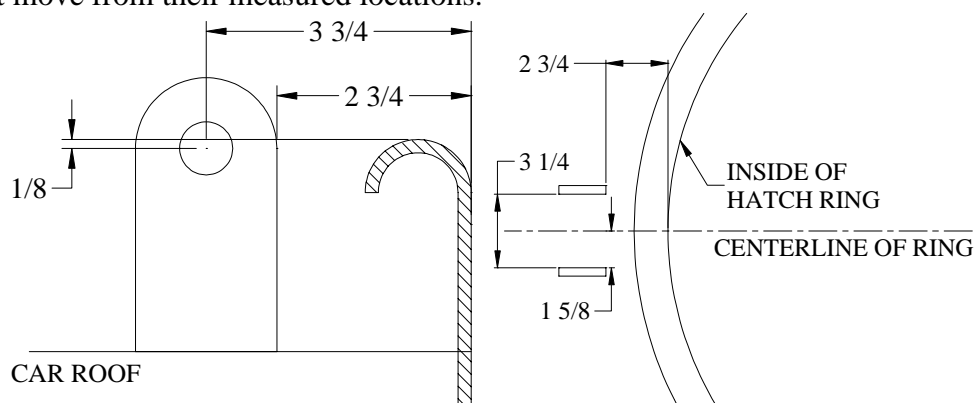




# INSTALLATION INSTRUCTIONS FOR BRACKETS AND LATCH FOR 30" PHC30UP AND VPHC30UP HATCH COVERS

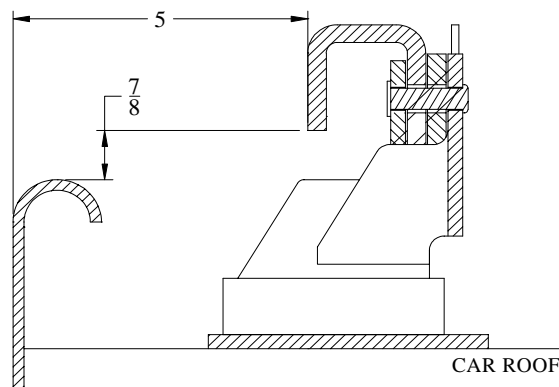
## Welding the Hinge Brackets to Fit Salco's PHC30UP and VPHC30UP Hatch Covers

1. Prepare the surface of the car to be welded.
2. Cut the hinge brackets to the correct length where the hinge hole is approximately 1/8" below the top of the ring.
3. Place each hinge bracket 2 3/4" to 2 7/8" from the inside of the ring so the hinge hole is 3 3/4" from the inside of the ring with a 3 1/4" spacing between the brackets.
4. Weld the brackets to the top of the car on all sides, making sure that the brackets do not move from their measured locations.



## Moving an IRECO Latch to Fit Salco's PHC30UP and VPHC30UP Hatch Covers

1. Cut the IRECO latch from the U-bracket and cut the U-bracket from the top of the car.
2. Prepare the surface of the car to be welded.
3. The mating part of the IRECO latch while in a closed position should be 7/8" above the top of the ring and 5" to 5 1/4" from the inside of the hatch ring.
4. Weld the U-bracket and latch to the top of the car maintaining the same dimensions described in number 3.



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