



SERVICE BULLETIN # 138

WARNING!!!!

THIS SERVICE BULLETIN ADDRESSES SAFETY RELATED INFORMATION. FAILURE TO COMPLY WITH THESE REQUIREMENTS CAN RESULT IN DEATH OR SERIOUS INJURY

DATE: 3-18-2014

TO: All Distributors and Up-fitters

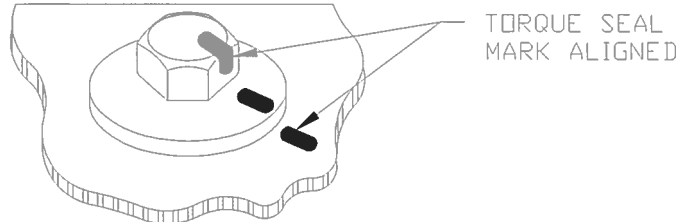
SUBJECT: Torqueing the Ring Gear Bolts after load testing.

CHANGE IN POLICY: Time Manufacturing has adopted a new policy regarding the torque of the rotation bearing bolts and pedestal/sub-frame mounting bolts. This new policy will replace the requirement to have the rotation bearing bolts and pedestal/sub-frame mounting bolts re-torqued 30 days after the initial In-Service (One-Time Service).

UNITS AFFECTED: All Versalift models manufactured after the date of this publication.

DETAILS OF THE NEW POLICY: Our new process of re-torqueing rotation bearing bolts and pedestal/sub-frame mounting bolts after the initial stability testing replaces the previous requirement to re-torque these bolts 30 days after the In-Service date. Our floor technicians will still initially torque all of the bolts to their proper tension, but you will notice that on the rotation bearing bolts (where applicable), there will only be a dot placed on the head of the bolt instead of our traditional torque stripe. For lifts shipped without the rotation bearing bolts and/or mounting bolts installed at Time Manufacturing, the up-fitter will be responsible for the initial torqueing prior to testing and then the final torqueing after testing is complete. We recommend marking the bolts after the first torqueing with a dot to indicate the bolts have been torqued prior to testing. The mounting bolts in your loose parts box will not be dotted.

WHAT YOU MUST DO: Once the unit has been mounted, torque the mounting bolts to their specified torque and install a torque dot. Once the load test has been performed, your technician shall apply the proper torque to ALL ring gear and mounting bolts to ensure they are tightened to factory specifications. Once this has been accomplished, your tech will install a torque stripe in accordance with our proper torque stripping procedure as addressed in the Service Manual.



BOLT MARKINGS & TORQUE CHART

Bolts With Nuts

Bolt Head Markings	Grade 5 Bolt	Grade 8 Bolt	Socket Head
Nut Markings	Grade B PTLN	Grade C PTLN	Grade C PTLN
Bolt Thread & Size	Torque ft-lb (N-m)	Torque ft-lb (N-m)	Torque ft-lb (N-m)
1/4 - 20	74 in-lb (8)	N/A	150 in-lb (17)
5/16 - 18	150 in-lb (17)	N/A	21 (29)
3/8 - 16	15 (20)	21 (29)	32 (44)
7/16 - 14	28 (38)	N/A	N/A
1/2 - 13	43 (58)	55 (75)	55 (75)
5/8 - 11	75 (102)	98 (133)	160 (218)
3/4 - 10	125 (170)	160 (218)	N/A
7/8 - 9	178 (242)	N/A	N/A
1 - 8	378 (514)	450 (610)	N/A

Special Threaded Fastener Applications

Bolt Thread Size & Type	Lubricant	Tapped Material	Torque ft-lb (N-m)
1/4 - 20 Grade 5 HHCS	Loctite 262	Steel	15(20)
3/8 - 16 Grade 5 HHCS	Loctite 262	Steel	28 (38)
3/8 - 16 SHCS & SHFH	Loctite 262	Aluminum	15 (20)
3/8 - 16 Grade 8 HHCS	Loctite 262	Steel	37 (50)
1/2 - 13 SHCS	Loctite 262	Steel	89 (121)
5/8 - 11 SHCS	30W Motor Oil	Rotation Bearing	160 (218)
5/8 - 11 Grade 8 HHCS	30W Motor Oil	Rotation Bearing	160 (218)
3/4 - 10 Grade 5 Threaded Rod	Loctite 262	Grade B Nut	145 (197)
3/4 - 10 Grade 8 HHCS	30W Motor Oil	Rotation Bearing	315 (428)
3/4 - 10 Grade 8 HHCS	Loctite 262	A572-50 Steel	210 (286)
7/8 - 9 Grade 8 HHCS	30W Motor Oil	Rotation Bearing	475 (644)

NOTES:

- Lubricate bolt threads liberally with 30W motor oil, unless fastener application is to be used on tapped material. Then use Loctite 262 on these fasteners with exception of rotation bearing.
- Apply torque to nut unless bolt is used in a tapped hole.
- All torque values are "running" torques (for initial and replacement installation only); the nut (bolt head) must turn. Use of an impact wrench is permissible only for run-up, not for tightening. During confirmation of previously torqued fasteners, the nut (bolt head) should not turn if proper torque is maintained.
- A minimum of two threads must protrude beyond the nut after tightening.
- The marks shown on this chart are for our current fastener suppliers.
- Refer to the critical fastener drawings for each Versalift for identification of specific fasteners.
- HHCS = Hex Head Cap Screw; HW = Hardened Washers; PTLN = Prevailing Torque Lock Nut; SHCS = Socket Head Cap Screw; SHFH = Socket Head Flat Head.

Letter of Compliance for Service Bulletin #138

This is to certify that Service Bulletin #138 has been reviewed and will be adhered to from the date of publication until further notice is given.

Distributor

Name _____