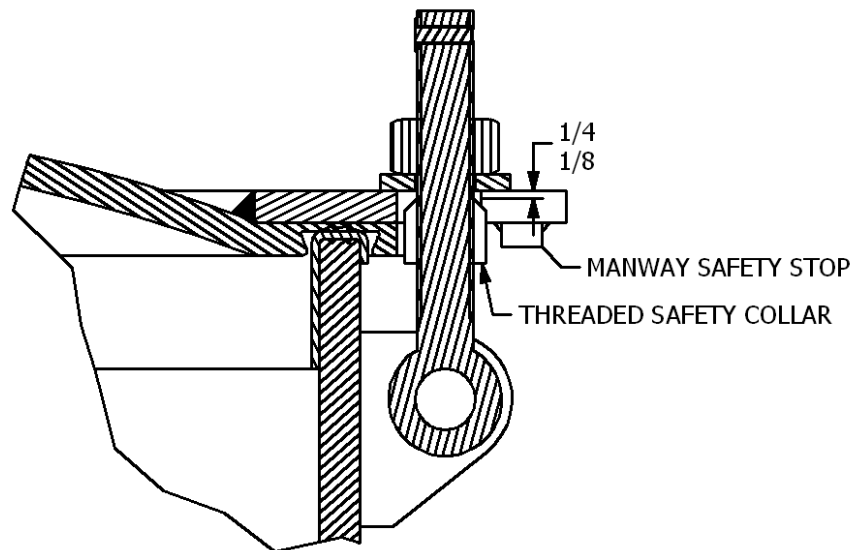


INSTALLATION INSTRUCTIONS FOR MANWAY EYEBOLT THREADED SAFETY COLLAR



1. Close the manway cover with gasket in place and hand tighten the nuts on the eyebolts
2. Tighten the manway cover eyebolts with a torque wrench to your company's specifications and using the proper tightening sequence per the AAR Appendix D, Section 6.6.
3. After the manway cover is tightened, position the threaded safety collar upwards so that it goes through the manway cover ring and touches the washer.
4. Move the threaded safety collar down 1/8" to 1/4" below the washer.
5. Weld, chisel check, or loctite the threaded safety collar in place (per your company procedures).
6. Loosen all manway cover eyebolts and nuts and check to make sure that the safety feature is functioning. The manway cover must be lifted upwards slightly in order for the eyebolt to swing out fully.
7. Because of tolerances on manway covers, eyebolts, and nozzles, the placement of the safety collar may vary slightly for each manway cover.