

CHLORINE MANWAY BONNET DOME COVER INSTALLATION PROCEDURE

This procedure will explain how to install the SALCO chlorine dome cover. For new cars, skip the first step. The cover should fit standard arrangements for GATX, Union Tank, and ACF cars. Because of some differences in the car themselves, some steps may need to be added or removed for proper installation.

1. Remove the existing cover from the manway bonnet. If the seal pin is in good condition, it may be kept on the car. The existing cover and hinge pin may be discarded.
2. The provided hinge pin needs to be placed through the correct hole in the correct hinge casting. The pivot end casting and the hole it is used in is dependent on the car builder.
3. For GATX built cars, the hinge casting with the thin arc must be the pivot end. The hinge pin goes into the hole closest to the manway bonnet. Spacers are required on the pivoting end. Each spacer is placed between the hinge casting and the tabs welded to the manway bonnet. See Figure 1 for a picture of the hinge.
4. For ACF/Union Tank built cars, the hinge casting with the thick arc must be the pivot end. The hinge pin fits the vertical slotted hole furthest away from the manway bonnet. Spacers are not required on the pivoting end. See Figure 2 for a picture of the hinge.
5. (Recommended) Slide the clevis in each hole in the bottom of the pivot end casting. Tack weld the pin to the pivot end casting. This will keep the cover from sliding from the hole and slot when opening the cover.
6. Weld washers to the ends of the hinge pin to secure the cover.
7. Secure the other end of the cover with the seal pin.

Figure 1

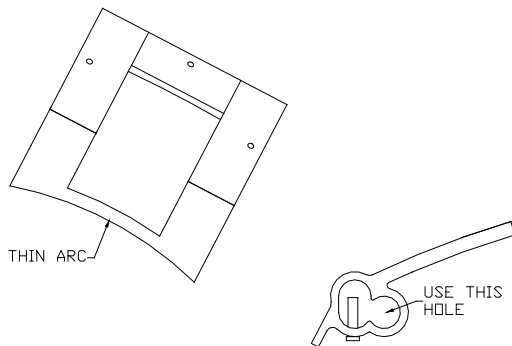


Figure 2

