOT USE CHAIN, WIRE ROPE ETC.**
- **OBSERVE AND FOLLOW ALL RAILROAD SAFETY RULES AND REGULATIONS.**
- **DO NOT ACCELERATE SUDDENLY. TRACTION IS REDUCED ON TRACK, SPINNING TOWING VEHICLE / MACHINE WHEELS COULD DAMAGE THEM.**
- **TOW DISABLED VEHICLE TO NEAREST ROAD CROSSING AND REMOVE FROM TRACK.**

FAILURE TO HEED THESE PRECAUTIONS COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.

2.13 Towing Disabled Vehicle On Track

1. See your vehicle operator's manual for towing information.

2. The towing vehicle / machine must have an adequate brake system to safely decelerate and stop the towing vehicle / machine and the disabled vehicle being towed. The towing vehicle / machine must weigh as much or more than the disabled vehicle towed.

3. Make sure that the disabled vehicle has:
   a. Front and rear guide wheel units lowered and locked in the rail position.
   b. All front and rear guide wheel flanges engaged on the inside of the rails.
   c. Front wheels are set straight ahead and the steering wheel lock is engaged on the steering column.

4. Make sure the towing vehicle / machine is in good working condition (tires, brakes, lights, etc.) and that current maintenance has been performed on the vehicle / machine.

5. The towing equipment (hitches, tow bars, etc.) on the towing vehicle / machine must have a rating equal to or greater than the weight of the disabled vehicle being towed.

6. The tow bar must be mounted or attached to the disabled vehicle's frame. Do not mount or attach the tow bar to the disabled vehicle guide wheel units. Use a rigid type tow bar with safety locking couplers.

7. Observe and follow all railroad safety rules and regulations.

8. Do not accelerate suddenly. Traction is reduced on track. Spinning the towing vehicle tires / machine wheels could damage them.

9. Stopping distance is greater on track than on typical road surfaces. Apply the towing vehicle / machine brakes gradually to avoid sliding the vehicle tires / machine wheels. Towing disabled vehicle lengthens stopping distances. Allow adequate distance for stopping. Anticipate stops so that you can brake gradually.

10. Tow the disabled vehicle on the track at a reasonable speed, 10 MPH (16 km/h) maximum, taking into account track conditions, track grade, weather, visibility and stopping distance to assure safe operation. Railroad rules and regulations governing speed limits and right of way should be observed at all times.

11. Tow the disabled vehicle to the nearest road crossing and remove the vehicle from the track.

2.14 Towing Disabled Vehicle On Road

- **TOW DISABLED VEHICLE PER VEHICLE MANUFACTURER'S TOWING SPECIFICATIONS LISTED IN YOUR VEHICLE'S OPERATORS MANUAL.**
- **VEHICLE USED FOR TOWING MUST HAVE AN ADEQUATE BRAKE SYSTEM TO SAFELY DECELERATE AND STOP TOWING VEHICLE AND DISABLED VEHICLE BEING TOWED.**
- **TOW DISABLED VEHICLE AT A REASONABLE SPEED TAKING INTO ACCOUNT ROAD CONDITIONS, ROAD GRADE, WEATHER, VISIBILITY AND STOPPING DISTANCE TO ASSURE SAFE OPERATION. POSTED SPEED LIMITS SHOULD BE OBSERVED AT ALL TIMES.**
- **MAKE SURE DISABLED VEHICLE HAS:**
  - **FRONT AND REAR GUIDE WHEEL UNITS RAISED AND LOCKED IN HIGHWAY POSITION.**
  - **STEERING WHEEL LOCK DISENGAGED.**

FAILURE TO HEED THESE WARNINGS COULD RESULT IN SEVERE BODILY INJURY.

- **TOWING EQUIPMENT (TOW TRUCK, TOW BARS, ETC.) MUST BE ATTACHED TO DISABLED VEHICLE FRAME. DO NOT MOUNT OR ATTACH TOWING EQUIPMENT TO DISABLED VEHICLE GUIDE WHEEL UNITS.**
- **TOWING EQUIPMENT (TOW TRUCK, TOW BARS, ETC.) MUST HAVE A RATED TOWING CAPACITY EQUAL TO OR GREATER THAN WEIGHT OF DISABLED VEHICLE BEING TOWED.**
- **OBSERVE AND FOLLOW ALL FEDERAL, STATE AND LOCAL DRIVING RULES AND REGULATIONS.**
- **STATE LAWS MAY REQUIRE TOWING VEHICLE AND DISABLED VEHICLE TO BE EQUIPPED WITH SPECIAL SAFETY EQUIPMENT (LIGHTS, ETC.).**

FAILURE TO HEED THESE PRECAUTIONS COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.

2.14 Towing Disabled Vehicle On Road

1. See your vehicle operator's manual for towing information.

2. The towing vehicle must have an adequate brake system to safely decelerate and stop the towing vehicle and the disabled vehicle being towed.

3. Make sure that the disabled vehicle's:
   a. Front and rear guide wheel units are raised and locked in the highway position.
   b. Vehicle steering wheel lock is disengaged on the steering column.

4. Make sure the towing vehicle is in good working condition (tires, brakes, lights, etc.) and that current maintenance has been performed on the vehicle.

5. The towing equipment (tow truck, tow bars, etc.) on the towing vehicle must have a rating equal to or greater than the weight of the disabled vehicle being towed.

6. The towing equipment (tow truck, tow bars, etc.) must be mounted or attached to the disabled vehicle frame. Do not mount or attach the towing equipment to the disabled vehicle guide wheel units.

7. Observe and follow all federal, state and local driving rules, regulations and laws.

8. State laws may require the towing vehicle and disabled vehicle being towed to be equipped with special safety equipment (lights, etc.).

9. Tow the disabled vehicle on the road at a reasonable speed taking into account road conditions, road grade, weather, visibility and stopping distance to assure safe operation. Always observe posted speed limits.

SECTION 3 - ADJUSTMENTS
TABLE OF CONTENTS

3.1 Guide Wheel Equipment Alignment Procedure

- **BEFORE PERFORMING ANY ADJUSTMENTS TO THE GUIDE WHEEL UNITS OR VEHICLE, ALWAYS PLACE THE AUTOMATIC TRANSMISSION IN "PARK" OR THE MANUAL TRANSMISSION IN "NEUTRAL". APPLY THE PARKING BRAKE.**

- **UNDERSTAND EQUIPMENT OPERATION AND BE AWARE OF ALL PINCH POINTS BEFORE OPERATING OR MAKING ADJUSTMENTS TO THE GUIDE WHEEL EQUIPMENT.**

FAILURE TO HEED THESE WARNINGS COULD RESULT IN SEVERE BODILY INJURY.

The Guide Wheel Alignment Procedure must be completed when the guide wheel equipment is applied to the vehicle, or when any of the misalignment indicators occur. See Operation Section -Misalignment Indicators.

3.1.1 Vehicle Check

1. The vehicle must be at curb weight with permanent attachments: spare tire, tool box less tools, utility box, crane, aerial lift boom, etc. and without: passengers, baggage, load, etc.

2. Weigh the entire vehicle and record this weight. Weigh both the front and rear axles of the vehicle separately and record these weights. Weights will be used when calculating the guide wheel load.

3. The weight of the vehicle should not exceed the GVWR (Gross Vehicle Weight Rating) and the weight on the front and rear axles should not exceed their respective GAWR (Gross Axle Weight Rating).

4. Permanent attachments to the vehicle such as a tool box, utility box, crane aerial lift boom, etc. which could cause uneven loading on the guide wheels should be compensated for by adjusting the vehicle suspension by adding leaf springs, coil springs, torsion bars, etc.

5. Tires must be inflated to the tire manufacturer's recommended maximum pressure printed on the sidewalls of the tires or the wheel manufacturer's recommended maximum pressure stamped on the wheel, whichever is lower.

6. Visually inspect the entire vehicle, especially the guide wheel equipment for loose or missing bolts and bent or damaged components. Tighten, repair or replace as necessary.

7. Verify that the vehicle that the guide wheel equipment is being mounted on is equipped correctly (springs, tires, wheels, etc.). See the Harsco Track Technologies HY-RAIL® Vehicle Specifications Manual.

3.1 Guide Wheel Equipment Alignment Procedure

3.1.1 Vehicle Check

8. Check the following measurements on the vehicle that the guide wheel equipment is to be mounted on before applying the guide wheel equipment to the vehicle.

    a. Frame must be square. Diagonal measurements of frame should be equal within 1/8 inch (3.2 mm).

    b. Wheelbase (as measured on each side) must be equal within 1/16 inch (1.8 mm).

    c. Vehicle axles must be square with the frame within 1/64 inch per foot (.4 mm per 305 mm). Harsco Track Technologies, Harsco Corporation recommends that this be checked by a reputable alignment shop.

9. Follow the mounting instructions on the application drawing which is supplied with each Guide Wheel Equipment Group.

    Note: The applicator of the guide wheel equipment must make sure the application drawings remain with the vehicle for further reference. If the application drawings are not with the vehicle, contact Harsco Track Technologies, Fairmont Minnesota Facility to obtain these drawings.

10. After mounting the guide wheel equipment, have a four point alignment completed on the vehicle including checking the caster, camber, toe-in on the front wheels and thrust angle of the rear axle. The thrust angle of the rear axle should be set as close to zero as possible. If necessary, adjust to vehicle manufacturer's recommendations.

11. Have the headlight aim checked and adjusted, if necessary.

3.1.2 Placing Vehicle On Track

1. Place the vehicle on straight, level, tangent track or on an alignment rack constructed for guide wheel equipment alignment. If track or an alignment rack is not available, use 4 x 4 inch lumber, on a level floor, to simulate track. Space the lumber so it measures 56-1/2 inches between the inside edges.

2. Place the automatic transmission in "Park" or manual transmission in "Neutral". Apply the parking brake. Stop the engine. Lower and lock the guide wheels in the "rail" position. See Operation Section - Placing Vehicle On Track.

3. Set the vehicle wheels straight ahead. Secure the steering wheel using the steering lock. Stop the engine.

3.1 Guide Wheel Equipment Alignment Procedure

3.1.3 Guide Wheel Unit Track Gauge - See Figure 3-1

1. Measure the track gauge of the front and rear guide wheel units. Measure from the back of the left wheel flange, directly below the center line of the wheel spindle, to the same point on the right wheel flange. This dimension must be 53-3/8 - 53-1/2 inches (1356 - 1359 mm).

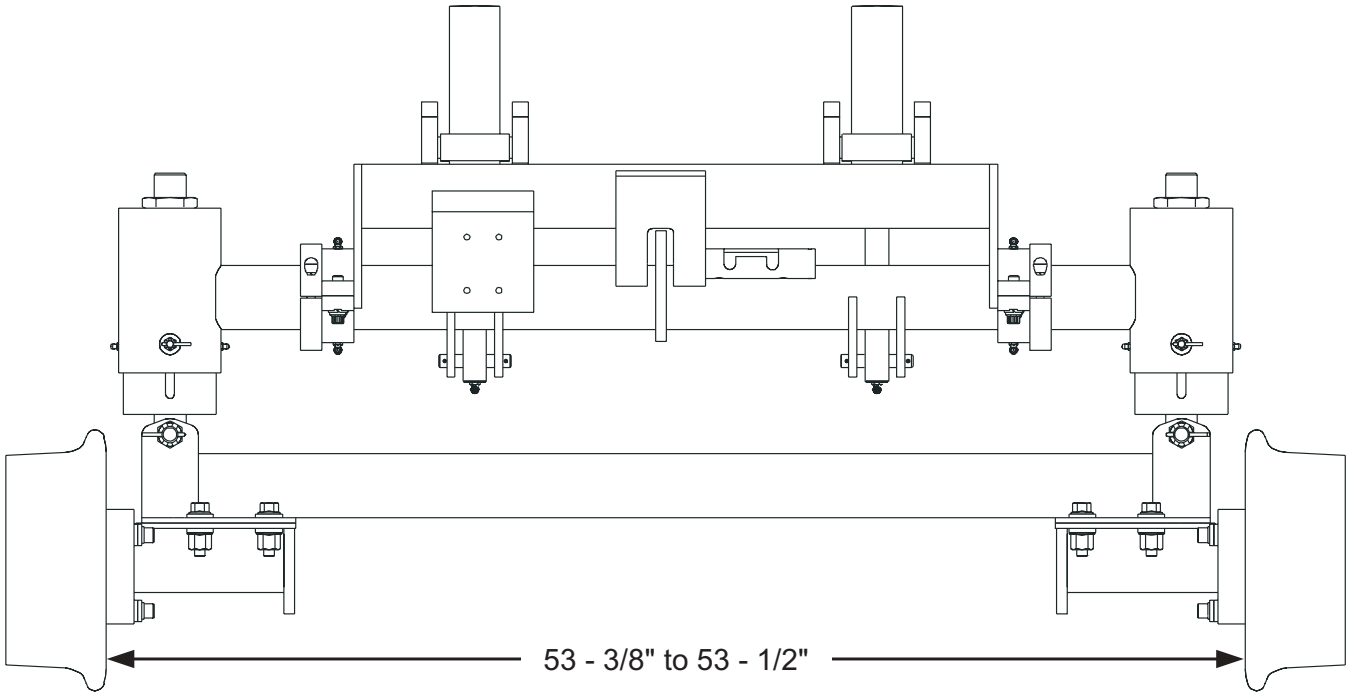
2. Although the front and rear guide wheel unit track gauge is preset at the factory, it is possible for the track gauge to change when guide wheel alignment procedures are performed on the guide wheel unit.

3. Always check the guide wheel track gauge after performing any guide wheel alignment procedures to ensure the track gauge is within the allowable limits.

3.1 Guide Wheel Equipment Alignment Procedure

3.1.3 Guide Wheel Unit Track Gauge

FIGURE 3-1
GUIDE WHEEL UNIT



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3.1 Guide Wheel Equipment Alignment Procedure

- **IMPROPER LOADING OF GUIDE WHEEL EQUIPPED VEHICLE CAN CAUSE DERAILMENT OF VEHICLE.**
- **APPLY VEHICLE PARKING BRAKE AND STOP VEHICLE ENGINE BEFORE CHECKING GUIDE WHEEL LOAD.**
- **ALWAYS CHECK THE GUIDE WHEEL LOAD BEFORE OPERATING THE VEHICLE ON TRACK. NEVER OPERATE THE VEHICLE ON TRACK IF LOAD EXCEEDS THE MAXIMUM RATED LOAD ON THE FRONT AND/OR REAR GUIDE WHEEL UNITS. THE MAXIMUM LOAD ON THE FRONT OR REAR GUIDE WHEEL UNIT IS 3,000 LBS (1361 kg) OR 1,500 LBS (680 kg) MAXIMUM PER GUIDE WHEEL.**
- **DO NOT USE ANY OTHER JACK THEN THE HARSCO TRACK TECHNOLOGIES WHEEL WEIGHING JACK NO. 073527 TO CHECK THE GUIDE WHEEL LOAD. USE OF ANY OTHER JACK WILL RESULT IN INCORRECT GUIDE WHEEL LOAD INFORMATION.**
- **MISUSE OF THE WHEEL WEIGHING JACK MAY CAUSE GAUGE TO EXPLODE. READ ANSI B40.1 AND APPARATUS INSTALLATION / OPERATING INSTRUCTIONS BEFORE USE.**
- **DO NOT USE THE WHEEL WEIGHING JACK TO LIFT THE VEHICLE. EXCESSIVE WEIGHT MAY CAUSE THE JACK TO FAIL.**

FAILURE TO HEED THESE WARNINGS COULD RESULT IN DERAILMENT OF VEHICLE AND/OR SEVERE BODILY INJURY.

3

3.1.4 Guide Wheel Load

3.1.4.1 Checking Guide Wheel Load Using The Guide Wheel Load Jack - See Figure 3-2

1. Apply the parking brake. Lower and lock the guide wheels in the rail position. Stop the vehicle's engine.

2. The guide wheel load can be checked using the HTT # 073527 Wheel Weighing Jack. Do not use any other jack to check the guide wheel load. The use of an other jack will result in incorrect guide wheel load information.

3. Place the jack under the square tube as close to the guide wheel as possible. Jack the guide wheel up until the guide wheel just clears the top of the rail. Note the gauge reading. The gauge reading indicates the pounds of load on the guide wheel.

Note: An easy way to tell when the guide wheel just clears the top of rail is to jack the wheel up approximately 1/4" (6.4 mm) above the top of the rail. Place a piece of paper between the rail and the guide wheel. Lower the guide wheel onto the paper. Slowly jack the guide wheel up while applying a steady pulling force on the paper until the paper can be pulled out. Note the gauge reading when the paper can be removed.

3.1 Guide Wheel Equipment Alignment Procedure

3.1.4 Guide Wheel Load

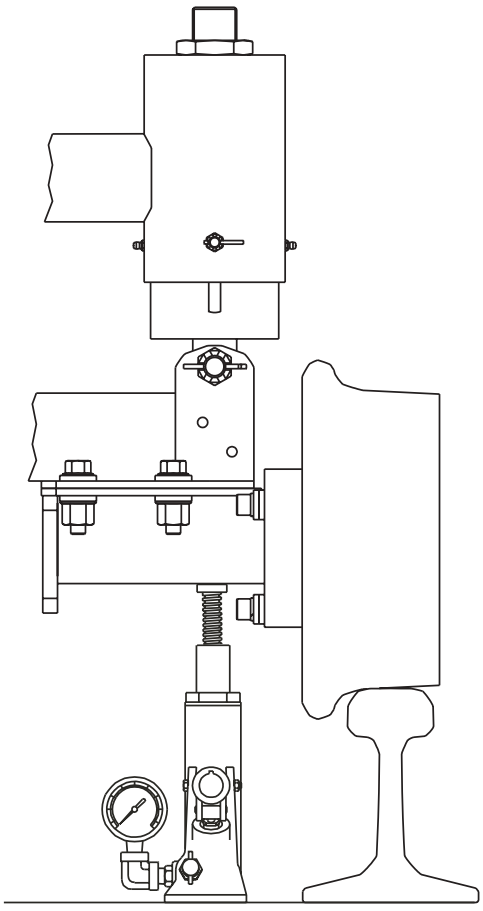
3.1.4.1 Checking Guide Wheel Load Using The Guide Wheel Load Jack - Continued

4. With the vehicle at curb weight, the recommended guide wheel load is 500 lbs ± 25 lbs (227 kg ± 11 kg) per guide wheel. The recommended guide wheel load must also be equal on the left and right sides of the front or rear guide wheel unit.

5. The maximum rated load on the front and / or rear guide wheel unit is 3,000 lbs (1361 kg) or 1,500 lbs (680 kg) maximum per guide wheel. The front and / or rear guide wheel unit spring cells are adjustable.

6. If the load exceeds the maximum rated load capacity of the front and / or rear guide wheel unit or the maximum rated load capacity of any guide wheel, the load must be redistributed or some of the load removed. Never operate the vehicle on track if the load on the front and / or rear guide wheel unit exceeds the maximum rated load capacity.

FIGURE 3-2
WHEEL LOAD WEIGHING JACK



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3.1 Guide Wheel Equipment Alignment Procedure

3.1.4 Guide Wheel Load

3.1.4.2 Checking Guide Wheel Load By Measuring - See Figure 3-3 and Chart 3-4

1. Apply the parking brake. Lower and lock the guide wheels in the rail position. Stop the vehicle's engine.

2. Measure from the top of the adjusting stud (1) to the bottom of the inner spring cell tube (2). This measured dimension will be designated as Dimension "A".

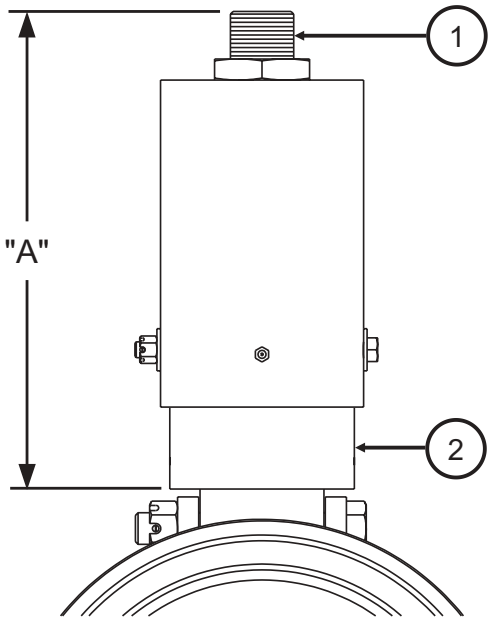
3. See Chart 3-4 to convert the measured Dimension "A" to the approximate load on the guide wheel.

4. With the vehicle at curb weight, the recommended guide wheel load is 500 lbs ± 25 lbs (227 kg ± 11 kg) per guide wheel. The recommended guide wheel load must also be equal on the left and right sides of the front or rear guide wheel unit.

5. The maximum rated load on the front and / or rear guide wheel unit is 3,000 lbs (1361 kg) or 1,500 lbs (680 kg) maximum per guide wheel. The front and / or rear guide wheel unit spring cells are adjustable.

6. If the load exceeds the maximum rated load capacity of the front and / or rear guide wheel unit or the maximum rated load capacity of any guide wheel, the load must be redistributed or some of the load removed. Never operate the vehicle on track if the load on the front and / or rear guide wheel unit exceeds the maximum rated load capacity.

FIGURE 3-3
MEASURING SPRING CELL



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3.1 Guide Wheel Equipment Alignment Procedure

3.1.4 Guide Wheel Load

3.1.4.2 Checking Guide Wheel Load By Measuring

CHART 3-4
GUIDE WHEEL LOAD

	DIMENSION "A"		APPROXIMATE LOAD PER SIDE	
	11-1/4"	(285.8 mm).	25 lbs	(11 kg)
	11-1/8"	(282.6 mm).	100 lbs	(45 kg)
	11"	(279.4 mm).	150 lbs	(68 kg)
	10-7/8"	(276.2 mm).	225 lbs	(102 kg)
	10-3/4"	(273.0 mm).	275 lbs	(125 kg)
	10-5/8"	(269.9 mm	325 lbs	(147 kg)
	10-1/2"	(266.7 mm).	375 lbs	(170 kg)
	10-3/8"	(263.5 mm).	425 lbs	(193 kg)
	10-1/4"	(260.4 mm).	475 lbs	(216 kg)
	10-3/16"	(258.8 mm).	500 lbs	(227 kg)
	10-1/8"	(257.2 mm).	525 lbs	(238 kg)
	10"	(254.0 mm).	575 lbs	(261 kg)
	9-7/8"	(250.8 mm).	625 lbs	(284 kg)
	9-3/4"	(250.2 mm).	725 lbs	(329 kg)
	9-5/8"	(244.5 mm).	825 lbs	(374 kg)
	9-1/2"	(241.3 mm).	1000 lbs	(454 kg)
	9-3/8"	(238.1 mm).	1250 lbs	(567 kg)
	9-5/16"	(236.5 mm).	1500 lbs	(680 kg)
①	**9-1/4"**	**(235.0 mm). . . . . .**	**1800 lbs**	**(817 kg)**

① **GUIDE WHEEL IS OVERLOADED. REDISTRIBUTE OR REMOVE SOME OF THE LOAD. MAXIMUM LOAD ON GUIDE WHEEL UNIT MUST NOT EXCEED 3,000 LBS (1361 kg) OR 1,500 LBS (680 kg) MAXIMUM PER GUIDE WHEEL.**

3.1 Guide Wheel Equipment Alignment Procedure

3.1.4 Guide Wheel Load

3.1.4.3 Adjusting Guide Wheel Load - See Figure 3-2, Figure 3-3, Chart 3-4 and Figure 3-5

1. With the vehicle at curb weight the spring cell must be set to the recommended guide wheel load of 500 lbs ± 25 lbs (227 kg ± 11 kg) per guide wheel. The recommended guide wheel load must also be equal on the left and right sides of the front or rear guide wheel unit.

2. See Figure 3-5. To adjust the spring cell load, raise the guide wheels and let them rest on the rails. DO NOT adjust the spring cell with any load on the guide wheels. To do so may damage the rubber suspension spring.

   Loosen lock nut (3). Insert a 1/2 inch drive ratchet into the 1/2 inch socket in the adjusting stud (1). Turn the adjusting stud clockwise to increase the load on the guide wheel or counter-clockwise to decrease the load on the guide wheel. Tighten lock nut (3).

3. See Figure 3-2, Figure 3-3 and Chart 3-4. Lower and lock the guide wheels in the rail position. See Checking Guide Wheel Load. Use the Wheel Weighing Jack or measure from the top of adjusting stud to the bottom of the inner spring cell tube to determine the load on the guide wheel.

4. Repeat Steps 1 through 3 until the guide wheel unit is set at the recommend guide wheel load. The recommended guide wheel load must be equal on the left and right sides of the front or rear guide wheel unit.

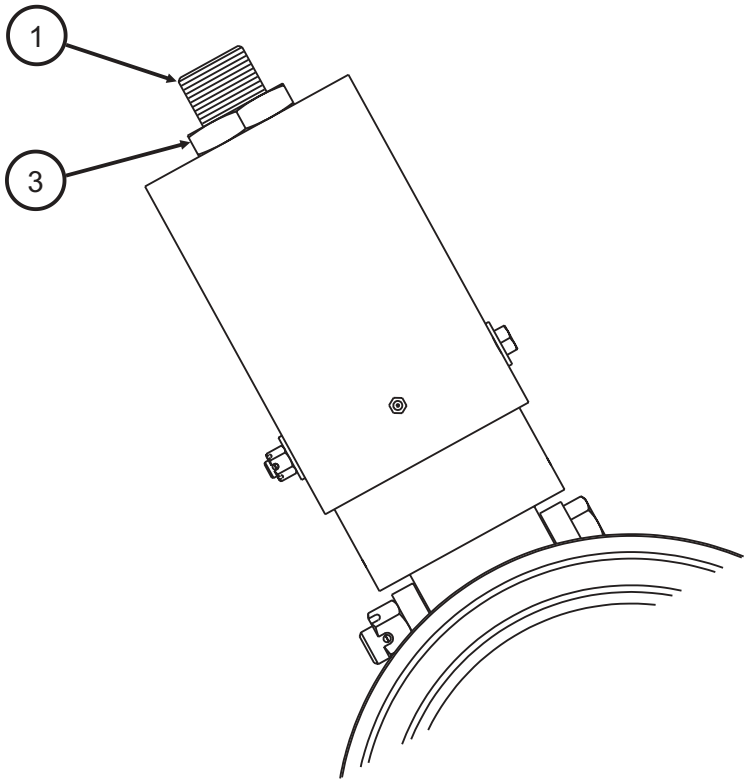
5. If the spring cells cannot be adjusted to the recommended guide wheel load, the guide wheel unit must be repositioned in a different set of mounting holes.

3.1 Guide Wheel Equipment Alignment Procedure

3.1.4 Guide Wheel Load

3.1.4.3 Adjusting Guide Wheel Load

FIGURE 3-5
ADJUSTING GUIDE WHEEL LOAD



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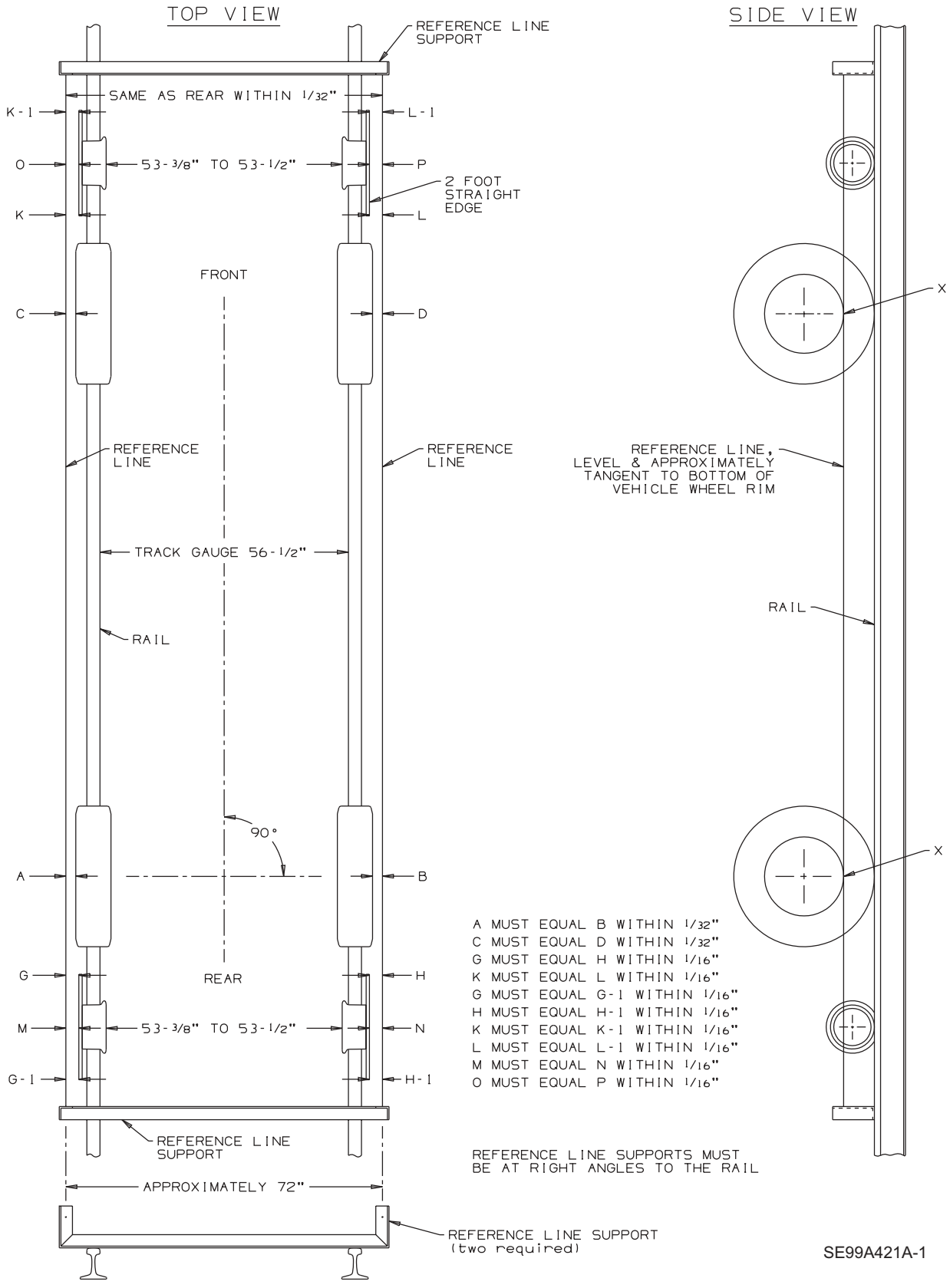
3.1 Guide Wheel Equipment Alignment Procedure

FIGURE 3-6
GUIDE WHEEL EQUIPMENT ALIGNMENT



3.1 Guide Wheel Equipment Alignment Procedure

3.1.5 String Lining Set-Up - See Figure 3-6

1. The string lining procedure is only a guide to check and make alignment adjustments to the guide wheel equipment. String lining the vehicle and guide wheel equipment will not guarantee that the guide wheel equipped vehicle will track properly. Harsco Track Technologies recommends that all HY-RAIL® equipped vehicles be track tested. The vehicle should be at its normal operating load for track testing. The vehicle should be track tested when:

   a. The guide wheel equipment is installed on the vehicle.
   b. Any adjustments are made to the guide wheel equipment.
   c. The load on the vehicle is changed.
   d. Periodically to ensure that the vehicle is tracking properly.

2. Establish parallel reference lines on each side of vehicle as shown in Figure 3-6.

3. Parallel reference lines can be established by building two supports or brackets. These can be built out of scrap angle iron or other material. The supports should be approximately 6 inches high, and a few inches longer than the width of the vehicle. Wires or cords stretched between the front and rear supports will be the reference lines. The wires or cords should be spaced approximately 72 inches apart. The distance between the wires or cords must be equal or within 1/32 inch at each support.

4. Clamp the supports to the rail in front of and behind the vehicle. The supports should be at right angles to the rail. Stretch the wires or cords between the supports, level with the bottom edge of the vehicle wheel rim (point X). The reference lines must be level.

5. Shift the supports on the rail until dimensions A = B and C = D are equal or within 1/32 inch. These measurements should be taken from the bead seat of the vehicle rim directly below the axle (point X) to the reference line. When shifting the supports, keep them at right angles to the rail so the reference lines stay level and parallel to each other.

6. After the reference lines have been established, measurements can be taken from these lines to the guide wheels to ensure correct alignment.

3.1 Guide Wheel Equipment Alignment Procedure

3.1.6 Guide Wheel Unit Alignment

3.1.6.1 Checking Guide Wheel Unit Alignment - See Figures 3-6 and 3-7

1. Lower and lock the guide wheels in the "rail" position. Take measurements M, N, O & P. Measure from the outer edge of the guide wheels, directly below the center line of the wheel spindle, to the reference line. Measurements M, N, O & P must all be equal or within 1/16 inch. If not, see Adjustment.

3.1.6.2 Adjusting Guide Wheels

a. Unlock and raise the front and/or rear guide wheels until they rest on the rail.

b. Loosen the four socket head cap screws (1) on collars (2).

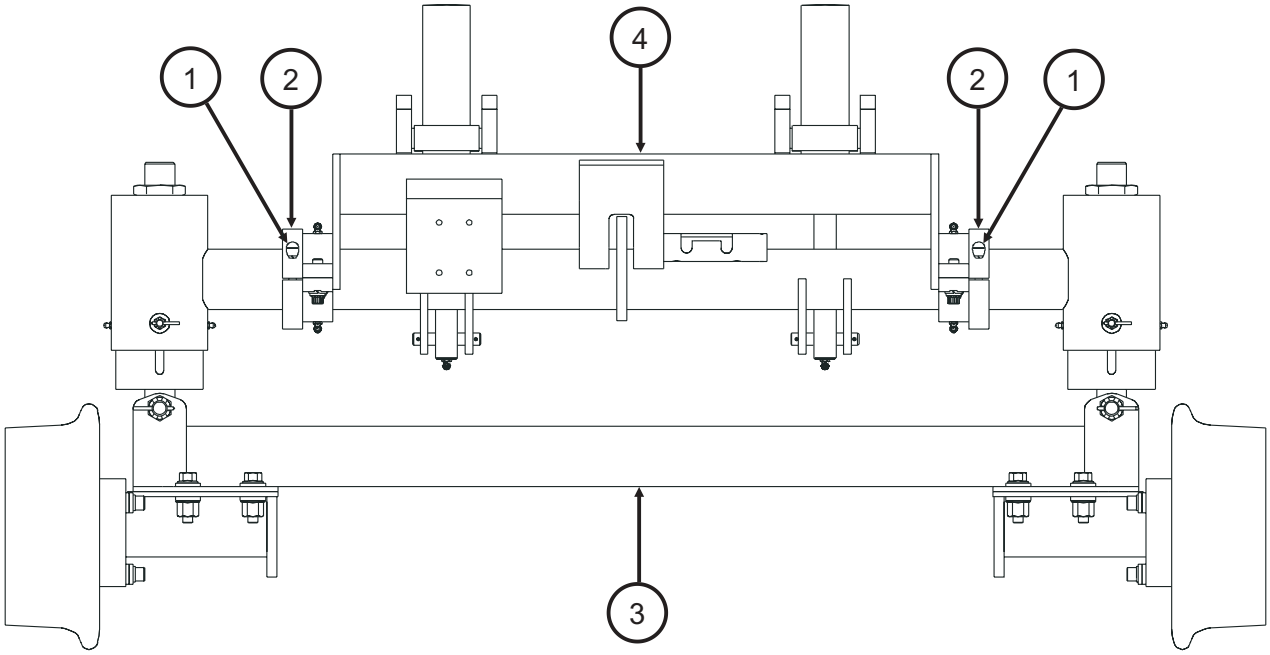
d. Shift the entire cross tube and axle assembly (3) until measurements M & N or O & P are all equal. Make sure collars (2) are snug against the frame mounting assembly (4).

e. Re-tighten socket head cap screws (1). Torque to 35 ft.-lbs. (47 N-m).

f. Lower and lock the guide wheels in the "rail" position. Recheck measurements M, N, O & P.

g. Repeat steps a through f until measurements M, N, O & P are all equal or within 1/16 inch.

FIGURE 3-7
FRONT GUIDE WHEEL UNIT - REAR UNIT SIMILAR



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3.1 Guide Wheel Equipment Alignment Procedure

3.1.6 Guide Wheel Unit Alignment

3.1.6.2 Adjusting Guide Wheels - See Figures 3-6 and 3-8

If it is not possible to get enough horizontal movement of the guide wheels by moving the cross tube and axle assembly, it will be necessary to move the entire guide wheel unit in the mounting brackets.

a. Unlock and raise the front and/or rear guide wheels until they rest on the rail.

b. Loosen the six cap screws and nuts (5).

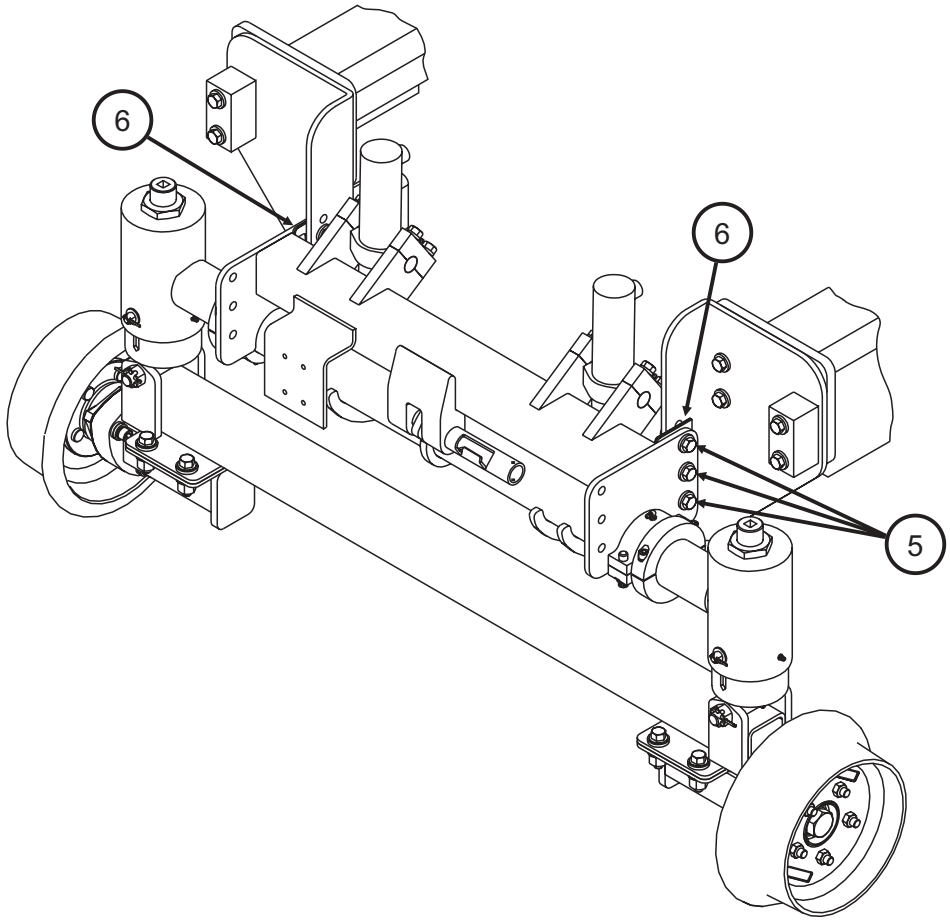
d. Remove the 1/16" or 1/4" shims (6) from one side and place on the other side between the unit and the mounting bracket.

e. Re-tighten cap screws and nuts (5). Torque to 106 ft.-lbs. (140 N-m).

f. Lower and lock the guide wheels in the "rail" position. Recheck measurements M, N, O & P.

g. Repeat steps a through f until measurements M, N, O & P are all equal or within 1/16 inch.

FIGURE 3-8
FRONT GUIDE WHEEL UNIT - REAR UNIT SIMILAR



3.1 Guide Wheel Equipment Alignment Procedure

3.1.6 Guide Wheel Unit Alignment

3.1.6.1 Checking Guide Wheel Unit Alignment - See Figures 3-6 and 3-9

2. Lower and lock the guide wheels in the "rail" position. The guide wheels must track straight, not toed in or out. Hold a two foot long straight edge against the outer edge of the guide wheel with the straight edge centered on the guide wheel. Check that dimensions G = G-1, H = H-1, K = K-1 & L = L-1. These dimensions must be equal or within 1/16 inch. If not, see Adjustment.

Note: When verifying whether the guide wheel is toed-in or toed-out, it may be helpful to visualize the traveling direction of the vehicle when in rail position.

The guide wheel is toed-in if the front dimension of the straight edge to the reference line is larger than the rear dimension. (Example - Left Rear Guide Wheel: Dimension G is larger than dimension G-1).

The guide wheel is toed-out if the front dimension of the straight edge to the reference line is smaller than the rear dimension. (Example - Left Rear Guide Wheel: Dimension G is smaller than dimension G-1).

3.1.6.3 Adjusting Guide Wheels

a. Unlock and raise the front and/or rear guide wheels until they rest on the rail.

b. Loosen the four fasteners (1) that secure the stub axle (2) to the axle assembly (3) on the guide wheel that needs to be adjusted.

c. Holding the straight edge against the outer edge of the guide wheel, pivot the hub assembly (2) until the dimensions from both ends of the straight edge to the string line are equal or within 1/16" (dimensions G = G-1, H = H-1, K = K-1 & L = L-1).

d. Re-tighten fasteners (1). Torque to 130 ft.-lbs. (176 N-m)

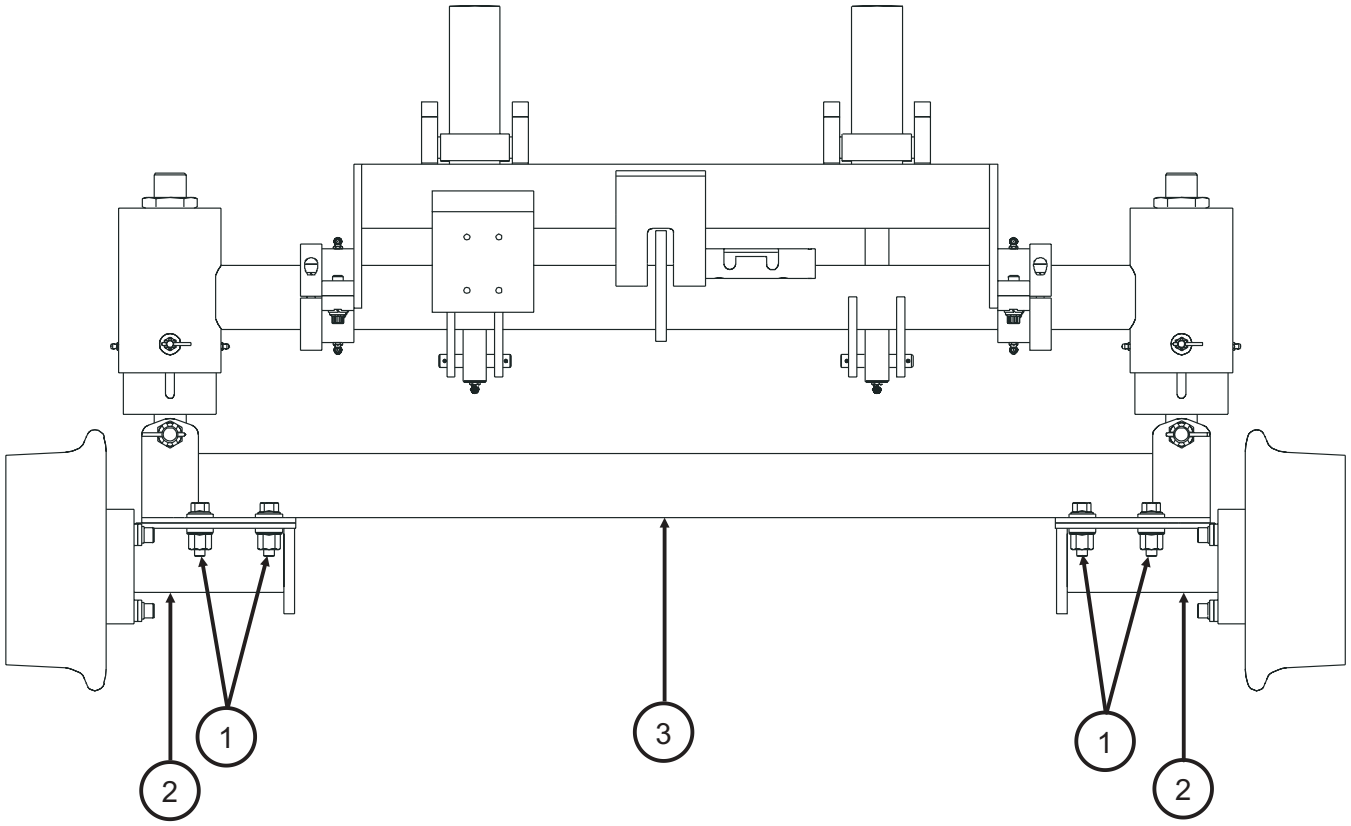
e. Lower and lock the guide wheels in the "rail" position. Recheck dimensions G = G-1, H = H-1, K = K-1 & L = L-1.

f. Repeat steps a through e until dimensions G = G-1, H = H-1, K = K-1 & L = L-1 are all equal or within 1/16 inch.

3.1 Guide Wheel Equipment Alignment Procedure

3.1.6 Guide Wheel Unit Alignment

FIGURE 3-9
GUIDE WHEEL UNIT



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3.1 Guide Wheel Equipment Alignment Procedure

3.1.7 Vehicle Track Test

■ **CHECK AND CORRECT ALIGNMENT PROMPTLY IF MISALIGNMENT IS INDICATED. MISALIGNMENT OF GUIDE WHEEL EQUIPMENT COULD RESULT IN DERAILMENT OF THE VEHICLE AND SEVERE BODILY INJURY.**

1. Harsco Track Technologies recommends that all HY-RAIL® equipped vehicles be track tested. The vehicle should be at its normal operating load for track testing. The vehicle should be track tested when:

   a. The guide wheel equipment is installed on the vehicle.
   b. Any adjustments are made to the guide wheel equipment.
   c. The load on the vehicle is changed.
   d. Periodically to ensure that the vehicle is tracking properly.

2. The vehicle must be placed on straight, level, tangent track. See Operation Section - Placing Vehicle On Track.

3. Apply spray paint to the flanges and treads of all guide wheels.

4. Lower and lock all guide wheels in the "rail" position.

5. Operate the vehicle for a short distance at a normal operating speed.

6. The paint should wear evenly around the flanges and treads of all guide wheels. If the paint is worn evenly on all guide wheels, the vehicle and guide wheel equipment is properly aligned.

7. If the paint did not wear evenly, note which guide wheels, flange and / or tread the paint is worn on.

   a. Repaint the flanges and treads on all guide wheels.
   b. Operate the vehicle in reverse for a short distance at a normal operating speed.
   c. Note which guide wheels, flange and / or tread the paint is worn on.
      If the paint wore off on the right front flange when traveling forward and then on the left rear flange when traveling in reverse, the vehicle is probably not aligned properly. Have the vehicle frame checked for proper alignment. See Vehicle Check.

8. If the vehicle pulls noticeable to the right when traveling forward, adjust the right front guide wheel to a slightly towed-in position. See Checking Guide Wheel Alignment.

9. If the vehicle pulls noticeable to the left when traveling forward, adjust the left front guide wheel to a slightly towed-in position. See Checking Guide Wheel Alignment.

10. If the vehicle continues to track improperly, repeat the String Lining and Guide Wheel Alignment Procedure.

3.2 Adjustments

The following checking and adjusting procedures apply to all types of HTT rail sweeps applied to the front or rear guide wheel units.

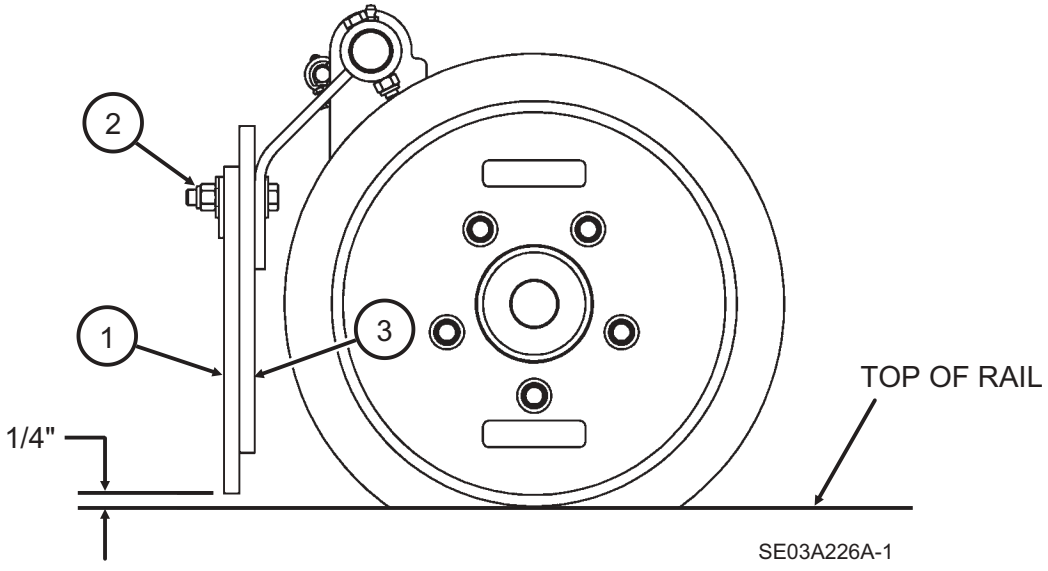
3.2.1 Checking Rail Sweeps

1. Place the vehicle on straight, level track. Place the automatic transmission in "Park" or manual transmission in "Neutral". Apply the parking brake. Stop the engine.
2. Lower and lock the guide wheels in the "rail" position. The rear rail sweeps are mounted to the axle assembly and will lower to the rail when the guide wheels are lowered. The front rail sweeps are attached to the front axle and pivot up and down. After lowering the front guide wheels, pivot the front rail sweeps down.
3. The rubber sweep (1) should clear the top of the rail by 1/4 inch (6.4 mm). If not, adjustment is necessary.

3.2.2 Adjusting Rail Sweep - See Figure 3-10

1. Loosen the two fasteners (2). Slide the rubber sweep (1) down until the sweep clears the top of the rail by 1/4 inch (6.4 mm). Re-tighten the fasteners.
2. If the rubber sweep cannot be lowered because the fasteners are at the bottom of the slots in the mounting plate, remove the two fasteners. Relocate the fasteners in the next upper set of holes in the rubber sweep. Adjust the rubber sweep.
3. If the rubber sweep (1) is in the last, upper set of holes, move the rear sweep (3) to the front and the front sweep (1) to the rear as a stiffener. Adjust the rubber sweep.
4. When both rubber sweeps are worn and can not be adjusted lowered, replace both rubber sweeps.

FIGURE 3-10
FRONT RAIL SWEEP SHOWN - REAR SIMILAR



NOTES

SECTION 4 - MAINTENANCE
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4.1 Maintenance Schedule

■ **RE-TORQUE VEHICLE WHEEL LUG NUTS, WHEEL SPACER LUG NUTS AND GUIDE WHEEL LUG NUTS AFTER FIRST 50 MILES OF OPERATION. THEREAFTER TORQUE WHEEL NUTS ACCORDING TO RECOMMENDED MAINTENANCE SCHEDULE. FAILURE TO HEED THIS WARNING COULD RESULT IN SEVERE BODILY INJURY.**

4.1.1 Daily:

1. Inspect both front and rear guide wheel units for damaged or missing parts.

2. Check the mechanical locks for proper operation. If the locks do not operate properly, repair or replace the lock mechanism.

3. Check the hydraulic fluid reservoir to ensure that the oil level is full. If low, fill to the proper level with the correct fluid.

4. When the vehicle is operated on the track, listen for unusual noises. Unusual noises may indicate incorrectly lowered guide wheels, or damaged or missing parts. Pay attention to the quality of the ride. Check alignment if the vehicle crowds one side of the track instead of floating from side to side. See Adjustment - Guide Wheel Equipment Alignment Procedure.

4.1.2 Weekly:

1. Check guide wheel equipment alignment. See Adjustments Section, Guide Wheel Equipment Alignment Procedure - Vehicle Track Test.

2. Inspect guide wheel tread and flanges for wear or damage. See Maintenance - Guide Wheel Allowable Wear.

3. Spin each guide wheel by hand, checking for ease of rotation or excessive play. If the guide wheel does not rotate properly, the bearings and spindle may be damaged. Replace the bearing/spindle assembly if necessary.

4. Inspect vehicle wheels, studs, lug nuts and tires for wear, damage, cuts, etc.

5. Check vehicle tires for correct inflation pressure. Operate at the tire manufacturer's recommended maximum pressure printed on the sidewalls of the tires or the wheel manufacturer's recommended maximum pressure stamped on the wheel, whichever is lower.

6. Check all bolts for tightness. See Appendices, Appendix A - Bolt Torque Requirements Chart.

Maintenance Schedule

4.1.3 At 50 Vehicle Miles (80 Vehicle km):

1. At 50 vehicle miles (80 Km) after initial installation of vehicle wheels or when tires are rotated or new tires installed, torque wheel spacer lug nuts and vehicle wheel lug nuts to the recommended specifications. See the decal attached to the vehicle wheel for the recommended wheel bolt torque specifications. Thereafter refer to the wheel manufacturer's wheel torque specifications.

4.1.4 At 50 Track Miles (80 Vehicle km):

1. At 50 track miles (80 Km) after initial installation of the guide wheel unit, torque guide wheel lug nuts to the recommended specifications.

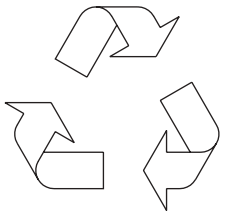
4.1.5 Every 2000 Track Miles (3200 Track km):

1. Lubricate guide wheel unit locations provided with grease fittings. See Lubrication.
2. Lubricate the locking mechanism and other pivot points with light oil or a lubricating spray.
3. Torque guide wheel lug nuts to 90 ft lbs (122 N-m).

4.1.6 Annually:

1. Perform annual inspections as required by railroad rules and regulations.

4.2 Waste Disposal



Dispose of waste properly. Improper disposal of waste can threaten the environment. The operation and maintenance of Harsco Track Technologies equipment may involve the use of such items as hydraulic oil, engine oil, fuel, coolant, brake fluid, filters, batteries, etc.

Use leak proof containers when draining fluids. Do not pour waste onto the ground, down a drain, or into any water source. Inquire on the proper way to recycle or dispose of waste according to applicable Federal, State and/or local regulations.

4.3 Guide Wheel Unit Lubrication

Lubricate the guide wheel equipment every 2000 track miles (3200 track km) maximum or each time the vehicle is serviced.

4.3.1 Guide Wheel Unit Lubrication - See Figure 4-1

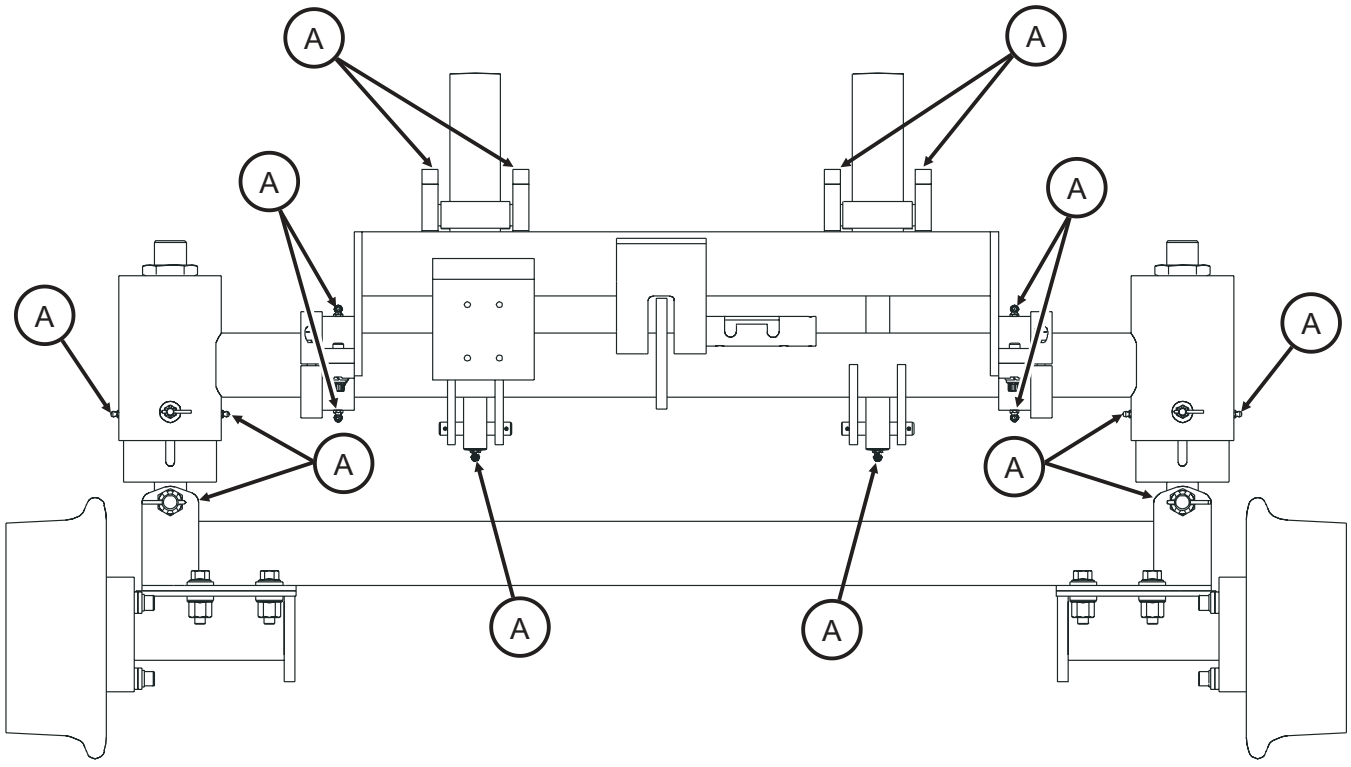
1. Apply the vehicle parking brake. Stop the engine.

2. Lubricate all grease fittings (A) using Mobil Special Moly or equivalent.

3. Lubricate the locking mechanism and other pivot points with a light weight oil or a lubricating spray.

Note: HR1500 Series B2 guide wheel equipment utilizes sealed bearings in the guide wheels. Do not re-pack the guide wheel bearings. If the bearings are worn, replace the integral spindle assembly.

FIGURE 4-1
GUIDE WHEEL UNIT LUBRICATION DIAGRAM
FRONT UNIT SHOWN - REAR UNIT SIMILAR



SE02A107A-1

4.4 Guide Wheels

4.4.1 Allowable Wear

4.4.1.1 198690 Steel Guide Wheel - See Figure 4-2

WARNING

■ **REPLACE ANY GUIDE WHEEL IMMEDIATELY WHICH SHOWS DAMAGE AND/OR HAS WORN MORE THAN THE ALLOWABLE LIMITS. FAILURE TO COMPLY COULD RESULT IN DERAILMENT OF THE VEHICLE, AND SEVERE BODILY INJURY.**

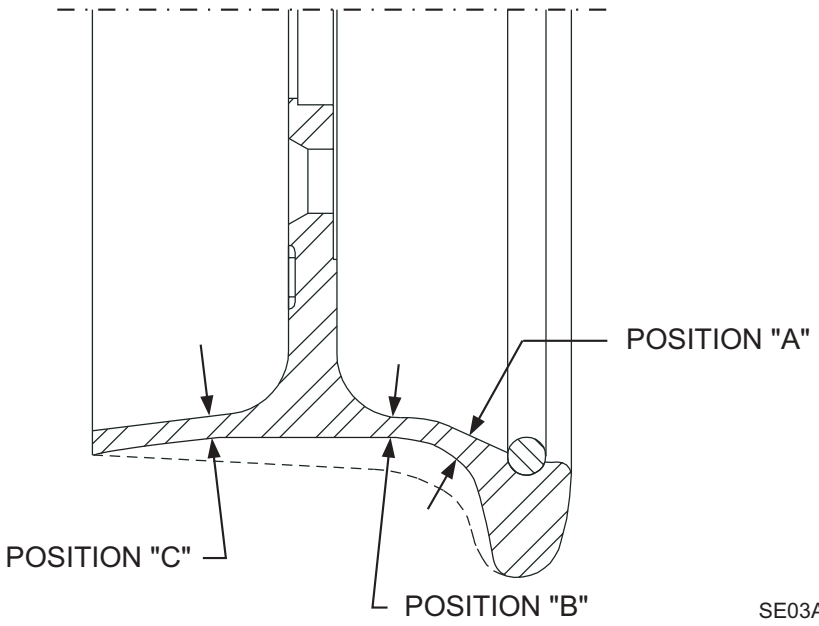
1. Tools needed: Harsco Track Technologies wheel caliper (M019889), or equivalent.

2. Measure the guide wheel flange at position "A" with the wheel caliper. The minimum allowable flange dimension at Position "A" is 1/4 inch (6.4 mm). If the wheel flange dimension is less than the allowable limit, replace the wheel immediately.

3. Measure the wheel tread at positions "B" and "C" with the wheel caliper. The minimum allowable tread dimension at Positions "B" and "C" is 1/4 inch (6.4 mm). If any of the guide wheel tread dimensions are less than the allowable limits, replace the wheel immediately.

4. The entire wheel must not have any gouges or cracks. If any of these are evident, replace the wheel immediately.

FIGURE 4-2
ALLOWABLE WEAR - 198690 STEEL GUIDE WHEEL



4.4 Guide Wheels

4.4.1 Allowable Wear

4.4.1.2 198510 Rubber Tread Guide Wheel - See Figure 4-3

WARNING

■ **REPLACE ANY GUIDE WHEEL IMMEDIATELY WHICH SHOWS DAMAGE AND/OR HAS WORN MORE THAN THE ALLOWABLE LIMITS. FAILURE TO COMPLY COULD RESULT IN DERAILMENT OF THE VEHICLE, AND SEVERE BODILY INJURY.**

1. Tools needed: Harsco Track Technologies wheel caliper (M019889), or equivalent.

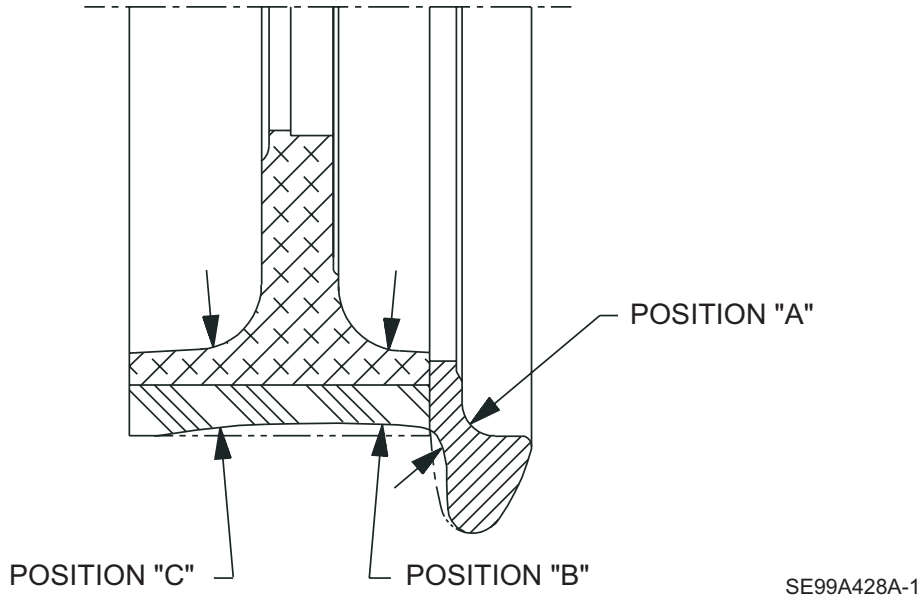
2. Measure the guide wheel flange at position "A" with the wheel caliper. The minimum allowable flange dimension at Position "A" is 1/4 inch (6.4 mm). If the guide wheel flange dimension is less than the allowable limit, replace the wheel immediately.

4

3. Measure the wheel tread at positions "B" and "C" with the wheel caliper. The minimum allowable tread dimension at Positions "B" and "C" is 11/16 inch (17.5 mm). If the guide wheel tread dimensions are less than the allowable limits, replace the wheel immediately.

4. The rubber tread must not have gouges. The aluminum wheel and/or flange must not have hairline cracks. If any of these are evident, replace the wheel immediately.

FIGURE 4-3
ALLOWABLE WEAR - 198510 ALUMINUM GUIDE WHEEL WITH RUBBER TREAD



4.4 Guide Wheels

4.4.2 Guide Wheel Check

Guide wheels which do not run true on the tread and flange will vibrate and give a rough ride. If the vehicle vibrates and gives a rough ride on track, there may be foreign matter (dirt, rust, paint, etc.) between the wheel and hub, the spindle bearings may be worn, or the tread and flange of the wheel may be worn or damaged, causing a wobbling sensation. On wheels with rubber tread, there may also be foreign matter lodged between the mating surfaces of the steel flange and the aluminum wheel, giving the same sensation.

1. Verify that the five lug nuts are torqued properly to 90 ft lbs (122 N-m). Tighten if necessary.

2. Rubber Guide Wheels Only: Verify that the web of the guide wheel is stamped "1500". Verify that the six 3/8 inch hex flange head cap screws securing flange to the rubber tread wheel are torqued properly to 40 ft lbs (55 N-m).

3. Track test the vehicle to verify whether the vibrations were caused by loose guide wheels or flanges.

   If track testing shows that the vibrations persist, go on to the following steps.

4. Check the spindle bearing by grasping the guide wheel and working it from side to side. If there is excessive play in the spindle, remove the guide wheel and verify that the three M12 cap screws that secure the integral spindle to the stub axle are properly torqued to 120 ft lbs (163 N-m). Re-tighten if necessary.

5. Recheck the spindle bearing by grasping the spindle and working it from side to side. If there is excessive play in the spindle bearing, the bearings are worn. Replace the integral spindle.

6. Check for foreign material on the mating surfaces of the guide wheel and the hub. Remove any foreign material on these surfaces.

7. Rubber Guide Wheels Only: Remove the flange from the guide wheel and check for foreign material on the mating surfaces of the flange and the guide wheel. Remove any foreign material on these surfaces. Reinstall the flange on the guide wheel and torque the fasteners to 40 ft lbs (55 N-m).

8. Reinstall the guide wheel onto the spindle and hub. Torque wheel nuts to 90 ft lbs (122 N-m).

9. Track test the vehicle to verify whether the vibrations were caused by worn spindle bearings or foreign material between guide wheel/flange mounting surfaces. If track testing shows that the vibrations persist, the wheel may be sprung or bent. Replace the wheel.

4.5 Vehicle Wheels

4.5.1 Wheel Replacement

■ **USE REPLACEMENT WHEEL(S) AS RECOMMENDED IN THE HARSCO TRACK TECHNOLOGIES HY-RAIL® VEHICLE SPECIFICATIONS MANUAL. FAILURE TO COMPLY COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.**

Use replacement wheel rim(s) as recommended in the Harsco Track Technologies HY-RAIL® Vehicle Specifications Manual to ensure correct vehicle wheel spacing and accurate guide wheel load. The wheels and tires should be static balanced or balanced after installation on the vehicle for the best results. Torque vehicle wheel lug nuts to recommended specifications. See the decal attached to the vehicle wheel for the recommended wheel bolt torque specifications.

4.5.2 Tire Replacement

■ **USE REPLACEMENT TIRES WITH THE SAME ROLLING RADIUS, TREAD WIDTH, PLY RATING, AND LOAD RATING AS RECOMMENDED IN THE HARSCO TRACK TECHNOLOGIES HY-RAIL® VEHICLE SPECIFICATIONS MANUAL. FAILURE TO COMPLY COULD RESULT IN BODILY INJURY AND/OR PROPERTY DAMAGE.**

Replacement tires must have the same rolling radius, tread width, ply rating, and load rating as recommended in the Harsco Track Technologies HY-RAIL® Vehicle Specifications Manual. Using tires of equal diameter will help keep the speedometer reading and the guide wheel load accurate. Tires must have a minimum 5-1/2 inches of tread width. After installing new tire(s) on the vehicle, check guide wheel load. See the Adjustment Section - Guide Wheel Equipment Alignment Procedure.

Inflate tires to the tire manufacturer's recommended maximum pressure printed on the sidewalls of the tires or the wheel manufacturer's recommended maximum pressure stamped on the wheel, whichever is lower. The wheels and tires should be static balanced or balanced after installation on the vehicle for the best results. Torque vehicle wheel lug nuts to recommended specifications. See the decal attached to the vehicle wheel for the recommended wheel bolt torque specifications.

4.6 Bolt Torque Requirements

■ **CHECK ALL BOLTS AND NUTS PERIODICALLY, AND KEEP THEM TIGHTENED TO TORQUE SPECIFIED IN APPENDICES SECTION - APPENDIX A. IF BOLT REPLACEMENT BECOMES NECESSARY, REPLACE WORN BOLT WITH EQUAL GRADE BOLT. FAILURE TO COMPLY COULD RESULT IN BODILY INJURY, AND/OR PROPERTY DAMAGE.**

See Appendices Section - Appendix A, for bolt torque requirements table and grade identification markings used by manufacturers.

4.7 Hoses and Fittings

WARNING

■ **ALL HOSES AND FITTINGS ON THIS EQUIPMENT MUST COMPLY WITH SAE STANDARD J1273 RECOMMENDED PRACTICE FOR SELECTION, INSTALLATION AND MAINTENANCE OF HOSE AND HOSE ASSEMBLIES. FAILURE TO COMPLY TO THIS STANDARD COULD RESULT IN SEVERE BODILY INJURY.**

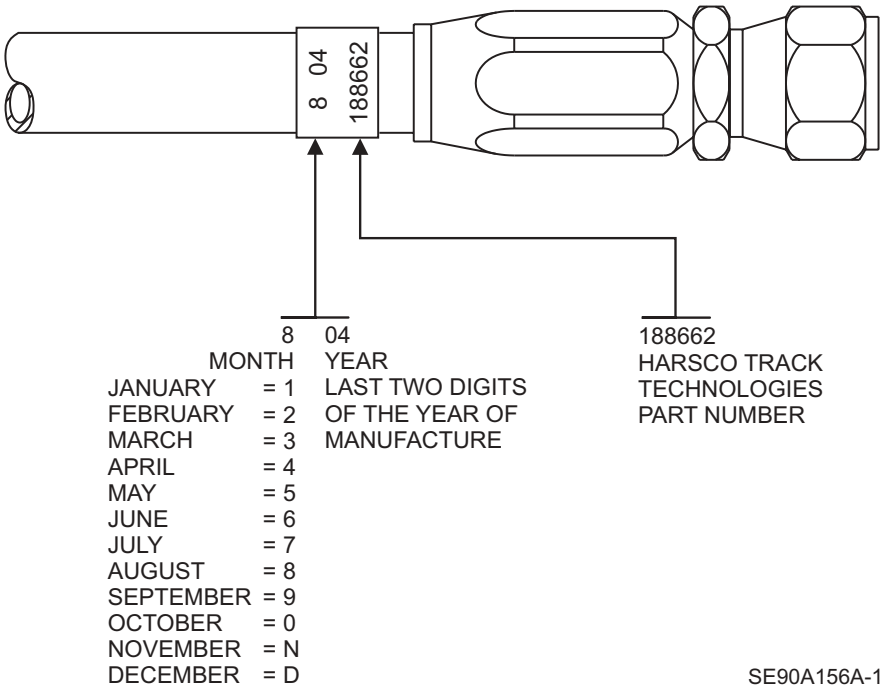
4.7.1 Inspection, Maintenance, Replacement And Installation

The inspection, maintenance, replacement and installation of hydraulic hose assemblies and fittings on this equipment must conform with SAE Standard J1273. See Appendices Section - Appendix B.

4.7.2 Hose Band - See Figure 4-4

All Harsco Track Technologies original and replacement hose assemblies manufactured for this equipment at the Harsco Track Technologies, Harsco Corporation Fairmont, Minnesota plant facility are supplied with a hose band displaying the date of manufacture and the Harsco Track Technologies part number. The hose assembly illustrated in the example was manufactured in August 2004 and is Harsco Track Technologies part number 188662.

FIGURE 4-4
HOSE BAND



NOTES

SECTION 5 - TROUBLESHOOTING
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5.1 Troubleshooting Guide Wheel Equipment

PROBLEM	PROBABLE CAUSE	POSSIBLE REMEDY
Guide wheel unit does not lower or raise.	Mechanical or electric lock engaged.	Disengage mechanical or electric lock. See Operation Section - Placing Vehicle On Track or Removing Vehicle From Track.
	Hydraulic pump not operating.	Check operation of hydraulic pump.
	Hydraulic reservoir oil level low.	Fill reservoir to full level with recommended hydraulic oil.
	Components bent, broken, worn, etc.	Replace components.
	Lack of lubrication.	Lubricate front and rear guide wheel units. See Maintenance Section - Lubrication.
Guide wheel unit is difficult to lower or raise.	Vehicle over-loaded.	Remove excess load from vehicle.
	Guide wheel load adjusted incorrectly.	Re-adjust. See Adjustment Section - Guide Wheel Equipment Alignment Procedure.
	Components bent, broken, worn, etc.	Replace components.
	Lack of lubrication.	Lubricate front and rear guide wheel units. See Maintenance Section - Lubrication.
Lock mechanism not working properly.	Mud, slush, dirt, etc. in locking mechanism.	Clean foreign material from locking mechanism.
	Lack of lubrication.	Lubricate front and rear guide wheel units. See Maintenance Section - Lubrication.
	Components bent, broken, worn, etc.	Replace components.

5.1 Troubleshooting Guide Wheel Equipment

PROBLEM	PROBABLE CAUSE	POSSIBLE REMEDY
Vehicle pulls noticeably to the left or right when on track.	Vehicle loaded heavy on one side.	Move load to center of vehicle.
	Steering lock not engaged.	Engage the steering lock.
	Vehicle wheels not aligned with steering lock when engaged.	Re-align. See Adjustment Section - Guide Wheel Equipment Adjustment Procedure.
	Guide wheels are not aligned with vehicle.	Re-align. See Adjustment Section - Guide Wheel Equipment Alignment Procedure.
	Vehicle tires under inflated.	Check pressure. Inflate if low. Do not exceed tire manufacturer's recommended maximum pressure printed on the sidewalls, or wheel manufacturer's recommended maximum pressure stamped on the wheel, whichever is lower.
	Guide wheel equipment bent, broken, etc.	Repair or replace components.
	Vehicle front tires out of alignment.	Check for pulling noticeably to the left or right when driven on the highway. Re-align front tires.
Vehicle derails.	Guide wheel units, vehicle axle(s), etc. not aligned with vehicle frame.	Check alignment. See Adjustment Section - Guide Wheel Equipment Alignment Procedure.
Unusual or excessive noise when traveling on track.	Guide wheel spindle bearings worn.	Replace bearing/spindle assembly.
	Guide wheel unit flanging hard to the right or left.	Re-align. See Adjustment Section - Guide Wheel Equipment Alignment Procedure.

5.1 Troubleshooting Guide Wheel Equipment

PROBLEM	PROBABLE CAUSE	POSSIBLE REMEDY
Vibration felt in the vehicle when traveling on track.	Guide wheel unit mounting hardware loose.	Tighten all bolts to recommended torque.
	Guide wheel spindle bearings worn.	Replace bearing/spindle assembly.
	Guide wheel worn or damaged.	Replace guide wheel.
	Vehicle rim bent.	Replace rim. See Maintenance Section - Vehicle Wheels.
	Vehicle tires out of balance.	Balance tires. See Maintenance Section - Tire Replacement.
	Wheel spacer lug nuts and or vehicle lug nuts loose.	Torque wheel spacer lug nuts and vehicle lug nuts to recommended specifications. See maintenance Section.
Vibration felt in the vehicle when traveling on road.	Guide wheel unit mounting hardware loose.	Tighten all bolts to recommended torque.
	Guide wheel units are not raised and locked in "highway" position.	STOP IMMEDIATELY. Make sure all guide wheels are locked and secured in "highway" position.
	Vehicle wheel bent.	Replace wheel. See Maintenance Section - Vehicle Wheels.
	Vehicle tires out of balance.	Balance tires. See Maintenance Section - Tire Replacement.
	Wheel spacer lug nuts and or vehicle lug nuts loose.	Torque wheel spacer lug nuts and vehicle lug nuts to recommended specifications. See maintenance Section.

APPENDIX A - CONVERSION TABLES
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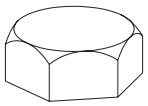
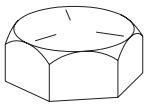
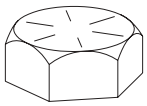
Appendix A

FIGURE 6-1
STANDARD BOLT TORQUE REQUIREMENTS TABLE
STANDARD TYPE FASTENERS

The torque values listed below are for standard-type fasteners only. The torque values listed are based on wet and (lubricated) dry conditions. The torque values for 1/4 and 5/16 inch size fasteners are listed in lb-in and N-m torque equivalents. The torque values for all other size fasteners are listed lb-ft and N-m torque equivalents. Use lower grade torque values if bolt and nut have different SAE grades. Manufacturer's SAE grade markings may vary.

STANDARD MARKINGS AND TORQUE SPECIFICATIONS

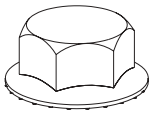
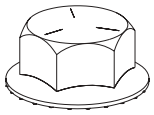
SAE Grade	1 or 2				5				8			
Fastener Standard SAE Grade Markings												
Fastener Body Size Inch-Thread	**Torque**				**Torque**				**Torque**			
	Wet		**Dry**		**Wet**		**Dry**		**Wet**		**Dry**	
	lb-in	N-m	lb-in	N-m	lb-in	N-m	lb-in	N-m	lb-in	N-m	lb-in	N-m
1/4 - 20	49	5.5	65	7.3	75	8.5	100	11.3	107	12.0	142	16.0
1/4 - 28	56	6.5	74	8.3	86	9.7	114	12.8	122	13.8	162	18.3
5/16 - 18	103	11.6	137	15.5	157	17.7	208	23.5	220	24.8	293	33.1
5/16 - 24	113	12.7	150	16.9	173	19.5	230	25.9	244	27.5	325	36.7
Fastener Body Size Inch-Thread	**Torque**				**Torque**				**Torque**			
	Wet		**Dry**		**Wet**		**Dry**		**Wet**		**Dry**	
	lb-ft	N-m	lb-ft	N-m	lb-ft	N-m	lb-ft	N-m	lb-ft	N-m	lb-ft	N-m
3/8 - 16	15	20	20	27	23	31	31	42	32	43	43	58
3/8 - 24	17	23	23	31	26	35	35	47	37	50	49	66
7/16 - 14	24	32	32	43	37	50	49	66	52	70	69	93
7/16 - 20	27	36	36	49	42	57	56	76	58	78	77	104
1/2 - 13	39	53	52	70	57	77	76	103	80	108	106	144
1/2 - 20	41	55	55	74	64	87	85	115	90	122	120	163
9/16 - 12	53	72	71	96	82	111	109	148	115	156	153	207
9/16 - 18	59	80	78	106	91	123	121	164	129	175	172	233
5/8 - 11	73	99	97	131	113	155	150	203	160	217	213	289
5/8 - 18	83	112	110	149	128	173	170	230	180	244	239	324
3/4 - 10	129	175	172	233	200	271	266	361	282	382	375	508
3/4 - 16	144	195	192	260	223	302	297	403	315	427	419	568
7/8 - 9	124	168	165	224	323	438	430	583	454	615	604	819
7/8 - 14	138	187	184	249	355	481	472	640	501	679	666	903
1 - 8	188	255	250	339	483	655	642	870	681	923	906	1228
1 - 14	210	285	279	378	541	733	720	976	764	1036	1016	1377
1-1/8 - 7	266	361	354	480	596	808	793	1075	966	1310	1285	1742
1-1/8 - 12	297	403	395	535	668	906	888	1204	1083	1468	1440	1952
1-1/4 - 7	375	508	499	676	841	1140	1119	1517	1363	1848	1813	2458
1-1/4 - 12	415	563	552	748	930	1261	1237	1677	1509	2046	2007	2721
1-3/8 - 6	492	667	654	887	1102	1494	1466	1988	1787	2423	2377	3223
1-3/8 - 12	560	759	745	1010	1255	1701	1670	2264	2034	2758	2705	3667
1-1/2 - 6	653	885	868	1177	1463	1983	1946	2638	2371	3215	3153	4275
1-1/2 - 12	734	995	976	1323	1645	2230	2188	2966	2668	3617	3548	4810

Appendix A

FIGURE 6-2
STANDARD BOLT TORQUE REQUIREMENTS TABLE
SERRATED TYPE FLANGE FASTENERS

The torque values listed below are for serrated-type flange fasteners only. The torque values listed are based on wet (lubricated) and dry conditions. The torque values for all other size fasteners are listed in lb-ft and N-m torque equivalents. Use lower grade torque values if bolt and nut have different SAE grades. Manufacturer's SAE grade markings may vary.

STANDARD MARKINGS AND TORQUE SPECIFICATIONS

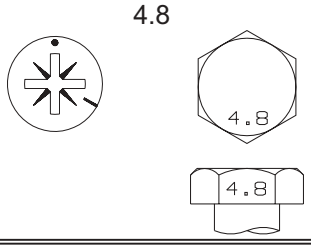
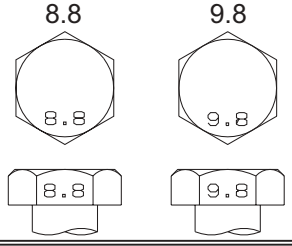
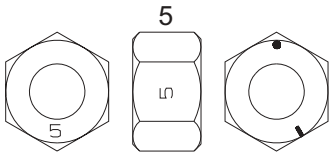
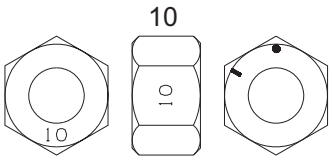
SAE Grade	**1 or 2**				5			
Fastener Standard SAE Grade Markings								
Fastener Body Size Inch-Thread	**Torque**				**Torque**			
	Wet		**Dry**		**Wet**		**Dry**	
	lb-ft	N-m	lb-ft	N-m	lb-ft	N-m	lb-ft	N-m
1/4 - 20	8	10.8	11	14.9	11	14.9	15	20.3
1/4 - 28	9	12.2	12	16.3	12	16.3	16	21.7
5/16 - 18	13	17.6	17	23.0	20	27.1	27	36.6
5/16 - 24	13	17.6	17	23.0	32	43.3	43	58.3
3/8 - 16	23	31	31	42	40	54	53	72
3/8 - 24	25	34	33	45	43	58	57	77
7/16 - 14	38	51	51	69	55	74	73	99
7/16 - 20	40	54	53	72	60	81	80	108
1/2 - 13	60	81	80	108	95	129	127	172
1/2 - 20	65	88	87	118	100	135	133	180
9/16 - 12	78	106	104	141	140	190	187	253
9/16 - 18	85	115	113	153	150	203	200	271
5/8 - 11	125	169	167	226	190	258	253	343
5/8 - 18	135	183	180	244	220	298	293	397
3/4 - 10	225	305	300	407	350	474	467	633
3/4 - 16	250	339	333	451	400	542	533	723
7/8 - 9	350	474	467	633	550	746	733	994
7/8 - 14	375	508	500	678	600	813	800	1085
1 - 8	480	651	640	868	750	1017	1000	1356
1 - 14	500	678	666	903	800	1085	1066	1445

Appendix A

FIGURE 6-3
BOLT TORQUE REQUIREMENTS TABLE
METRIC TYPE FASTENERS

Do not use these values if a different torque value or tightening procedure is given for a specific application. Torque values listed are for general use only. Check tightness of fasteners periodically. Fasteners should be replaced with the same or higher property class. If higher property class fasteners are used, these should only be tightened to the strength of the original. Make sure fastener's threads are clean and that thread engagement is properly started. This will help prevent them from failing when tightening.

* Lubricated means coated with a lubricant such as engine oil, or fasteners with phosphate and oil coatings. Dry means plain or zinc plated without any lubrication.

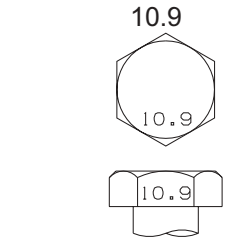
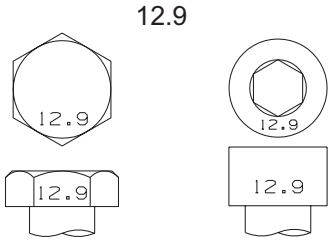
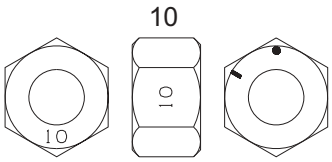
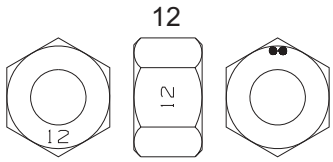
Property Class and Head Markings								
Property Class and Head Markings								
Size	Class 4.8				Class 8.8 or 9.8			
	* Lubricated		* Dry		* Lubricated		* Dry	
	N - m	lb - ft	N - m	lb - ft	N - m	lb - ft	N - m	lb - ft
M 6	4.8	3.5	6	4.5	9	6.5	11	8.5
M 8	12	8.5	15	11	22	16	28	20
M10	23	17	29	21	43	32	55	40
M12	40	29	50	37	75	55	95	70
M14	63	47	80	60	120	88	150	110
M16	100	73	125	92	190	140	240	175
M18	135	100	175	125	260	195	330	250
M20	190	140	240	180	375	275	475	350
M22	260	190	330	250	510	375	650	475
M24	330	250	425	310	650	475	825	600
M27	490	360	625	450	950	700	1200	875
M30	675	490	850	625	1300	950	1650	1200
M33	900	675	1150	850	1750	1300	2200	1650
M36	1150	850	1450	1075	2250	1650	2850	2100

Appendix A

FIGURE 6-4
BOLT TORQUE REQUIREMENTS TABLE
METRIC TYPE FASTENERS

Do not use these values if a different torque value or tightening procedure is given for a specific application. Torque values listed are for general use only. Check tightness of fasteners periodically. Fasteners should be replaced with the same or higher property class. If higher property class fasteners are used, these should only be tightened to the strength of the original. Make sure fastener's threads are clean and that thread engagement is properly started. This will help prevent them from failing when tightening.

* Lubricated means coated with a lubricant such as engine oil, or fasteners with phosphate and oil coatings.
Dry means plain or zinc plated without any lubrication.

Property Class and Head Markings		
Property Class and Head Markings		

Size	Class 10.9				Class 12.9			
	* Lubricated		* Dry		* Lubricated		* Dry	
	N - m	lb - ft	N - m	lb - ft	N - m	lb - ft	N - m	lb - ft
M 6	13	9.5	17	12	15	11.5	19	14.5
M 8	32	24	40	30	37	28	47	35
M10	63	47	80	60	75	55	95	70
M12	110	80	140	105	130	95	165	120
M14	175	130	225	165	205	150	260	190
M16	275	200	350	255	320	240	400	300
M18	375	275	475	350	440	325	560	410
M20	530	400	675	500	625	460	800	580
M22	725	540	925	675	850	625	1075	800
M24	925	675	1150	850	1075	800	1350	1000
M27	1350	1000	1700	1250	1600	1150	2000	1500
M30	1850	1350	2300	1700	2150	1600	2700	2000
M33	2500	1850	3150	2350	2900	2150	3700	2750
M36	3200	2350	4050	3000	3750	2750	4750	3500

Appendix A

FIGURE 6-5
INCH TO MILLIMETER CONVERSION TABLE
1 INCH = 25.4 MILLIMETERS

FRACTIONS	DECIMALS	MILLIMETERS	FRACTIONS	DECIMALS	MILLIMETERS
1/64	.016	0.397	33/64	.516	13.097
1/32	.031	0.794	17/32	.531	13.494
3/64	.047	1.191	35/64	.547	13.891
1/16	.063	1.588	9/16	.563	14.288
5/64	.078	1.984	37/64	.578	14.684
3/32	.094	2.381	19/32	.594	15.081
7/64	.109	2.778	39/64	.609	15.478
1/8	.125	3.175	5/8	.625	15.875
9/64	.141	3.572	41/64	.641	16.272
5/32	.156	3.969	21/32	.656	16.669
11/64	.172	4.366	43/64	.672	17.066
3/16	.188	4.763	11/16	.688	17.463
13/64	.203	5.159	45/64	.703	17.859
7/32	.219	5.556	23/32	.719	18.256
15/64	.234	5.953	47/64	.734	18.653
1/4	.250	6.350	3/4	.750	19.050
17/64	.266	6.747	49/64	.766	19.447
9/32	.281	7.144	25/32	.781	19.844
19/64	.297	7.541	51/64	.797	20.241
5/16	.313	7.938	13/16	.813	20.638
21/64	.328	8.334	53/64	.828	21.034
11/32	.344	8.731	27/32	.844	21.431
23/64	.359	9.128	55/64	.859	21.828
3/8	.375	9.525	7/8	.875	22.225
25/64	.391	9.922	57/64	.891	22.622
13/32	.406	10.319	29/32	.906	23.019
27/64	.422	10.716	59/64	.922	23.416
7/16	.438	11.113	15/16	.938	23.813
29/64	.453	11.509	61/64	.953	24.209
15/32	.469	11.906	31/32	.969	24.606
31/64	.484	12.303	63/64	.984	25.003
1/2	.500	12.700	1	1.000	25.400

FIGURE 6-6
FEET TO METERS CONVERSION TABLE
1 FOOT = 0.3048 METER

FEET	METERS	FEET	METERS	FEET	METERS	FEET	METERS	FEET	METERS
100	30.480	10	3.048	1	0.305	0.1	0.030	0.01	0.003
200	60.960	20	6.096	2	0.610	0.2	0.061	0.02	0.006
300	91.440	30	9.144	3	0.914	0.3	0.091	0.03	0.009
400	121.920	40	12.192	4	1.219	0.4	0.122	0.04	0.012
500	152.400	50	15.240	5	1.524	0.5	0.152	0.05	0.015
600	182.880	60	18.288	6	1.829	0.6	0.183	0.06	0.018
700	213.360	70	21.336	7	2.134	0.7	0.213	0.07	0.021
800	243.840	80	24.384	8	2.438	0.8	0.244	0.08	0.024
900	274.320	90	27.432	9	2.743	0.9	0.274	0.09	0.027
1,000	304.800	100	30.480	10	3.048	1.0	0.305	0.10	0.030

Appendix A

FIGURE 6-7
POUNDS TO KILOGRAMS CONVERSION TABLE
1 POUND = 0.4536 KILOGRAM

LB	KG	LB	KG	LB	KG	LB	KG	LB	KG
1,000	453.59	100	45.36	10	4.54	1	0.45	0.1	0.05
2,000	907.18	200	90.72	20	9.07	2	0.91	0.2	0.09
3,000	1,360.78	300	136.08	30	13.61	3	1.36	0.3	0.14
4,000	1,814.37	400	181.44	40	18.14	4	1.81	0.4	0.18
5,000	2,267.96	500	226.80	50	22.68	5	2.27	0.5	0.23
6,000	2,721.55	600	272.16	60	27.22	6	2.72	0.6	0.27
7,000	3,175.15	700	317.51	70	31.75	7	3.18	0.7	0.32
8,000	3,628.74	800	362.87	80	36.29	8	3.63	0.8	0.36
9,000	4,082.33	900	408.23	90	40.82	9	4.08	0.9	0.41
10,000	4,535.92	1,000	453.59	100	45.36	10	4.54	1.0	0.45

FIGURE 6-8
POUNDS PER SQUARE INCH TO BAR CONVERSION TABLE
1 PSI = 0.06895 BAR

PSI	BAR	PSI	BAR	PSI	BAR	PSI	BAR
1,000	68.95	100	6.90	10	0.69	1	0.07
2,000	137.90	200	13.79	20	1.38	2	0.14
3,000	206.84	300	20.68	30	2.07	3	0.21
4,000	275.80	400	27.58	40	2.76	4	0.28
5,000	344.70	500	34.47	50	3.45	5	0.35
6,000	413.64	600	41.36	60	4.14	6	0.41
7,000	482.58	700	48.26	70	4.83	7	0.48
8,000	551.52	800	55.15	80	5.52	8	0.55
9,000	620.46	900	62.05	90	6.21	9	0.62
10,000	689.48	1,000	68.95	100	6.90	10	0.69

FIGURE 6-9
POUNDS PER SQUARE INCH TO KILOPASCALS CONVERSION TABLE
1 PSI = 6.895 kPa

PSI	kPa	PSI	kPa
10	68.95	1	6.90
20	137.90	2	13.79
30	206.84	3	20.68
40	275.80	4	27.58
50	344.70	5	34.47
60	413.64	6	41.36
70	482.58	7	48.26
80	551.52	8	55.15
90	620.46	9	62.05
100	689.48	10	68.95

Appendix A

FIGURE 6-10
FAHRENHEIT TO CELSIUS (Centigrade) CONVERSION TABLE
(DEGREES F - 32°) ÷ 1.8 = DEGREES C

deg F	deg C	deg F	deg C	deg F	deg C	deg F	deg C
1	-17.2	51	10.6	101	38.3	151	66.1
2	-16.7	52	11.1	102	38.9	152	66.7
3	-16.1	53	11.7	103	39.4	153	67.2
4	-15.6	54	12.2	104	40.0	154	67.8
5	-15.0	55	12.8	105	40.6	155	68.3
6	-14.4	56	13.3	106	41.1	156	68.9
7	-13.9	57	13.9	107	41.7	157	69.4
8	-13.3	58	14.4	108	42.2	158	70.0
9	-12.8	59	15.0	109	42.8	159	70.6
10	-12.2	60	15.6	110	43.3	160	71.1
11	-11.7	61	16.1	111	43.9	161	71.7
12	-11.1	62	16.7	112	44.4	162	72.2
13	-10.6	63	17.2	113	45.0	163	72.8
14	-10.0	64	17.8	114	45.6	164	73.3
15	-9.4	65	18.3	115	46.1	165	73.9
16	-8.9	66	18.9	116	46.7	166	74.4
17	-8.3	67	19.4	117	47.2	167	75.0
18	-7.8	68	20.0	118	47.8	168	75.6
19	-7.2	69	20.6	119	48.3	169	76.1
20	-6.7	70	21.1	120	48.9	170	76.7
21	-6.1	71	21.7	121	49.4	171	77.2
22	-5.6	72	22.2	122	50.0	172	77.8
23	-5.0	73	22.8	123	50.6	173	78.3
24	-4.4	74	23.3	124	51.1	174	78.9
25	-3.9	75	23.9	125	51.7	175	79.4
26	-3.3	76	24.4	126	52.2	176	80.0
27	-2.8	77	25.0	127	52.8	177	80.6
28	-2.2	78	25.6	128	53.3	178	81.1
29	-1.7	79	26.1	129	53.9	179	81.7
30	-1.1	80	26.7	130	54.4	180	82.2
31	-0.6	81	27.2	131	55.0	181	82.8
32	0.0	82	27.8	132	55.6	182	83.3
33	0.6	83	28.3	133	56.1	183	83.9
34	1.1	84	28.9	134	56.7	184	84.4
35	1.7	85	29.4	135	57.2	185	85.0
36	2.2	86	30.0	136	57.8	186	85.6
37	2.7	87	30.6	137	58.3	187	86.1
38	3.3	88	31.1	138	58.9	188	86.7
39	3.9	89	31.7	139	59.4	189	87.2
40	4.4	90	32.2	140	60.0	190	87.8
41	5.0	91	32.8	141	60.6	191	88.3
42	5.6	92	33.3	142	61.1	192	88.9
43	6.1	93	33.9	143	61.7	193	89.4
44	6.7	94	34.4	144	62.2	194	90.0
45	7.2	95	35.0	145	62.8	195	90.6
46	7.8	96	35.6	146	63.3	196	91.1
47	8.3	97	36.1	147	63.9	197	91.7
48	8.9	98	36.7	148	64.4	198	92.2
49	9.4	99	37.2	149	65.0	199	92.8
50	10.0	100	37.8	150	65.5	200	93.3

Appendix A

FIGURE 6-11
MILES PER HOUR TO KILOMETERS
PER HOUR CONVERSION TABLE
1 MPH = 1.609 KM/H

MPH	KM/H	MPH	KM/H	MPH	KM/H
10	16.09	1	1.61	0.1	0.16
20	32.19	2	3.22	0.2	0.32
30	48.28	3	4.83	.03	0.48
40	64.37	4	6.44	0.4	0.64
50	80.47	5	8.05	0.5	0.80
60	96.56	6	9.66	0.6	0.97
70	112.65	7	11.27	0.7	1.13
80	128.75	8	12.87	0.8	1.29
90	144.84	9	14.48	0.9	1.45
100	160.93	10	16.09	1.0	1.61

FIGURE 6-12
U.S. GALLONS TO LITERS CONVERSION TABLE
1 U.S. GALLON = 3.785 LITERS

GAL	LITER	GAL	LITER	GAL	LITER	GAL	LITER
100	378.54	10	37.85	1	3.79	0.1	0.38
200	757.08	20	75.71	2	7.57	0.2	0.76
300	1,135.62	30	113.56	3	11.36	0.3	1.14
400	1,514.16	40	151.42	4	15.14	0.4	1.51
500	1,892.71	50	189.27	5	18.93	0.5	1.89
600	2,271.25	60	227.12	6	22.71	0.6	2.27
700	2,649.79	70	264.98	7	26.50	0.7	2.65
800	3,028.33	80	302.83	8	30.28	0.8	3.03
900	3,406.87	90	340.69	9	34.07	0.9	3.41
1,000	3,785.41	100	378.54	10	37.85	1.0	3.79

NOTES

APPENDIX B - SAE J1273

* SAE J1273 - DEC 2002
RECOMMENDED PRACTICES FOR HYDRAULIC HOSE ASSEMBLIES

DISCLAIMER

HARSCO TRACK TECHNOLOGIES, HARSCO CORPORATION RECOMMENDS THAT ALL HOSE, HOSE ASSEMBLIES AND/OR FITTINGS REPLACED BY THE CUSTOMER SHOULD BE EQUAL TO OR EXCEED THE CURRENT SPECIFICATIONS OF THE ORIGINAL EQUIPMENT SUPPLIED BY HARSCO TRACK TECHNOLOGIES, HARSCO CORPORATION. HARSCO TRACK TECHNOLOGIES, HARSCO CORPORATION WILL NOT BE LIABLE FOR ANY CLAIMS OF PERSONAL INJURY RESULTING FROM THE USE OF HOSE, HOSE ASSEMBLIES AND/OR FITTINGS THAT DO NOT MEET CURRENT ORIGINAL EQUIPMENT SPECIFICATIONS. THE CUSTOMER IS ADVISED TO COMPLY WITH SAE J1273 DECEMBER 2002, RECOMMENDED PRACTICES FOR HYDRAULIC HOSE ASSEMBLIES.

SAE International™

SURFACE VEHICLE RECOMMENDED PRACTICE

SAE J1273 REV. DEC2002

Issued 1979-09
Revised 2002-12

Superseding J1273 MAR2001

Recommended Practices for Hydraulic Hose Assemblies

Foreword—This SAE Recommended Practice is intended as a guide to consider when selecting, routing, fabricating, installing, replacing, maintaining, and storing hose for fluid-power systems. It is subject to change to keep pace with experience and technical advances. For those new to hose use in fluid-power systems, this guide outlines practices to note during each phase of system design and use. Experienced designers and users skilled in achieving proper results, as well as the less experienced, can use this outline as a list of considerations to keep in mind.

Fluid power systems are complex and require extensive knowledge of both the system requirements and the various types of hose. Therefore, all-inclusive, detailed, step-by-step instructions are not practical and are beyond the scope of this document. Less experienced designers and users who need more information can consult specialists such as hose suppliers and manufacturers. This guide can improve the communication process.

Safety Considerations—These recommended practices involve safety considerations; note these carefully during all phases of design and use of hose systems. Improper selection, fabrication, installation, or maintenance of hose and hose assemblies for fluid-power systems may result in serious personal injury or property damage. These recommended practices can reduce the likelihood of component or system failure, thereby reducing the risk of injury or damage.

6

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TO PLACE A DOCUMENT ORDER:
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SAE J1273 Revised DEC2002

1. ***Scope***—SAE J1273 provides guidelines for selection, routing, fabrication, installation, replacement, maintenance, and storage of hose and hose assemblies for fluid-power systems. Many of these SAE Recommended Practices also may be suitable for other hoses and systems.

2. ***References***

2.1 **Applicable Publications**—The following publications form a part of this specification to the extent specified herein. Unless otherwise specified, the latest issue of SAE publications shall apply.

2.1.1 SAE PUBLICATIONS—Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

SAE J343—Test and Procedures for SAE 100 R Series Hydraulic Hose and Hose Assemblies
SAE J514—Hydraulic Tube Fittings
SAE J517—Hydraulic Hose
SAE J1927—Cumulative Damage Analysis for Hydraulic Hose Assemblies

2.1.2 ISO PUBLICATION—Available from ANSI, 25 West 43rd Street, New York, NY 10036-8002.

ISO 3457—Earth moving machinery—Guards and shields—Definitions and specifications

3. ***Definitions***—These explanations serve only to clarify this document and are not intended to stand alone. They are presented sequentially, with the former helping to explain the latter.

3.1 **Fluid Power**—Energy transmitted and controlled using pressurized hydraulic fluids or compressed air.

3.2 **Hose**—Flexible conductor. In this document, the term hose also may refer to a hose assembly with related accessories used in fluid power applications.

3.3 **Hose Fitting or Fitting**—Connector which can be attached to the end of a hose.

3.4 **Hose Assembly**—Hose with hose fittings attached.

3.5 **Hose Failure**—Occurrence in which a hose stops meeting system requirements.

3.6 **Hose Service Life**—Length of time a hose meets system requirements without needing replacement.

4. ***Safety Considerations***—Listed in 4.1 to 4.7 are some potential conditions and situations that may lead to personal injury and/or property damage. This list is not necessarily all inclusive. Consider reasonable and feasible means, including those described in this section, to reduce the risk of injuries or property damage.

Training, including the information in this document, for operators, maintenance personnel, and other individuals working with hoses under pressure is encouraged.

4.1 **Fluid Injections**—Fine streams of escaping pressurized fluid can penetrate skin and enter a human body. These fluid injections may cause severe tissue damage and loss of limb.

Consider various means to reduce the risk of fluid injections, particularly in areas normally occupied by operators. Consider careful routing, adjacent components, warnings, guards, shields, and training programs.

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Relieve pressure before disconnecting hydraulic or other lines. Tighten all connections before applying pressure.

Avoid contact with escaping fluids. Treat all leaks as though pressurized and hot enough to burn skin. Never use any part of your body to check a hose for leaks.

If a fluid-injection accident occurs, see a doctor immediately. **DO NOT DELAY OR TREAT AS A SIMPLE CUT!** Any fluid injected into the skin must be surgically removed *within a few hours* or gangrene may result. Doctors unfamiliar with this type of injury should consult a knowledgeable medical source.

4.2 **Whipping Hose**—If a pressurized hose assembly blows apart, the fittings can be thrown off at high speed, and the loose hose can flail or whip with great force. This is particularly true in compressible-fluid systems.

When this risk exists, consider guards and restraints to protect against injury.

4.3 **Burns from Conveyed Fluids**—Fluid-power media may reach temperatures that can burn human skin. If there is risk of burns from escaping fluid, consider guards and shields to prevent injury, particularly in areas normally occupied by operators.

4.4 **Fire and Explosions from Conveyed Fluids**—Most fluid-power media, including fire-resistant hydraulic fluids, will burn under certain conditions. Fluids which escape from pressurized systems may form a mist or fine spray which can flash or explode upon contact with an ignition source.

Consider selecting, guarding, and routing hose to minimize the risk of combustion (see Section 5 and ISO 3457).

4.5 **Fire and Explosions from Static-Electric Discharge**—Fluid passing through hose can generate static electricity, resulting in static-electric discharge. This may create sparks that can ignite system fluids or gases in the surrounding atmosphere.

When this potential exists, select hose specifically designed to carry the static-electric charge to ground.

4.6 **Electrical Shock**—Electrocution could occur if hose conducts electricity through a person. Most hoses are conductive. Many contain metal or have metal fittings. Even nonconductive hoses can be conduits for electricity if they carry conductive fluids.

Be aware of routing or using hose near electrical sources. When this cannot be avoided, select appropriate hose. Nonconductive hoses should be considered. SAE J517—100R7 and 100R8 hoses, with orange covers marked "Nonconductive" are available for applications requiring nonconductive hose.

4.7 **Mechanisms Controlled by Fluid Power**—Mechanisms controlled by fluids in hoses can become hazardous when a hose fails. For example, when a hose bursts, objects supported by fluid pressure may fall, or vehicles or machines may lose their brakes or steering.

If mechanisms are controlled by fluid power, consider safe modes of failure that minimize risks of injury or damage.

5. ***Hose Selection and Routing***—A wide variety of interacting factors influence hose service life and the ability of each fluid-power system to operate satisfactorily, and the combined effects of these factors on service life are often unpredictable. Therefore, these documents should not be construed as design standards. For applications outside the specifications in SAE J517, SAE J514, or other relevant design standards, performance of hose assemblies should be determined by appropriate testing.

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Carefully analyze each system. Then design routings and select hose and related components to meet the system-performance and hose-service-life requirements, and to minimize the risks of personal injury and/or property damage. Consider the following factors:

5.1 System Pressures—Excessive pressure can accelerate hose assembly failure. Analyze the steady-state pressures, and the frequency and amplitude of pressure surges, such as pulses and spikes. These are rapid and transient rises in pressure which may not be indicated on many common pressure gages and can be identified best on high-frequency-response electronic measuring instruments.

For maximum hose service life, hose selection should be based on a system pressure, including surges, that is less than the hose maximum working pressure. Hose may be used above its maximum working pressure where reduced life expectancy is acceptable. SAE J1927 provides one method to help predict wire-reinforced hose service life for a given hydraulic application, where the surge pressure peaks vary, and/or the highest pressure peaks occur infrequently.

5.2 Suction—For suction applications, such as inlet flow to pumps, select hose to withstand both the negative and positive pressures the system imposes on the hose.

5.3 External Pressure—In certain applications, such as in autoclaves or under water, the external environmental pressures may exceed the fluid pressure inside the hose. In these applications, consider the external pressures, and if necessary, consult the manufacturers.

5.4 Temperature—Exceeding hose temperature ratings may significantly reduce hose life. Select hose so the fluid and ambient temperatures, both static and transient, fall within the hose ratings. The effects of external heat sources should not raise the temperature of the hose above its maximum operating temperature. Select hose, heat shields, sleeving, and other methods for these requirements, and route or shield hose to avoid hose damage from external heat sources.

5.5 Permeation—Permeation, or effusion, is seepage of fluid through the hose. Certain materials in hose construction are more permeable than others. Consider the effects of permeation when selecting hose, especially with gaseous fluids. Consult the hose and fluid manufacturers for permeability information.

5.6 Hose-Material Compatibility—Variables that can affect compatibility of system fluids with hose materials include, but are not limited to:

a. Fluid pressure
b. Temperature
c. Concentration
d. Duration of exposure

Because of permeation (see 5.5), consider compatibility of system fluids with the hose, tube, cover, reinforcement, and fittings. Consult the fluid and hose manufacturers for compatibility information.

NOTE— Many fluid/elastomer compatibility tables in manufacturers' catalogs show ratings based on fluids at 21 °C, room temperature. These ratings may change at other temperatures. Carefully read the notes on the compatibility tables, and if in doubt, consult the manufacturer.

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5.7 Environment—Environmental conditions can cause hose and fitting degradation. Conditions to evaluate include, but are not limited to:

a. Ultraviolet light
b. Salt water
c. Air pollutants
d. Temperature (see 5.4)
e. Ozone
f. Chemicals
g. Electricity
h. Abrasion

If necessary, consult the manufacturers for more information.

5.8 Static-Electric Discharge—Fluid passing through hose can generate static electricity resulting in static-electric discharge. This may create sparks that can puncture hose. If this potential exists, select hose with sufficient conductivity to carry the static-electric charge to ground.

5.9 Sizing—The power transmitted by pressurized fluid varies with pressure and rate of flow. Select hose with adequate size to minimize pressure loss, and to avoid hose damage from heat generation or excessive velocity. Conduct calculations, or consult the manufacturers for sizing at flow velocities.

5.10 Unintended Uses—Hose assemblies are designed for the internal forces of conducted fluids. Do not pull hose or use it for purposes that may apply external forces for which the hose or fittings were not designed.

5.11 Specifications and Standards—When selecting hose and fittings for specific applications, refer to applicable government, industry, and manufacturer's specifications and standards.

5.12 Unusual Applications—Applications not addressed by the manufacturer or by industry standards may require special testing prior to selecting hose.

5.13 Hose Cleanliness—The cleanliness requirements of system components, other than hose, will determine the cleanliness requirements of the application. Consult the component manufacturers' cleanliness information for all components in the system. Hose assemblies vary in cleanliness levels; therefore, specify hose assemblies with adequate cleanliness for the system.

5.14 Hose Fittings—Selection of the proper hose fittings for the hose and application is essential for proper operation and safe use of hose and related assembly equipment. Hose fittings are qualified with the hose. Therefore, select only hose fittings compatible with the hose for the applications.

Improper selection of hose fittings or related assembly equipment for the application can result in injury or damage from leaks, or from hose assemblies blowing apart (see 4.2, 6.2, 6.3, and 6.4).

5.15 Vibration—Vibration can reduce hose service life. If required, conduct tests to evaluate the frequency and amplitude of system vibration. Clamps or other means may be used to reduce the effects of vibration. Consider the vibration requirements when selecting hose and predicting service life.

5.16 Hose Cover Protection—Protect the hose cover from abrasion, erosion, snagging, and cutting. Special abrasion-resistant hoses and hose guards are available for additional protection. Route hose to reduce abrasion from hose rubbing other hose or objects that may abrade it. (See Figure 1)

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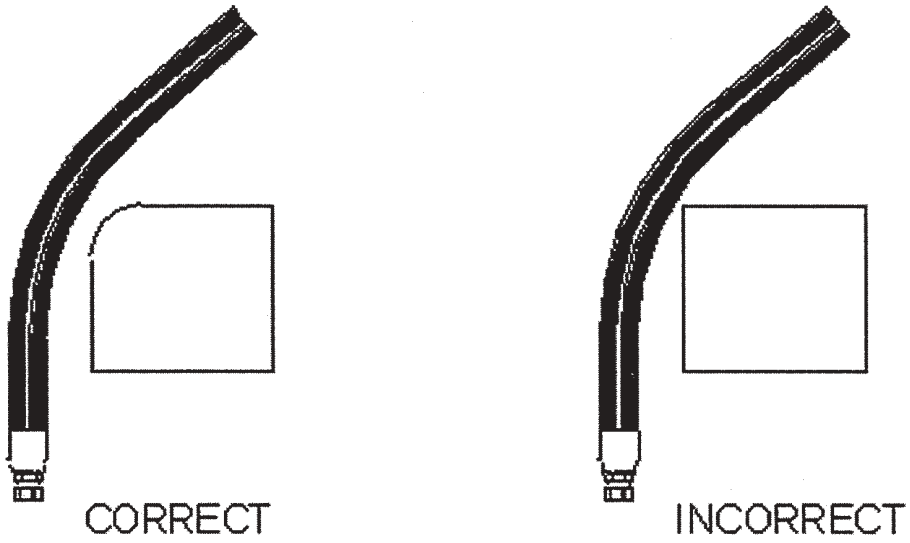

FIGURE 1—PREVENTION OF EXTERNAL DAMAGE

5.17 External Physical Abuse—Route hose to avoid:

a. Tensile loads
b. Side loads
c. Flattening
d. Thread damage
e. Kinking
f. Damage to sealing surfaces
g. Abrasion
h. Twisting

5.18 Swivel-Type Adapters—Swivel-type fittings or adapters do not transfer torque to hose while being tightened. Use these as needed to prevent twisting during installation.

5.19 Live Swivels—If two components in the system are rotating in relation to each other, live swivels may be necessary. These connectors reduce the torque transmitted to the hose.

5.20 Slings and Clamps—Use slings and clamps to support heavy or long hose and to keep it away from moving parts. Use clamps that prevent hose movement that will cause abrasion.

5.21 Minimum Bend Radius—The minimum bend radius is defined in SAE J343 and is specified in other SAE standards and hose manufacturer's product literature. Routing at less than minimum bend radius may reduce hose life. Sharp bending at the hose/fitting juncture may result in leaking, hose rupturing, or the hose assembly blowing apart (see 4.2 and Figures 2A and 2B).

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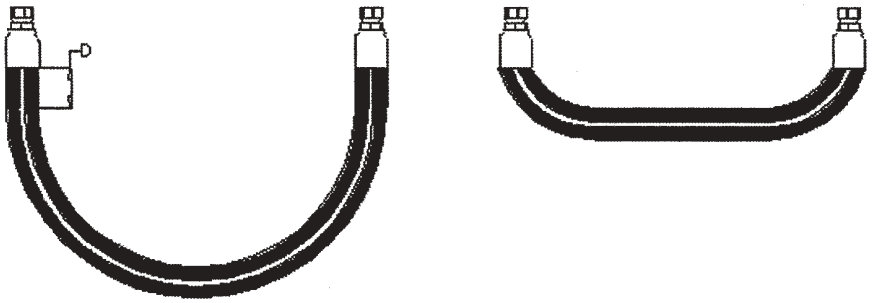

FIGURE 2A—MINIMUM BEND RADIUS

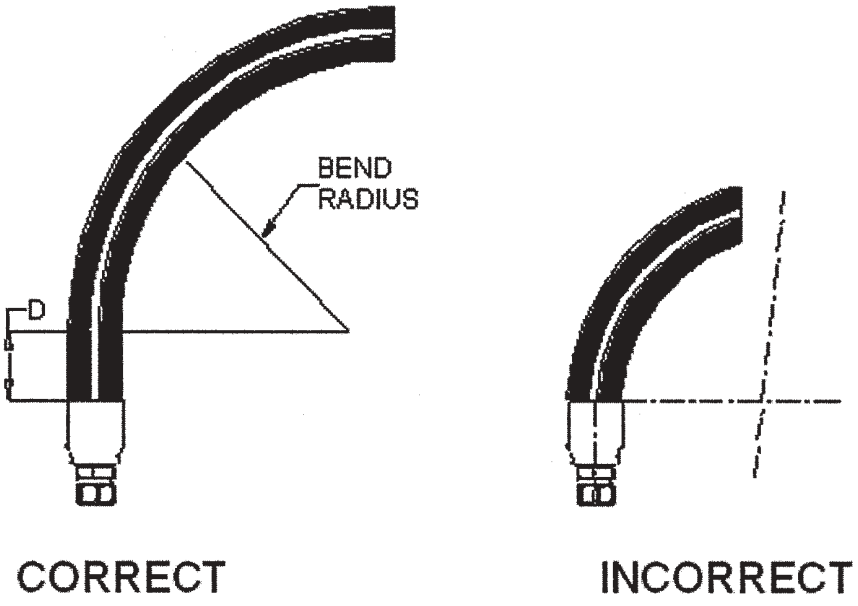

FIGURE 2B—MINIMUM BEND RADIUS

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5.22 Elbows and Adapters—In special cases, use elbows or adapters to relieve hose strain (see Figure 3).

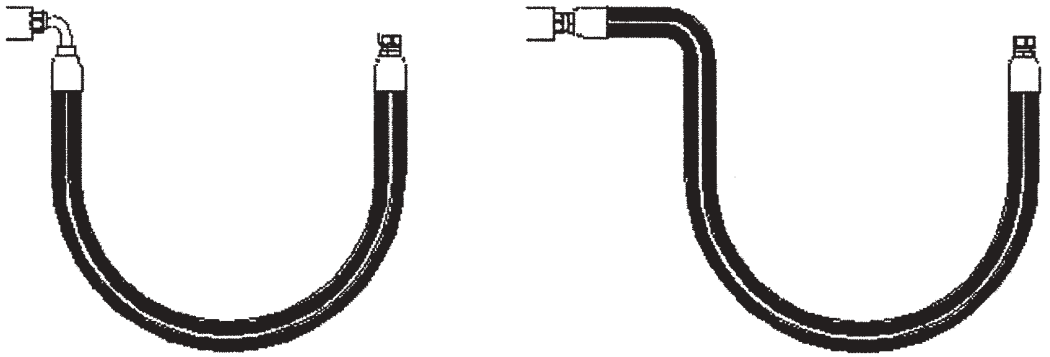

FIGURE 3—ELBOWS AND ADAPTERS

5.23 Lengths—Unnecessarily long hose can increase pressure drop and affect system performance. When pressurized, hose that is too short may pull loose from its fittings, or stress the fitting connections, causing premature metallic or seal failures. When establishing hose length, refer to Figures 4, 5, and 6; and use the following practices:

5.23.1 MOTION ABSORPTION—Provide adequate hose length to distribute movement and prevent bends smaller than the minimum bend radius.

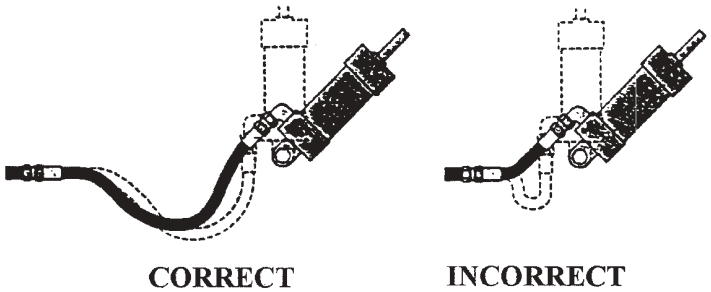

FIGURE 4—MOTION ABSORPTION

5.23.2 HOSE AND MACHINE TOLERANCES—Design hose to allow for changes in length due to machine motion and tolerances.

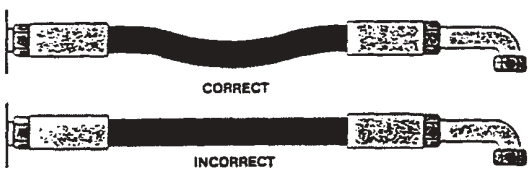

FIGURE 5—HOSE AND MACHINE TOLERANCES

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5.23.3 HOSE LENGTH CHANGE DUE TO PRESSURE—Design hose to accommodate length changes from changing pressures. Do not cross or clamp together high- and low-pressure hoses. The difference in length changes could wear the hose covers.

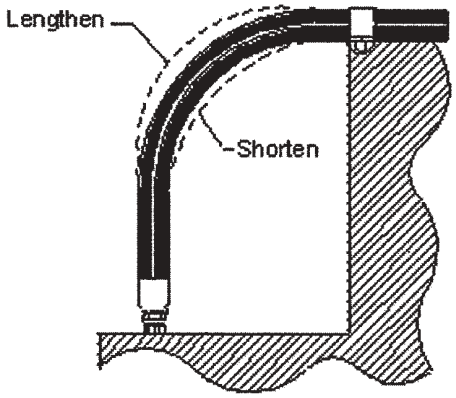

FIGURE 6—HOSE LENGTH CHANGE DUE TO PRESSURE

5.24 Hose Movement and Bending—Hose allows relative motion between system components. Analyze this motion when designing hose systems. The number of cycles per day may significantly affect hose life. Also avoid multiple planes of motion and twisting motion. Consider the motion of the hose when selecting hose and predicting service life. In applications that require hose to move or bend, refer to Figures 7A, 7B, and 8; and use these practices:

5.24.1 BEND IN ONLY ONE PLANE TO AVOID TWISTING

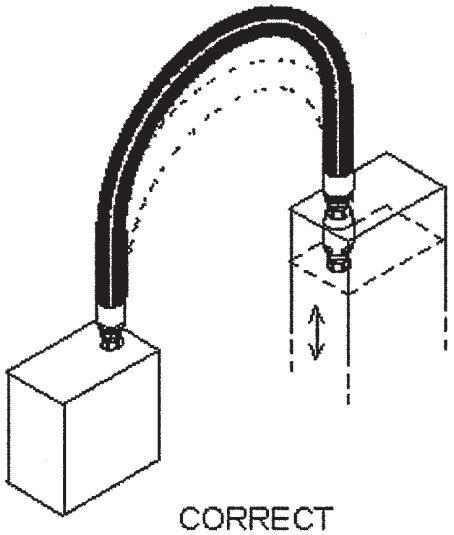

FIGURE 7A—BEND IN ONLY ONE PLANE TO AVOID TWISTING

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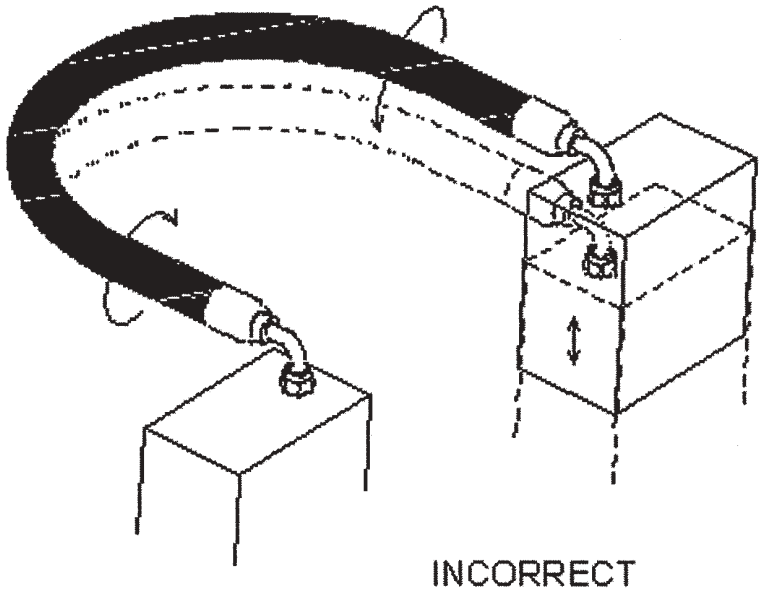

FIGURE 7B—BEND IN ONLY ONE PLANE TO AVOID TWISTING

5.24.2 PREVENT HOSE BENDING IN MORE THAN ONE PLANE—If hose follows a compound bend, couple it into separate segments, or clamp it into segments that flex in only one plane.

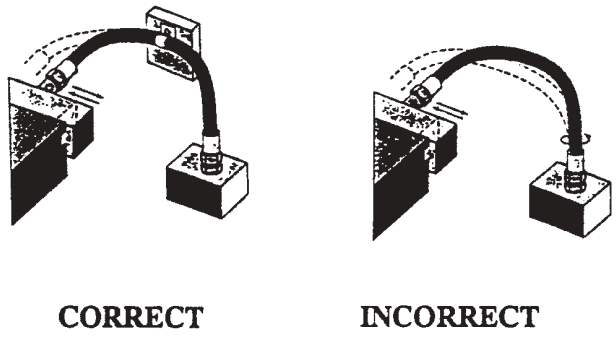

FIGURE 8—PREVENT HOSE BENDING IN MORE THAN ONE PLANE

6. ***Hose-Assembly Fabrication***—Persons fabricating hose assemblies should be trained in the proper use of equipment and materials. The manufacturers' instructions and the practices listed as follows must be followed. Properly assembled fittings are vital to the integrity of a hose assembly. Improperly assembled fittings can separate from the hose and may cause serious injury or property damage from whipping hose, or from fire or explosion of vapor expelled from the hose.

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6.1 Component Inspection—Prior to assembly, examine components for:

a. Style or type
b. Cleanliness
c. Loose covers
d. Nicks
e. Size
f. Inside obstructions
g. Visible defects
h. Damage
i. Length
j. Blisters
k. Burrs

6.2 Hose Fittings—Hose fitting components from one manufacturer are not usually compatible with fitting components supplied by another manufacturer. For example, do not use a hose fitting nipple from one manufacturer with a hose socket from another manufacturer.

It is the responsibility of the fabricator to consult the manufacturer's written instructions or the manufacturer directly for information on proper fitting components.

6.3 Hose and Fitting Compatibility—Care must be taken to determine proper compatibility between the hose and fitting. Base selection on the manufacturers' recommendations substantiated by testing to industry standards such as SAE J517. Hose from one manufacturer is not usually compatible with fittings from another. Do not intermix hose and fittings from two manufacturers without approval from both manufacturers.

6.4 Hose Assembly Equipment—Assembly equipment from one manufacturer is usually not interchangeable with that from another manufacturer. Hoses and fittings from one manufacturer should not generally be assembled with the equipment of another manufacturer.

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6.5 Safety Equipment—During fabrication, use proper safety equipment, including eye protection, breathing apparatus, and adequate ventilation.

6.6 Reuse of Hose and Fittings—When fabricating hose assemblies, do **not** reuse:

a. Field-attachable fittings that have blown or pulled off hose
b. Any part of hose fittings that were permanently crimped or swaged to hose
c. Hose that has been in service after system checkout (see 7.7)

6.7 Cleanliness of Hose Assemblies—Hose assemblies may be contaminated during fabrication. Clean hoses to specified cleanliness levels (see 5.13).

7. Hose Installation and Replacement—Use the following practices when installing hose assemblies in new systems or replacing hose assemblies in existing systems:

7.1 Pre-Installation Inspection—Before installing hose assemblies, examine:

a. Hose length and routing for compliance with original design
b. Assemblies for correct style, size, length, and visible nonconformities
c. Fitting sealing surfaces for burrs, nicks, or other damage

NOTE— When replacing hose assemblies in existing systems, verify that the replacement is of equal quality to the original assembly.

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7.2 Handling During Installation—Handle hose with care during installation. Kinking hose, or bending at less than minimum bend radius may reduce hose life. Avoid sharp bending at the hose/fitting juncture (see 5.21).

7.3 Twist Angle and Orientation—Pressure applied to a twisted hose may shorten the life of the hose or loosen the connections. To avoid twisting, use the hose lay line or marking as a reference (see Figure 9).

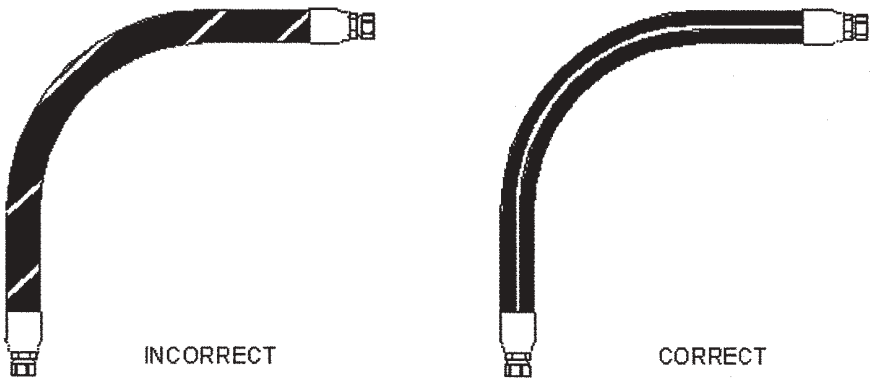

FIGURE 9—TWIST ANGLE AND ORIENTATION

7.4 Securement and Protection—Install necessary restraints and protective devices. Determine that such devices do not create additional stress or wear points.

7.5 Routing—Review proper routing practices provided in Section 5 and make appropriate corrections to obtain optimum performance.

7.6 Assembly Torque—The connection end of a hose fitting is normally threaded to obtain a tight pressure seal when attached to a port, an adapter, or another fitting. Sometimes bolts or screws provide the threaded connection. Each size and type of connection requires different torque values, and these may vary due to type of material or exterior coating.

Follow appropriate torquing instructions to obtain a proper pressure seal without over-torquing. A properly calibrated torque wrench should be used to tighten each connection, except when the manufacturer specifies tightening a specified number of hex flat turns beyond finger tight to obtain a seal.

7.7 System Checkouts—In hydraulic or other liquid systems, eliminate all air entrapment after completing the installation. Follow manufacturers' instructions to test the system for possible malfunctions and leaks.

7.7.1 To avoid injury during system checkouts:

a. Do not touch any part of the system when checking for leaks (see 4.1).
b. Stay out of potentially hazardous areas while testing hose systems (see Section 4).
c. Relieve system pressure before tightening connections.

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8. ***Maintenance Inspection***—A hose and fitting maintenance program may reduce equipment downtime, maintain peak operating performance, and reduce the risk of personal injury and/or property damage. The user should design and implement a maintenance program that suits the specific application and each specific hose in that application.

8.1 **Inspection Frequency**—Evaluate factors such as the nature and severity of the application, past history, and manufacturers' information to establish the frequency of visual inspections and functional tests.

8.2 **Visual Inspection (Hose and Fittings)**—Visually inspect hose and fittings for:

a. Leaks at hose fitting or in hose
b. Damaged, cut, or abraded cover
c. Exposed reinforcement
d. Kinked, crushed, flattened, or twisted hose
e. Hard, stiff, heat cracked, or charred hose
f. Blistered, soft, degraded, or loose cover
g. Cracked, damaged, or badly corroded fittings
h. Fitting slippage on hose
i. Other signs of significant deterioration

If any of these conditions exist, evaluate the hose assemblies for correction or replacement.

8.3 **Visual Inspection (All Other Components)**—When visually inspecting hose and fittings, inspect for related items including:

a. Leaking ports
b. Damaged or missing hose clamps, guards, or shields
c. Excessive dirt and debris around hose
d. System fluid: level, type, contamination, condition, and air entrainment

If any of these are found, address them appropriately.

8.4 **Functional Test**—Functional tests determine if systems with hose are leak free and operating properly. Carry out functional tests per information from equipment manufacturers.

9. ***Hose Storage***—Age control and the manner of storage can affect hose life. Use the following practices when storing hose.

9.1 **Age Control**—Maintain a system of age control to determine that hose is used before its shelf life has expired. Shelf life is the period of time when it is reasonable to expect the hose to retain full capabilities for rendering the intended service.

Store hose in a manner that facilitates age control and first-in, first-out usage based on manufacturing date on hose or hose assembly. Per SAE J517:

a. Shelf life of rubber hose in bulk form, or in hose assemblies passing visual inspection and proof test, is forty quarters (ten years) from the date of vulcanization.
b. Shelf life of thermoplastic and polytetrafluoroethylene hose is considered to be unlimited.

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9.2 Storage—Store hose and hose assemblies in a cool, dark, dry area with the ends capped. When storing hose, take care to avoid damage that could reduce hose life, and follow the manufacturers' information for storage and shelf life. Examples of factors that can adversely affect hose products in storage are:

a. Temperature
b. Ozone
c. Oils
d. Corrosive liquids and fumes
e. Rodents
f. Humidity
g. Ultraviolet light
h. Solvents
i. Insects
j. Radioactive materials

If there are questions regarding the quality or usability of hose or hose assemblies, evaluate appropriately:

a. Flex the hose to the minimum bend radius and compare it with new hose. After flexing, examine the cover and tube for cracks. If any appear, no matter how small, reject the hose.
b. If the hose is wire reinforced, and the hose is unusually stiff, or a cracking sound is heard during flexing, check for rust by cutting away a section of the cover from a sample. Rust would be another reason for rejection.
c. If doubt still persists, contact hose assembler to conduct proof-pressure tests or any other tests needed to verify hose quality.

10. Notes

10.1 Marginal Indicia—The (R) is for the convenience of the user in locating areas where technical revisions have been made to the previous issue of the report. If the symbol is next to the report title, it indicates a complete revision of the report.

PREPARED BY THE SAE FLUID CONDUCTORS AND CONNECTORS TECHNICAL COMMITTEE SC3—TRAINING AND EDUCATION SUBCOMMITTEE

SAE J1273 Revised DEC2002

Rationale—SAE J1273 is being updated in order to show figures that more clearly describe the section. These updated figures have been redrawn by new equipment. Therefore the pictures clarify the task in order to accurately depict what is in the text. The figures are also positioned in order to show the "Correct" version prior to showing the "Incorrect" version. Each figure will be set up in this fashion for uniformity.

Relationship of SAE Standard to ISO Standard—Not applicable.

Application—SAE J1273 provides guidelines for selection, routing, fabrication, installation, replacement, maintenance, and storage of hose and hose assemblies for fluid-power systems. Many of these SAE Recommended Practices also may be suitable for other hoses and systems.

Reference Section

SAE J343—Test and Procedures for SAE 100 R Series Hydraulic Hose and Hose Assemblies

SAE J514—Hydraulic Tube Fittings

SAE J517—Hydraulic Hose

SAE J1927—Cumulative Damage Analysis for Hydraulic Hose Assemblies

ISO 3457—Earth moving machinery—Guards and shields—Definitions and specifications

Developed by the SAE Fluid Conductors and Connectors Technical Committee SC3—Training and Education Subcommittee

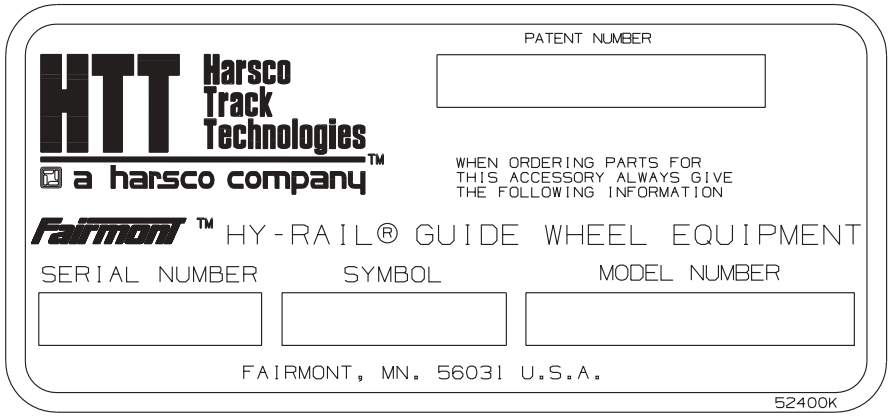
Sponsored by the SAE Fluid Conductor and Connectors Technical Committee

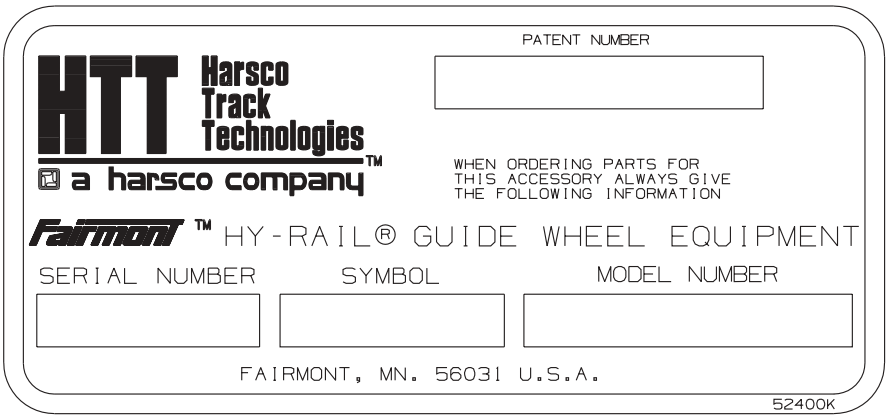
SECTION 7 - PARTS
TABLE OF CONTENTS

Application Drawings

Serial Numbers

When this bulletin is received, fill in the spaces provided below using the information from the serial number tags on the guide wheel units. Always provide these factory serial numbers when calling or writing about the units. The serial number tag is located on the mounting frame on the units.





Instructions For Ordering Parts

1. Locate the appropriate group numbers in the Parts Section to find the individual parts required.

2. Front - rear and left - right are determined from the operator's position.

3. Assemblies: Items listed in CAPITALS are assemblies which include all parts listed immediately following and with the part description indented to the right. When assemblies can be used, always order them to save work of fitting separate parts.

4. For convenience in ordering, parts are listed by item number, part number, description, and quantity in each assembly or group. If in doubt as to any part wanted, send full description, sketch, or send the old part with the order.

5. To insure prompt and correct shipment of parts on orders, always give:

   a. Quantity of each part wanted.
   b. Part number of each part as shown in this book. Include any prefix and suffix letters.
   c. Description of each part as shown in this book.
   d. Factory serial numbers from the serial number tag.
   e. Purchase order number (if required).
   f. Preferred method of shipment.

6. All parts are shipped F.O.B. factory, transportation charges to be paid by customer. Terms to be determined by the Credit Department.

Limited Warranty

HARSCO TRACK TECHNOLOGIES products are designed to give high quality service and are manufactured from high grade material, by competent workmen under careful supervision. Harsco Track Technologies, Harsco Corporation warrants products of its manufacture to be free of defects in material and workmanship, under normal use and service for a period of six (6) months from date of delivery to the original user. The obligation of Harsco Track Technologies, Harsco Corporation under this warranty is limited to repairing or replacing at its factories, or other location designated by it, any part or parts thereof which are returned within 30 days of the date when failure occurs or defect is noted, with transportation charges prepaid, and which upon examination appears to the satisfaction of Harsco Track Technologies, Harsco Corporation to have been defective. Such free repair or replacement does not include transportation charges, or the cost of installing the new part or any other expense incident thereto. Harsco Track Technologies, Harsco Corporation will not be liable for other loss, damage, or expense directly or indirectly arising from the use of its products, nor will Harsco Track Technologies, Harsco Corporation be liable for special, incidental or consequential damages.

Ordinary wear and tear, and damage from abuse, misuse, neglect or alteration are not covered by this warranty. Harsco Track Technologies, Harsco Corporation assumes no liability for expenses incurred or repairs made outside its factories except by written consent. This warranty is null and void if instructions and operating procedures are not followed.

Equipment or parts not manufactured by this company, but which are furnished in connection with HARSCO TRACK TECHNOLOGIES products, are covered directly by the warranty of the manufacturer supplying them. However, Harsco Track Technologies, Harsco Corporation will assist in obtaining adjustment on such equipment or parts when necessary.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES EXPRESSED OR IMPLIED INCLUDING ANY IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE AND OF ANY OTHER OBLIGATION OR LIABILITY OF HARSCO TRACK TECHNOLOGIES, HARSCO CORPORATION.

Product Improvement Liability Disclaimer

HARSCO TRACK TECHNOLOGIES, HARSCO CORPORATION RESERVES THE RIGHT TO MAKE ANY CHANGES IN OR IMPROVEMENTS ON ITS PRODUCTS WITHOUT INCURRING ANY LIABILITY OR OBLIGATION WHATEVER AND WITHOUT BEING REQUIRED TO MAKE ANY CORRESPONDING CHANGES OR IMPROVEMENTS IN PRODUCTS PREVIOUSLY MANUFACTURED OR SOLD.

Hazardous Material Disclaimer

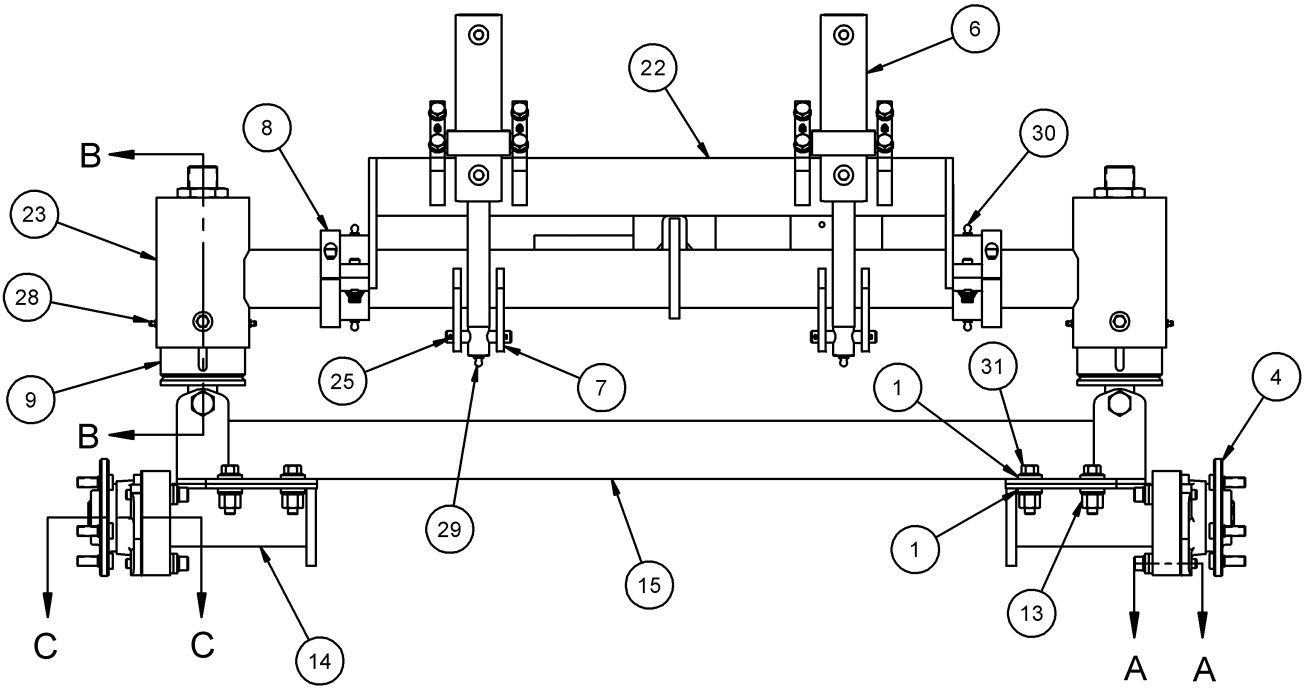
THE PARTS/ASSEMBLIES THAT ARE USED IN THIS PRODUCT ARE CLASSIFIED AS "ARTICLES" ACCORDING TO 29 CFR 1910.1200 (C). THEY ARE FORMED TO A SPECIFIC SHAPE OR DESIGN DURING MANUFACTURE, HAVE END USE FUNCTION DEPENDENT UPON THEIR SHAPE OR DESIGN, AND DO NOT RELEASE ANY HAZARDOUS CHEMICAL UNDER NORMAL CONDITIONS OF USE. ACCORDINGLY, WE ARE NOT REQUIRED TO SUPPLY MATERIAL SAFETY DATA SHEETS (MSDS) OR TO LABEL SHIPPING CONTAINERS FOR "ARTICLES". HOWEVER, LUBRICANTS, LIQUIDS, GASEOUS CHEMICALS AND SOLIDS USED IN OPERATION OR MAINTENANCE OF THE PRODUCT MAY REQUIRE THAT USER'S TAKE OCCUPATIONAL PROTECTIVE MEASURES. MSDS SHEETS FOR SUCH MATERIALS WILL BE SUPPLIED TO YOUR PURCHASING MANAGER/SAFETY DIRECTOR TO BE USED IN YOUR EMPLOYEE SAFETY TRAINING EDUCATION AND ENVIRONMENTAL HEALTH TRAINING.

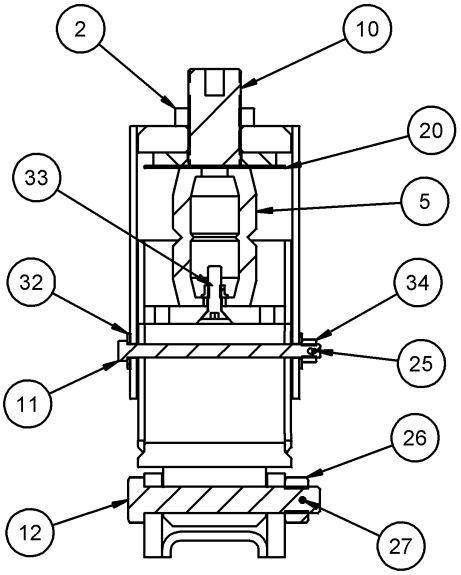
200433 GUIDE WHEEL UNIT GROUP

PART NO	DESCRIPTION	QTY
200431	Guide Wheel Unit, Front	1
F018860	Cap Screw, 1/2-13 x 2-3/4" Hex Hd GR 8	6
F024047	Washer	12
F013500	Elastic Stop Nut, 1/2"	6
196377	Shim, 1/16"	4
196378	Shim, 1/4"	4
200432	Guide Wheel Unit, Rear	1
F018860	Cap Screw, 1/2-13 x 2-3/4" GR 8 Hex Hd	6
F024047	Washer	12
F013500	Elastic Stop Nut, 1/2"	6
196379	Shim, 1/16"	4
196380	Shim, 1/4"	4
140220	Decal, Warning - Do Not Operate This Machine Before...	1
155007	Decal, HY-RAIL® Vehicle Completion By...	1
191761	Decal, Harsco Track Technologies	1
196490	Decal, Operating Instructions	1
F018082	Decal, Safety Instructions - Lock Front Wheels....	1

REVISED 8-2014

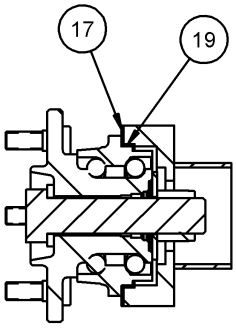
200431 FRONT GUIDE WHEEL UNIT

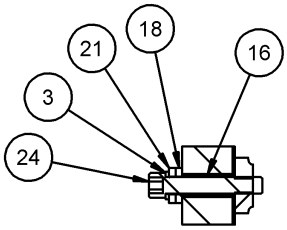




APPLY BLUE LOCTITE 242 TO THE THREADS ON ITEM 24.

TORQUE TO 60 LB-FT. (6 PLACES)





SECTION C - C

SECTION B - B

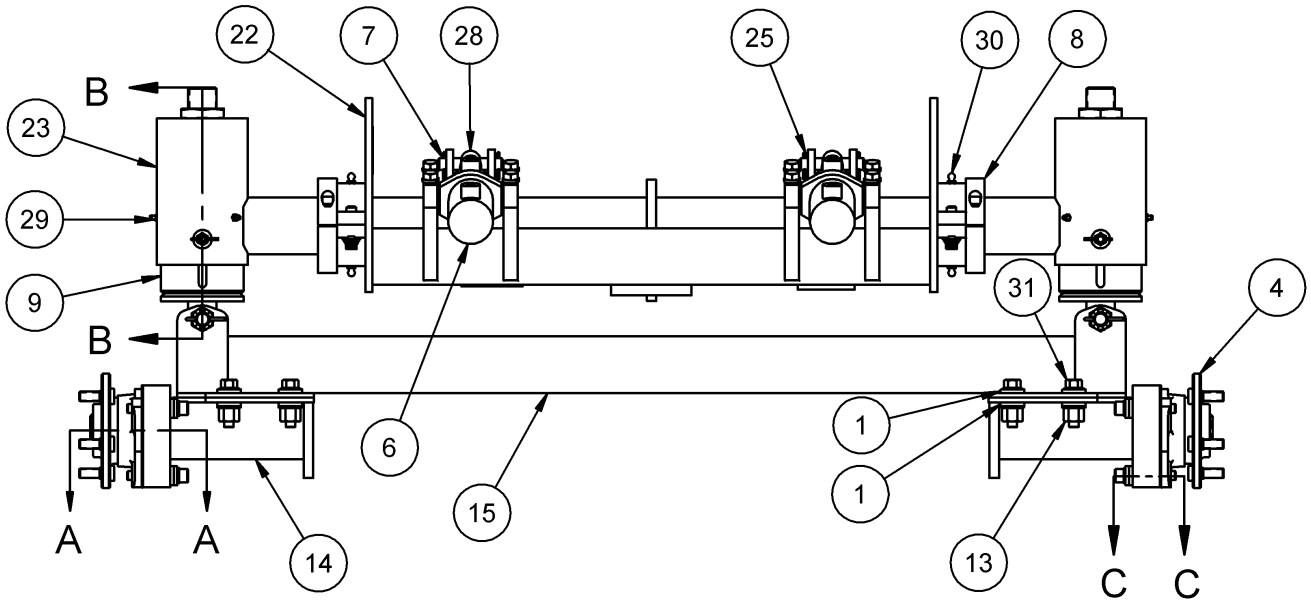
SECTION A - A

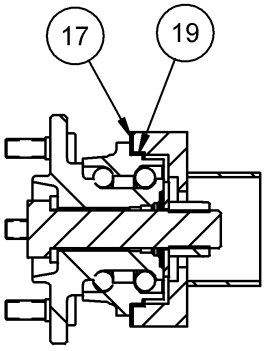
7

200431 FRONT GUIDE WHEEL UNIT

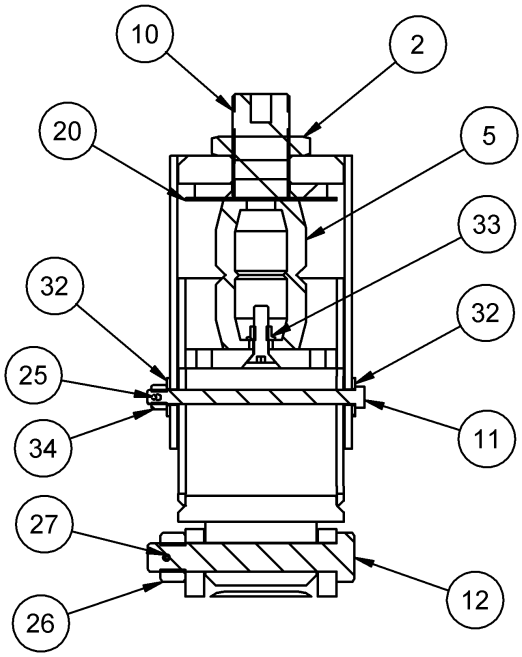
ITEM	PART NO	DESCRIPTION	QTY
1	072897	Washer	16
2	108560	Hex Jam Nut, 1-1/2" - 12	2
3	150791	Lock Washer, 12 mm	6
4	198689	Integral Spindle Assembly	2
5	193892	Rubber Spring	2
6	193904	Hydraulic Cylinder	2
7	193944	Pin	2
8	196481	Clamp Assembly	2
9	198830	Spring Cell, Lower	2
10	198836	Adjusting Stud	2
11	198844	Cap Screw, 3/8-16 x 5-1/2" Hex Hd	2
12	200330	Cap Screw, 3/4-10 x 5" Hex Hd.	2
13	201754	Disk Lock Nut, 1/2"-20	8
14	200407	Stub Axle	2
15	200410	Axle	1
16	200414	Insulating Bushing	6
17	200415	Insulating Plate.	2
18	200416	Insulating Washer	6
19	200417	Insulating Bushing	2
20	200418	Plate	2
21	200419	Washer.	6
22	200420	Upper Structure	1
23	200426	Cross Tube.	1
24	408735	Cap Screw, M12 x 1.75 x 70 mm CL 12.9 Hex Soc Hd	6
25	F001104	Cotter Pin, 1/8 x 1"	6
26	F002485	Hex Slotted Nut, 3/4"	2
27	F003038	Cotter Pin, 5/32 x 1-3/4"	2
28	F008014	Grease Fitting.	12
29	F009217	Grease Fitting, 90°	2
30	F010722	Grease Fitting, 90°	4
31	F020440	Cap Screw, 1/2-20 x 2" GR 8 Hex Flg Hd	8
32	F023111	Hardened Washer	4
33	F023225	Hex Flg Nut, 3/8"-16 GR 5	2
34	F040705	Hex Slotted Nut, 3/8"-16 GR 5	2

200432 REAR GUIDE WHEEL UNIT





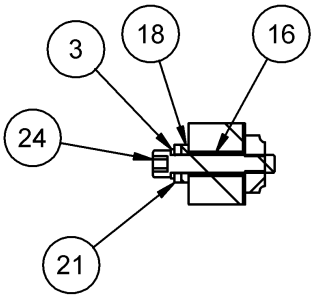
SECTION A-A



SECTION B-B

APPLY BLUE LOCTITE 242 TO THE THREADS ON ITEM 24.

TORQUE TO 60 LB-FT. (6 PLACES)



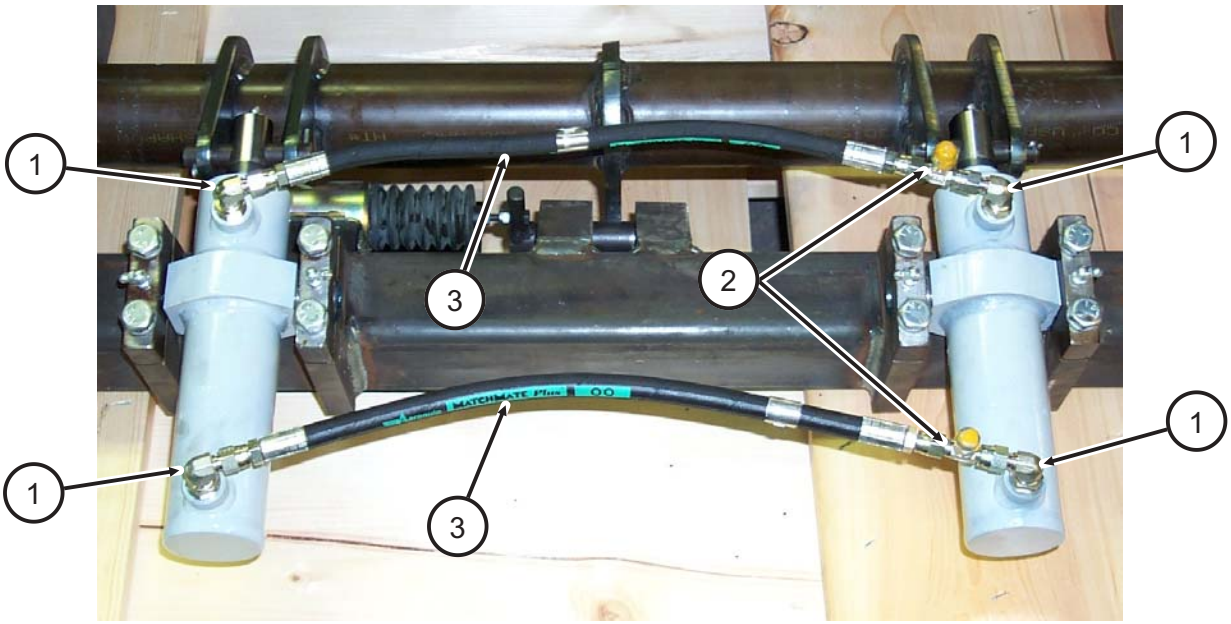
SECTION C-C

7

200432 REAR GUIDE WHEEL UNIT

ITEM	PART NO	DESCRIPTION	QTY
1	072897	Washer	16
2	108560	Hex Jam Nut, 1-1/2" - 12	2
3	150791	Lock Washer, 12 mm	6
4	198689	Integral Spindle Assembly	2
5	193892	Rubber Spring	2
6	193904	Hydraulic Cylinder	2
7	193944	Pin	2
8	196481	Clamp Assembly	2
9	198830	Lower Spring Cell	2
10	198836	Adjusting Stud	2
11	198844	Cap Screw, 3/8-16 x 5-1/2" Hex Hd	2
12	200330	Cap Screw, 3/4-10 x 5" Hex Hd	2
13	201754	Disk Lock Nut, 1/2"-20	8
14	200407	Stub Axle	2
15	200410	Axle	1
16	200414	Insulating Bushing	6
17	200415	Insulating Plate	2
18	200416	Insulating Washer	6
19	200417	Insulating Bushing	2
20	200418	Plate	2
21	200419	Washer	6
22	200421	Upper Structure	1
23	200429	Cross Tube	1
24	408735	Cap Screw, M12 x 1.75 x 70 mm CL 12.9 Hex Soc Hd	6
25	F001104	Cotter Pin, 1/8 x 1"	6
26	F002485	Hex Slotted Nut, 3/4"	2
27	F003038	Cotter Pin, 5/32 x 1-3/4"	2
28	F004252	Grease Fitting	2
29	F008014	Grease Fitting	12
30	F010722	Grease Fitting, 90°	4
31	F020440	Cap Screw, 1/2-20 x 2" GR 8 Hex Flg Hd	8
32	F023111	Hardened Washer	4
33	F023225	Hex Flg Nut, 3/8"-16 GR 5	2
34	F040705	Hex Slotted Nut, 3/8"-16 GR 5	2

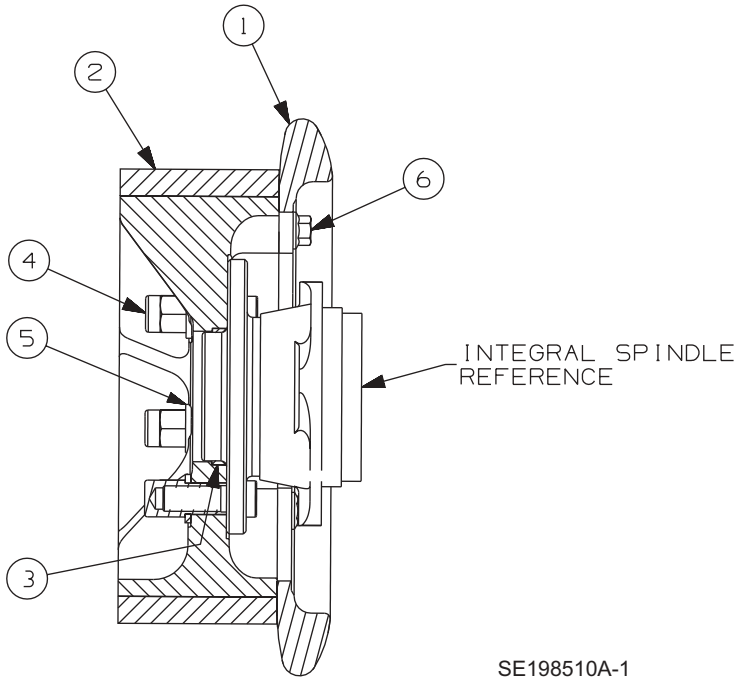
HYDRAULIC PIPING - FRONT OR REAR GUIDE WHEEL UNIT



03-192

ITEM	PART NO	DESCRIPTION	QTY
1	F022262	90° Elbow	4
2	F021905	Tee	2
3	184216	Hose	2

198510 GUIDE WHEEL, RUBBER TREAD

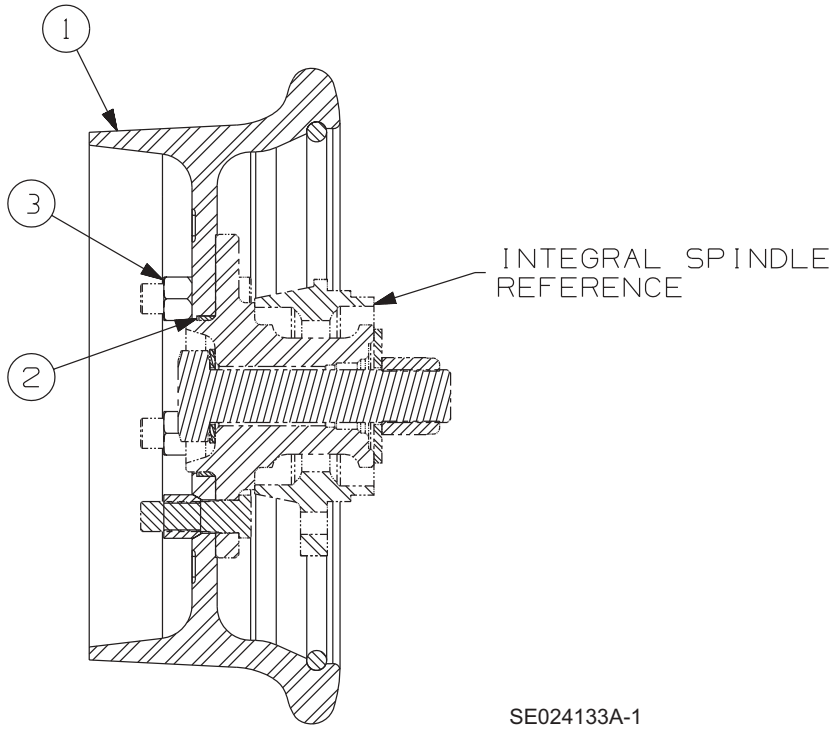


Note: Quantities Listed Are For One Wheel Only.

ITEM	PART NO	DESCRIPTION	QTY
	198510	GUIDE WHEEL, RUBBER TREAD	1
1	136133	Flange	1
2	196489	Rubber Tread	1
3	194007	Bushing	1
4	196492	Lug Nut (torque to 90 ft / lbs)	5
5	F023457	Washer	5
6	F023255	Cap Screw, 3/8-16 x 1" GR 5 Hex Flg Hd (torque to 40 ft / lbs)	6

When replacing the 198510 Rubber Tread Guide Wheel, make sure that the correct guide wheel is used on the HR1500 Series B2 Guide Wheel Unit.
All 198510 Guide Wheels are marked with "1500" on the web of the guide wheel as shown in the photo at the right.

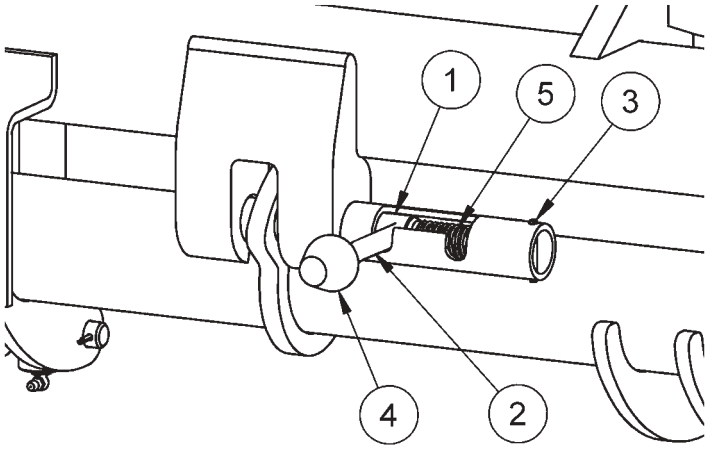
198690 GUIDE WHEEL, STEEL TREAD



Note: Quantities Listed Are For One Wheel Only.

ITEM	PART NO	DESCRIPTION	QTY
	198690	GUIDE WHEEL, STEEL TREAD	1
1	200854	Steel Tread	1
2	194007	Bushing	1
3	F010448	Wheel Nut (torque to 90 ft / lbs)	5

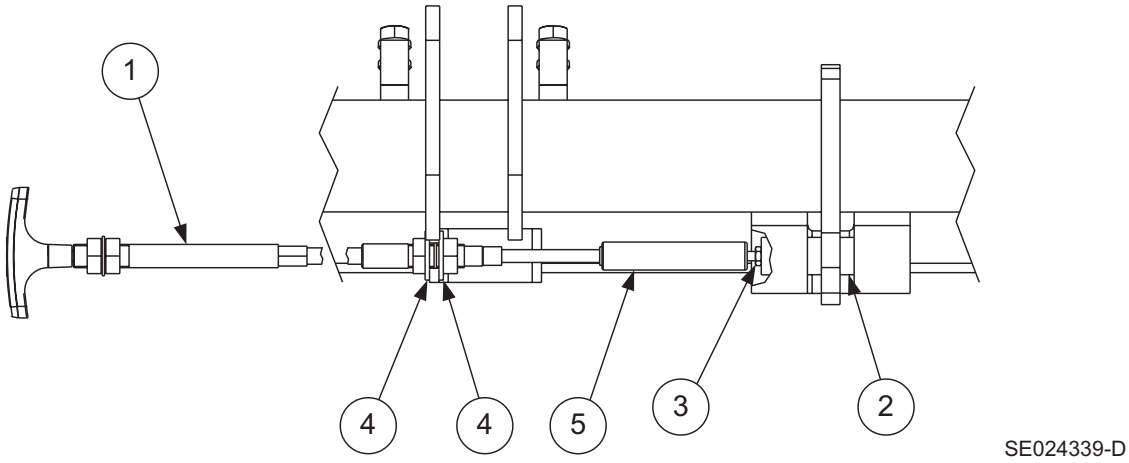
200973 MANUAL LOCK GROUP - FRONT



SE024338A-1

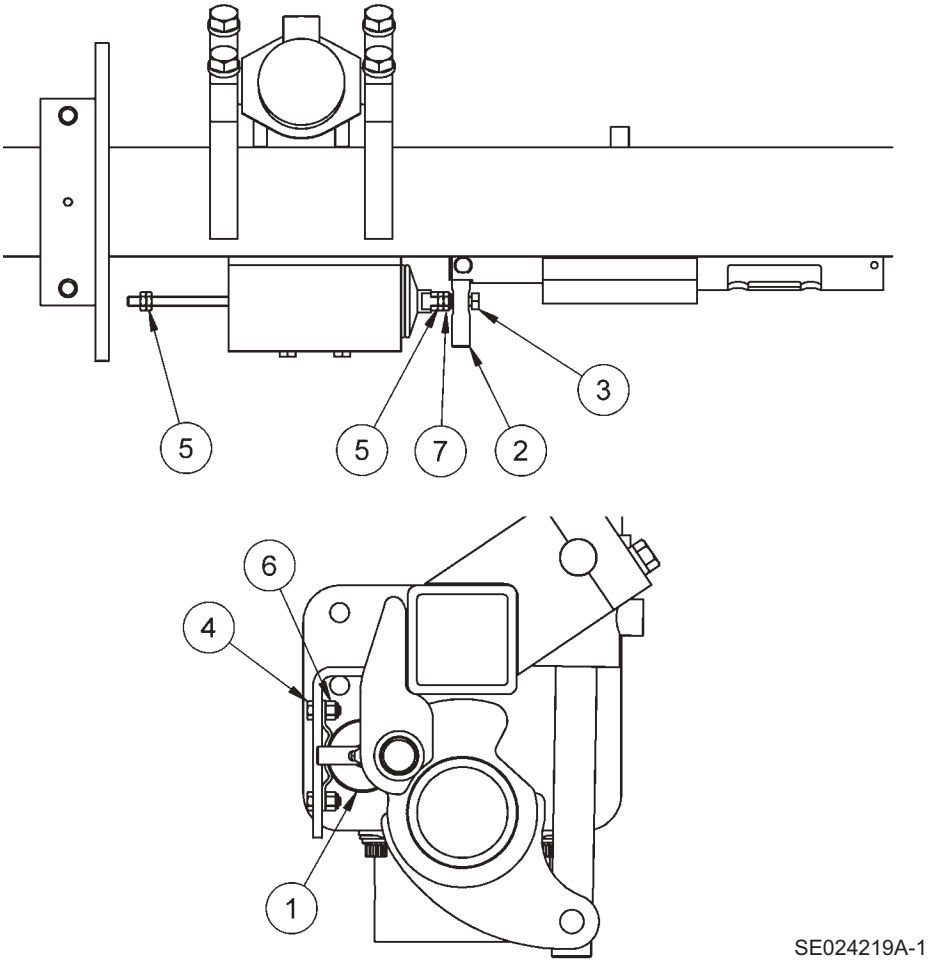
ITEM	PART NO	DESCRIPTION	QTY
	200973	MANUAL LOCK GROUP - FRONT	1
1	198190	Pin	1
2	201341	Stud	1
3	700751150	Roll Pin, 3/16 x 1-1/2"	1
4	F014260K	Ball Handle	1
5	F023159	Spring	1

200974 MANUAL LOCK GROUP - REAR



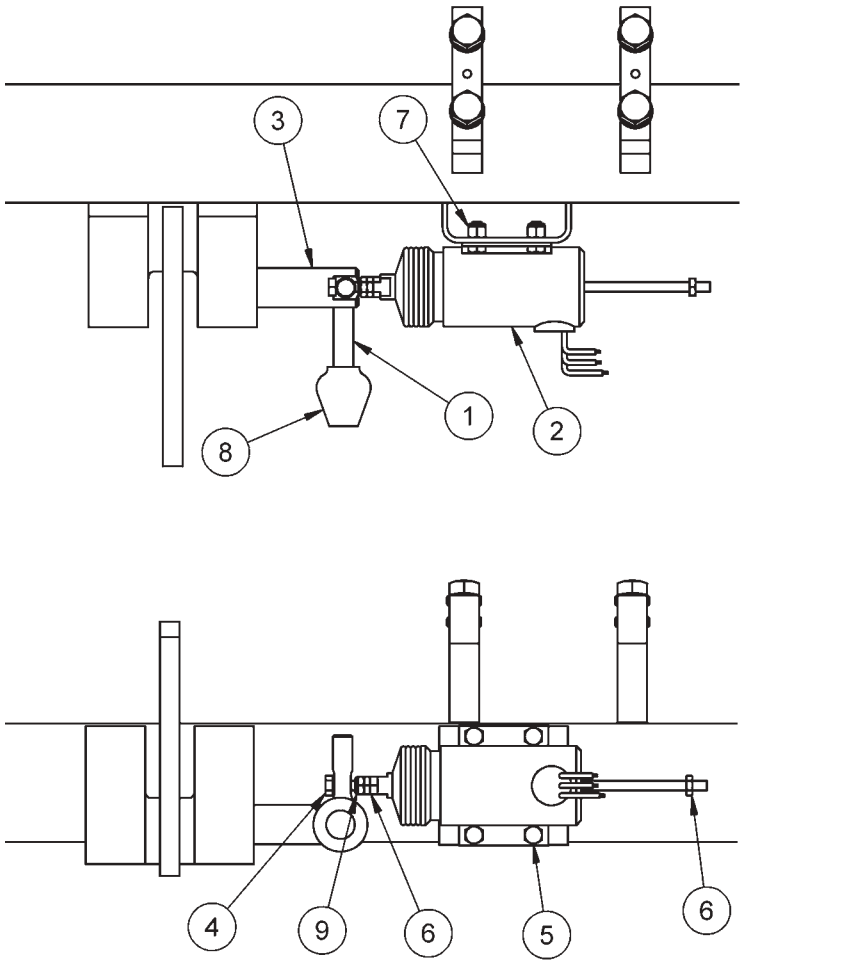
ITEM	PART NO	DESCRIPTION	QTY
	200974	MANUAL LOCK GROUP - REAR	1
1	201535	Control Cable	1
2	200339	Pin	1
3	F011483	Hex Jam Nut, 1/4"-28 GR 2	1
4	F009425	SAE Washer, 5/8"	2
5	203253	Seal, Tube	1

200312 ELECTRIC LOCK GROUP - FRONT



ITEM	PART NO	DESCRIPTION	QTY
	200312	ELECTRIC LOCK GROUP - FRONT	1
1	200290	Solenoid	1
2	200404	Pin Assembly	1
3	200478	Bolt	1
4	F002355	Cap Screw, 1/4-20 x 3/4" GR 5 Hex Hd	4
5	F011483	Hex Jam Nut, 1/4"-28 GR 2	3
6	F013588	Elastic Stop Nut, 1/4"-20	4
7	F015435	Hex Lock Nut, 1/4"-28	4

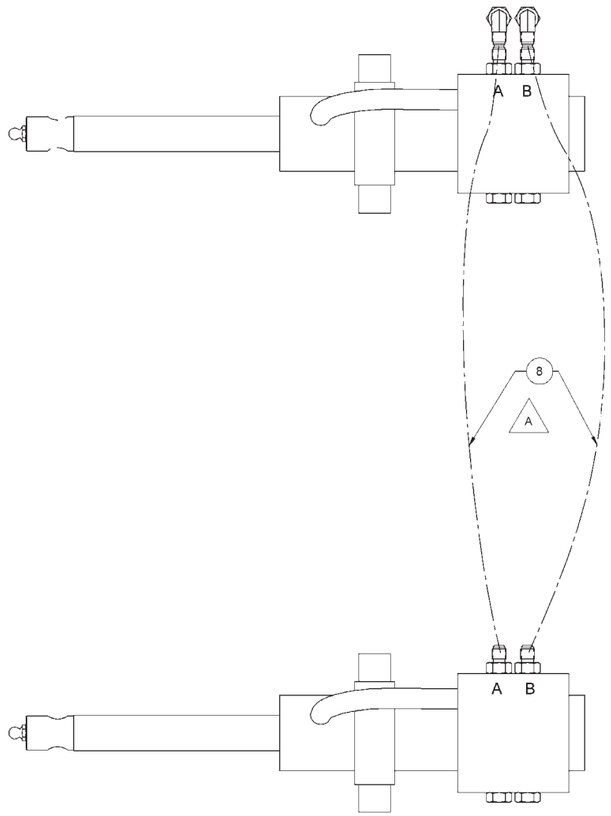
200313 ELECTRIC LOCK GROUP - REAR



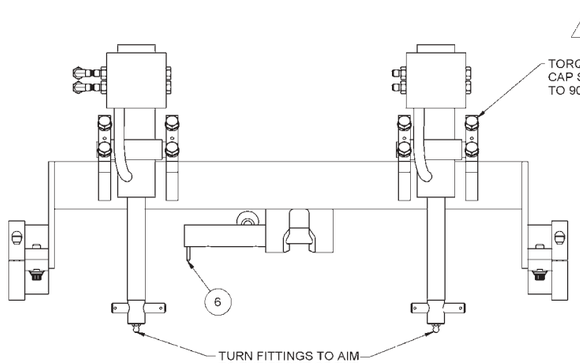
SE024220A-1

ITEM	PART NO	DESCRIPTION	QTY
	200313	ELECTRIC LOCK GROUP - REAR	1
1	178105	Stud	1
2	200290	Solenoid	1
3	200404	Pin Assembly	1
4	200478	Bolt	1
5	F003067	Cap Screw, 1/4-20 x 5/8" GR 5 Hex Hd	4
6	F011483	Hex Jam Nut, 1/4"-28 GR 2	2
7	F013588	Elastic Stop Nut, 1/4"-20	4
8	F014260K	Ball Handle	1
9	F015435	Hex Lock Nut, 1/4"-28	1

201622 HYDRAULIC / MANUAL LOCK GROUP - FRONT



PARTS OF PILOT UNIT NOT SHOWN FOR CLARITY



HYDRAULIC LOCK APPLICATION

1) INSTALL PIN 198190 INTO TUBE WITH THREADED HOLE SHOWING THROUGH SLOT.

2) CLEAN THREADS ON BOTH PIN AND STUD AND APPLY LOCKTITE F013548 TO THE THREADS. INSTALL STUD 201341 INTO PIN.

3) INSTALL HANDLE F014260K ONTO STUD.

4) INSTALL SPRING F023159 INTO TUBE AND PRESS ROLL PIN 700751150 INTO HOLES ON THE END OF TUBE.

A 5) INSTALL CYLINDERS 201340 AND TORQUE THE TRUNION MOUNT CAP SCREWS TO 90 LB FT.

A 6) ADD GREASE FITTINGS F009217 ONTO CYLINDER RODS.

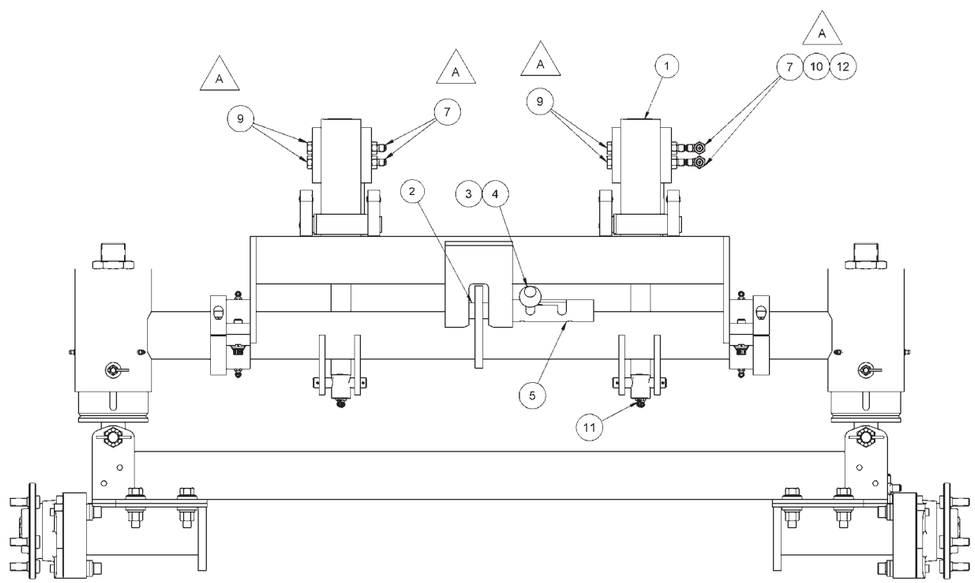
A 7) INSTALL FITTINGS F022230,F021905, AND F015085 AS SHOWN AND INSTALL HOSES 175541 TO CORRESPONDING FITTINGS ON EACH CYLINDER (I.E. A TO A, B TO B).

A 8) INSTALL PLUGS F015292 INTO THE UNUSED PORTS ON THE CYLINDERS.

9) VERIFY THAT THE PIN TRAVELS FULL PATH THROUGH LOCKING PLATES WITH NO INTERFERENCES IN HIGHWAY AND RAIL POSITION.

10) ENSURE THE HOSES ARE NOT RUBBING ON ANY PART OF THE UNIT.

ITEM	QTY	PART NO	DESCRIPTION
1	2	201340	CYLINDER 6" STROKE
2	1	198190	PIN
3	1	201341	STUD
4	1	F014260K	SEMI BALL HANDLE
5	1	F023159	SPRING
6	1	700751150	ROLL PIN .19 X 1.50
A 7	4	F022230	STR 4X6SAE
8	2	175541	HYDRAULIC HOSE
A 9	4	F015292	PLUG
A 10	2	F021905	TEE 4FSX4X4
11	2	F009217	ZERK ELB90 X 02NPT
A 12	2	F015085	ELB 90 4X4FS



SOLID EDGE DRAWING

MACHINING TOLERANCES UNLESS OTHERWISE SPECIFIED
1. 2 PLACE DECIMAL DIM ±.02 FOR EACH 1" OVER ±.005
2. 3 PLACE DECIMAL DIM ±.005 UP TO 36". ±.010 OVER 36"
3. CONCENTRICITY OF CYLINDRICAL SURFACES = .030 TIR
4. PARALLELISM, SQUARENESS OR ANGULARITY BETWEEN SURFACES .010 FOR EACH INCH OR FRACTION OF 1. (.002 IN/IN)
5. FINISH 125 MICROINCHES
FABRICATION TOLERANCES UNLESS OTHERWISE SPECIFIED

NOMINAL THICKNESS	DIMS ±TOL	DIMS ±TOL
a. LESS THAN .12	0 TO 15 = .01	OVER 30 = .06
b. .12 TO 1.00	0 TO 15 = .01	OVER 15 = .03
c. 1.00 TO 3.00	0 TO 15 = .03	OVER 30 = .10
d. OVER 3.00	0 TO 15 = .10	OVER 30 = .25

2. BENT ANGLE ±2. (.017 IN/IN) FOR EACH .38 OF MATERIAL THICKNESS (MAX ±3°)

QTY IS REF FOR ALL DC (DECONTROLLED) PARTS LIST ITEMS

CHANGE	R/L	REVISION	DATE
65956	A	CHANGE FITTINGS AND HOSE ROUTING	9/03
66812	B	UPDATE DWG	6/04

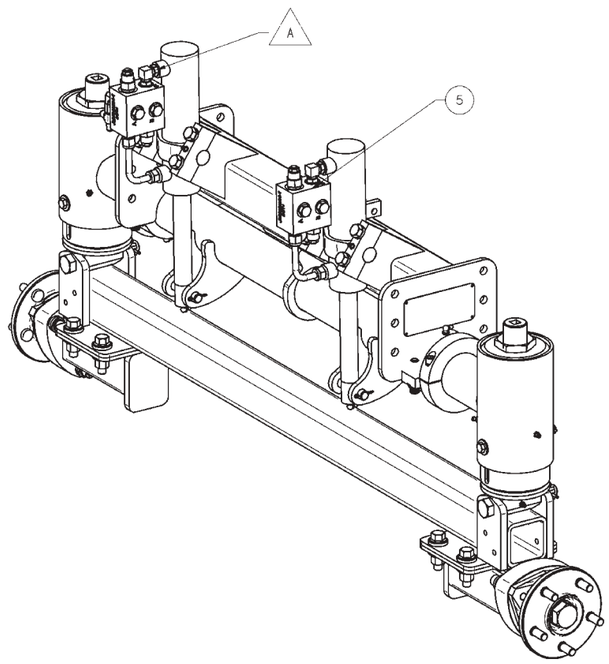
DESCRIPTION: HYD LOCK FRONT
PART NUMBER: 024426
MODEL: HR1500
DRAWN: kjorgensen
DATE: 03/07/2005
WEIGHT: 0.0 lbm
SCALE: 1=1
APVD Desg / APVD Chng / APVD Mfgng
MATERIAL
SIZE: D
DRAWING NUMBER: XXXXXXX,X
SHEET 1 OF 1
DO NOT SCALE PRINT

Harsco Track Technologies
Harsco
FAIRMONT, MN

Plotted by techwriters on 03/07/2005 SE024426-B.dft

202462 HYDRAULIC / MANUAL LOCK GROUP - FRONT

ITEM	QTY	PART NO	DESCRIPTION
1	1	198190	PIN
2	1	F014260K	SEMI BALL HANDLE
3	1	F023159	SPRING
4	1	700751150	ROLL PIN .19 X 1.50
5	2	202410	MANIFOLD
6	4	F022230	STR 4X6SAE
7	4	F015292	PLUG
8	2	F015085	ELB 90 4X4FS
9	2	F021905	TEE 4FSX4X4



HYDRAULIC LOCK AND MANIFOLD APPLICATION W/ P.O. CHECK VALVES

1) INSTALL PIN 198190 INTO TUBE WITH THREADED HOLE SHOWING THROUGH SLOT.

2) CLEAN THREADS ON BOTH PIN AND STUD AND APPLY LOCKTITE F013548 TO THREADS. INSTALL STUD 201341 INTO PIN.

3) INSTALL BALL HANDLE F014260K ONTO STUD.

4) INSTALL SPRING F023159 INTO TUBE AND PRESS ROLL PIN 700751150 INTO HOLES ON THE END OF TUBE.

5) MOUNTING MANIFOLD ASSEMBLY.

A) MOUNT MANIFOLD ASSEMBLY TO CYLINDER BY PLACING SAE # 6 ELBOW IN TOP PORT OF CYLINDER AND TURNING MANIFOLD ASSEMBLY AS SHOWN. SEE A

B) SLIDE NUT, TAPERED SPLIT RING, AND FITTING BODY ON LONG SIDE OF TUBE UNTIL TUBE IS FLUSH WITH FITTING.

C) SLIDE ONLY THE NUT AND TAPERED SPLIT RING ON SHORT END OF TUBE.

D) INSERT FITTING INTO BOTTOM CYLINDER PORT.

E) PUSH TUBE INTO THE INSTALLED FITTING UNTIL END OF THE LONG END OF TUBE IS ALIGNED WITH OTHER PORT

F) INSTALL FITTING BODY INTO MANIFOLD PORT.

G) SLIDE BOTH SPLIT RING AND NUT UP TO FITTING AND TIGHTEN.

H) INSURE ALL FITTINGS ARE TIGHT AND JAM NUTS ON THE FITTINGS ARE TIGHT TO CYLINDER PORTS.

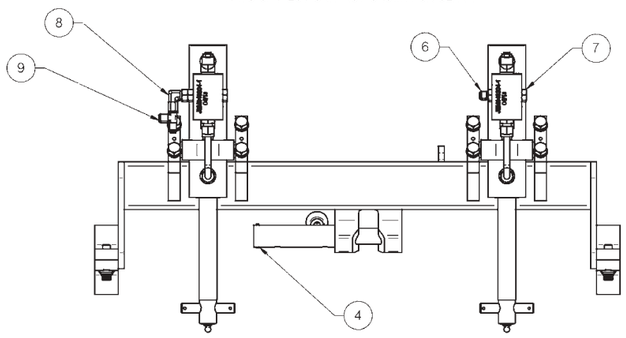
6) INSTALL FITTINGS F022230, F015085, AND F021905, AS SHOWN AND INSTALL HOSES TO CORRESPONDING FITTINGS ON EACH MANIFOLD (A TO A, B TO B).

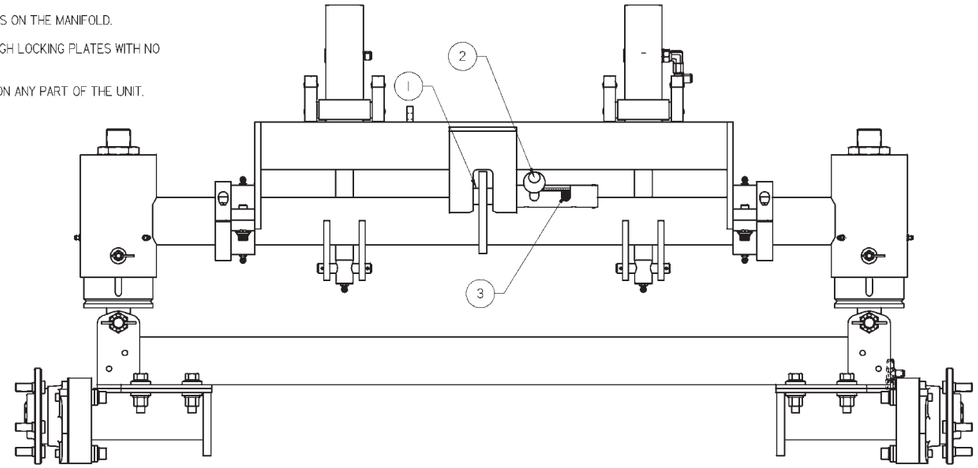
7) INSTALL PLUGS F015292 INTO THE UNUSED PORTS ON THE MANIFOLD.

8) VERIFY THAT THE PIN TRAVELS FULL PATH THROUGH LOCKING PLATES WITH NO INTERFERENCES IN HIGHWAY AND RAIL POSITION.

9) ENSURE THAT APPLIED HOSES ARE NOT RUBBING ON ANY PART OF THE UNIT.

PARTS OF PILOT UNIT NOT SHOWN FOR CLARITY





SOLID EDGE DRAWING

IMPLIED TOLERANCES
ALL DIMENSIONS ARE IN INCHES - TOLERANCE UNLESS OTHERWISE SPECIFIED

INCH PLUS OR MINUS		METRIC PLUS OR MINUS	
.X	.03	X	1
.XX	.005	.XX	0.13
.XXX	.010	.XXX	0.25
ANGLES	1°	ANGLES	1°

UNLESS OTHERWISE SPECIFIED ALL MACHINED SURFACES "FULL MIKE"

THIRD ANGLE PROJECTION

CHANGE	R/L	REVISION	DATE
66700	A	NEW RELEASE	6/04
66812	B	UPDATE DWG	6/04
66968	C	UPDATE DRAWING	9/04
67150	D	REFLECT CHANGES TO PILOT UNIT 200431	11/04
67331	E	REFLECT CHANGES TO PILOT UNIT 200431	1/05

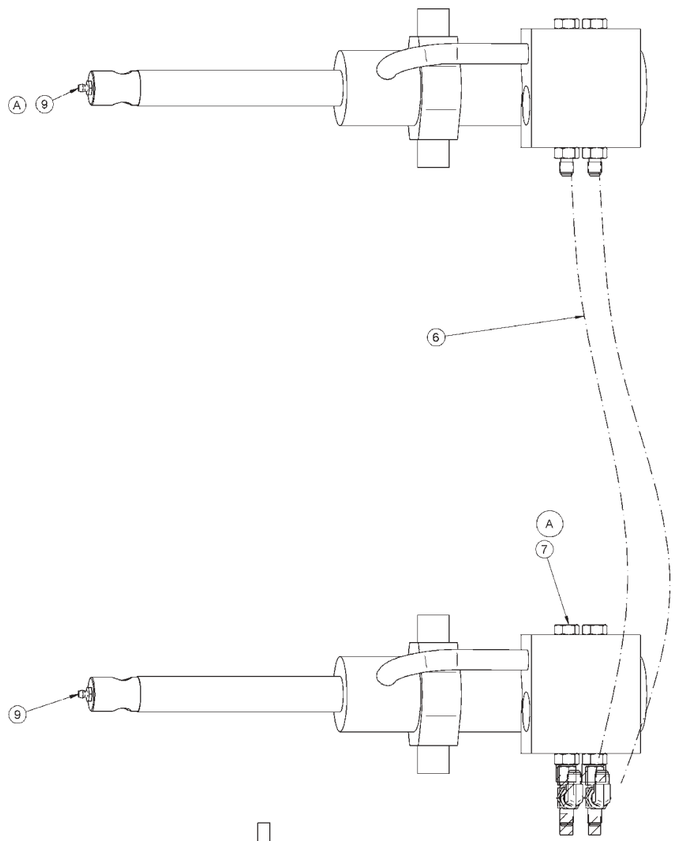
Description: HYDRAULIC LOCKS- FRONT
Drawing Number: ----------
Machine Type: HR1500
Model: 024546_e.asm
Drawn: dschultz
Date Drawn: 03/07/2005
Weight: 0.0 lbm
Scale: 1:4
Dec .X: XXX
Dec .XXX: XXX
MAT: 024564, HYD LOCK FRONT

HTT
Harsco Track Technologies
Harsco
Columbia, SC

Part Number: 024546
Size: D
Sheet: 1 of 1

Plotted by techwriters on 03/07/2005 SE024546-E.dft

201623 HYDRAULIC / MANUAL LOCK GROUP - REAR



HYDRAULIC LOCK APPLICATION

1) ADD WASHERS, SEAL, (B) AND NUT TO CONTROL CABLE.

2) INSERT PIN INTO BLOCK ON UPPER STRUCTURE SO THAT THREADED HOLE FACES ANGLE.

3) THREAD CONTROL CABLE INTO PIN. TIGHTEN JAM NUT AGAINST PIN.

4) PLACE CONTROL CABLE INTO ANGLE SO THAT THERE IS A WASHER AND NUT TO EACH SIDE OF THE ANGLE. TIGHTEN NUTS SO CONTROL CABLE IS ATTACHED TO ANGLE.

(A) 5) INSTALL CYLINDERS 201340 AND TORQUE THE TRUNNION MOUNT CAP SCREWS TO 90 LB-FT.

(A) 6) INSTALL GREASE FITTINGS F004252 ONTO CYLINDER RODS.

(A) 7) INSTALL FITTINGS F022230, F021905, AND F015085 AS SHOWN.

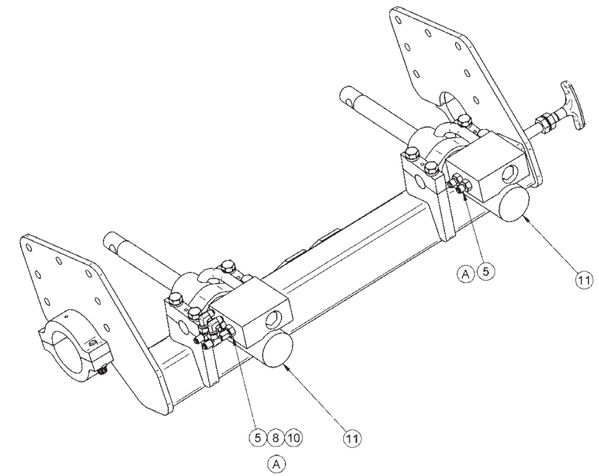
8) INSTALL HOSES 175541 TO CORRESPONDING FITTINGS ON EACH CYLINDER.

(A) 9) INSTALL PLUGS F015292 INTO THE UNUSED PORTS ON THE CYLINDERS.

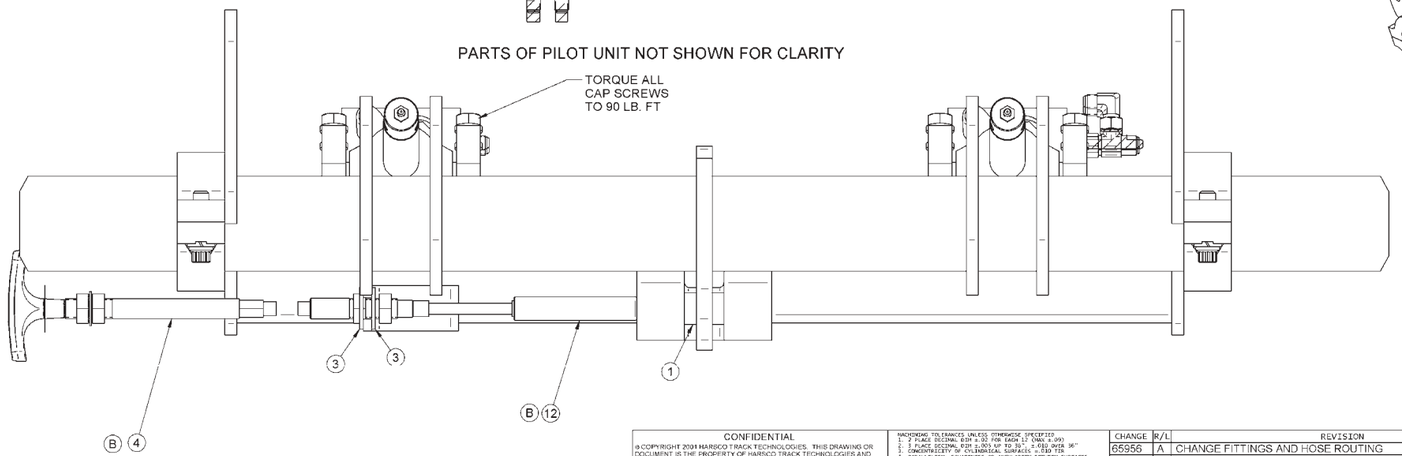
9) VERIFY THE PIN TRAVELS FULL PATH TROUGH LOCKING PLATES WITH NO INTERFERENCES IN HIGHWAY AND RAIL POSITION.

10) ENSURE THE HOSES ARE NOT RUBBING ON ANY PART OF THE UNIT.

ITEM	QTY	PART NO	DESCRIPTION
1	1	200339	PIN
2	1	F011483	HEX JAM NUT .250-28
3	2	F009425	SAE FLAT WASHER .625
(B) 4	1	201535	CONTROL CABLE
(A) 5	4	F022230	STR 4X6SAE
6	2	175541	HYDRAULIC HOSE
(A) 7	4	F015292	PLUG
(A) 8	2	F021905	TEE 4FSX4X4
9	2	F004252	ZERK STRX2NPT
(A) 10	2	F015085	ELB 90 4X4FS
11	2	201340	CYLINDER 6" STROKE
(B) 12	1	203253	SEAL



PARTS OF PILOT UNIT NOT SHOWN FOR CLARITY



SOLID EDGE DRAWING

MACHINING TOLERANCES UNLESS OTHERWISE SPECIFIED
1. 2 PLACE DECIMAL ±.03 FOR FINISH 32 RMS (.8 RMS-CLAY)
2. 3 PLACE DECIMAL ±.005 FOR FINISH 32 RMS (.8 RMS-CLAY)
3. CONCENTRICITY OF CYLINDRICAL SURFACES = .010 TIR
4. PARALLELISM, SQUARENESS OR ANGULARITY BETWEEN SURFACES AND/OR HOLE CENTERLINES ±0°7' (.003 IN/IN)
5. FINISH 125 MICROINCHES
WELDMENT TOLERANCES UNLESS OTHERWISE SPECIFIED

MATERIAL THICKNESS	DIM. ±TOL.	ANG. ±TOL.
a. LESS THAN .12	0 TO 36 = ±.03 - OVER 36 = ±.06	
b. .12 TO .50	0 TO 36 = ±.05 - OVER 36 = ±.12	
c. .50 TO 1.00	0 TO 36 = ±.09 - OVER 36 = ±.25	
d. 1.00 & UP	0 TO 36 = ±.12 - OVER 36 = ±.38	

2. JOINT ANGLE ±0° (.052" IN/IN) FOR EACH .1E OF MATERIAL THICKNESS (MAX 83°)

QTY IS REF FOR ALL EC (DECONTROLLED) PARTS LIST ITEMS

CHANGE	R/L	REVISION	DATE
65956	A	CHANGE FITTINGS AND HOSE ROUTING	9/03
67148	B	REPLACE CABLE W/ 201535; ADD SEAL 203253; REMOVE SPRING, TUBE	11/04
67331	C	UPDATE DRAWING	1/05

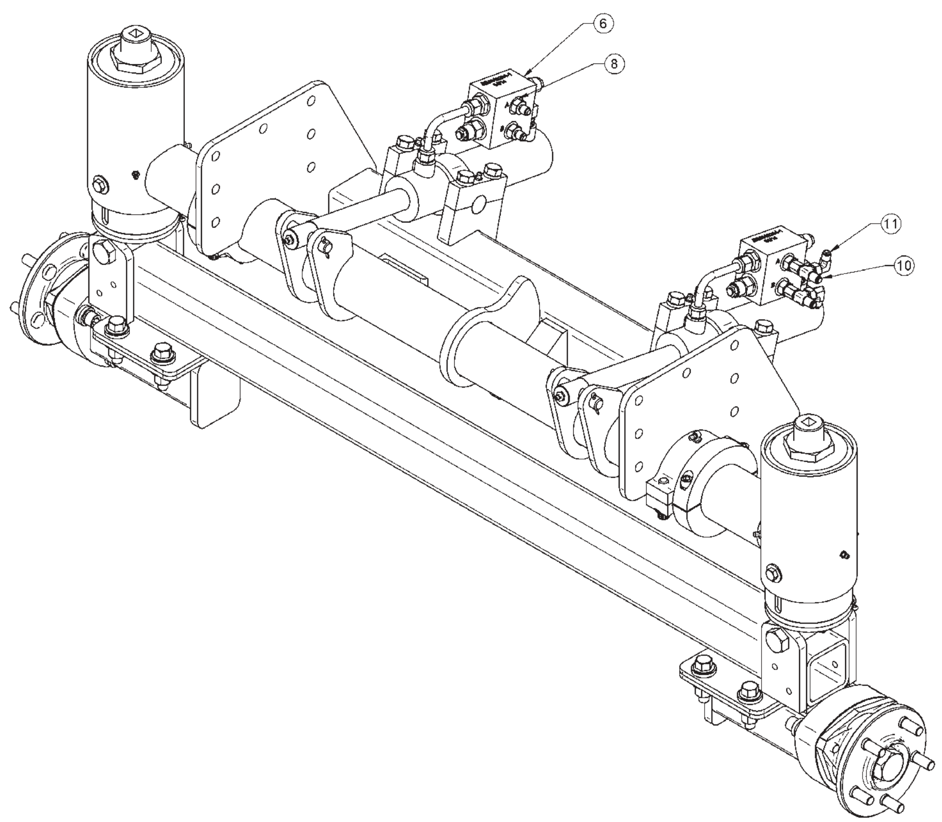
DESCRIPTION: HYD LOCK REAR
PART NUMBER: 024427
MODEL: HR1500B
APVD Engg: APVD Engng: APVD Mfgtng:
DRAWN: kjorgensen DATE: 03/07/2005
MATERIAL:
WEIGHT: 0.0 lbm CORP
SCALE: 1=1 DO NOT SCALE PRINT
SIZE: D
DRAWING NUMBER: XXXXXXX,X
SHEET 1 OF 1

Harsco Track Technologies
Harsco
FAIRMONT, MN

Plotted by jripley on 03/07/2005 SE024427-C.dft

202463 HYDRAULIC / MANUAL LOCK GROUP - REAR

	ITEM	QTY	PART NO	DESCRIPTION
	1	1	200339	PIN
	2	1	F011483	HEX JAM NUT .250-28
(C)	3	2	184216	HOSE ASSEMBLY
(C)	4	1	203253	SEAL
	5	2	F009425	SAE FLAT WASHER .625
	6	2	202410	MANIFOLD
(C)	7	1	201535	CONTROL CABLE
	8	4	F022230	STR 4X6SAE
	9	4	F015292	PLUG
	10	2	F021905	TEE 4FSX4X4
	11	2	F015085	ELB 90 4X4FS



HYDRAULIC LOCK AND MANIFOLD APPLICATION

1) ADD WASHERS, SEAL, AND NUT TO CONTROL CABLE.

2) INSERT PIN INTO BLOCK ON UPPER STRUCTURE SO THAT THREADED HOLE FACES ANGLE.

3) THREAD CONTROL CABLE INTO PIN. TIGHTEN JAM NUT AGAINST PIN.

4) PLACE CONTROL CABLE INTO ANGLE SO THAT THERE IS A WASHER AND NUT TO EACH SIDE OF THE ANGLE. TIGHTEN NUTS SO CONTROL CABLE IS ATTACHED TO ANGLE.

5) MOUNTING MANIFOLD ASSEMBLY:

A) MOUNT MANIFOLD ASSEMBLY TO CYLINDER BY PLACING SAE #6 ELBOW IN TOP PORT OF CYLINDER AND TURNING MANIFOLD ASSEMBLY AS SHOWN. SEE (A)

B) SLIDE NUT, TAPERED SPLIT RING, AND FITTING BODY ON LONG SIDE OF TUBE UNTIL TUBE IS FLUSH WITH FITTING.

C) SLIDE ONLY THE NUT AND TAPERED SPLIT RING ON SHORT END OF TUBE.

D) INSERT FITTING INTO BOTTOM CYLINDER PORT.

E) PUSH TUBE INTO THE INSTALLED FITTING UNTIL END OF THE LONG END OF TUBE IS ALIGNED WITH OTHER PORT.

F) INSTALL FITTING BODY INTO MANIFOLD PORT.

G) SLIDE BOTH SPLIT RING AND NUT UP TO FITTING AND TIGHTEN.

H) INSURE ALL FITTINGS ARE TIGHT AND JAM NUTS ON THE FITTINGS ARE TIGHT TO CYLINDER PORTS.

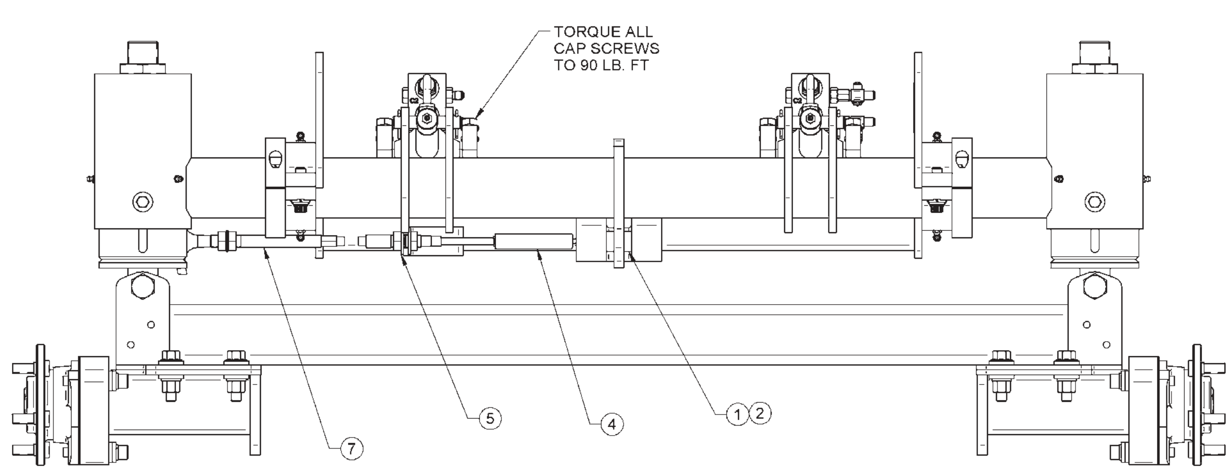
6) INSTALL FITTINGS F022230, F021905, AND F015085 AS SHOWN.

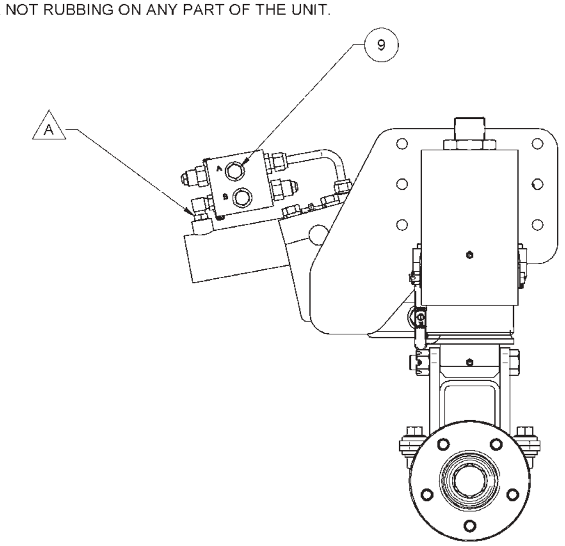
7) INSTALL HOSES 184216 TO CORRESPONDING FITTINGS ON EACH MANIFOLD.

8) INSTALL PLUGS F015292 INTO UNUSED PORTS ON MANIFOLDS.

9) VERIFY THE PIN TRAVELS FULL PATH THROUGH LOCKING PLATES WITH NO INTERFERENCES IN HIGHWAY AND RAIL POSITIONS.

10) ENSURE THAT HOSES ARE NOT RUBBING ON ANY PART OF THE UNIT.





SOLID EDGE DRAWING

CONFIDENTIAL

IMPLIED TOLERANCES
ALL DIMENSIONS ARE IN INCHES - TOLERANCE UNLESS OTHERWISE SPECIFIED

		INCH				METRIC	
		PLUS OR MINUS				PLUS OR MINUS	
0	6	.03	.005	0	150	.8	.127
6	24	.04	.008	150	600	1.0	.203
24	-	.06	.010	-	600	1.5	.254

UNLESS OTHERWISE SPECIFIED ALL MACHINED SURFACES WILL HAVE:

THIRD ANGLE PROJECTION

CHANGE	R/L	REVISION	DATE
66812	A	UPDATE DWG	6/04
66968	B	UPDATE DRAWING	9/04
67148	C	ADD SEAL, HOSES; REMOVE SPRING, TUBE; REPLACE CABLE W/ 201535	11/04
67331	D	UPDATE DRAWING	1/05

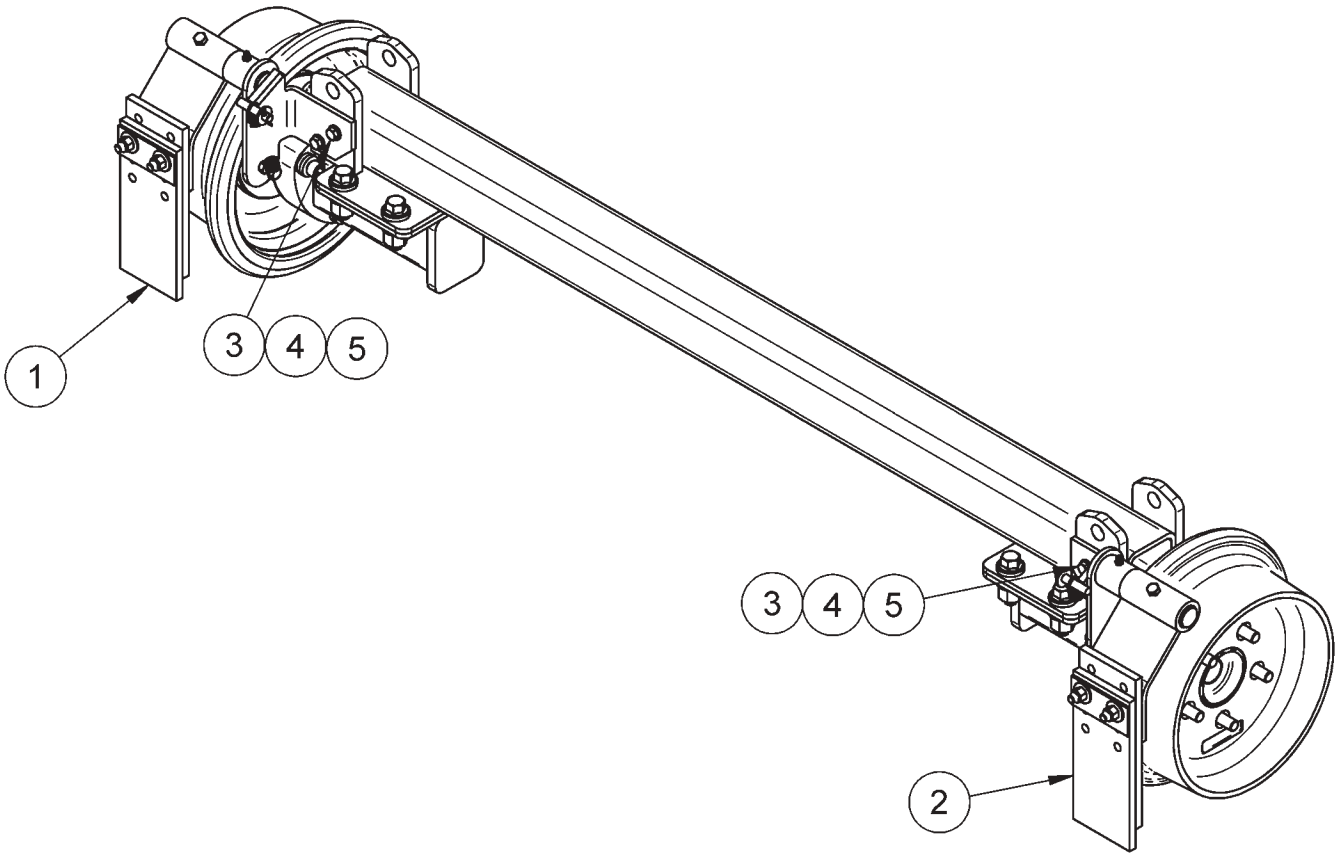
Description: HYD LOCK REAR
Drawing Number: ----------
Machine Type: HR1500B
Model: 024547_d.asm
Drawn: techwriters
Date Drawn: 03/07/2005
Weight: 0.0 lbm
Scale: .25=1
XXX XXX
Mat'l: Error: No reference, HYD LOCK REAR

HTT
Harsco Track Technologies
Harsco
Columbia, SC

Part Number: 024547 Size: D Sheet: 1 of 1

Plotted by techwriters on 03/07/2005 SE024547-D.dft

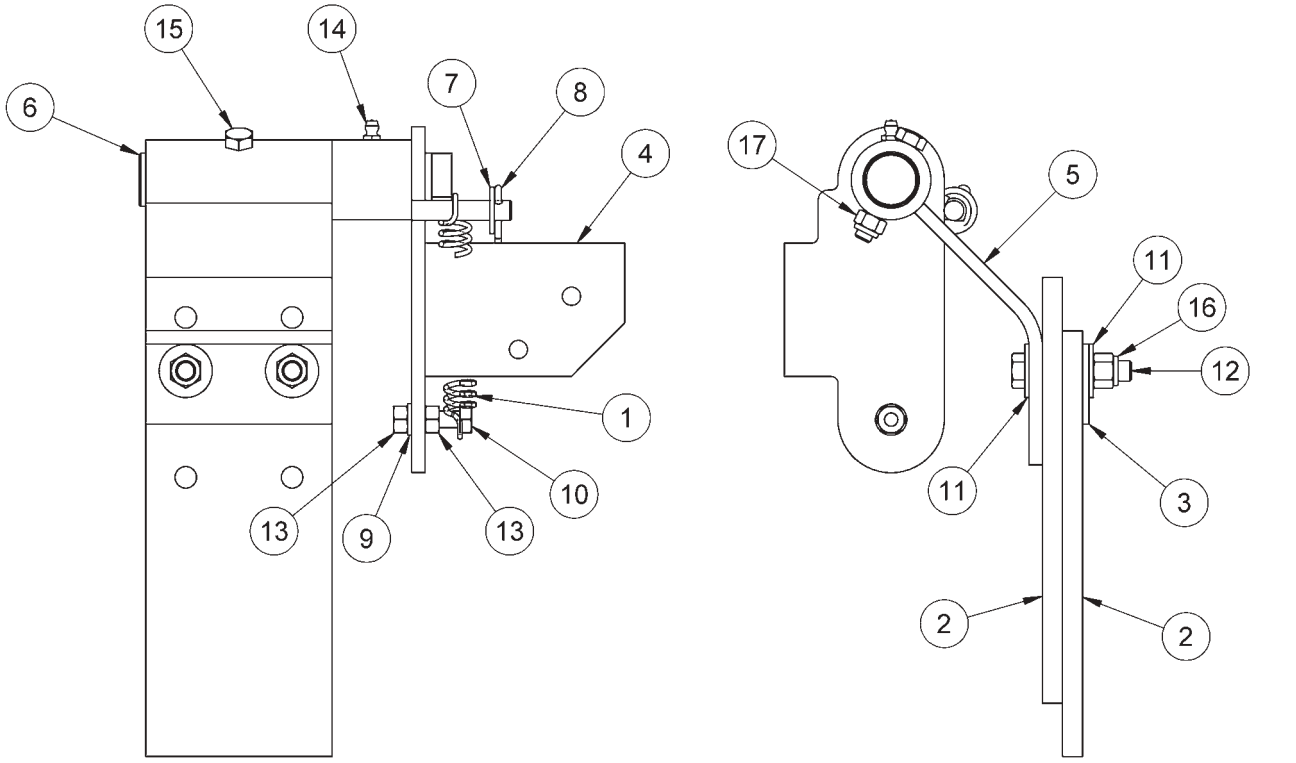
200476 RAIL SWEEP GROUP - FRONT



SE024283A-1

ITEM	PART NO	DESCRIPTION	QTY
	200476	RAIL SWEEP GROUP - FRONT	1
1	200984	Rail Sweep Assembly, Right (see separate breakdown)	1
2	200985	Rail Sweep Assembly, Left (see separate breakdown)	1
3	F040088	Hex Flg Nut, 5/16"-18 GR 5	4
4	F018615	SAE Washer, 5/16"	4
5	700561150	Cap Screw, 5/16-18 x 1-1/2" GR 8 Hex Hd	4

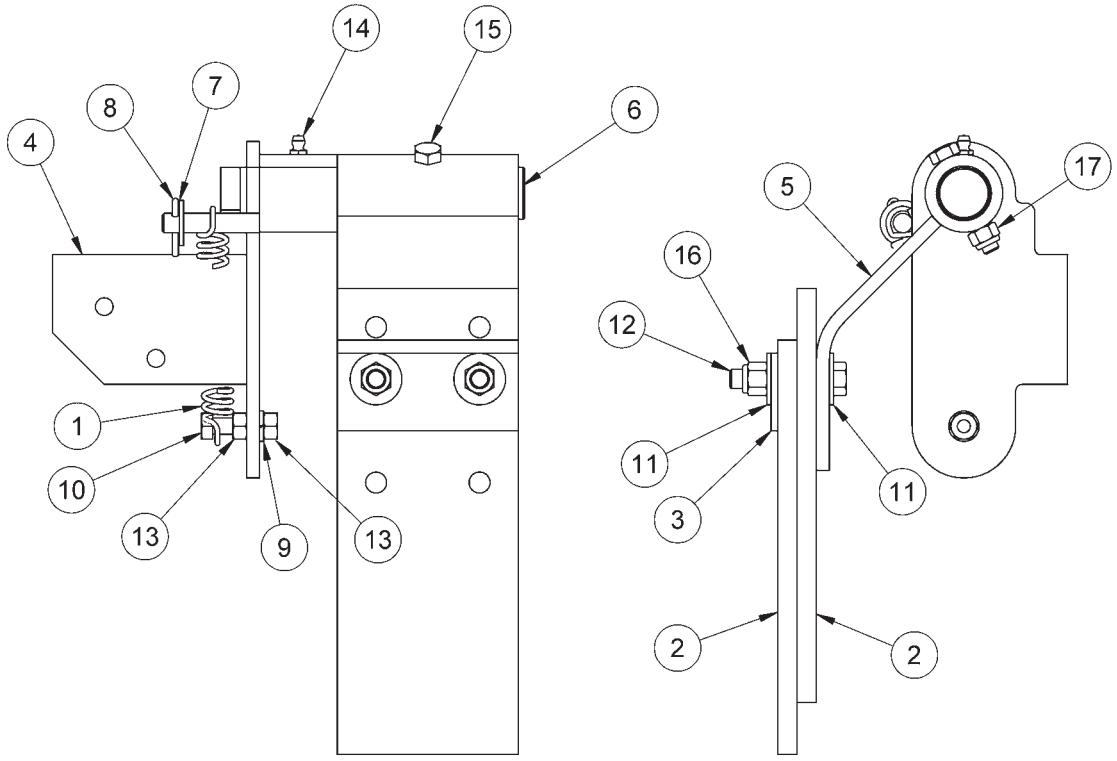
200984 RAIL SWEEP ASSEMBLY, RIGHT



SE200985A-1

ITEM	PART NO	DESCRIPTION	QTY
	200984	RAIL SWEEP ASSEMBLY, RIGHT	1
1	072909	Spring	1
2	118580	Rubber Sweep	2
3	118581	Plate	1
4	200980	Rail Sweep Bracket, Right	1
5	200982	Bracket	1
6	200983	Shaft	1
7	F001362	Wrought Washer, 5/16"	1
8	F001030	Cotter Pin, 1/8 x 3/4"	1
9	F001100	SAE Lock Washer, 5/16"	1
10	F001113	Cap Screw, 5/16-18 x 1-1/4" GR 5 Hex Hd	1
11	F001115	Wrought Washer, 3/8"	4
12	F001885	Cap Screw, 3/8-16 x 1-3/4" GR 5 Hex Hd	2
13	F007021	Hex Nut, 5/16"	2
14	F008014	Grease Fitting	1
15	F009663	Cap Screw, 5/16-18 x 2" GR 5 Hex Hd	1
16	F011998	Elastic Stop Nut, 3/8"-16	2
17	F014476	Elastic Stop Nut, 5/16"-18	1

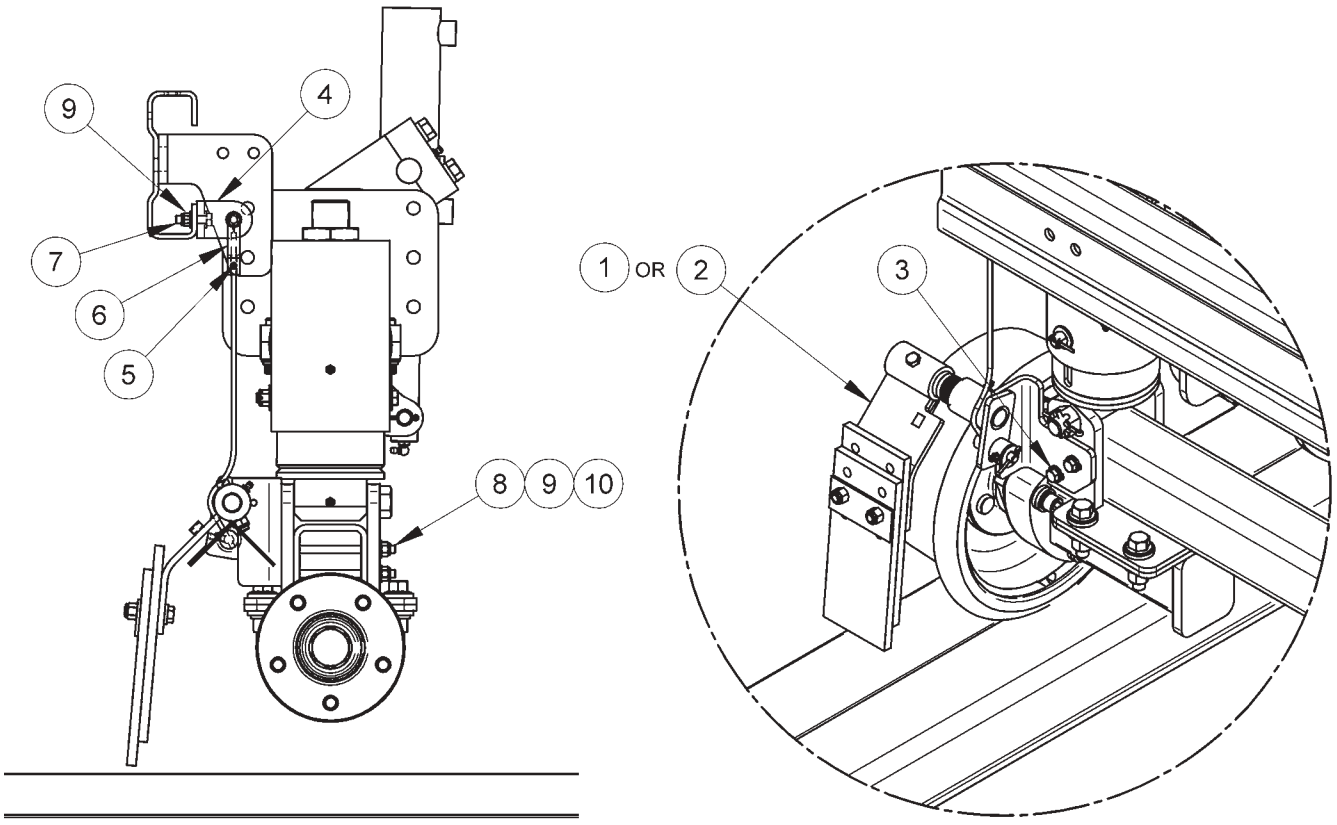
200985 RAIL SWEEP ASSEMBLY, LEFT



SE200985A-1

ITEM	PART NO	DESCRIPTION	QTY
	200985	RAIL SWEEP ASSEMBLY, LEFT	1
1	072909	Spring	1
2	118580	Rubber Sweep	2
3	118581	Plate	1
4	200981	Rail Sweep Bracket, Left.	1
5	200982	Bracket	1
6	200983	Shaft	1
7	F001362	Wrought Washer, 5/16".	1
8	F001030	Cotter Pin, 1/8 x 3/4".	1
9	F001100	SAE Lock Washer, 5/16"	1
10	F001113	Cap Screw, 5/16-18 x 1-1/4" GR 5 Hex Hd.	1
11	F001115	Wrought Washer, 3/8".	4
12	F001885	Cap Screw, 3/8-16 x 1-3/4" GR 5 Hex Hd.	2
13	F007021	Hex Nut, 5/16".	2
14	F008014	Grease Fitting	1
15	F009663	Cap Screw, 5/16-18 x 2" GR 5 Hex Hd.	1
16	F011998	Elastic Stop Nut, 3/8"-16.	2
17	F014476	Elastic Stop Nut, 5/16"-18.	1

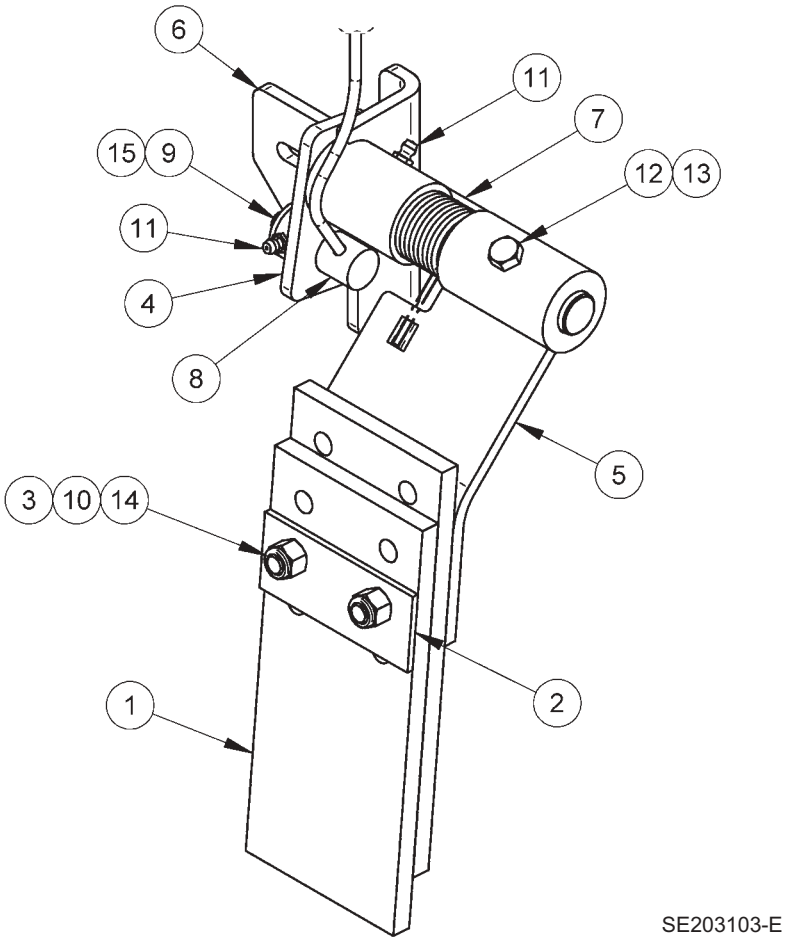
203113 RAIL SWEEP GROUP - FRONT



SE024590-E

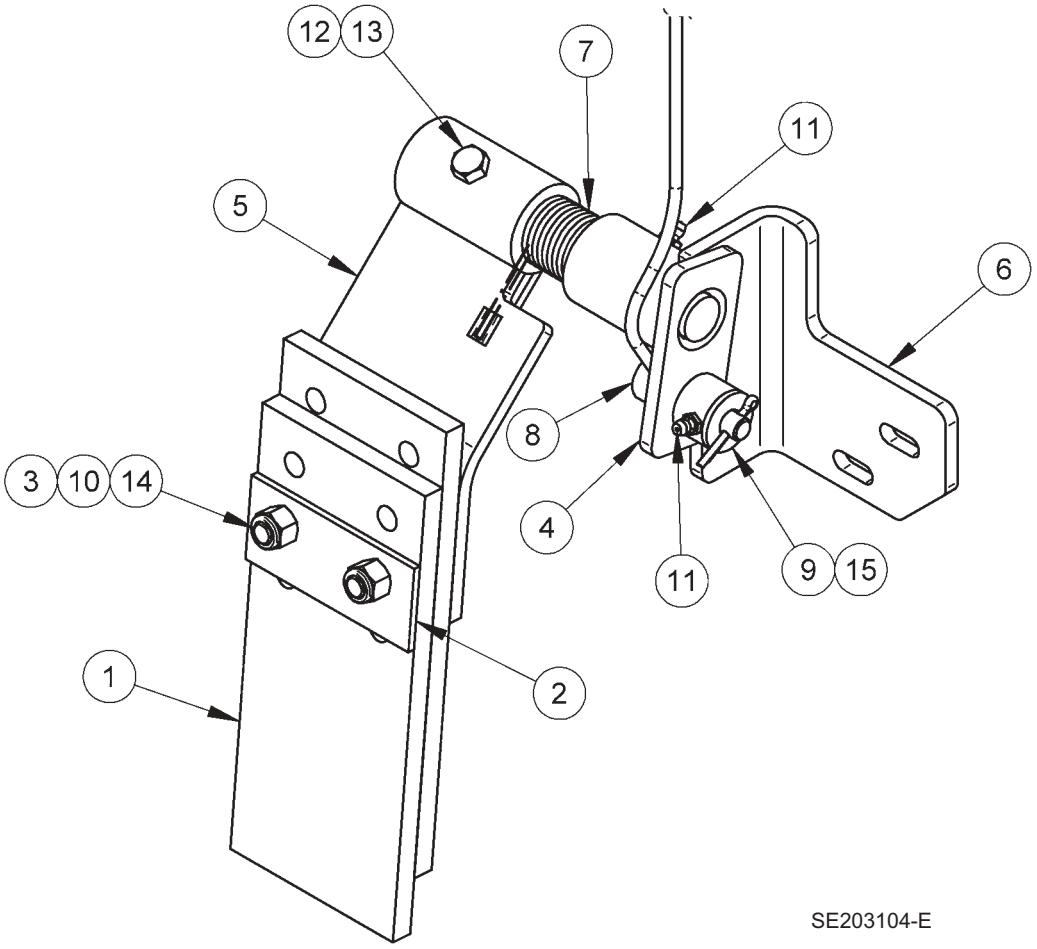
ITEM	PART NO	DESCRIPTION	QTY
	203113	RAIL SWEEP GROUP - FRONT	1
1	203103	Rail Sweep Assembly, Left (see separate breakdown)	1
2	203104	Rail Sweep Assembly, Right (see separate breakdown)	1
3	202532	Hardened Washer, 5/16"	4
4	203098	Bracket	2
5	203121	Set Screw, 1/4"-28	2
6	203122	Clevis	2
7	F001113	Cap Screw, 5/16-18 x 1-1/4" GR 5 Hex Hd	4
8	F007168	Cap Screw, 5/16-18 x 5" GR 5 Hex Hd	4
9	F014476	Elastic Stop Nut, 5/16"	8
10	F018615	SAE Washer, 5/16"	12

203103 RAIL SWEEP ASSEMBLY, LEFT



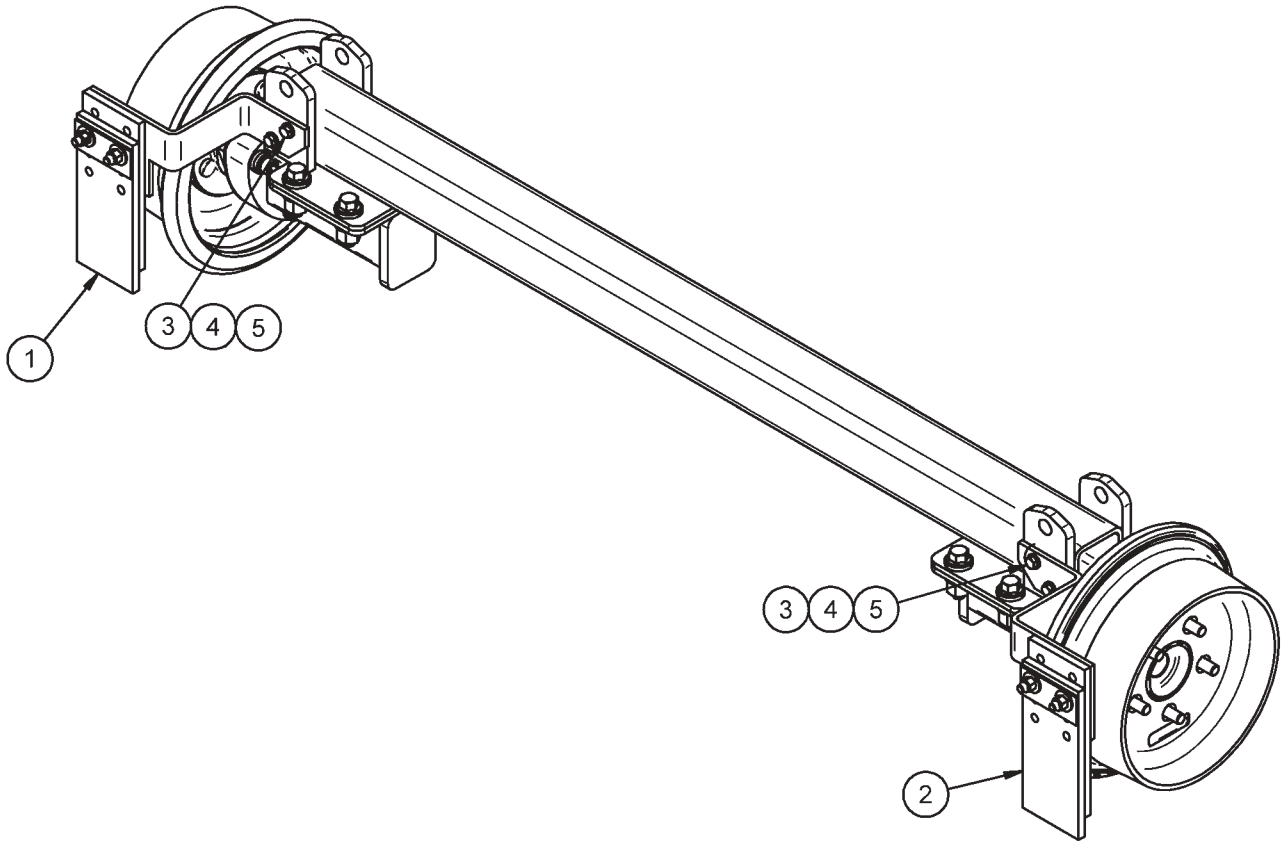
ITEM	PART NO	DESCRIPTION	QTY
	203103	RAIL SWEEP ASSEMBLY, LEFT	1
1	118580	Rail Sweep	2
2	118581	Rail Sweep Plate	1
3	202061	Hardened Washer, 3/8"	2
4	202676	Shaft	1
5	202678	Bracket	1
6	203100	Rail Sweep Bracket	1
7	203105	Spring, Left Wind	1
8	203107	Pin Assembly	1
9	F001104	Cotter Pin, 1/8 x 1"	1
10	F001885	Cap Screw, 3/8-16 x 1-3/4" GR 5 Hex Hd	2
11	F008014	Grease Fitting	2
12	F009663	Cap Screw, 5/16-18 x 2" GR 5 Hex Hd	1
13	F014476	Elastic Stop Nut, 5/16"	1
14	F015922	Elastic Stop Nut, 3/8"-16	2
15	F023111	Washer	2

203104 RAIL SWEEP ASSEMBLY, RIGHT



ITEM	PART NO	DESCRIPTION	QTY
	203104	RAIL SWEEP ASSEMBLY, RIGHT	1
1	118580	Rail Sweep	2
2	118581	Rail Sweep Plate	1
3	202061	Hardened Washer, 3/8"	2
4	202677	Shaft	1
5	202679	Bracket	1
6	203101	Rail Sweep Bracket	1
7	203106	Spring, Right Wind	1
8	203107	Pin Assembly	1
9	F001104	Cotter Pin, 1/8 x 1"	1
10	F001885	Cap Screw, 3/8-16 x 1-3/4" GR 5 Hex Hd	2
11	F008014	Grease Fitting	2
12	F009663	Cap Screw, 5/16-18 x 2" GR 5 Hex Hd	1
13	F014476	Elastic Stop Nut, 5/16"	1
14	F015922	Elastic Stop Nut, 3/8"-16	2
15	F023111	Washer	2

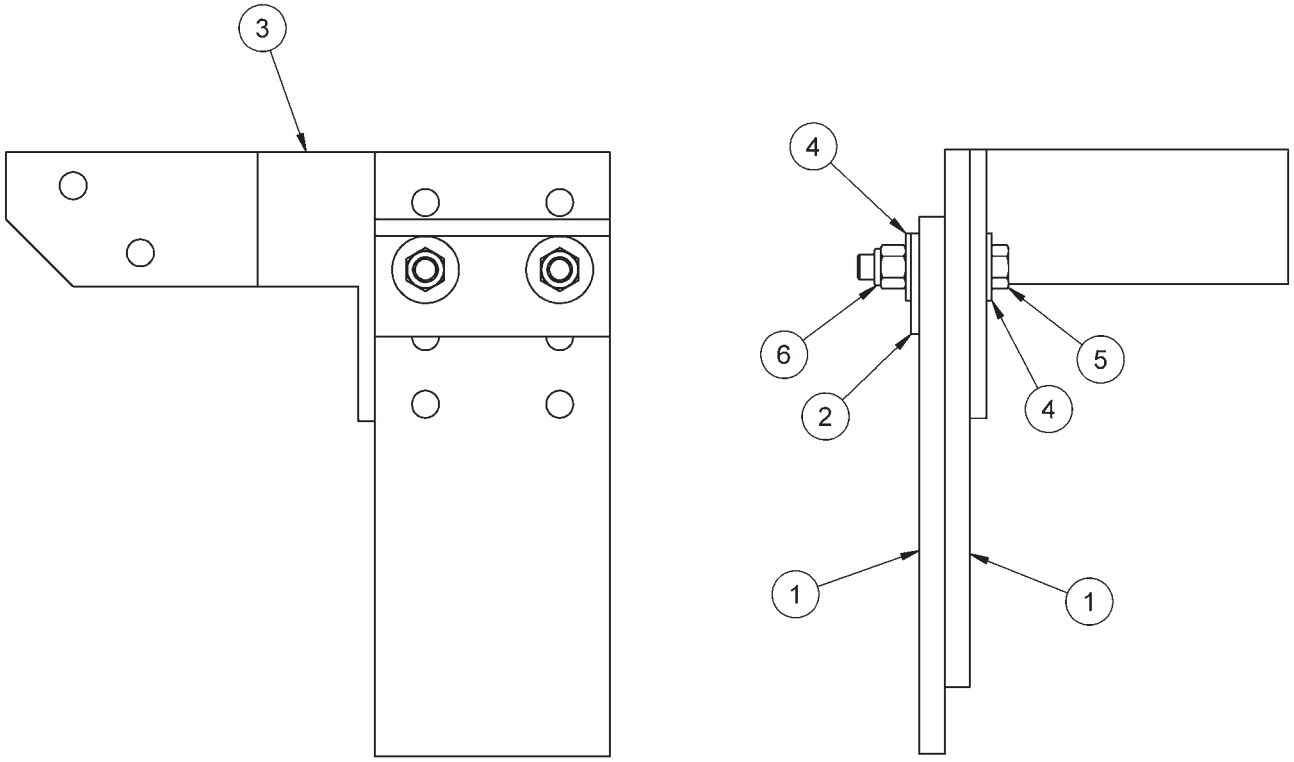
200477 RAIL SWEEP GROUP - REAR



SE024284A-1

ITEM	PART NO	DESCRIPTION	QTY
	200477	RAIL SWEEP GROUP - REAR	1
1	201295	Rail Sweep Assembly, Left (see separate breakdown)	1
2	201296	Rail Sweep Assembly, Right (see separate breakdown)	1
3	700561150	Cap Screw, 5/16-18 x 1-1/2" GR 8 Hex Hd	4
4	F018615	SAE Washer, 5/16"	4
5	F040088	Hex Flg Nut, 5/16"-18 GR 5	4

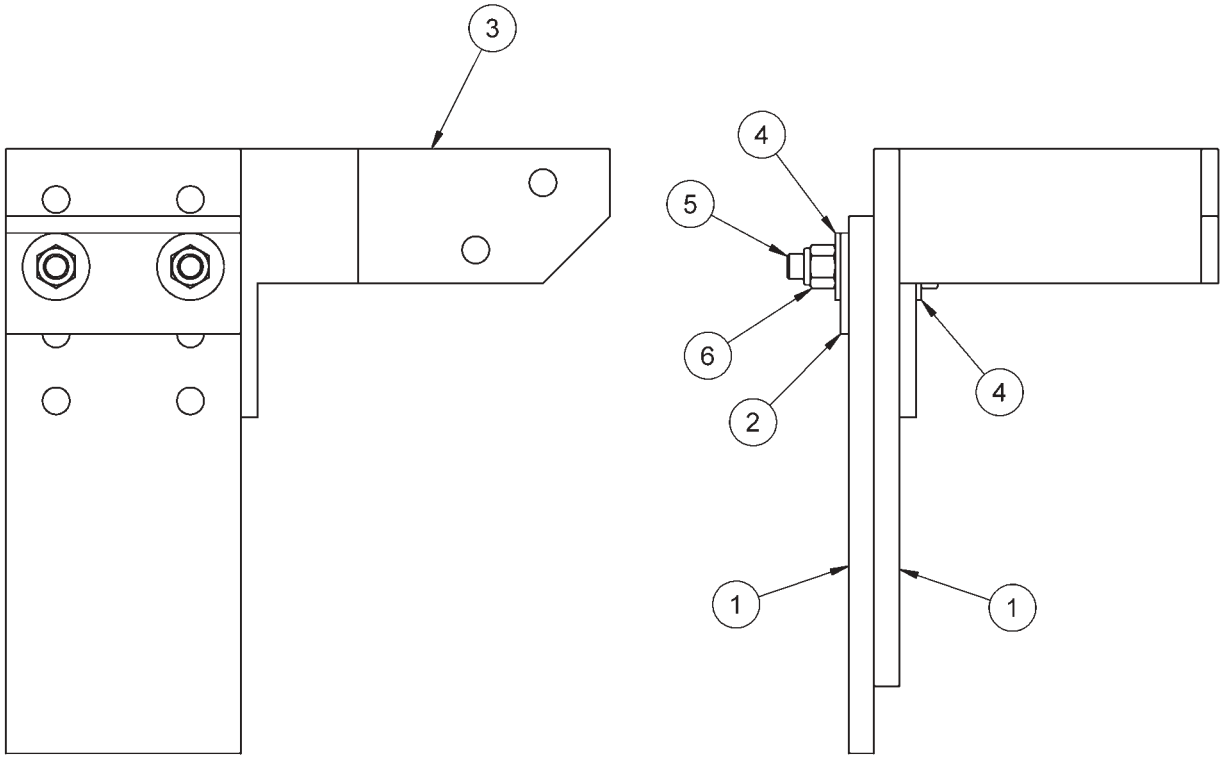
201296 RAIL SWEEP ASSEMBLY, RIGHT



SE201295A-1

ITEM	PART NO	DESCRIPTION	QTY
	201296	RAIL SWEEP ASSEMBLY, RIGHT	1
1	118580	Rail Sweep	2
2	118581	Rail Sweep Plate.	1
3	200481	Rail Sweep Bracket, Right	1
4	F001115	Wrought Washer, 3/8"	4
5	F001885	Cap Screw, 3/8-16 x 1-3/4" GR 5 Hex Hd.	2
6	F011998	Elastic Stop Nut, 3/8"-16	2

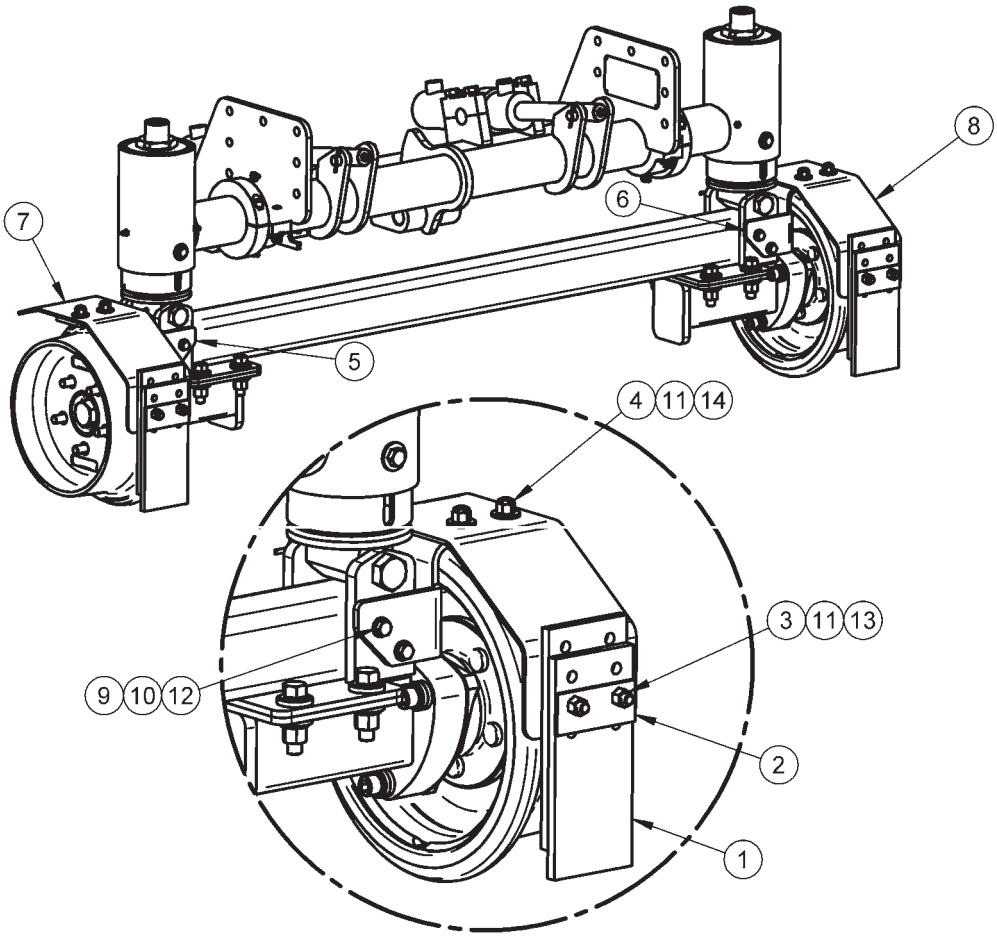
201295 RAIL SWEEP ASSEMBLY, LEFT



SE201296A-1

ITEM	PART NO	DESCRIPTION	QTY
	201295	RAIL SWEEP ASSEMBLY, LEFT	1
1	118580	Rail Sweep	2
2	118581	Rail Sweep Plate	1
3	200482	Rail Sweep Bracket, Left	1
4	F001115	Wrought Washer, 3/8"	4
5	F001885	Cap Screw, 3/8-16 x 1-3/4" GR 5 Hex Hd	2
6	F011998	Elastic Stop Nut, 3/8"-16	2

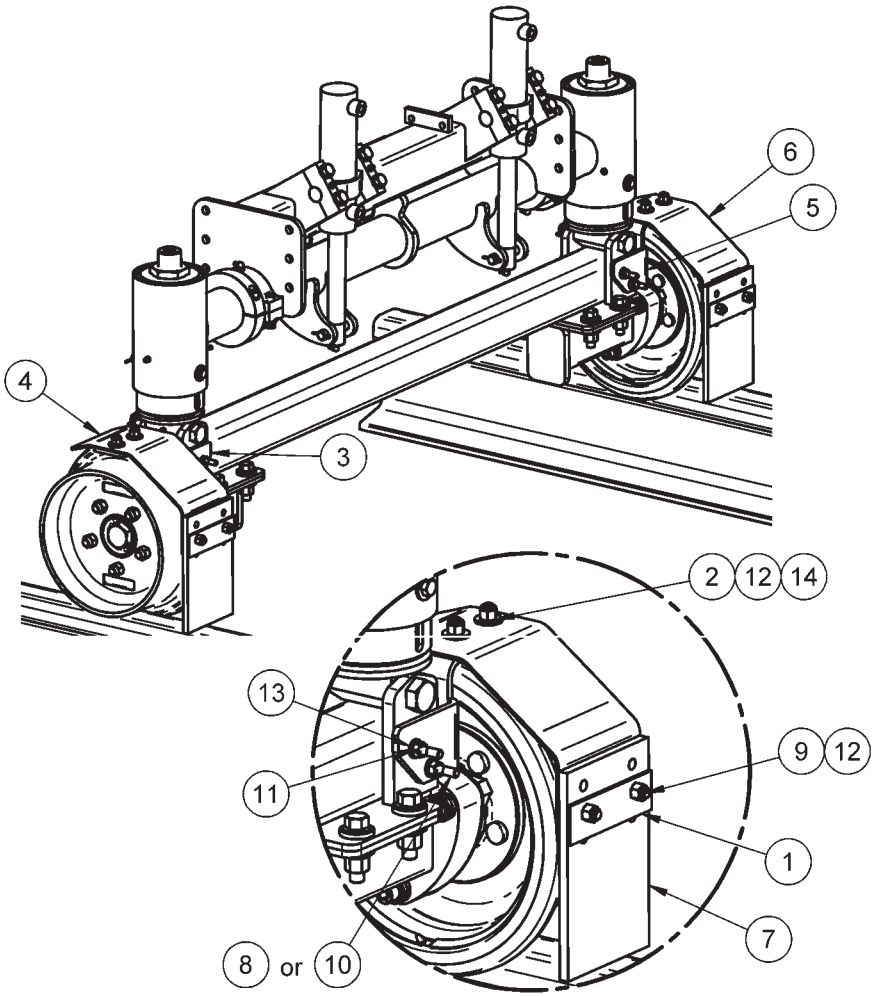
203192 RAIL SWEEP AND GUARD GROUP - REAR



SE024606-A

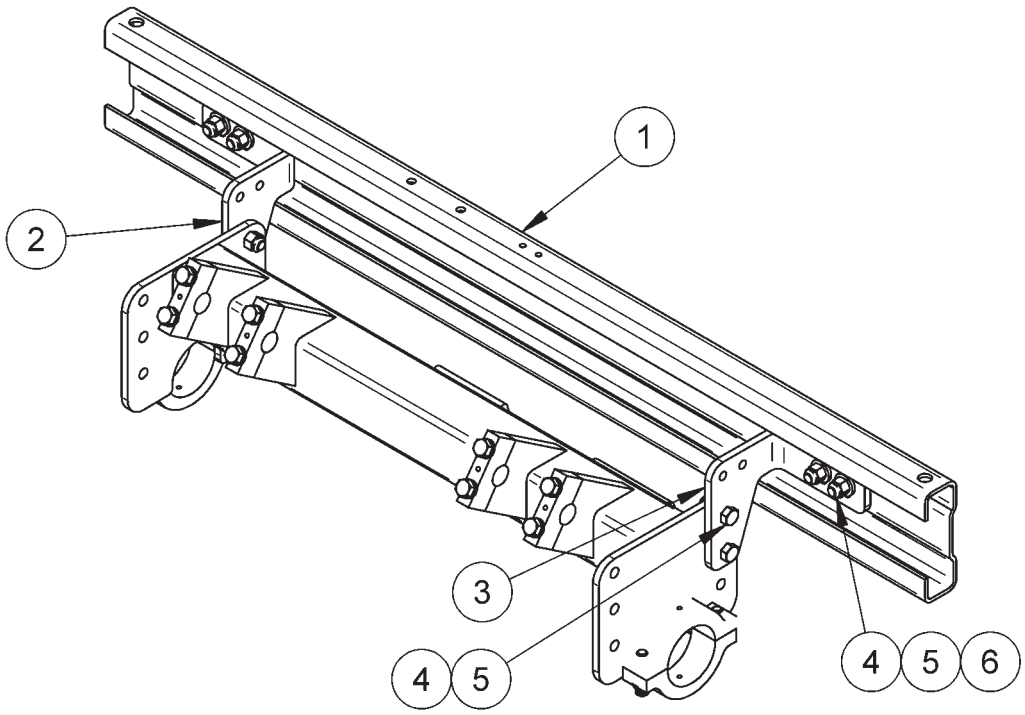
ITEM	PART NO	DESCRIPTION	QTY
	203192	RAIL SWEEP AND GUARD GROUP - REAR	1
1	118580	Rail Sweep	4
2	118581	Rail Sweep Plate.	2
3	202061	Washer, Hardened, 3/8"	4
4	202531	Carriage Bolt, 3/8-16 x 1"	4
5	203123	Bracket, Left	1
6	203125	Bracket, Right	1
7	203183	Grease Guard - Left	1
8	203184	Grease Guard - Right	1
9	F007168	Cap Screw, 5/16-18 x 5" GR 5 Hex Hd	4
10	F014476	Elastic Stop Nut, 5/16"	4
11	F015922	Elastic Stop Nut, 3/8"-16	8
12	F018615	SAE Washer, 5/16"	8
13	F019742	Cap Screw, 3/8-16 x 1-3/4" GR 8 Hex Hd	4
14	F023111	Washer	4

203166 GREASE GUARD GROUP - FRONT OR REAR



ITEM	PART NO	DESCRIPTION	QTY
	203166	GREASE GUARD GROUP - FRONT OR REAR	1
1	108510	Rail Sweep Plate	2
2	202531	Carriage Bolt, 3/8-16 x 1"	4
3	203123	Bracket, Left	1
4	203124	Grease Guard, Left	1
5	203125	Bracket, Right	1
6	203126	Grease Guard, Right	1
7	203215	Rail Sweep	2
8	700561550	Cap Screw, 5/16-18 x 5-1/2" Hex Hd	4
9	F001125	Cap Screw, 3/8-16 x 1-1/4" GR 5 Hex Hd	4
10	F007168	Cap Screw, 5/16-18 x 5" GR 5 Hex Hd	4
11	F014476	Elastic Stop Nut, 5/16"-18	4
12	F015922	Elastic Stop Nut, 3/8"-16	8
13	F018615	SAE Washer, 5/16"	8
14	F023111	Washer	8

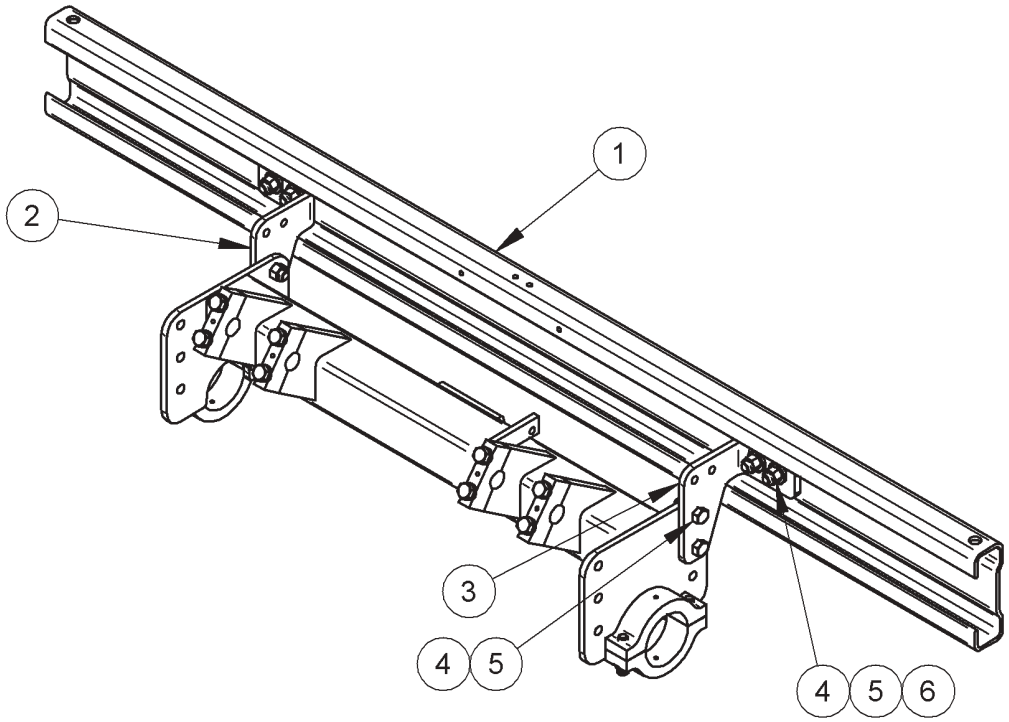
196382 BUMPER GROUP - FRONT - SHORT



SE023993A-1

ITEM	PART NO	DESCRIPTION	QTY
	196382	BUMPER GROUP - FRONT	1
1	140790	Bumper	1
2	200427	Bumper Bracket, Left	1
3	200428	Bumper Bracket, Right	1
4	F013500	Elastic Stop Nut, 1/2"	8
5	F018650	Cap Screw, 1/2-13 x 1-1/2" GR 8 Hex Hd	8
6	F024047	Hardened Washer	4
	130195	Sight Rod Kit (not illustrated) (includes two sight rods and mounting hardware)	1

202649 BUMPER GROUP - FRONT - LONG



SE024583-D

ITEM	PART NO	DESCRIPTION	QTY
	202649	BUMPER GROUP - FRONT	1
1	164510	Bumper	1
2	202641	Bumper Bracket, Left	1
3	202642	Bumper Bracket, Right	1
4	F013500	Elastic Stop Nut, 1/2"	8
5	F018650	Cap Screw, 1/2-13 x 1-1/2" GR 8 Hex Hd	8
6	F024047	Hardened Washer	4
	130195	Sight Rod Kit (not illustrated) (includes two sight rods and mounting hardware)	1

200870 EMERGENCY HYDRAULIC HAND PUMP GROUP

See Application Drawings: 024341
024342
024343

PART NO	DESCRIPTION	QTY
200870	EMERGENCY HYDRAULIC HAND PUMP GROUP	1
174519	Cap Screw, 1/4-20 x 1" GR 5 Hex Flg Hd	4
201201	Hand Pump Bracket, Front	1
201202	Hand Pump Bracket, Rear	1
201203	Emergency Pump and Handle	2
201207	Decal, Selector Valve Operation	2
201737	Pipe Fitting	2
202096	Control Valve	2
202097	Mounting Plate	1
F001106	Wrought Washer, 1/4"	10
F001433	Pipe Coupling, 1/8	2
F010994	Adapter, 6 x 4 NPT	2
F011964	90° Elbow, 6 x 2 NPT	1
F012318	Adapter, 4 x 4 NPT	5
F012808	90° Elbow, 6 x 6 FS	3
F013402	45° Elbow	1
F013588	Elastic Stop Nut, 1/4"-20	10
F013627	Tee, 6 x 6 FS x 6	1
F015085	90° Elbow	6
F021905	Tee	2
F022230	Adapter, 4 x 6 SAE	8
F023402	Cap Screw, 1/4-20 x 2" GR 5 Hex Flg Hd	4
F023407	Cap Screw, 1/4-20 x 5/8" GR 5 Hex Flg Hd	2
F024887	Tee	4

202605 EMERGENCY HYDRAULIC HAND PUMP RETROFIT KIT

See Application Drawing: 024549

PART NO	DESCRIPTION	QTY
202605	EMERGENCY HYDRAULIC HAND PUMP RETROFIT KIT	1
201201	Hand Pump Bracket, Front	1
202404	Hand Pump	1
202405	Handle	1
202496	Operation Decal	1
202530	Kit, Manual Override	4
203528	Check Valve	1
409944	Adapter	1
F012056	Adapter, STR 6 x 6 NPT	2
F012808	90° Elbow, 6 x 6 FS	6
F013326	Adapter, STR 6 x 6 SAE	2
F013627	Tee, 6 x 6 FS x 6	2
F014242	45° Elbow, 6 x 6 FS	1
F015626	Tee, 6 x 6 x 6 FS	1
F022138	Hex Flg Nut, 1/4"-20 GR 5	2
F023402	Cap Screw, 1/4-20 x 2" GR 5 Hex Flg Hd	2

202461 EMERGENCY HYDRAULIC HAND PUMP GROUP

See Application Drawing: 024549

PART NO	DESCRIPTION	QTY
202461	EMERGENCY HYDRAULIC HAND PUMP GROUP	1
202404	Hand Pump	1
202405	Handle	1
F013326	Adapter, STR 6 x 6 SAE	2
F012808	90° Elbow, 6 x 6 FS	6
202530	Kit, Manual Override	4
202496	Operation Decal	1
201201	Hand Pump Bracket Front	1
F012056	Adapter, STR 6 x 6 NPT	2
F013627	Tee, 6 x 6 FS x 6	2
F023402	Cap Screw, 1/4-20 x 2" GR 5 Hex Flg Hd	2
F022138	Hex Flg Nut, 1/4"-20 GR 5	2
409944	Adapter	1
F014242	45° Elbow, 6 x 6 FS	1
203528	Check Valve	1
F015626	Tee, 6 x 6 x 6 FS	1

198696 HYDRAULIC GROUP - ABBREVIATED

See Application Drawing: 024204

PART NO	DESCRIPTION	QTY
198696	HYDRAULIC GROUP - ABBREVIATED	1
198883	Valve Manifold Assembly	1
198881	Switch Box	2

201306 ELECTRIC / HYDRAULIC GROUP - MANUAL OR HYDRAULIC LOCKS

See Application Drawings: 024326
024454

PART NO	DESCRIPTION	QTY
201306	ELECTRIC / HYDRAULIC GROUP MANUAL OR HYDRAULIC LOCKS	1
168107	Switch Mount	1
168108	Decal	1
194056	HYDRAULIC UNIT	1
198881	Up / Down Switch Box	2
201538	Relay	1
203631	Breather Cap	1
200901	Cap Screw, M4 x .7 x 30 mm Hex Hd	8
200964	Terminal Block	1
200965	Cable, 1/0	40'
201258	Cable End	8
201260	Butt Connector	20
201265	Sealed Ring Connector	8
201268	Spade Connector	20
201269	Spade Connector	8
201521	Switch Plate	1
701099063	Auto Loom, 5/8"	117'
F001025	SAE Lock Washer, 3/8"	2
F001125	Cap Screw, 3/8-16 x 1-1/4" GR 5 Hex Hd	2
F004600	Elastic Stop Nut, 3/8"-16	2
F004683	Cap Screw, 3/8-16 x 5/8" GR 5 Hex Hd	2
F009542	Hex Nut, #10-24 GR 2	4
F009681	SAE Washer, 3/8"	4
F011840	Cable, 14/4 Conductor	30'
F015085	90° Elbow, 4 x 4 FS	2
F015104	90° Elbow, 4 x 6 NPT	2
F016656	Ty Rap	50
F017476	Fused Line Connector	1
F020891	Wire, 14 GA. Red	5'
F023886	Switch	1
F024046	Adapter, STR 4 x 6 NPT	2
H6206Y35	Circuit Breaker, 150 AMP	2

202460 ELECTRIC / HYDRAULIC GROUP - MANUAL OR HYDRAULIC LOCKS

See Application Drawings: 024454
024549

PART NO	DESCRIPTION	QTY
202460	ELECTRIC / HYDRAULIC GROUP MANUAL OR HYDRAULIC LOCKS	1
168107	Switch Mount	1
168108	Decal	1
198881	Switch Box	1
200901	Cap Screw, M4 x .7 x 30 mm Hex Hd	8
200964	Terminal Block	2
200965	Cable, 1/0	30'
201258	Cable End	8
201260	Connector, Butt	20
201265	Connector, Sealed Ring	8
201268	Connector, Spade	20
201269	Connector, Spade	8
201521	Switch Plate	1
202409	Mounting Plate	1
202419	HYDRAULIC UNIT	1
198881	Up / Down Switch Box	2
201538	Relay	1
203631	Breather Cap	1
203533	Hydraulic Manifold Assembly	1
701099063	Auto Loom, 5/8"	117'
F001025	SAE Lock Washer, 3/8"	2
F001125	Cap Screw, 3/8-16 x 1-1/4" GR 5 Hex Hd	2
F004600	Elastic Stop Nut, 3/8"-16	2
F004683	Cap Screw, 3/8-16 x 5/8" GR 5 Hex Hd	2
F009542	Hex Nut, #10-24 GR 2	4
F009681	SAE Washer, 3/8"	4
F011840	Cable, 14/4 Conductor	30'
F014241	Tee, 4 x 4 x 4	4
F015085	90° Elbow, 4 x 4 FS	10
F015104	90° Elbow, 4 x 6 NPT	2
F016656	Ty Rap	50
F017476	Fused Line Connector	1
F020891	Wire, 14 GA. Red	5'
F022230	Adapter, STR 4 x 6 SAE	8
F023886	Switch	1
F024046	Adapter, STR 4 x 6 NPT	2
H6206Y35	Circuit Breaker, 150 AMP	1

202515 ELECTRIC / HYDRAULIC GROUP - MANUAL OR HYDRAULIC LOCKS

See Application Drawings: 024454
024549

PART NO	DESCRIPTION	QTY
202515	ELECTRIC / HYDRAULIC GROUP MANUAL OR HYDRAULIC LOCKS	1
168107	Switch Mount	1
168108	Decal	1
198881	Switch Box	2
200901	Cap Screw, M4 x .7 x 30 mm Hex Hd	8
200964	Terminal Block	1
200965	Cable, 1/0	30'
201521	Switch Plate	1
201258	Cable End	8
201260	Connector, Butt	20
201265	Connector, Sealed Ring	8
201268	Connector, Spade	20
201269	Connector, Spade	8
201270	Connector, Push On	3
202514	HYDRAULIC UNIT	1
198881	Up / Down Switch Box	2
201538	Relay	1
203631	Breather Cap	1
701099063	Auto Loom, 5/8"	116'
F001025	SAE Lock Washer, 3/8"	2
F001125	Cap Screw, 3/8-16 x 1-1/4" GR 5 Hex Hd	2
F004600	Elastic Stop Nut, 3/8"-16	2
F004683	Cap Screw, 3/8-16 x 5/8" GR 5 Hex Hd	2
F009542	Hex Nut, #10-24 GR 2	4
F009681	SAE Washer, 3/8"	4
F013326	Adapter, STR 6 x 6 SAE	2
F013327	90° Elbow, 6 x 6 SAE	2
F014241	Tee, 4 x 4 x 4	4
F015085	90° Elbow, 4 x 4 FS	10
F015104	90° Elbow, 4 x 6 NPT	2
F016656	Ty Rap	50
F017476	Fused Line Connector	1
F020891	Wire, 14 GA. Red	5'
F022230	Adapter, STR 4 x 6 SAE	8
F023886	Switch	1
F024046	Adapter, STR 4 x 6 NPT	2
F023788	Diode	2
H6206Y35	Circuit Breaker, 150 AMP	1

201307 ELECTRIC / HYDRAULIC GROUP - ELECTRIC LOCKS ONLY

See Application Drawings: 024326
024454

PART NO	DESCRIPTION	QTY
201307	ELECTRIC / HYDRAULIC GROUP ELECTRIC LOCKS ONLY	1
168107	Switch Mount	1
168108	Decal	1
194056	HYDRAULIC UNIT	1
198881	Up / Down Switch Box	2
201538	Relay	1
203631	Breather Cap	1
200490	Module	2
200901	Cap Screw, M4 x .7 x 30 mm Hex Hd	8
200960	Fuse, 20 AMP	5
200963	Fuse Holder	3
200964	Terminal Block	1
200965	Cable, 1/0	30'
201258	Cable End	8
201260	Connector, Butt	20
201265	Connector, Sealed Ring	8
201268	Connector, Spade	20
201269	Connector, Spade	8
201521	Switch Plate	1
409488	Cable, 12/3	40'
701099063	Auto Loom, 5/8"	116'
F001025	SAE Lock Washer, 3/8"	2
F001125	Cap Screw, 3/8-16 x 1-1/4" GR 5 Hex Hd	2
F004600	Elastic Stop Nut, 3/8"-16	2
F004683	Cap Screw, 3/8-16 x 5/8" GR 5 Hex Hd	2
F006060	Cable	12"
F009542	Hex Nut, #10-24 GR 2	4
F009681	SAE Washer, 3/8"	4
F009803	Cable	6'
F011840	Cable, 14/4 Conductor	30'
F015085	90° Elbow, 4 x 4 FS	2
F015104	90° Elbow, 4 x 6 NPT	2
F016656	Ty Rap	50
F017476	Fused Line Connector	1
F020891	Wire, 14 GA. Red	5'
F023788	Diode	2
F023886	Switch	1
F024046	Adapter, STR 4 x 6 NPT	2
H6206Y35	Circuit Breaker, 150 AMP	1

202458 ELECTRIC / HYDRAULIC GROUP - ELECTRIC LOCKS ONLY

See Application Drawings: 024454
024549

PART NO	DESCRIPTION	QTY
202458	ELECTRIC / HYDRAULIC GROUP ELECTRIC LOCKS ONLY	1
168107	Switch Mount	1
168108	Decal	1
198881	Switch Box	2
200490	Module	2
200901	Cap Screw, M4 x .7 x 30 mm Hex Hd	8
200960	Fuse, 20 AMP	5
200963	Fuse Holder	3
200964	Terminal Block	1
200965	Cable, 1/0	40'
201258	Cable End	8
201260	Connector, Butt	20
201265	Connector, Sealed Ring	8
201268	Connector, Spade	20
201269	Connector, Spade	8
201270	Push On Connector	2
201521	Switch Plate	1
202514	HYDRAULIC UNIT	1
198881	Up / Down Switch Box	2
201538	Relay	1
203631	Breather Cap	1
203533	Hydraulic Manifold, Assembly	1
409488	Cable, 12/3	40'
701099063	Auto Loom, 5/8"	116'
F001025	SAE Lock Washer, 3/8"	2
F001125	Cap Screw, 3/8-16 x 1-1/4" GR 5 hex Hd	2
F004600	Elastic Stop Nut, 3/8-16	2
F004683	Cap Screw, 3/8-16 x 5/8" GR 5 Hex Hd	2
F006060	Cable	144"
F009542	Hex Nut, #10-24 GR 2	4
F009681	SAE Washer, 3/8"	4
F009803	Cable	6'
F015085	90° Elbow, 4 x 4 FS	2
F015104	90° Elbow, 4 x 6 NPT	2
F016656	Ty Rap	50
F017476	Fused Line Connector	1
F020891	Wire, 14 GA. Red	5'
F023886	Switch	1
F024046	Adapter, STR 4 x 6 NPT	2
H6206Y35	Circuit Breaker, 150 AMP	1

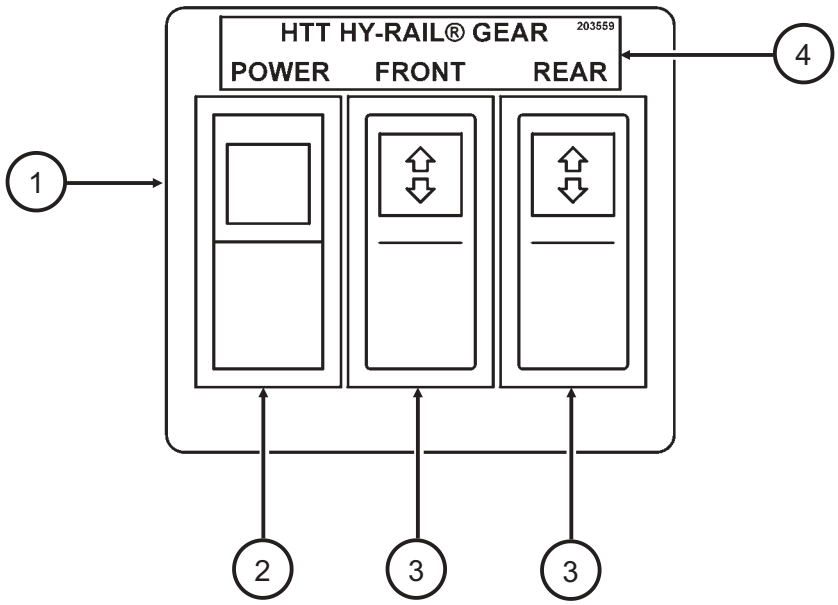
201308 IN CAB ACTUATION

See Application Drawing: 024454

PART NO	DESCRIPTION	QTY
201308	IN CAB ACTUATION	1
200967	Switch	1
200968	Switch	2
200986	Box Assembly	1
200987	Decal	1
201204	Socket Housing	3
201205	Socket Housing	3
201208	Connector	20
201265	Connector, Sealed Ring	4
201268	Connector, Spade	12
201269	Connector, Spade	1
701099063	Auto Loom, 5/8"	10'
F016656	Ty Rap	20
F024884	Cable, 8 Conductor	10'
F040160	Wire	5'
F040576	Wire	5'

203558 IN CAB ACTUATION

	PART NO	DESCRIPTION	QTY
	203558	IN CAB ACTUATION	1
1	203556	Plate, Switch	1
2	200967	Switch	1
3	200968	Switch	2
4	203559	Decal	1



196373 MOUNTING BRACKET GROUP

PART NO	DESCRIPTION	QTY
196373	MOUNTING BRACKET GROUP	1
Front Unit Mounting Parts		
196375	Side Bar, Left	1
196374	Side Bar, Right	1
196392	Bumper Spacer	2
196475	Spacer	2
700564200	Cap Screw, 1/2-13 x 2" GR 8 Hex Hd	4
F013500	Elastic Stop Nut, 1/2"	8
F024602	Hardened Washer	16
F020599	Cap Screw, 1/2-13 x 4" GR 8 Hex Hd	4
184480	Bar	4
F021137	Hardened Washer	2
F020458	Cap Screw, 3/4-10 x 2-1/2" GR 8 Hex Hd	2
184538	Plate	2
F041212	Hex Elastic Stop Nut, M12 x 1.75	6
F021068	Cap Screw, M12 x 1.75 x 45 mm CL8.8 Hex Hd	6
700562225	Cap Screw, 3/8-16 x 2-1/4" GR 8	2
F011998	Elastic Stop Nut, 3/8"-16	2
F023111	Washer	4
178965	Edge Trim	24"
200900	Stop Block	2
023956	Front Unit Application Drawing	
Rear Unit Mounting Parts		
196372	Side Bar, Left	1
196371	Side Bar, Right	1
F021137	Hardened Washer	4
700666075	Hex Lock Nut, 3/4"-10	2
F020458	Cap Screw, 3/4-10 x 2-1/2" GR 8 Hex Hd	2
149966	Cap Screw, 5/8-11 x 2-1/2" GR 8 Hex Hd	4
F012452	Elastic Stop Nut, 5/8"	4
F023012	Hardened Washer	8
023957	Rear Unit Application Drawing	

196518 MOUNTING BRACKET GROUP

PART NO	DESCRIPTION	QTY
196518	MOUNTING BRACKET GROUP	1
Front Unit Mounting Parts		
196485	Side Bar, Right	1
196484	Side Bar, Left	1
196491	Spacer	2
F024047	Washer	8
F013500	Elastic Stop Nut, 1/2"	4
F024602	Wrought Washer, 1/2"	8
F023742	Cap Screw, 1/2-13 x 5-1/2" GR 8 Hex Hd	4
F013500	Elastic Stop Nut, 1/2"	2
F023012	Hardened Washer	4
F012452	Elastic Stop Nut, 5/8"	2
149966	Cap Screw, 5/8-11 x 2-1/2" GR 8 Hex Hd	2
178965	Edge Trim	24"
024013	Front Unit Application Drawing	
Rear Unit Mounting Parts		
196499	Side Bar, Right	1
196501	Side Bar, Left	1
700666075	Hex Lock Nut, 3/4"-10	2
F012452	Elastic Stop Nut, 5/8"	4
F014487	Lock Nut, 1/2"-13	2
F018650	Cap Screw, 1/2-13 x 1-1/2" GR 8 Hex Hd	2
F024602	Wrought Washer, 1/2"	2
163634	Brace End	1
163636	Brace End	1
F020672	Cap Screw, 3/4-10 x 5" GR 8 Hex Hd	2
F021137	Hardened Washer	4
F022822	Cap Screw, 5/8-11 x 4-1/2" GR 8 Hex Hd	4
F023012	Hardened Washer	8
024014	Rear Unit Application Drawing	

198513 MOUNTING BRACKET GROUP

PART NO	DESCRIPTION	QTY
198513	MOUNTING BRACKET GROUP	1
Front Unit Mounting Parts		
F013500	Elastic Stop Nut, 1/2"	14
F018650	Cap Screw, 1/2-13 x 1-1/2" GR 8 Hex Hd	4
184480	Bar	4
198258	Side Bar, Right	1
198259	Side Bar, Left	1
F020458	Cap Screw, 3/4-10 x 2-1/2" GR 8 Hex Hd	2
F021137	Hardened Washer	2
184538	Plate	2
F018860	Cap Screw, 1/2-13 x 2-3/4" GR 8 Hex Hd	6
196392	Spacer	2
F024602	Hardened Washer	16
F020599	Cap Screw, 1/2-13 x 4" GR 8 Hex Hd	4
F009425	SAE Washer, 5/8"	12
023956	Front Unit Application Drawing	
Rear Unit Mounting Parts		
198266	Side Bar, Right	1
198267	Side Bar, Left	1
700666075	Hex Lock Nut, 3/4"-10	2
F012452	Elastic Stop Nut, 5/8"	6
F013500	Elastic Stop Nut, 1/2"	6
F018860	Cap Screw, 1/2-13 x 2-3/4" GR 8 Hex Hd	8
F020458	Cap Screw, 3/4-10 x 2-1/2" GR 8 Hex Hd	4
F021137	Hardened Washer	4
F023012	Hardened Washer	8
F024047	Washer	12
149966	Cap Screw, 5/8-11 x 2-1/2" GR 8 Hex Hd	2
023957	Rear Unit Application Drawing	

200906 MOUNTING BRACKET GROUP

PART NO	DESCRIPTION	QTY
200906	MOUNTING BRACKET GROUP	1
Front Unit Mounting Parts		
196484	Side Bar, Left	1
196485	Side Bar, Right	1
196491	Spacer	2
196377	Shim	4
196378	Shim	4
F024047	Washer	12
F018860	Cap Screw, 1/2-13 x 2-3/4" GR 8 Hex Hd	6
F013500	Elastic Stop Nut, 1/2"	10
F024602	Hardened Washer	8
F023012	Hardened Washer	8
188794	Cap Screw, 1/2-13 x 6" GR 8 Hex Hd	4
F025499	Cap Screw, 5/8-11 x 6" Gr 8 Hex Hd	2
F012452	Elastic Stop Nut, 5/8"	2
024324	Front Unit Application Drawing	
Rear Unit Mounting Parts		
200927	Side Bar, Right	1
200928	Side Bar, Left	1
200921	Block	2
183744	Hardened Washer	2
F021981	Cap Screw, Hex Hd	2
F023012	Hardened Washer	10
F019501	Cap Screw, 5/8-11 x 1-3/4" Hex Hd	2
700566225	Cap Screw, 5/8-11 x 2-1/4 GR 8 Hex Hd	4
F025764	Cap Screw, 5/8-11 x 4" GR 8 Hex Hd	2
F012452	Elastic Stop Nut, 5/8"	2
F024047	Washer	12
F018860	Cap Screw, 1/2-13 x 2-3/4" GR 8 Hex Hd	6
F013500	Elastic Stop Nut, 1/2"	6
196379	Shim	4
196380	Shim	4
024325	Rear Unit Application Drawing	

200946 MOUNTING BRACKET GROUP

PART NO	DESCRIPTION	QTY
200946	MOUNTING BRACKET GROUP	1
Front Unit Mounting Parts		
200937	Tube	2
200932	Plate	4
200935	Side Bar, Left	1
200934	Side Bar, Right	1
F023222	Washer	20
F013500	Elastic Stop Nut, 1/2"	8
F018811	Cap Screw, 1/2-13 x 2-1/2" GR 8 Hex Hd	6
196377	Shim	4
196378	Shim	4
F018861	Cap Screw, 1/2-13 x 2-1/4" GR 8 Hex Hd	4
197674	Cap Screw, 1/2-13 x 8" GR 8 Hex Hd	2
200936	Angle	1
200966	Bumper Bracket, Right	1
200961	Bumper Bracket, Left	1
024335	Front Unit Application Drawing	
Rear Unit Mounting Parts		
200912	Side Bar	2
F023012	Hardened Washer	16
F020460	Cap Screw, 5/8-11 x 2" GR 8 Hex Hd	8
F012452	Elastic Stop Nut, 5/8"	8
F023222	Washer	12
F018811	Cap Screw, 1/2-13 x 2-1/2" GR 8 Hex Hd	6
F013500	Elastic Stop Nut, 1/2"	12
196379	Shim	4
196380	Shim	4
024336	Rear Unit Application Drawing	

201507 MOUNTING BRACKET GROUP

PART NO	DESCRIPTION	QTY
201507	MOUNTING BRACKET GROUP	1
Front Unit Mounting Parts (HR1500B2)		
196375	Side Bar, Left	1
196374	Side Bar, Right	1
196377	Shim	2
196378	Shim	2
196392	Spacer	2
F024047	Washer	28
F013500	Elastic Stop Nut, 1/2"-13	14
F020599	Cap Screw, 1/2-13 x 4" GR 8 Hex Hd	4
700564200	Cap Screw, 1/2-13 x 2" GR 8 Hex Hd	4
F018860	Cap Screw, 1/2-13 x 2-3/4" GR 8 Hex Hd	6
184480	Bar	4
184538	Plate	2
F021137	Hardened Washer	2
F020458	Cap Screw, 3/4-10 x 2-1/2 GR 8 Hex Hd	2
200900	Stop Block	2
196475	Spacer	2
F023111	Washer	4
700562225	Cap Screw, 3/8-16 x 2-1/4" GR 8 Hex Hd	2
F011998	Elastic Stop Nut, 3/8"-16	2
023956	Front Unit Application Drawing	
Rear Unit Mounting Parts (HR2000B3-2		
200377	Side Bar	2
181524	Shim	4
F023012	Hardened Washer	16
188306	Cap Screw, 5/8-11 x 3" GR 8 Hex Hd	8
F017188	Hex Elastic Stop Nut, 5/8"-11	12
200396	Brace End	1
200397	Brace End	1
F021137	Hardened Washer	4
F020458	Cap Screw, 3/4-10 x 2-1/2" GR 8 Hex Hd	2
700666075	Hex Locknut, 3/4"-10	2
149966	Cap Screw, 5/8-11 x 2-1/2" GR 8 Hex Hd	4
201584	Washer	8
024422	Rear Unit Application Drawing	

203510 MOUNTING BRACKET GROUP

PART NO	DESCRIPTION	QTY
203510	MOUNTING BRACKET GROUP	1
Front Unit Mounting Parts (HR0307A)		
184477	Side Bar Left Assembly	1
184469	Side Bar Right Assembly	1
184480	Bar	4
203264	Bracket, Left	1
203265	Bracket, Right	1
203462	Plate	2
187178	Fastener Kit	1
F018650	Cap Screw, 1/2-13 x 1-1/2" GR 8 Hex Hd	6
F013500	Elastic Stop Nut, 1/2"-13	6
F001267	Wrought Washer, 1/2"	6
F023674	Cap Screw, 1/2-13 x 1-3/4" GR 8 Hex Hd	4
024627	Front Unit Application Drawing	
Rear Unit Mounting Parts (HR1500B2)		
196371	Side Bar, Right	1
196372	Side Bar, Left	1
149966	Cap Screw, 5/8-11 x 2-1/2" GR 8 Hex Hd	4
F021137	Hardened Washer	4
F012452	Elastic Stop Nut, 5/8"	4
F024047	Washer	12
F018860	Cap Screw, 1/2-13 x 2-3/4" Hex Hd	6
F013500	Elastic Stop Nut, 1/2"-13	6
700666075	Hex Locknut, 3/4"-10	2
F020458	Cap Screw, 3/4-10 x 2-1/2" GR 8 Hex Hd	2
196379	Shim	4
196380	Shim	2
200397	Brace End	1
163634	Brace End	1
F023012	Hardened Washer	8
023957	Rear Unit Application Drawing	

193848 WHEEL MODIFICATION GROUP

PART NO	DESCRIPTION	QTY
193848	WHEEL MODIFICATION GROUP	1
168661	WHEEL ASSEMBLY	5
161453	Decal, Warning: When Wheel...	1
162065	Decal, Wheel Nut Torque...	1
168681	Decal, Ratings Represent....	1
179523	Stud	12
193847	Stud	12
F025919	Hex Flange Nut	24
179128	Spacer	4
023759	Wheel Modification Application Drawing	
023428	Wheel Stop Application Drawing	

193871 WHEEL MODIFICATION GROUP

PART NO	DESCRIPTION	QTY
193871	WHEEL MODIFICATION GROUP	1
137649K	WHEEL 19 1/2 X 6	5
161453	Decal, Warning: When Wheel...	1
179142	Decal, Wheel Nut Torque...	1
137648	Decal, Ratings Represent....	1
188432	Wheel Stud	16
188490	Wheel Spacer	2
193872	WHEEL SPACER ASSEMBLY	2
F026230	Wheel Stud	8
162432	Decal, Studs In This Brake Drum...	1
184106	Hex Flange Nut	32
F025796	Wheel Nut	16
200453	Angle	2
200455	Wheel Stop, Left	1
200456	Wheel Stop, Right	1
023793	Wheel Modification Application Drawing	

200368 WHEEL MODIFICATION GROUP

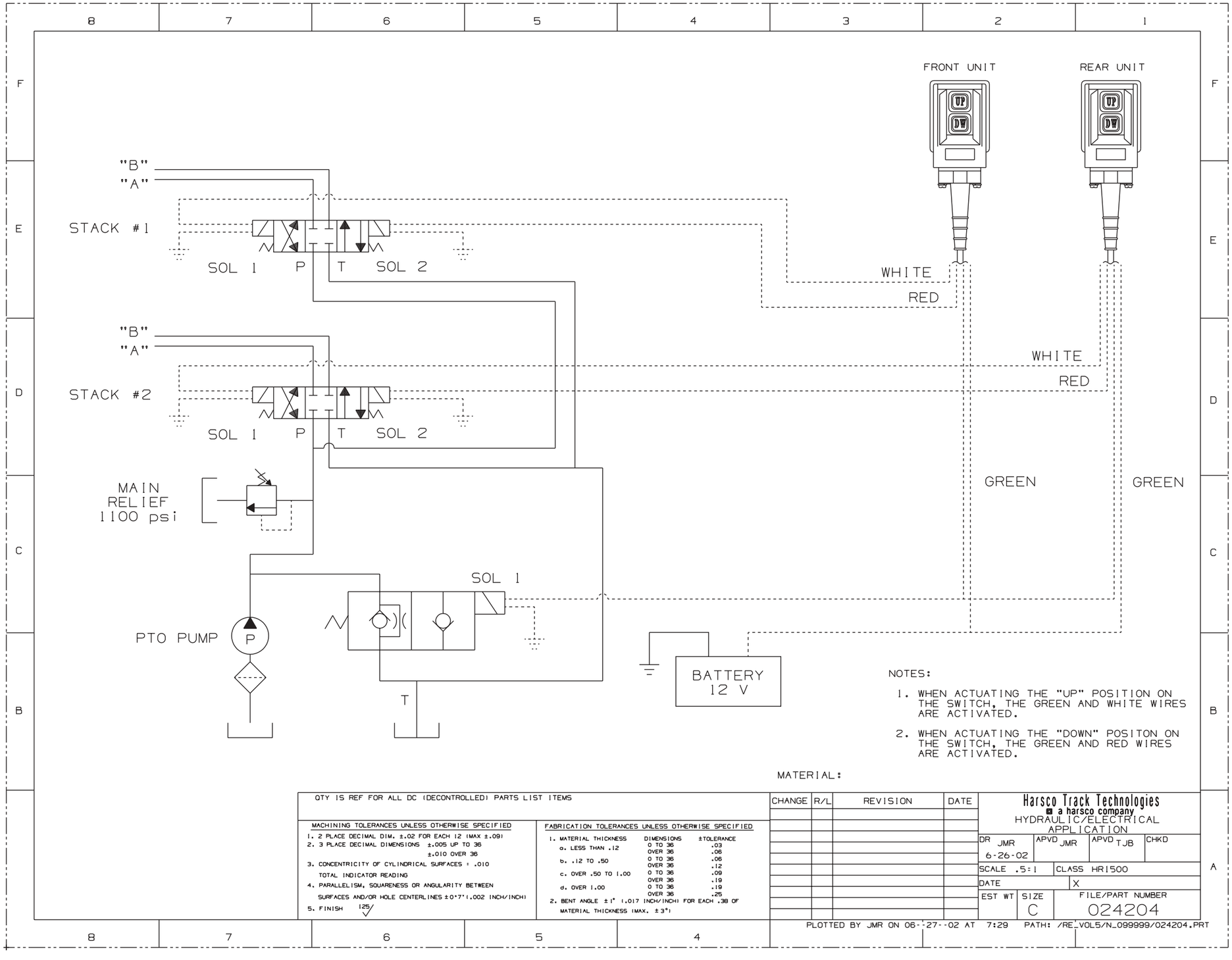
PART NO	DESCRIPTION	QTY
200368	WHEEL MODIFICATION GROUP	1
181612K	WHEEL ASSEMBLY, 19.5 x 6"	5
161453	Decal, Warning: When Wheel...	1
179142	Decal, Wheel Nut Torque...	1
184150	Decal, Ratings Represent....	1
186130	Spacer	2
188436	WHEEL STOP ASSEMBLY	1
188434	Bar	1
188438	Bar	1
188437	WHEEL STOP ASSEMBLY	1
188434	Bar	1
188435	Bar	1
187091	Bar	2
187092	Bar	1
201752	Disk-Lock Nut, 14 mm x 1.5	32
F002355	Cap Screw, 1/4-20 x 3/4" GR 5 Hex Hd	3
F011998	Elastic Stop Nut, 3/8"-16	4
F013588	Elastic Stop Nut, 1/4"-20	3
F014801	Hose Clamp, 1"	3
F019742	Cap Screw, 3/8-16 x 1-3/4" GR 8 Hex Hd	4
023413	Wheel Stop Application	
024227	Wheel Modification Application	

200371 WHEEL MODIFICATION GROUP

PART NO	DESCRIPTION	QTY
200371	WHEEL MODIFICATION GROUP	1
181612K	WHEEL ASSEMBLY, 19.5 x 6"	5
161453	Decal, Warning: When Wheel...	1
179142	Decal, Wheel Nut Torque...	1
184150	Decal, Ratings Represent....	1
186130	Spacer	2
184106	Hex Flange Nut	32
188359	Wheel Stop	2
F014801	Hose Clamp, 1"	1
F002355	Cap Screw, 1/4-20 x 3/4" GR 5 Hex Hd	3
F013588	Elastic Stop Nut, 1/4"-20	5
187092	Bar	1
F019742	Cap Screw, 3/8-16 x 1-3/4" GR 8 Hex Hd	2
F011998	Elastic Stop Nut, 3/8"-16	2
F006471	Cap Screw, 1/4-20 x 1-3/4" GR 5 Hex Hd	2
192408	Clamp	2
F001213	Cap Screw, 1/4-20 x 1-1/4" GR 5 Hex Hd	4
137349	Spring	2
F001106	Wrought Washer, 1/4"	8
024226	Wheel Modification Application Drawing	
023412	Wheel Stop Application Drawing	

203237 WHEEL MODIFICATION GROUP

PART NO	DESCRIPTION	QTY
203237	WHEEL MODIFICATION GROUP	1
203221	Wheel, 19.5 x 6"	5
203181	Wheel Spacer	4
201756	Disk Lock Nut	32
203239	Decal, 300 Lb-Ft	5
203229	Block	2
024628	Wheel Modification Application Drawing	



NOTES:

1. WHEN ACTUATING THE "UP" POSITION ON THE SWITCH, THE GREEN AND WHITE WIRES ARE ACTIVATED.
2. WHEN ACTUATING THE "DOWN" POSITON ON THE SWITCH, THE GREEN AND RED WIRES ARE ACTIVATED.

MATERIAL:

QTY IS REF FOR ALL DC (DECONTROLLED) PARTS LIST ITEMS

MACHINING TOLERANCES UNLESS OTHERWISE SPECIFIED
1. 2 PLACE DECIMAL DIM. ±.02 FOR EACH 12 (MAX ±.09)
2. 3 PLACE DECIMAL DIMENSIONS ±.005 UP TO 36
   ±.010 OVER 36
3. CONCENTRICITY OF CYLINDRICAL SURFACES = .010
   TOTAL INDICATOR READING
4. PARALLELISM, SQUARENESS OR ANGULARITY BETWEEN
   SURFACES AND/OR HOLE CENTERLINES ±0°7'(.002 INCH/INCH)
5. FINISH 125

FABRICATION TOLERANCES UNLESS OTHERWISE SPECIFIED
1. MATERIAL THICKNESS

	DIMENSIONS	±TOLERANCE
a. LESS THAN .12	0 TO 36	.03
	OVER 36	.06
b. .12 TO .50	0 TO 36	.06
	OVER 36	.12
c. OVER .50 TO 1.00	0 TO 36	.09
	OVER 36	.19
d. OVER 1.00	0 TO 36	.19
	OVER 36	.25

2. BENT ANGLE ±1° (.017 INCH/INCH) FOR EACH .38 OF MATERIAL THICKNESS (MAX. ±3°)

CHANGE	R/L	REVISION	DATE

Harsco Track Technologies
a harsco company
HYDRAULIC/ELECTRICAL APPLICATION

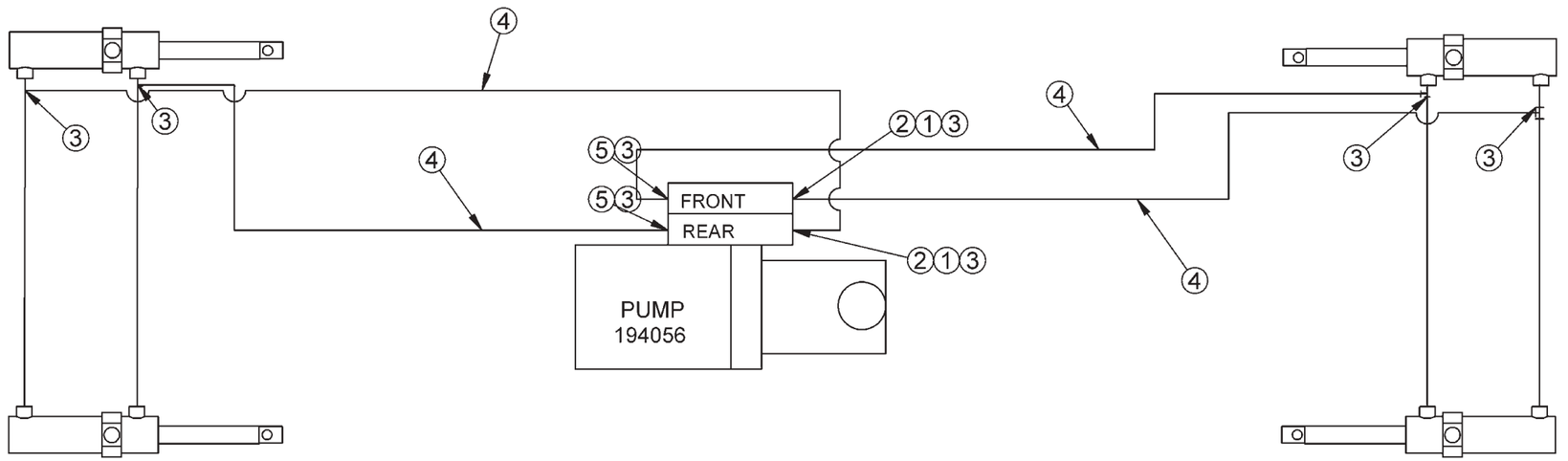
DR	APVD	APVD	CHKD
JMR 6-26-02	JMR	TJB	

SCALE .5=1 CLASS HR1500
DATE X
EST WT SIZE C FILE/PART NUMBER 024204

PLOTTED BY JMR ON 06--27--02 AT 7:29 PATH: /RE_VOL5/N_099999/024204.PRT

SOLID EDGE DRAWING

ITEM	QTY	PART NO	DESCRIPTION
1	2	F015085	ELB 90 4X4FS
2	2	F024046	STR 4X6 NPT
3	8	F014386	HOSE END REUSEABLE
4	1	F010590	3/16 ID MEDIUM PRESSURE HOSE
5	2	F015104	DC-ELB90 4 X 6 NPT



MACHINING TOLERANCES UNLESS OTHERWISE SPECIFIED
1. 2 PLACE DECIMAL DIM ±.02 FOR EACH 12 (MAX ±.09)
2. 3 PLACE DECIMAL DIM ±.005 UP TO 36", ±.010 OVER 36"
3. CONCENTRICITY OF CYLINDRICAL SURFACES =.010 TIR
4. PARALLELISM, SQUARENESS OR ANGULARITY BETWEEN SURFACES AND/OR HOLE CENTERLINES ±0°7' (.002 IN/IN)
5. FINISH 125 MICROINCHES

FABRICATION TOLERANCES UNLESS OTHERWISE SPECIFIED
1. MATERIAL THICKNESS DIMS ±TOL DIMS ±TOL
a. LESS THAN .12 ---- 0 TO 36 - ±.03 - OVER 36 - ±.06
b. .12 TO .50 ------- 0 TO 36 - ±.06 - OVER 36 - ±.12
c. .50 TO 1.00 ------ 0 TO 36 - ±.09 - OVER 36 - ±.19
d. OVER 1.00 -------- 0 TO 36 - ±.19 - OVER 36 - ±.25
2. BENT ANGLE ±0° (.017 IN/IN) FOR EACH .38 OF MATERIAL THICKNESS (MAX ±3°)

QTY IS REF FOR ALL DC (DECONTROLLED) PARTS LIST ITEMS

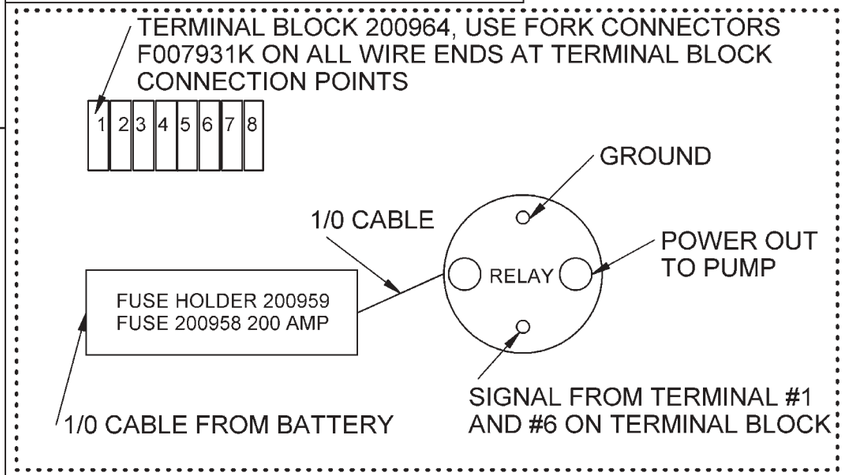
CHANGE	R/L	REVISION	DATE

DESCRIPTION: HYDRAULIC SCHEMATIC
PART NUMBER: 24326
MODEL:
APVD Desg | APVD ChEng | APVD MfgEng
DRAWN: kjorgensen
DATE: 03/18/2003
WEIGHT: 0.0 lbm
ECR#:
MATERIAL:
SCALE: 1=1 DO NOT SCALE PRINT
SIZE: B
DRAWING NUMBER: XXXXXXX,X
SHEET 1 OF 1

Harsco Track Technologies
Harsco
FAIRMONT, MN

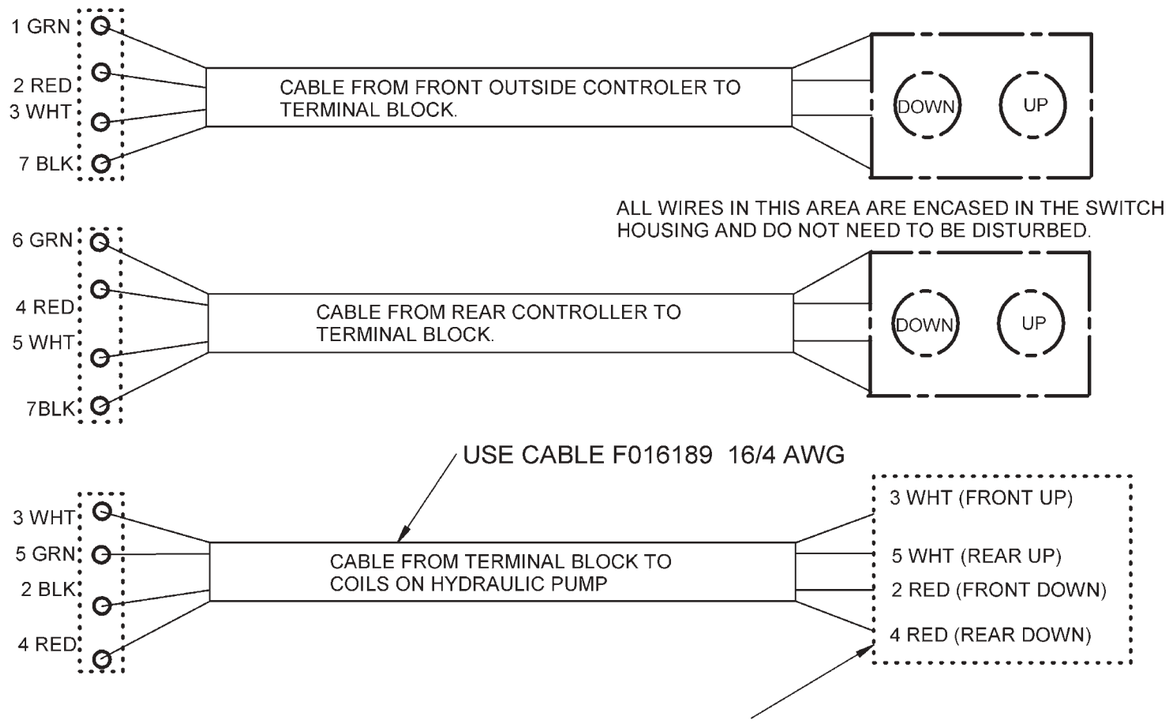
Plotted by kjorgensen on 03/18/2003 024326.dft

SOLID EDGE DRAWING



NOTES:

1. ALL COMPONENTS IN THIS AREA SHOULD BE LOCATED IN THE ENGINE COMPARTMENT IN THE APPROXIMATE SAME CONFIGURATION. PROTECT ALL COMPONENTS WITH A NON CONDUCTIVE COVER.
2. ALL CONNECTIONS SHOULD BE SEALED WITH PERFORMIX LIQUID TAPE OR EQUIVILANT.
3. CABLES SHOULD BE ENCASED IN CONVOLUTED TUBING 701099063 AND TY-RAPPED F016656 EVERY 12 INCHES.
4. EXERCISE EXTRA EFFORT TO KEEP ALL WIRE AWAY FROM FUEL TANK AND FUEL LINES.
5. KEEP WIRES AWAY FROM ANY MOVING PARTS.
6. WIRE #7 IS THE MAIN POWER ACTIVATOR FROM THE IGNITION AND SHOULD BE FUSED NEAR THE IGNITION SOURCE.
7. MOUNT THE FRONT CONTROLLER TO SWITCH PLATE 200892. MOUNT SWITCH PLATE TO CORRESPONDING HOLES ON BUMPER BRACKETS. USE 200901 IN PLACE OF EXISTING SCREWS ON CONTROLER.
8. USE CABLE 200965 AND TERMINALS F040165 ON ALL CONNECTIONS WHERE 1/0 CABLE IS USED.



MACHINING TOLERANCES UNLESS OTHERWISE SPECIFIED
1. 2 PLACE DECIMAL DIM ±.02 FOR EACH 12 (MAX ±.09)
2. 3 PLACE DECIMAL DIM ±.005 UP TO 36", ±.010 OVER 36"
3. CONCENTRICITY OF CYLINDRICAL SURFACES =.010 TIR
4. PARALLELISM, SQUARENESS OR ANGULARITY BETWEEN SURFACES AND/OR HOLE CENTERLINES ±0°7' (.002 IN/IN)
5. FINISH 125 MICROINCHES

FABRICATION TOLERANCES UNLESS OTHERWISE SPECIFIED
1. MATERIAL THICKNESS DIMS ±TOL DIMS ±TOL
a. LESS THAN .12 ---- 0 TO 36 - ±.03 - OVER 36 - ±.06
b. .12 TO .50 ------- 0 TO 36 - ±.06 - OVER 36 - ±.12
c. .50 TO 1.00 ------ 0 TO 36 - ±.09 - OVER 36 - ±.19
d. OVER 1.00 ------- 0 TO 36 - ±.19 - OVER 36 - ±.25
2. BENT ANGLE ±0° (.017 IN/IN) FOR EACH .38 OF MATERIAL THICKNESS (MAX ±3°)

QTY IS REF FOR ALL DC (DECONTROLLED) PARTS LIST ITEMS

CHANGE	R/L	REVISION	DATE

DESCRIPTION: ELECTRICAL APPLICATION.
PART NUMBER: 024327
MODEL: HR1500
APVD Desg | APVD ChEng | APVD MfgEng
DRAWN: KTJ
DATE: 05/07/2003
WEIGHT: 0
ECR#
MATERIAL
SCALE: 1=1 DO NOT SCALE PRINT
SIZE: B
DRAWING NUMBER
SHEET 1 OF 2

HTT Harsco Track Technologies
Harsco
FAIRMONT, MN

Plotted by kjorgensen on 11/24/2003 024327.dft

SOLID EDGE DRAWING

NOTES:

1) ALL WIRES 16 GAUGE UNLESS OTHERWISE SPECIFIED

2) SEAL ALL CONNECTIONS TO PREVENT CORROSION AND THE POSSIBILITY OF ELECTRICAL SHORTS. USE PERFORMIX LIQUID TAPE OR EQUIVILANT

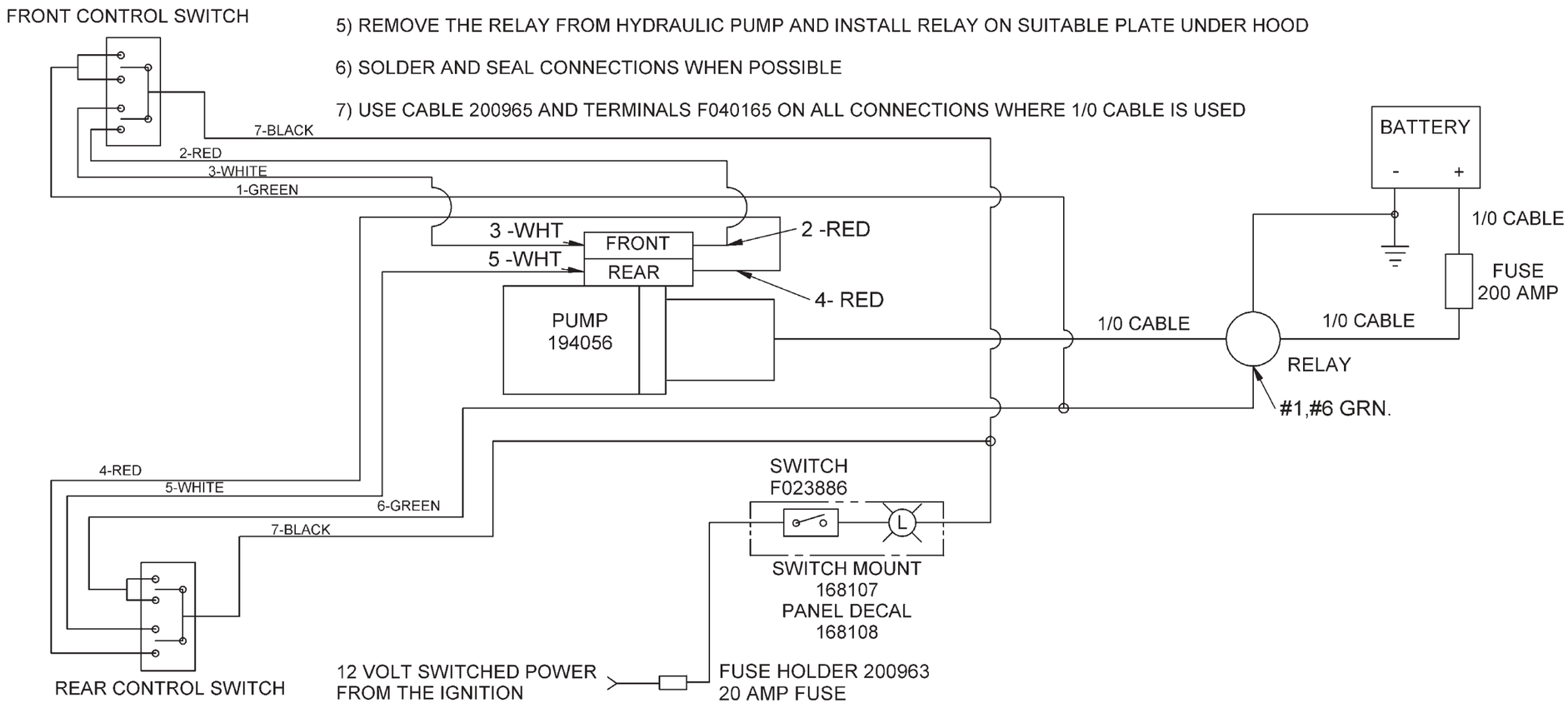
3) ROUTE ALL WIRES IN A MANNER TO PREVENT WIRES FROM GETTING PINCHED OR CUT

4) USE SUPPLIED 4 WIRE CABLE TO CONNECT THE CONTROL SWITCHES TO THE ELECTRIC PUMP

5) REMOVE THE RELAY FROM HYDRAULIC PUMP AND INSTALL RELAY ON SUITABLE PLATE UNDER HOOD

6) SOLDER AND SEAL CONNECTIONS WHEN POSSIBLE

7) USE CABLE 200965 AND TERMINALS F040165 ON ALL CONNECTIONS WHERE 1/0 CABLE IS USED



MACHINING TOLERANCES UNLESS OTHERWISE SPECIFIED
1. 2 PLACE DECIMAL DIM ±.02 FOR EACH 12 (MAX ±.09)
2. 3 PLACE DECIMAL DIM ±.005 UP TO 36", ±.010 OVER 36"
3. CONCENTRICITY OF CYLINDRICAL SURFACES =.010 TIR
4. PARALLELISM, SQUARENESS OR ANGULARITY BETWEEN SURFACES AND/OR HOLE CENTERLINES ±0°7' (.002 IN/IN)
5. FINISH 125 MICROINCHES

FABRICATION TOLERANCES UNLESS OTHERWISE SPECIFIED

1. MATERIAL THICKNESS	DIMS	±TOL	DIMS	±TOL
a. LESS THAN .12	0 TO 36	±.03	OVER 36	±.06
b. .12 TO .50	0 TO 36	±.06	OVER 36	±.12
c. .50 TO 1.00	0 TO 36	±.09	OVER 36	±.19
d. OVER 1.00	0 TO 36	±.19	OVER 36	±.25

2. BENT ANGLE ±0° (.017 IN/IN) FOR EACH .38 OF MATERIAL THICKNESS (MAX ±3°)

QTY IS REF FOR ALL DC (DECONTROLLED) PARTS LIST ITEMS

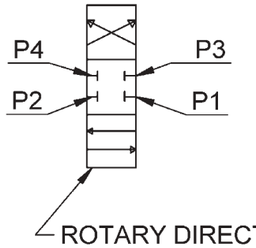
CHANGE	R/L	REVISION	DATE

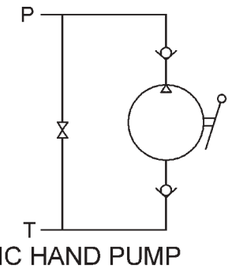
DESCRIPTION: ELECTRICAL APPLICATION.
PART NUMBER: 024327
MODEL: HR1500
APVD Desg | APVD ChEng | APVD MfgEng
DRAWN: KTJ
DATE: 05/07/2003
MATERIAL
SIZE: B
WEIGHT: 0
ECR#
SCALE
DO NOT SCALE PRINT
DRAWING NUMBER
SHEET 2 OF 2

Harsco Track Technologies
Harsco
FAIRMONT, MN

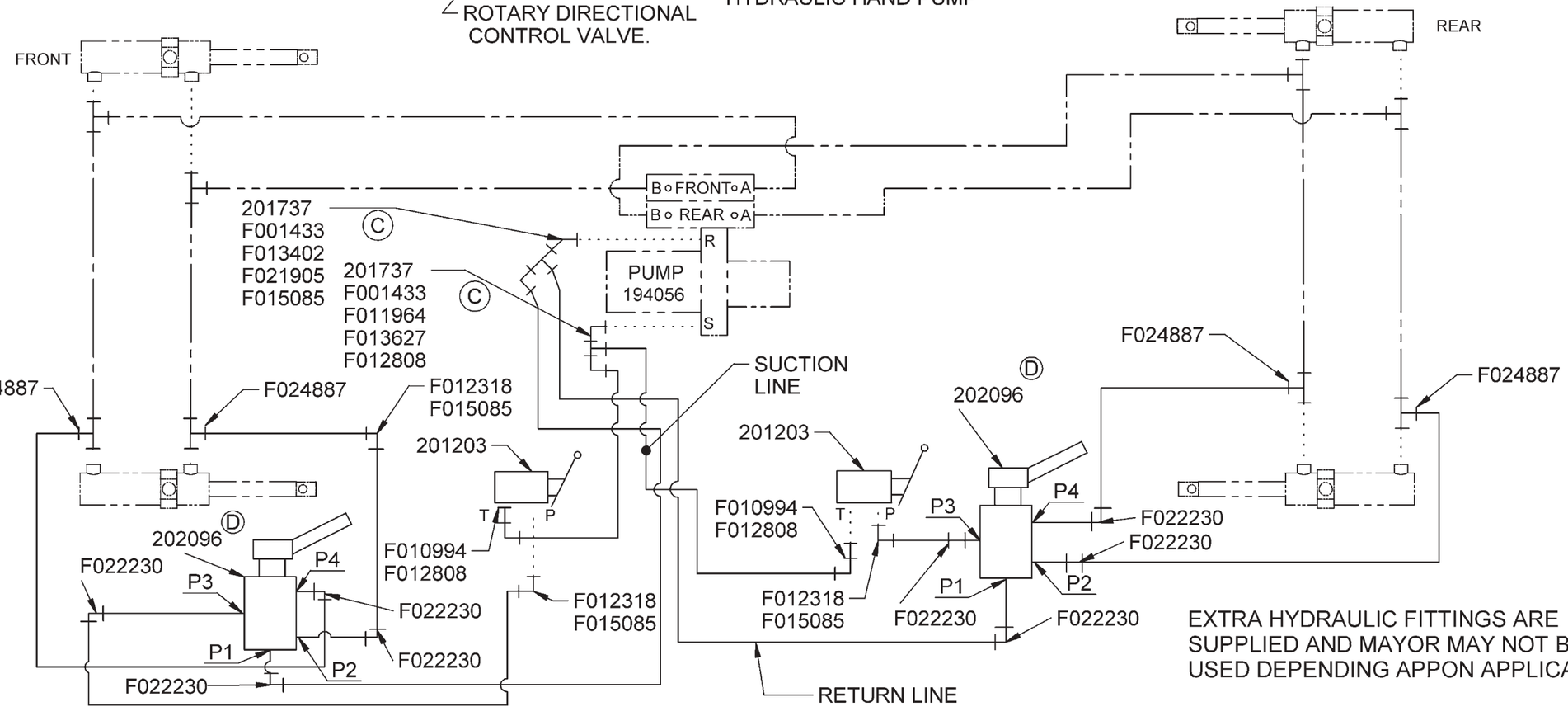
Plotted by kjorgensen on 11/24/2003 024327.dft

SOLID EDGE DRAWING





NOTE:
1. HOSES CONNECTED TO (S) PORTS ON ELECTRIC PUMP SHOULD ALL BE 3/8". SMALLER DIAMETER HOSES WILL CAUSE RESTRICTION AND IMPROPER OPERATION OF THE SYSTEM.
2. CONNECT PIPE 201737 TO THE SMALL FITTINGS ON THE PUMP AND AND EXTENDS OUT PAST THE PUMP MOTOR TO CONNECT ALL OTHER FITTINGS.



EXTRA HYDRAULIC FITTINGS ARE SUPPLIED AND MAYOR MAY NOT BE USED DEPENDING APPON APPLICATION.

MACHINING TOLERANCES UNLESS OTHERWISE SPECIFIED
1. 2 PLACE DECIMAL DIM ±.02 FOR EACH 12 (MAX ±.09)
2. 3 PLACE DECIMAL DIM ±.005 UP TO 36", ±.010 OVER 36"
3. CONCENTRICITY OF CYLINDRICAL SURFACES =.010 TIR
4. PARALLELISM, SQUARENESS OR ANGULARITY BETWEEN SURFACES AND/OR HOLE CENTERLINES ±0°7' (.002 IN/IN)
5. FINISH 125 MICROINCHES

FABRICATION TOLERANCES UNLESS OTHERWISE SPECIFIED
1. MATERIAL THICKNESS DIMS ±TOL DIMS ±TOL
a. LESS THAN .12 ---- 0 TO 36 - ±.03 - OVER 36 - ±.06
b. .12 TO .50 ------- 0 TO 36 - ±.06 - OVER 36 - ±.12
c. .50 TO 1.00 ------ 0 TO 36 - ±.09 - OVER 36 - ±.19
d. OVER 1.00 -------- 0 TO 36 - ±.19 - OVER 36 - ±.25
2. BENT ANGLE ±0° (.017 IN/IN) FOR EACH .38 OF MATERIAL THICKNESS (MAX ±3°)

QTY IS REF FOR ALL DC (DECONTROLLED) PARTS LIST ITEMS

CHANGE	R/L	REVISION	DATE
65883	A	CORRECT PIPING, AND TEES, ELBOWS, ETC.	6/03
65958	B	CHANGE FITTINGS TO ACCEPT 3/8 HOSE TO FEED HAND PUMPS	9/03
65974	C	ADD PIPE FITTINGS AND ADAPTE RS ON PUMP	12/03
66313	D	REPLACE CONTROL VALVES AND CORRESPONDING FITTINGS	2/04

DESCRIPTION: EMERGENCY HAND PUMP PIPING DIAGRAM
PART NUMBER: 024341
MODEL: HR1500B
APVD Desg | APVD ChEng | APVD MfgEng
DRAWN: kjorgensen
DATE: 02/03/2004
WEIGHT: 0.0 lbm
ECR#
MATERIAL
SCALE: 1=1 DO NOT SCALE PRINT
SIZE: B
DRAWING NUMBER: XXXXXX,X
SHEET 1 OF 1

Harsco Track Technologies
Harsco
FAIRMONT, MN

Plotted by kjorgensen on 12/09/2004 024341_d.dft

EMERGENCY HAND PUMP MOUNTING INSTRUCTIONS:

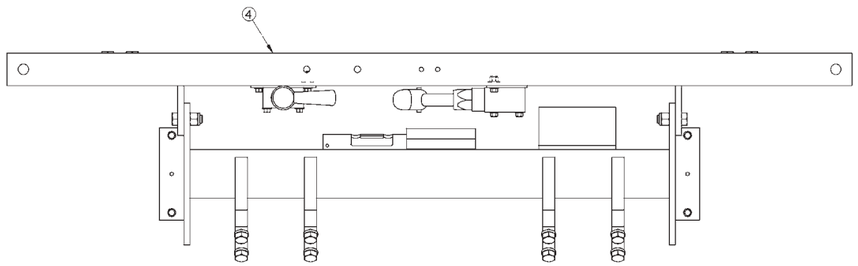
1) MOUNT HAND PUMP BRACKET 201201 TO HY-RAIL® BUMPER USING FASTENERS 174519, F001106, AND F013588

2) MOUNT EMERGENCY HAND PUMP 201203 TO HAND PUMP BRACKET USING FASTENERS F023402, F001106, AND F013588. HAND PUMP SHOULD BE MOUNTED SO OPERATION CAN BE PERFORMED FROM ABOVE. ENSURE PROPER CLEARANCE UNDER PUMP FOR HYDRAULIC HOSES AND FITTINGS.

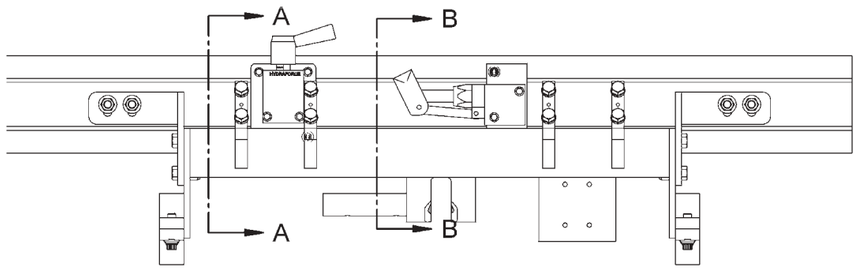
3) MOUNT CONTROL VALVE BRACKET 202096 TO HY-RAIL® BUMPER USING FASTENERS 174519, F001106, AND F013588

4) MOUNT CONTROL VALVE TO CONTROL VALVE BRACKET USING FASTENERS F013588, F023402, AND F001106. MAINTAIN ORIENTATION OF VALVE AS DEPICTED IN DIAGRAM.

5) MOUNT OPERATION DECAL 201207 NEAR CONTROL VALVE. NOTE THAT CONTROL VALVE OPERATION MATCHES DECAL INSTRUCTIONS.

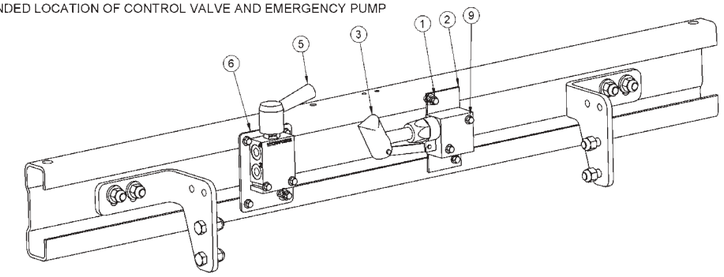


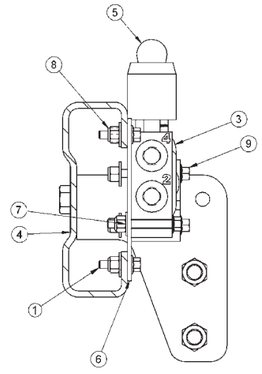
PARTS OF PILOT UNIT NOT SHOWN FOR CLARITY



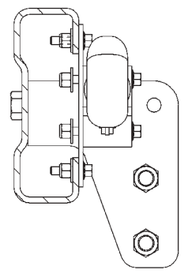
ITEM	QTY	PART NO	DESCRIPTION
1	6	174519	HFCS .250-20 X 1.00
2	1	201201	HAND PUMP BRACKET
3	1	201203	HAND PUMP
4	1	201207	DECAL
5	1	202096	CONTROL VALVE
6	1	202097	MOUNTING PLATE
7	10	F001106	WROUGHT WASHER - .250
8	10	F013588	HEX ELASTIC STOP NUT .250-20
9	4	F023402	HFCS .250-20 X 2.00

RECOMMENDED LOCATION OF CONTROL VALVE AND EMERGENCY PUMP





SECTION A-A



SECTION B-B

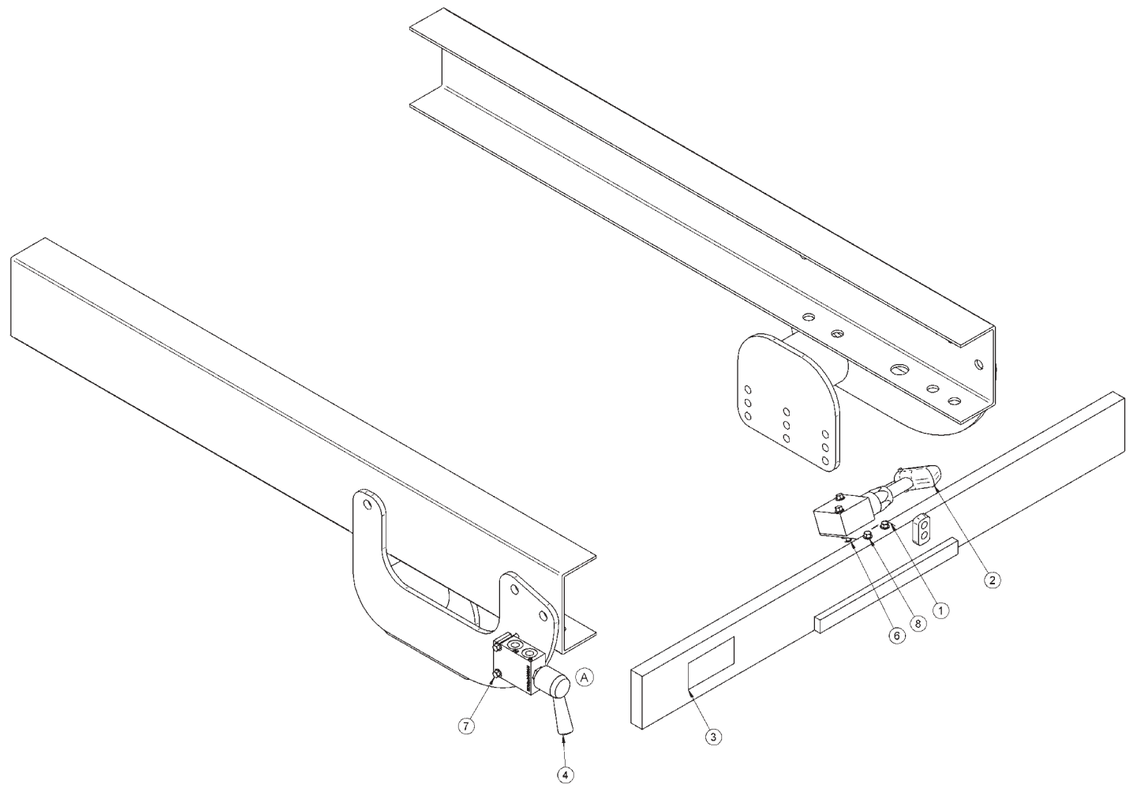
SOLID EDGE DRAWING

MACHINING TOLERANCES UNLESS OTHERWISE SPECIFIED
1. 2 PLACE DECIMAL DIM ±.02 FOR EACH 12 (MAX ± .05)
2. 3 PLACE DECIMAL DIM ±.005 UP TO 36". ±.010 OVER 36"
3. CONCENTRICITY OF CYLINDRICAL SURFACES = .010 TIR
4. PERPENDICULARITY OF SURFACES OR AXIS/AXIS BETWEEN SURFACES AND/OR HOLE CENTERLINES = .010 IN/IN
5. FINISH 125 MICROINCHES
FABRICATION TOLERANCES UNLESS OTHERWISE SPECIFIED
1. MATERIAL THICKNESS
DIMS	±TOL	DIMS	±TOL
a. LESS THAN .12	0 TO 35 = ±.03	OVER 35 = ±.06
b. .12 TO .150	0 TO 35 = ±.04	OVER 35 = ±.12
c. .151 TO 1.00	0 TO 35 = ±.05	OVER 35 = ±.19
d. OVER 1.00	0 TO 35 = ±.19	OVER 35 = ±.25
2. BENT ANGLE ±0° (.017 IN/IN) FOR EACH .38 OF MATERIAL THICKNESS OVER ±5°)

QTY IS REF FOR ALL DC (DECONTROLLED) PARTS LIST ITEMS

CHANGE	R/L	REVISION	DATE
66313	A	CHANGE CONTROL VALVE AND ALL NEEDED HARDWARE	02/04

DESCRIPTION: EMERGENCY PUMP APPLICATION - FRONT
PART NUMBER: 024342
Harsco Track Technologies
Harsco
FAIRMONT, MN
MODEL: HR1500B
APVD Desg: vomvig
APVD Chkng:
APVD Mfging:
DRAWN: vomvig
DATE: 02/03/2004
WEIGHT: 0.0 lbm
SCALE: 1=1
DO NOT SCALE PRINT
SIZE: D
MATERIAL:
DRAWING NUMBER: XXXXXXX,X
SHEET 1 of 1



ITEM	QTY	PART NO	DESCRIPTION
1	1	201202	HAND PUMP BRACKET
2	1	201203	HAND PUMP
3	1	201207	DECAL
4	1	202096	CONTROL VALVE
5	6	F001106	WROUGHT WASHER - .250
6	6	F013588	HEX ELASTIC STOP NUT .250-20
7	4	F023402	HFCS .250-20 X 2.00
8	2	F023407	DC-HEX FLG CS 1/4-20X5/8 GR5 ZP

EMERGENCY HAND PUMP MOUNTING INSTRUCTIONS:

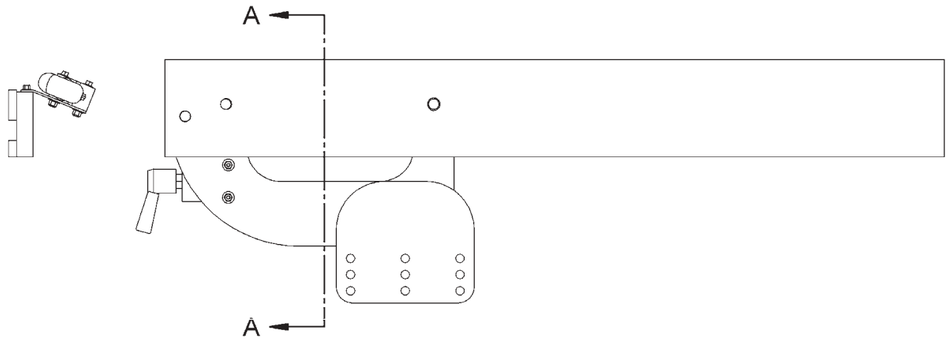
1) MOUNT HAND PUMP BRACKET 201202 TO VEHICLE BUMPER USING FASTENERS F023407, F001106, AND F013588.

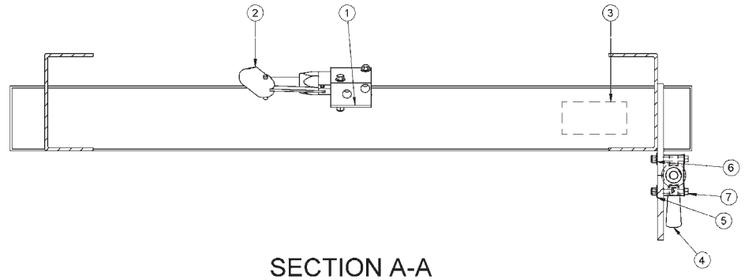
2) MOUNT EMERGENCY HAND PUMP 201203 TO HAND PUMP BRACKET USING FASTENERS F023402, F001106, AND F013588. HAND PUMP SHOULD BE MOUNTED SO OPERATION CAN BE PERFORMED FROM ABOVE. ENSURE PROPER CLEARANCE UNDER PUMP FOR HYDRAULIC HOSES AND FITTINGS.

3) MOUNT CONTROL VALVE TO HY-RAIL® MOUNTING BRACKETS USING FASTENERS F023402, F013588, AND F001106.

4) MOUNT OPERATION DECAL 201207 NEAR CONTROL VALVE. NOTE THAT CONTROL VALVE OPERATION MATCHES DECAL INSTRUCTIONS.

PARTS OF PILOT UNIT NOT SHOWN FOR CLARITY





SECTION A-A

SOLID EDGE DRAWING

MACHINING TOLERANCES UNLESS OTHERWISE SPECIFIED
1. 3 PLACE DECIMAL DIM ± .02 FOR EACH 12" (MAX ± .10)
2. 3 PLACE DECIMAL DIM ±.005 UP TO 36". ±.010 OVER 36"
3. CONCENTRICITY OF CYLINDRICAL SURFACES = 0.10 TIR
4. PARALLELISM, PERPENDICULARITY OR ANGULARITY BETWEEN SURFACES AND/OR AXES CONTAINED IN 6" (.002 IN/IN)
5. FINISH: 125 MICROINCHES

FABRICATION TOLERANCES UNLESS OTHERWISE SPECIFIED
1. MATERIAL THICKNESS DIM. ±TOL DIM. ±TOL
a. LESS THAN .12 ---- 0 TO 36 = ±.02 - OVER 36 = ±.06
b. .12 TO 1.00 ------- 0 TO 36 = ±.03 - OVER 36 = ±.09
c. 1.0 TO 3.00 ------- 0 TO 36 = ±.05 - OVER 36 = ±.09
d. OVER 3.00 -------- 0 TO 36 = ±.29 - OVER 36 = ±.25
2. BEND ANGLE ±5° (.017 IN/IN FOR EACH .18 OF MATERIAL THICKNESS (MAX 45°)

QTY. IS REF FOR ALL PC (DECONTROLLED) PARTS LIST ITEMS

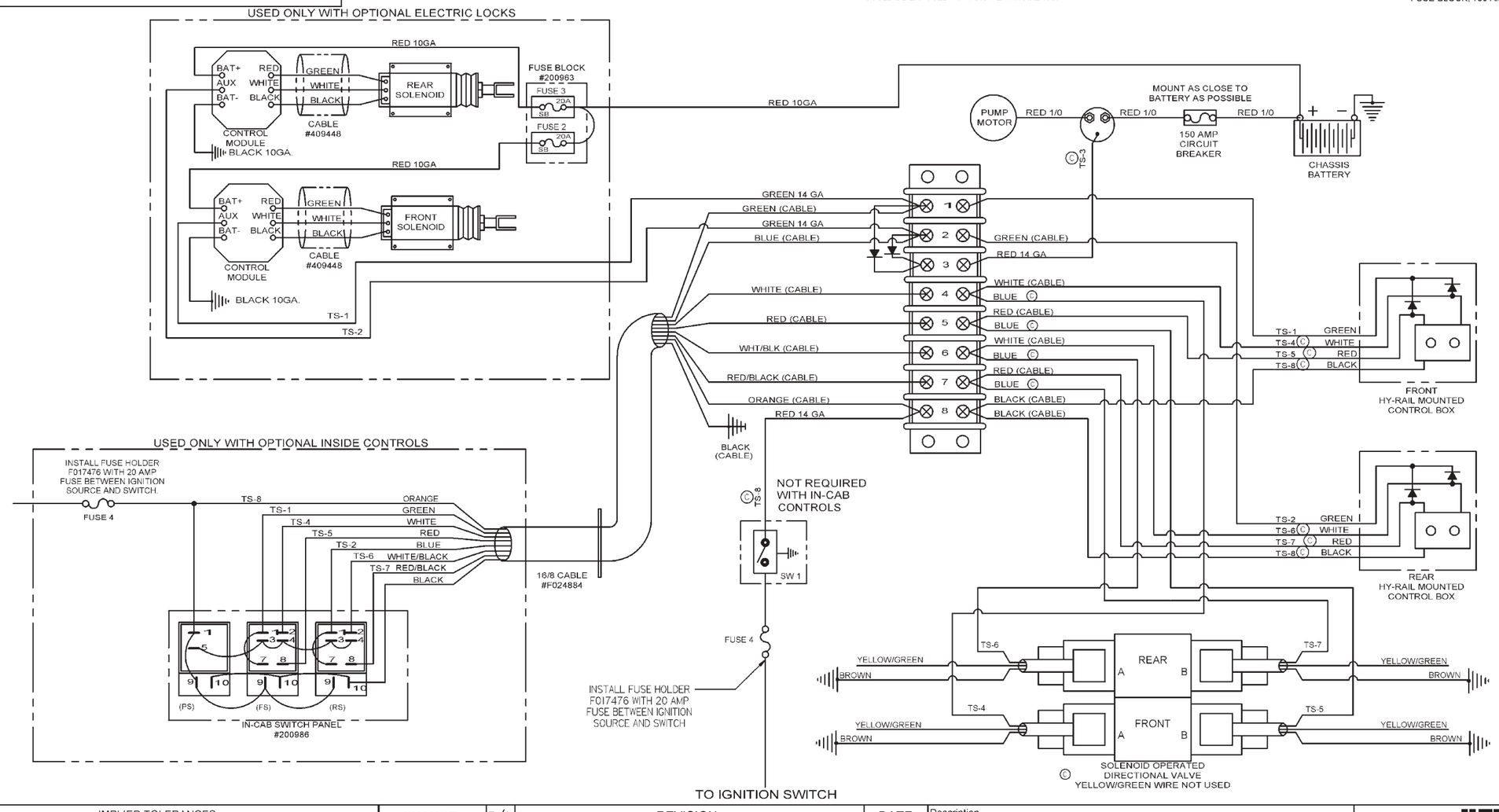
CHANGE	R/L	REVISION	DATE
65481	A	CHANGED LOCATION OF 200991	4/03
66313	B	CHANGED CONTROL VALVE AND ALL MOUNTING HARDWARE.	2/04

DESCRIPTION: EMGCY PMP APP, REAR
PART NUMBER: 024343
Harsco Track Technologies
Harsco
FAIRMONT, MN
MODEL: HR1500B
APVD Desg: APVD Chkng: APVD Mfgeng:
DRAWN: dwald DATE: 02/03/2004
WEIGHT: 510.3 lbm
MATERIAL:
SCALE: 1=1
SIZE: D
DRAWING NUMBER: XXXXXXX,X
SHEET 1 OF 1
DO NOT SCALE PRINT

SOLID EDGE DRAWING

NOTE:
RECOMMEND USING LIQUID TAPE ELECTRICAL BRUSH ON INSULATION, P/N 200946, ON ELECTRICAL CONNECTIONS THAT COULD BE EXPOSED TO HARSH ENVIROMENTS.

LOCATE UNDER HOOD:
CONTROL MOD
FUSE BLOCK, 20 AMP
TERMINAL STRIP
RELAY, PUMP
FUSE BLOCK, 150 AMP



IMPLIED TOLERANCES
ALL DIMENSIONS ARE IN INCHES - TOLERANCE UNLESS OTHERWISE SPECIFIED

NOMINAL SIZE RANGE		INCH PLUS OR MINUS		NOMINAL SIZE RANGE		METRIC PLUS OR MINUS	
OVER	TO	2 PLACE DECIMAL	3 PLACE DECIMAL	OVER	TO	1 PLACE DECIMAL	2 PLACE DECIMAL
0	6	.03	.005	0	150	.8	.127
6	24	.04	.008	150	600	1.0	.203
24	-	.06	.010	-	600	1.5	.254

UNLESS OTHERWISE SPECIFIED ALL MACHINED SURFACES WILL HAVE;
A SURFACE FINISH OF 125 MICRO/INCHES
ANGULAR TOLERANCE OF ± 30'
CONCENTRICITY WITHIN .010

THIRD ANGLE PROJECTION

UNLESS OTHERWISE SPECIFIED ALL WELDS SHOULD ADHERE TO THE LATEST HTT WELDING SPECIFICATION 101

CHANGE	R/L	REVISION	DATE
66450	A	CHANGE WIRES, ADD WIRES, CHANGE BOM	3/04
66684	B	CHANGE WIRES, ADD WIRES, CHANGE BOM	4/04
66958	C	CHANGE SOLENOID WIRING	8/04

Description: ELECTRICAL DIAGRAM
Drawing Number: ----------
Model: ----------
Wt:
Scale: 1:4
Mat'l ----------
Machine Type: HR1500-B
Drawn: jripley
Date Drawn: 08/13/2004
APVD Desg: XXX
APVD ChEng: XXX

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Harsco
Columbia, SC

Part Number: 024454
Size: B
Sheet: 1 of 2

Plotted by vomvig on 12/09/2004 024454_c.dft

SOLID EDGE DRAWING

© 202515 - Electrical With Manual Locks

ITEM	PART NUMBER	DESCRIPTION	QTY
1	F001025	Lock Washer, 3/8	2.00
2	F001125	Hex Head Cap Screw, 3/8-16 X 1-1/4	2.00
3	F004600	Elastic Stop Nut	2.00
4	F004683	Hex Head Cap Screw, 3/8-16 X 5/8	2.00
5	F009542	Nut, #10-24	4.00
6	F009681	Washer, 3/8	4.00
			©
8	F016656	Ty Rap	50.00
9	F017476	Fused Line Connector	1.00
10*	F023886	Switch	1.00
11	F020891	Wire, 14 Ga, Red	5FT
12*	168107	Switch Mount	1.00
13*	168108	Decal	1.00
14	201521	Switch Plate	1.00
15	200901	HHCS M4 X .7 X 30	8.00
16	200965	1/0 Cable	30FT
17	201258	Cable End	8.00
18	201260	Butt Connector	20.00
19	201265	Sealed Ring Connector	8.00
20	201268	Spade Connector	20.00
21	201269	Spade Connector	8.00
22	701099063	Auto-Loom 5/8	116FT
23	H6206Y35	Circuit Breaker	1.00
24	200964	Terminal Block	1.00
25	F023788	Diode	2.00 ©
26	201270	Push On Connector	3.00 ©

© 202458 - Electric Locks

ITEM	PART NUMBER	DESCRIPTION	QTY
27	409488	Cable 12/3	40FT
28	200963	Fuse Holder	3.00
29	200960	Fuse, 20 Amp	5.00
30	200490	Module	2.00
			©
32	F009803	Wire, 10 Ga, Red	6FT
33	F006060	Wire, 14 Ga, Green	12FT
34	200965	1/0 Cable	40FT ©
35	201270	Push On Connector	2.00 ©

201308 - In Cab Actuation

36	F016656	Ty Rap	20.00
37	F024884	Eight Conductor Cable	10FT
38	F040160	Wire, 16 Ga. Black	5FT
39	F040576	Wire, 16 Ga. Red	5FT
40	200986	Box Assembly	1.00
41	201204	Socket Housing	3.00
42	201205	Socket Housing	3.00
43	201208	Connector	20.00
44	201265	Sealed Ring Connector	4.00
45	201268	Spade Connector	12.00
46	201269	Spade Connector	1.00
47	701099063	Auto-Loom 5/8	10FT ©
48	200987	Decal	1.00
49	200968	Switch	2.00
50	200967	Switch	1.00

Power Supply

	Wire PN	From	Terminal	To	Terminal
	200965	Battery (+)	201258	Fuse 150A ©	201258
	200965	Cir Brkr 150A	201258	K Pump	201258
	200965	K Pump	201258	Pump	201258
	F020891	K Pump	201268	TS-3	201268
	F009803	Battery (+)	201208	Fuse 3	201270
	F009803	Fuse 3	201270	Fuse 2	201270
	F023788	TS-1	201268	TS-3	201260
	F023788	TS-2	201268	TS-3	201260
	F020891	Ignition	201208	Fuse 4	201260
	F020891	Fuse 4	201260	TS-8 ©	201268
*	F020891	Fuse 4	201260	SW1	201268
*	F020891	SW1	201268	TS-8 ©	201208

Front Outside Control

Color	Function	From	Terminal	To	Terminal
Black	Power	F.O Control	None	TS-8	201268
White	Up	F.O Control	None	TS-4	201268
Red	Down	F.O Control	None	TS-5	201268
Green	Relay	F.O Control	None	TS-1	201268

Rear Outside Control

Color	Function	From	Terminal	To	Terminal
Black	Power	R.O Control	None	TS-8	201268
White	Up	R.O Control	None	TS-6	201268
Red	Down	R.O Control	None	TS-7	201268
Green	Relay	R.O Control	None	TS-2	201268

Pump Valve Body Coils

Color	Function	From	Terminal	To	Terminal
© Blue	Up	Sol F.A.		TS-4	201268
© Brown	Ground	Sol F.A.		Ground	201268
© Blue	Down	Sol F.B.		TS-5	201268
© Brown	Ground	Sol F.B.		Ground	201268
© Blue	Up	Sol R.A.		TS-6	201268
© Brown	Ground	Sol R.A.		Ground	201268
© Blue	Down	Sol R.B.		TS-7	201268
© Brown	Ground	Sol R.B.		Ground	201268

Optional Electric Locks - 200312 & 200313

Color	Function	From	Terminal	To	Terminal
Green	Pull	F Mod Red	201269	F Lock Sol Red	201260
White	Hold	F Mod White	201269	F Lock Sol Wht	201260
Black	Ground	F Mod Black	201269	F Lock Sol Blk	201260
Green	Control	F Mod Aux	201268	TS-1	201268
Black	Ground	F Mod Bat (-)	201268	Ground	201268
Red	Power	F Mod Bat (+)	201268	Fuse 2	201270
Green	Pull	R Mod Red	201269	R Lock Sol Red	201260
White	Hold	R Mod White	201269	R Lock Sol Wht	201260
Black	Ground	R Mod Black	201269	R Lock Sol Blk	201260
Green	Control	R Mod Aux	201268	TS-2	201268
Black	Ground	R Mod Bat (-)	201268	Ground	201268
Red	Power	R Mod Bat (+)	201268	Fuse 3	201270

Optional Inside Cab Controls - 201308

Color	Function	From	Terminal	To	Terminal
Orange	Power	TS-8	201268	PS-1	201208
Green	Control	TS-1	201268	FS-1	201208
White	Down	TS-4	201268	FS-2	201208
Red	Up	TS-5	201268	FS-8	201208
Blue	Control	TS-2	201268	RS-1	201208
White/Black	Down	TS-6	201268	RS-2	201208
Red/Black	Up	TS-7	201268	RS-8	201208
Black	Ground	Ground	201268	RS-10	201208

Optional In-Cab Switch Panel - 200986

Wire PN	From	Terminal	To	Terminal
F040576	PS-1	201208	PS-9	201208
F040576	PS-9	201208	FS-9	201208
F040576	FS-9	201208	RS-9	201208
F040576	PS-10	201208	FS-10	201208
F040576	FS-10	201208	RS-10	201208
F040576	PS-5	201208	FS-3	201208
F040576	FS-3 ©	201208	FS-4	201208
F040576	FS-4	201208	RS-3	201208
F040576	RS-3	201208	RS-4	201208

NOTES:
1. MOUNTING LOCATIONS TO BE DETERMINED AT ASSEMBLY BY APPLICATOR.
2. USE AUTO-LOOM 701099063 TO ENCASE ALL WIRES AND CABLES. SECURE EVERY 12 INCHES WITH TY-RAP F016656.
3. © USE SWITCH PLATE 201521 TO MOUNT OUTSIDE CONTROL SWITCH.
4. ENSURE THE GRAY STRIPE ON DIODE F023788 IS POSITIONED TOWARD TS3.
5. GROUNDS NEED TO BE OBTAINED FROM NEAREST LOCATION ON VEHICLE CHASSIS.
6. REMOVE RELAY FROM PUMP AND INSTALL UNDER VEHICLE HOOD FOR PROTECTION.

TS = TERMINAL STRIP
K = RELAY
F.O. CONTROL = FRONT OUTSIDE CONTROL
R.O. CONTROL = REAR OUTSIDE CONTOL
SW = SWITCH
© SOL F.A. = PUMP SOLENOID, FRONT, UP
© SOL F.B. = PUMP SOLENOID, FRONT, DOWN
© SOL R.A. = PUMP SOLENOID, REAR, UP
© SOL R.B. = PUMP SOLENOID, REAR, DOWN
F MOD = FRONT LOCK MODULE
R MOD = REAR LOCK MODULE
F LOCK SOL = FRONT ELECTRIC LOCK SOLENOID
R LOCK SOL = REAR ELECTIC LOCK SOLENOID
PS = INSIDE CAB ON/OFF SWITCH
FS = INSIDE CAB FRONT UP/DOWN SWITCH
RS = INSIDE CAB REAR UP/DOWN SWITCH

*NOT REQUIRED WITH IN CAB ACTUATION

IMPLIED TOLERANCES
ALL DIMENSIONS ARE IN INCHES - TOLERANCE UNLESS OTHERWISE SPECIFIED

INCH NOMINAL SIZE RANGE OVER	TO	INCH PLUS OR MINUS 2 PLACE DECIMAL	3 PLACE DECIMAL	METRIC NOMINAL SIZE RANGE OVER	TO	METRIC PLUS OR MINUS 1 PLACE DECIMAL	2 PLACE DECIMAL
0	6	.03	.005	0	150	.8	.127
6	24	.04	.008	150	600	1.0	.203
24	-	.06	.010	-	600	1.5	.254

UNLESS OTHERWISE SPECIFIED ALL MACHINED SURFACES WILL HAVE:
A SURFACE FINISH OF 125 MICROINCHES
ANGULAR TOLERANCE OF ± .50°
CONCENTRICITY WITHIN .010

THIRD ANGLE PROJECTION

UNLESS OTHERWISE SPECIFIED ALL WELDS SHOULD ADHERE TO THE LATEST HTT WELDING SPECIFICATION 101

CHANGE	R/L	REVISION	DATE
66450	A	CHANGE WIRES, ADD WIRES, ADD BOM	3/04
66684	B	CHANGE WIRES, ADD WIRES, ADD BOM	4/04
66958	C	CHANGE SOLENOID WIRING	8/04

Description: ELECTRICAL DIAGRAM
Drawing Number: ----------
Machine Type: HR1500-B
Model: ----------
Drawn: jripley
Date Drawn: 08/13/2004
Wt.
Scale: 1:4
APVD Desg: XXX
APVD ChEng: XXX
Mat'l ----------

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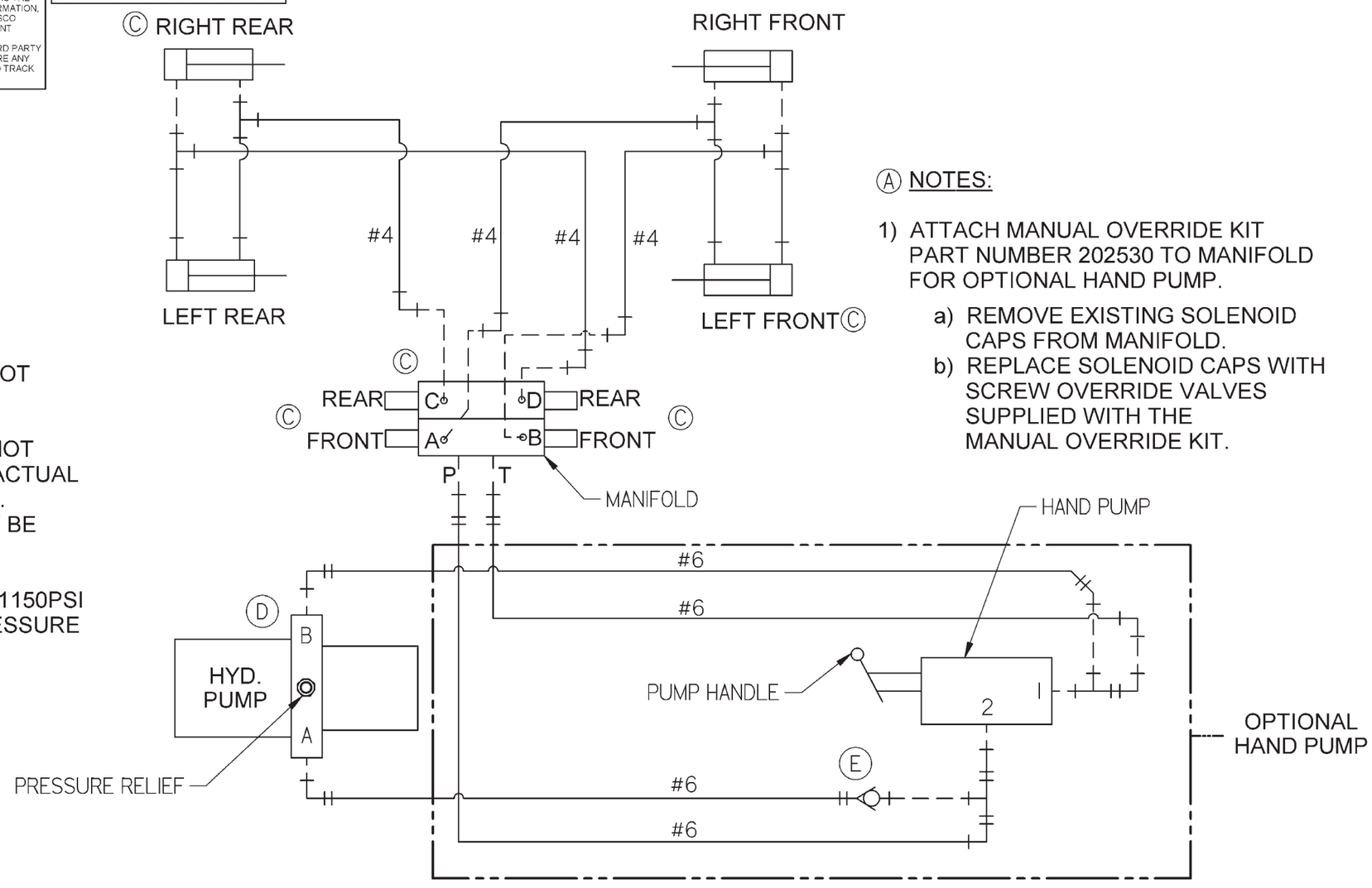
Harsco Track Technologies
Harsco
Columbia, SC

Part Number: 024454
Size: B
Sheet: 2 of 2

SOLID EDGE DRAWING

Ⓐ NOTES:

1) ALL HOSE FITTINGS MAY NOT BE NEEDED TO COMPLETE APPLICATION.
2) APPLICATION PRINT MAY NOT CORRECTLY REPRESENT ACTUAL HOSE FITTINGS REQUIRED. ADDITIONAL FITTINGS MAY BE REQUIRED FOR CERTAIN APPLICATIONS.
3) HYDRAULIC PUMP SET TO 1150PSI ADJUST IF NEEDED AT PRESSURE RELIEF.



Ⓐ NOTES:

1) ATTACH MANUAL OVERRIDE KIT PART NUMBER 202530 TO MANIFOLD FOR OPTIONAL HAND PUMP.
   a) REMOVE EXISTING SOLENOID CAPS FROM MANIFOLD.
   b) REPLACE SOLENOID CAPS WITH SCREW OVERRIDE VALVES SUPPLIED WITH THE MANUAL OVERRIDE KIT.

IMPLIED TOLERANCES
ALL DIMENSIONS ARE IN INCHES - TOLERANCE UNLESS OTHERWISE SPECIFIED

INCH NOMINAL SIZE RANGE OVER	TO	INCH PLUS OR MINUS 2 PLACE DECIMAL	INCH PLUS OR MINUS 3 PLACE DECIMAL	METRIC NOMINAL SIZE RANGE OVER	TO	METRIC PLUS OR MINUS 1 PLACE DECIMAL	METRIC PLUS OR MINUS 2 PLACE DECIMAL
0	6	.03	.005	0	150	.8	.127
6	24	.04	.008	150	600	1.0	.203
24	-	.06	.010	-	600	1.5	.254

UNLESS OTHERWISE SPECIFIED ALL MACHINED SURFACES WILL HAVE; A SURFACE FINISH OF 125 MICRO/INCHES ANGULAR TOLERANCE OF ± 50' CONCENTRICITY WITHIN .010

THIRD ANGLE PROJECTION

UNLESS OTHERWISE SPECIFIED ALL WELDS SHOULD ADHERE TO THE LATEST HTT WELDING SPECIFICATION 101

CHANGE	R/L	REVISION	DATE
66696	A	ADDED NOTES TO REFLECT 202530	5/04
66726	B	CHANGED DESCRIPTION	7/04
66968	C	CHANGE PORTS, CHANGE CYLINDER LABELS	9/04
67324	D	CHANGE PORT LABELS	12/04
67334	E	UPDATE HAND PUMP SCHEMATIC/ADD CHECK VALVE	12/04

Description: EMERGENCY /HYDRAULIC SCHEMATIC
Drawing Number: ----------
Machine Type: HR1500-B
Model:
Drawn: dschultz
Date Drawn: 12/14/2004
Wt: 0.0 lbm
Scale: 1:4
APVD Desg: XXX
APVD ChEng: XXX
Mat'l: 024549 EMERGENCY HYD POWER PACK
Part Number: 024549
Size: B
Sheet: 1 of 1

HTT
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Harsco
Columbia, SC

Plotted by dbecker on 12/14/2004 024549_e.dft

SECTION 8 - VEHICLE APPLICATIONS
TABLE OF CONTENTS

	2003 CHEV/GMC TAHOE 4 X 4 K15706 6,900 GVWR	2003 CHEV/GMC SUBURBAN 4 X 4 K25906 8,600 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200939	200908
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	200946	200906
Steering Lock	169632	169632
Velcro Steering Lock	201711	201711
Wheel Modification	193848	193871
Application Drawing - Front	024335	024324
Application Drawing - Rear	024336	024325
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2003 CHEV/GMC REGULAR CAB 4 X 4 K25903 HD 9,200 GVWR	2003 CHEV/GMC EXTENDED CAB 4 X 4 K25953 HD 9,200 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200488	200488
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196518	196518
Steering Lock	169632	169632
Velcro Steering Lock	201711	201711
Wheel Modification	193871	193871
Application Drawing - Front	024013	024013
Application Drawing - Rear	024014	024014
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2003 CHEV/GMC CREW CAB 4 X 4 K25933 HD 9,200 GVWR	2003 CHEV/GMC REGULAR CAB 4 X 2 C25903 HD 9,200 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200488	200488
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196518	196518
Steering Lock	169632	169632
Velcro Steering Lock	201711	201711
Wheel Modification	193871	193871
Application Drawing - Front	024013	024013
Application Drawing - Rear	024014	024014
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2003 CHEV/GMC EXTENDED CAB 4 X 2 C25953 HD 9,200 GVWR	2003 CHEV/GMC CREW CAB 4 X 2 C25943 HD 9,200 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200488	200488
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196518	196518
Steering Lock	169632	169632
Velcro Steering Lock	201711	201711
Wheel Modification	193871	193871
Application Drawing - Front	024013	024013
Application Drawing - Rear	024014	024014
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2003 FORD F250 REGULAR CAB 4 X 4 9,900 GVWR	2003 FORD F250 EXTENDED CAB 4 X 4 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200473	200473
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196373	196373
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200368	200368
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2003 FORD F250 SUPER CAB 4 X 4 9,900 GVWR	2003 FORD F250 REGULAR CAB 4 X 2 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200473	200890
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196373	198513
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200368	200371
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2003 FORD F250 EXTENDED CAB 4 X 2 9,900 GVWR	2003 FORD F250 SUPER CAB 4 X 2 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200890	200890
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	198513	198513
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200371	200371
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2003 FORD F350 REGULAR CAB 4 X 4 9,900 GVWR	2003 FORD F350 EXTENDED CAB 4 X 4 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200473	200473
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196373	196373
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200368	200368
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2003 FORD F350 SUPER CAB 4 X 4 9,900 GVWR	2003 FORD F350 REGULAR CAB 4 X 2 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200473	200890
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196373	198513
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200368	200371
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS OPTIONS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2003 FORD F350 EXTENDED CAB 4 X 2 9,900 GVWR	2003 FORD F350 SUPER CAB 4 X 2 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200890	200890
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	198513	198513
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200371	200371
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2004 CHEV/GMC TAHOE 4 X 4 K15706 6,900 GVWR	2004 CHEV/GMC SUBURBAN 4 X 4 K25906 8,600 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200939	200908
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	200946	200906
Steering Lock	169632	169632
Velcro Steering Lock	201711	201711
Wheel Modification	193848	193871
Application Drawing - Front	024335	024324
Application Drawing - Rear	024336	024325
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2004 CHEV/GMC REGULAR CAB 4 X 4 K25903 HD 9,200 GVWR	2004 CHEV/GMC EXTENDED CAB 4 X 4 K25953 HD 9,200 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200488	200488
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196518	196518
Steering Lock	169632	169632
Velcro Steering Lock	201711	201711
Wheel Modification	193871	193871
Application Drawing - Front	024013	024013
Application Drawing - Rear	024014	024014
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2004 CHEV/GMC CREW CAB 4 X 4 K25933 HD 9,200 GVWR	2004 CHEV/GMC REGULAR CAB 4 X 2 C25903 HD 9,200 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200488	200488
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196518	196518
Steering Lock	169632	169632
Velcro Steering Lock	201711	201711
Wheel Modification	193871	193871
Application Drawing - Front	024013	024013
Application Drawing - Rear	024014	024014
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2004 CHEV/GMC EXTENDED CAB 4 X 2 C25953 HD 9,200 GVWR	2004 CHEV/GMC CREW CAB 4 X 2 C25943 HD 9,200 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200488	200488
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196518	196518
Steering Lock	169632	169632
Velcro Steering Lock	201711	201711
Wheel Modification	193871	193871
Application Drawing - Front	024013	024013
Application Drawing - Rear	024014	024014
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2004 FORD F250 REGULAR CAB 4 X 4 9,900 GVWR	2004 FORD F250 EXTENDED CAB 4 X 4 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200473	200473
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196373	196373
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200368	200368
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2004 FORD F250 SUPER CAB 4 X 4 9,900 GVWR	2004 FORD F250 REGULAR CAB 4 X 2 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200473	200890
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196373	198513
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200368	200371
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2004 FORD F250 EXTENDED CAB 4 X 2 9,900 GVWR	2004 FORD F250 SUPER CAB 4 X 2 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200890	200890
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	198513	198513
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200371	200371
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2004 FORD F350 REGULAR CAB 4 X 4 9,900 GVWR	2004 FORD F350 EXTENDED CAB 4 X 4 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200473	200473
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196373	196373
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200368	200368
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2004 FORD F350 SUPER CAB 4 X 4 9,900 GVWR	2004 FORD F350 REGULAR CAB 4 X 2 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200473	200890
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196373	198513
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200368	200371
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS OPTIONS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2004 FORD F350 EXTENDED CAB 4 X 2 9,900 GVWR	2004 FORD F350 SUPER CAB 4 X 2 9,900 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	200890	200890
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	198513	198513
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	200371	200371
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2005 FORD F250 CREW CAB 4 X 4 11,200 GVWR	2005 FORD F350 CREW CAB 4 X 4 11,200 GVWR
REQUIRED GROUPS		
HY-RAIL® Application	203470	203470
Guide Wheel Unit - Front	200431	200431
Guide Wheel Unit - Rear	200432	200431
Manual Locks		
Front	200973	200973
Rear	200974	200974
Electric Locks		
Front	200312	200312
Rear	200313	200312
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	201622	201622
Front (Removable Manifold)	202462	202462
Rear (Manifold Welded on Cylinder)	201623	201623
Rear (Removable Manifold)	202463	202463
Mounting Brackets	196373	196373
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	203237	203237
Application Drawing - Front	023956	023956
Application Drawing - Rear	023957	023957
GUIDE WHEEL OPTIONS		
Rubber Tread	198510	198510
Steel Tread	198690	198690
BUMPER GROUPS		
Front With Sight Rods - Short	196382	196382
Front With Sight Rods - Long	202649	202649

	2005 FORD F350 SUPER CAB 4 X 4 11,200 GVWR HR0307A FRONT HR1500B2 REAR	2005 FORD F350 CREW CAB 4 X 4 WITH SRW 11,000 GVWR HR1500B2 FRONT HR2000B3-2 REAR
REQUIRED GROUPS		
HY-RAIL® Application	202509	203240
Guide Wheel Unit - Front	———	200431
Guide Wheel Unit - Rear	200432	———
Manual Locks		
Front	———	200973
Rear	200974	———
Electric Locks		
Front	———	200312
Rear	200313	———
Hydraulic / Manual Lock Group		
Front (Manifold Welded on Cylinder)	———	201622
Front (Removable Manifold)	———	202462
Rear (Manifold Welded on Cylinder)	201623	———
Rear (Removable Manifold)	202463	———
Mounting Brackets	203510	201507
Steering Lock	181548	181548
Velcro Steering Lock	201711	201711
Wheel Modification	203237	203237
Application Drawing - Front	024627	023956
Application Drawing - Rear	023957	024422
GUIDE WHEEL OPTIONS		
Rubber Tread - Front	198510	198510
Steel Tread - Front	198690	198690
BUMPER GROUPS		
Front Only With Sight Rods	———	202649

ACCESSORY GROUP OPTIONS

*	Rail Sweeps		
	Front (Flip Up)	200476	200476
	Front (Pull Up)	203113	203113
	Rear	200477	200477
	Rear With Splash Guard	203192	203192
	Grease Guard Group	203166	203166
	Hydraulic Group - Abbreviated	198696	198696
	Electric / Hydraulic Group		
	Manual Or Hydraulic Locks	201306	201306
	Manual Or Hydraulic Locks (With Remote Manifold - 1150 PSI)	202515	202515
	Manual Or Hydraulic Locks (With Remote Manifold - 1150 / 2000 PSI)	202460	202460
	Electric / Hydraulic Group		
	Electric Locks Only	201307	201307
	Electric / Hydraulic Group		
	Electric Locks Only (With Remote Manifold)	202458	202458
	Emergency Hydraulic Hand Pump Group	200870	200870
	Emergency Hydraulic Hand Pump Group (With Manual Lock Out)	202461	202461
	Emergency Hydraulic Hand Pump Retrofit Kit (Update 200870)	202605	202605
	In Cab Actuation	201308	201308
	In Cab Actuation (switch plate only)	203558	203558

* Recommended Safety Option

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