

INSTALLATION INSTRUCTIONS FOR PHBK202

These instructions apply to the installment of hinge and latch brackets for Procor built hopper car with 20" rings. The installation instructions for the hatch cover assemblies are separate.

1. Remove all existing brackets and latch mechanisms from the ring and car roof.
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 1/2" diameter X 6 1/2" long bolt through the hinge brackets and weld fixture, see figure below for a picture of the brackets. 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 hinges fit.
4. Weld the hinges to the ring. If the brackets are close enough to the car roof, they may be welded to the car roof also.
5. Repeat Step 3 and 4 for the latch brackets except the bolt length should be 2-1/4" long.
6. Remove the weld fixture and use for the next ring on the car.
7. Install the SALCO hatch cover assembly per those directions.

