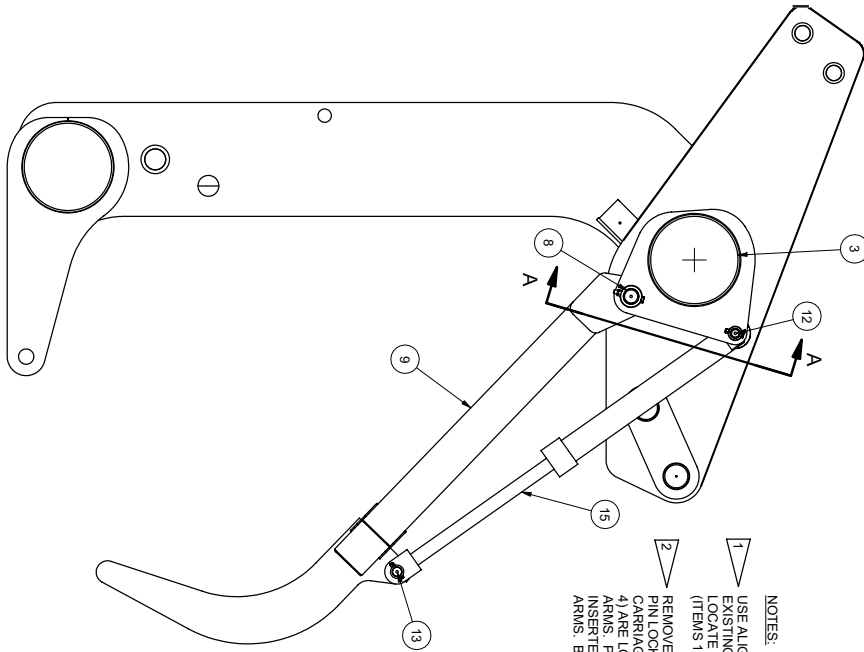
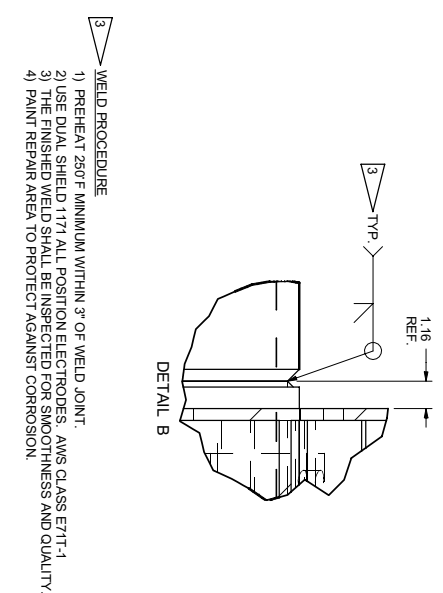
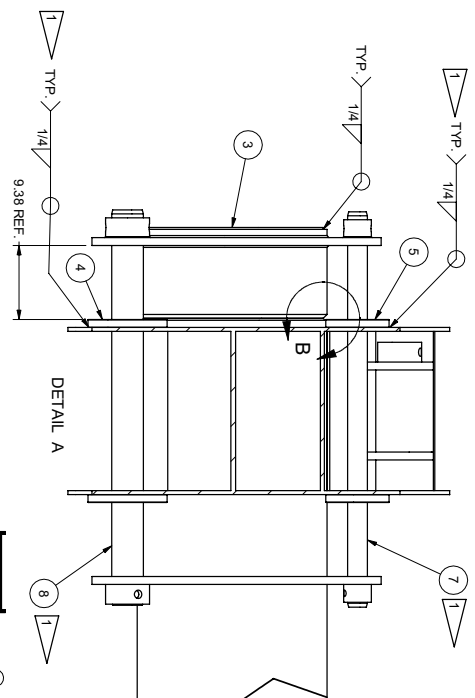

Auxiliary Holddown Kit



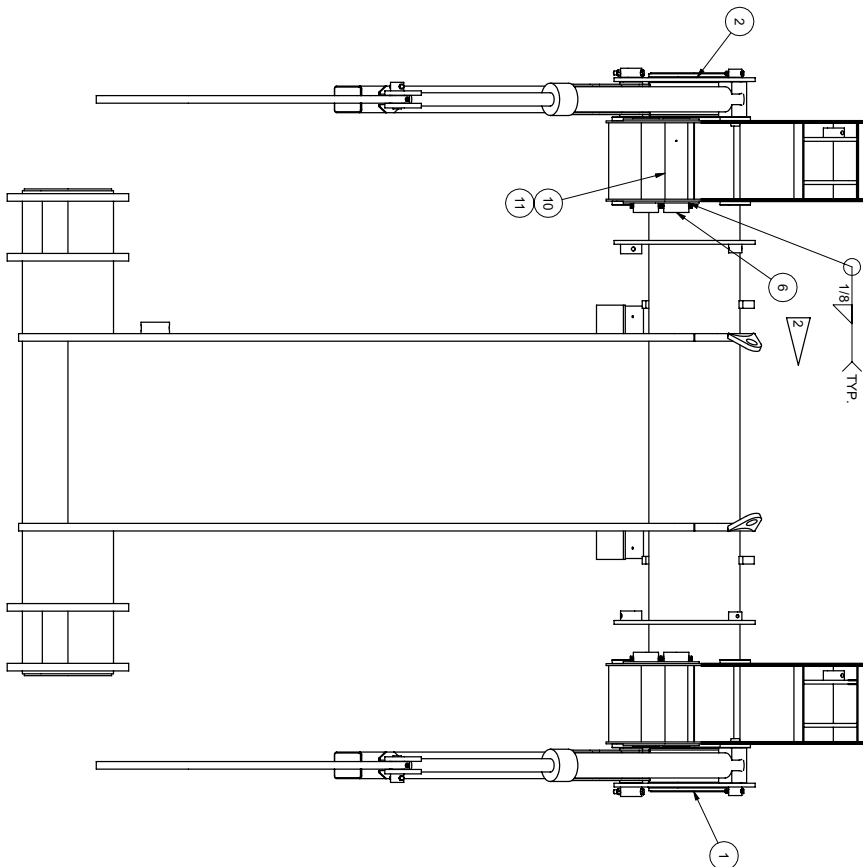
NOTES:

- 1) USE ALIGNMENT TUBES (ITEMS 7&8) AND EXISTING AIN, HOLD-DOWN AND LOCATOR BUSHES (ITEMS 4 & 5) AND EARS (ITEMS 1 & 2) FOR WELDING. BOTH SIDES.
- 2) REMOVE EXISTING KICK-OFF AND HOLD-DOWN PIN LOCK COLLARS FROM OUTSIDE OF THE CARRIAGE ARMS. NEW LOCK COLLARS (ITEM 4) ARE LOCATED ON THE INSIDE OF CARRIAGE ARMS. PIN WELDMENTS (ITEM 10) MUST BE INSERTED FROM THE OUTSIDE OF CARRIAGE ARMS. BOTH SIDES.



WELD PROCEDURE

- 1) PREHEAT 250°F MINIMUM WITHIN 3" OF WELD JOINT.
- 2) USE DUAL SHIELD 1171 ALL POSITION ELECTRODES. AWS CLASS E71T-1.
- 3) THE FINISHED WELD SHOULD BE INSPECTED FOR FITNESS AND QUALITY.
- 4) PAINT REPAIR AREA TO PROTECT AGAINST CORROSION.



Auxiliary Holddown Kit

Item	Part No.	Qty	Description	Item	Part No.	Qty	Description
	580747		Auxiliary Holddown Kit				
1	580750	1	. Ear, LH	9	570207	Ref.	Auxiliary Holddown Arm
2	580751	1	. Ear, RH	10	558364	Ref.	Pin
3	558194	2	. Pipe, Cap	11	558914	Ref.	Keeper
4	558322	2	. Boss	12	558326	Ref.	Pin
5	558323	2	. Boss	13	558325	Ref.	Pin
6	558228	4	. Lock Collar	14	558324	Ref.	Pin
7	580764	1	. Tube	15	558313	Ref.	Cylinder Assembly, Aux Holddown
8	580765	1	. Tube				