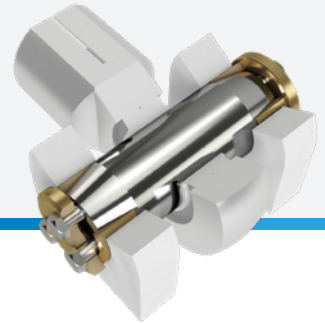


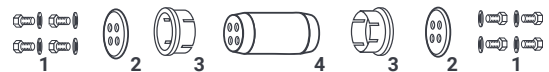
Expander[®] System Straight Pin, Multibolt INSTALLATION INSTRUCTIONS

6.0



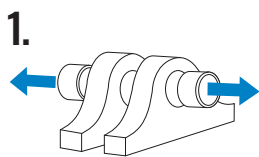
Congratulations

You have purchased a custom engineered solution to the pivot wear problem on your machine. Contact your dealer or Expander before proceeding if you have any questions.

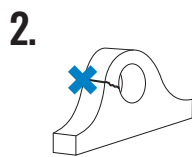


1 Bolt 2 Washer 3 Sleeve 4 Axle (Pin)

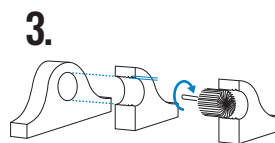
Preparation



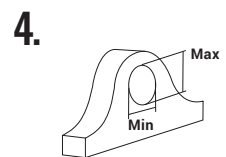
1. Remove any bushings in the lug ears to eliminate future wear between the bushing and the mounting lug.



2. Repair any structural damage i.e. cracks or bent lug ears before installation.



3. Smooth out irregularities and clean the bore surfaces.

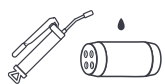


4. The difference between min and max diameter in the worn lugs must be within 1.5 mm (.06") for the sleeves to fit correctly.

ATTENTION! If the worn lugs diameter at any point is 2 mm (.080") or more over original lug diameter contact your dealer or Expander System. You will need oversized sleeves.

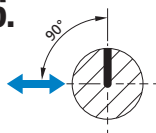
Installation

5.

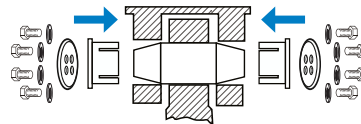


Lubricate the axle with available lubrication. Graphite grease is not to be used on threads.

6.



NOTE! If applicable: position greasing outlet 90 degrees to force direction to minimize stress concentration at outlet.



Insert the axle and position it in the bores. Install the sleeves, then the tension washers and fasteners. Cross-tighten the fasteners with torque as specified.

Torque recommendations

7.

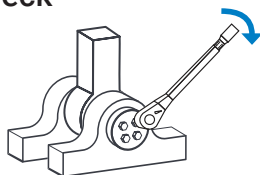
Hex Bolts

Torques M12-M24 $\pm 10\%$, M30... $+30/-0\%$

	M12	M14	M16	M20	M24	M30	M36	M42
lb-ft	52	85	129	258	369	443	516	664
Nm	70	115	175	350	500	600	700	900

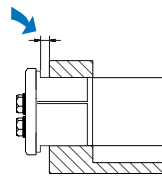
Final Check

8.



After initial torque, grease the pivot (if applicable), move the machine through full range of motion several times and recheck the torque. Check the torque after 10 hours, 40 hours and at regular service intervals to ensure proper seating of the sleeves.

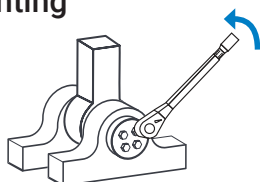
9.



Ensure that there is a minimum distance of 0,5 mm (0.02") between the washer and the lug. **NOTE!** If flange design for easy removal of the sleeve is used there should be a minimum distance of 6 mm. **ATTENTION!** If the washer is in contact with the lug, contact your dealer or Expander System.

Dismounting

10.



To dismount the Expander System, unscrew the fasteners on both sides and remove the washers.

11.



Tap the axle alternatively on left and right side until the tension on the sleeves is released (use a piece of pipe between the axle and the mallet/hammer not to damage the threads). Remove the sleeves (flanged sleeves could be removed using a puller). Remove the axle. Do not damage the threads.