

BIRRANA A7031 PIN TO SUIT CAT 773 REAR STRUT CAT 777 CONTROL ROD ASSEMBLY INSTRUCTIONS

Most accidents involving machine operation or maintenance are caused by failure to observe basic safety rules or safety precautions. Read and understand all safety precautions and warnings, before attempting installation and operation of this component.

H-E Parts International cannot anticipate every possible circumstance that may involve a potential hazard. You must comply with all mine-specific safety procedures, and satisfy yourself that any procedure, tool or operation method used is safe for yourself and others.

Refer to the truck manufacturer's repair and maintenance instructions in conjunction with these instructions where applicable. Obey all recommended safety instructions or warnings.

Before working on any equipment make sure that the work area is safe, and that the equipment is tagged and locked out in accordance with mine safety procedures.

1. Remove the original pin as per manufacturer's instructions.
2. Ensure that the pin components, the chassis & axle housing / strut bores, and the surrounding areas are clean. The chassis & axle housing / strut bores must measure $\varnothing 69.80/69.95$. If the bores do not measure within specification, the bores must be reworked.
3. Assemble the pin through the bearing.
It is essential that an anti-seize compound (ie "Never-seize" or similar product) is used on the collet bores and tapers of the pin.
Do NOT use "Never-seize" on the outside of the collets, or in the chassis and axle housing bores. These surfaces must be clean and dry.
4. Loosely fit the collets to the chassis and axle housing bores. Tap the collets inwards, using a soft-faced hammer to engage the taper on the pin.
5. Apply Loctite 262 to the bolt thread. Install bolt with shields and washer. Fit the nut, and tighten finger tight only.
6. Ensure the pin is positioned centrally in the bearing, and tighten the 7/8" nut to a torque of 450 ft lbs (610 Nm).
7. Fit the grease nipples into the ends of the collets.
8. Use the grease nipples to slowly fill the collets with grease, until the grease can be seen at the positions illustrated.
Note: The purpose of the grease is not to lubricate the pin, but simply to prevent corrosion and make disassembly easier at a later stage.
9. At the next service interval, check the collet bolt torques. If below 450 ft lbs (610 Nm), use the procedure in step 6 to re-torque the bolt.

DISASSEMBLY INSTRUCTIONS

Most accidents involving machine operation or maintenance are caused by failure to observe basic safety rules or safety precautions. Read and understand all safety precautions and warnings, before attempting installation and operation of the brake wear gauge.

H-E Parts International cannot anticipate every possible circumstance that may involve a potential hazard. You must comply with all mine-specific safety procedures, and satisfy yourself that any procedure, tool or operation method used is safe for yourself and others.

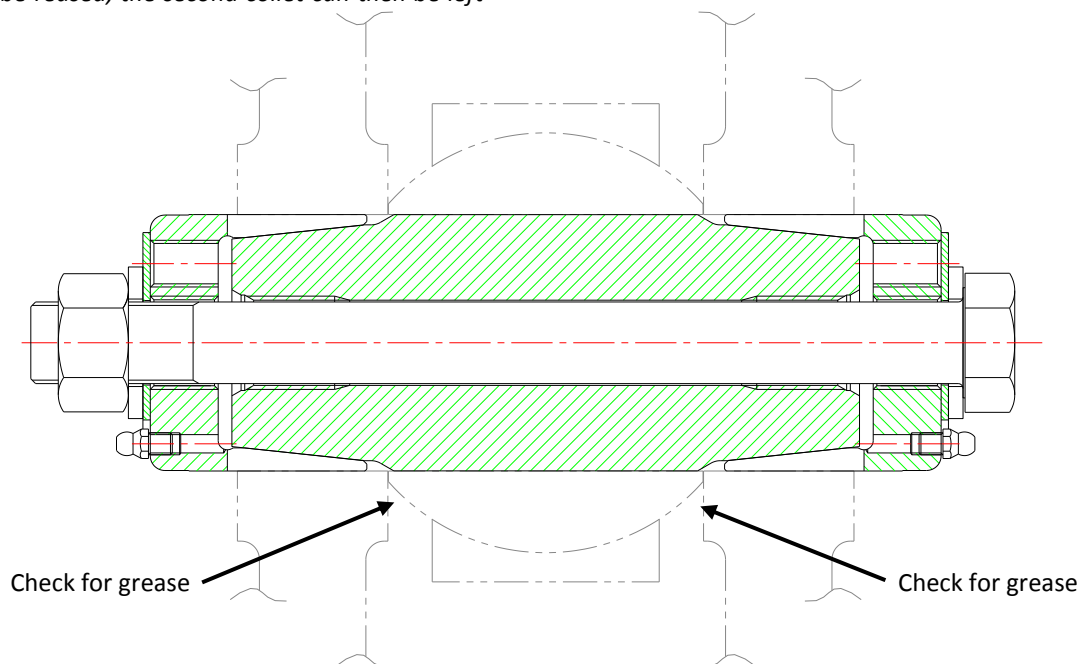
Refer to the truck manufacturer's repair and maintenance instructions in conjunction with these instructions where applicable. Obey all recommended safety instructions or warnings.

Before working on any equipment make sure that the work area is safe, and that the equipment is tagged and locked out in accordance with mine safety procedures.

Note: If the collets are undamaged, they may be used again. However, it is advisable that they are replaced with new ones. The old bolts should not be reused and should always be replaced with new bolts.

1. Undo the 7/8" nut, and remove the bolt from the centre of the pin.
2. Use either the three 1/2" UNF jacking holes, or the central 1" UNS extraction hole to extract one collet from it's bore.
3. Extract the remaining collet from it's bore, using either the jacking holes or central extraction hole.
4. If not previously removed, remove the pin.
5. Remove the control rod or strut assembly as per manufacturer's instructions.
6. If the second collet was not successfully removed previously, and the collet is to be replaced, it can now be removed with a soft drift.

Note: If when attempting to remove the collet, the pin moves instead of the collet, remove the pin. If the existing collets are to be reused, the second collet can then be left in it's bore.



If you require any further assistance with this procedure please contact your local H-E Parts representative.

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