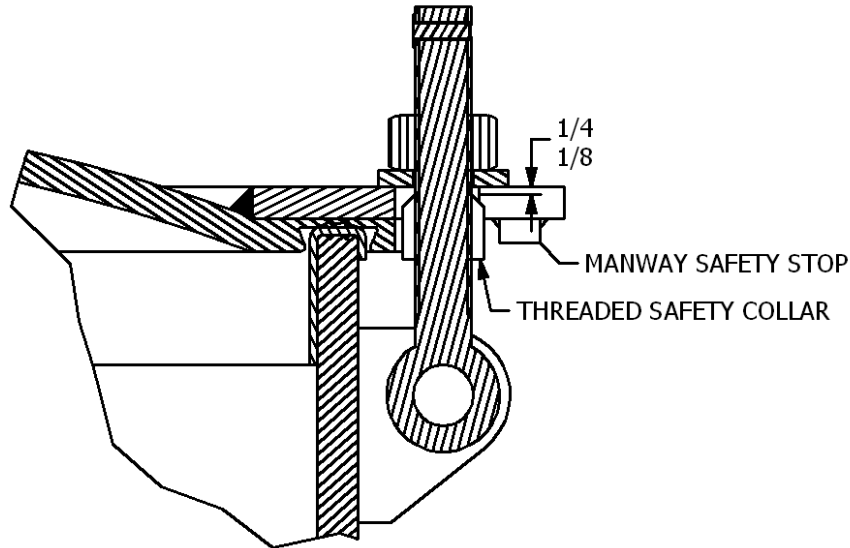


CUSTOMER ASSEMBLY INSTRUCTIONS FOR MANWAY EYEBOLT THREADED SAFETY COLLAR



1. Inspect all manway or fill hole cover eyebolts per C-III D 6.0, replace if defective and apply new gasket. Ensure replacement eyebolts are of the same material grade, thread size and length as were on the tank car.
2. Close the manway cover with gasket in place and hand tighten the nuts on the eyebolts.
3. Tighten the manway cover eyebolts with a torque wrench to car owner or lessee's specifications using the proper tightening sequence per the AAR Appendix D, Section 6.6.
4. After the manway cover is tightened, position the threaded safety collar upwards so that it goes through the manway cover ring and engages the washer.
5. Move the threaded safety collar down 1/8" to 1/4" below the washer.
6. Loosen all manway cover eyebolt nuts and check to make sure that the safety feature is functioning. The manway cover must be lifted upwards 3/8" to 1" in order for the eyebolt to swing out fully.
7. Weld or chisel check the threaded safety collar in place per car owner or lessee's procedures.
8. Because of tolerances on manway covers, eyebolts, and nozzles, the placement of the safety collar may vary slightly for each safety eyebolt.