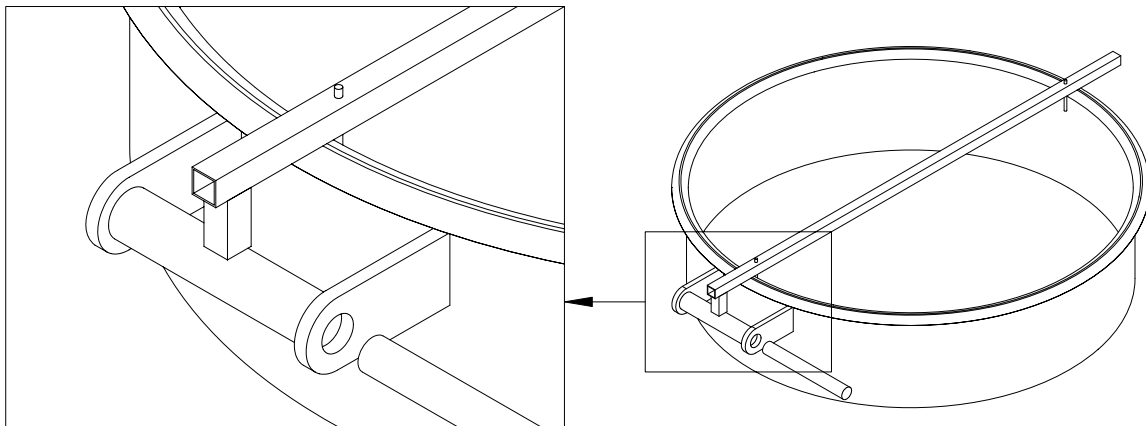


## INSTALLATION INSTRUCTIONS FOR HATCH COVER BRACKETS WITH THE HC30FIX3

These instructions apply to the installment of hinge brackets for Marine style hopper cars with 30" rings. The installation instructions for the hatch cover assemblies are separate.

1. Remove all existing hinge brackets that will interfere with the application of the new hinge brackets and the operation of the hatch cover.
2. Place the weld fixture on the ring. Center the fixture as best as possible. The fixture should be in line with the centerline of the car, parallel to the track.
3. Place a 1" diameter bolt or pin that is at least 7 1/2" long through the hinge brackets and weld fixture (Figure 1) to hold the brackets in place. If the position of the bracket causes an interference with the ring or the car roof, grind or cut the excess material to make the hinge bracket fit.
4. Weld the hinge brackets to the ring. If the brackets are close enough to the car roof, they may be welded to the car roof also.
5. Remove the weld fixture and use for the next ring on the car.
6. Install the SALCO hatch cover assembly per those directions.



**Figure 1**