

INSTALLATION INSTRUCTIONS FOR SALCO 30" HATCH COVERS AND RINGS

The kit contains a car's worth of covers, rings, U-brackets and fasteners. If something is missing from a kit please call our Inside Sales department. These instructions will detail the installation of the ring, the placement of the latch, and installation of the cover.

Installation of the 30" Ring

1. All rings should have the hinge tabs and a location tab welded 180 degrees apart. The hinge brackets should be parallel to the centerline of the car.
2. Place the ring in the hole cut in the car. The hinge tabs and locator tab will lay on top of the roof of the car. Follow your company's welding procedure to ensure ring flatness and a seal around the ring and hinge tabs.
3. The U-bracket should be placed as shown on Fig 1, and be centered with the centerline of the car. Use the weld fixture to center the U-bracket. Seal weld around the whole U-bracket to the top of the car.

Installing an IRECO Latch to Fit Salco's PHC30SAL or VPHC30SAL Hatch Covers

4. On the hinge end, place a bolt through the hinge tabs and the weld fixture.
5. With the Ireco latch in the closed position, place the latch as shown in Fig 1.
6. Tack weld the Ireco latch on both sides.
7. Follow the steps in the cover installation, if the cover installation is found to be good, fully weld the latch to the U-bracket. The fillets weld should be 3/16" on the top and bottom of the Ireco latch and U-bracket. If it is not possible to put a full 3/16" fillet weld on the bottom of the Ireco latch, a smaller weld is allowable. The welds on the sides will be 3/16" fillet and/or flare bevel groove welds depending on exact layout. It is highly suggested to fully weld around the Ireco latch and U-bracket to keep rust from bleeding off on top of the car.

Cover Installation

8. Remove the cover from packaging with the nuts, bolts and washers.
9. Open the Ireco latch to the unlocked position.
10. Place the bolt and one washer through the holes in the hinge tab and the hole in the arm casting. Thread the nut on the bolt with the other washer. Make sure the cover opens and closes freely. For vented covers, there should be a minimum of a 1/2" between the car roof and bottom of the vent.
11. Follow your company's procedure for pull testing (aka dollar bill test) to ensure the gasket seals.
12. If the cover passes the pull test, follow step 7 in the previous section. If the cover fails the pull test, lower the Ireco latch to add more preload. If for some reason, there are other interference issues with the cover and the Ireco latch, they should be addressed at this point.
13. The cover should be able to freely rotate, and lay on top of the car roof in the open position. The rubber bumper should hit the car roof first.
14. The cover should be removed during painting and blasting, if any should occur after fit up.
15. During final fit up, ensure the gasket is clean before installation.

16. Please note, some customer specifications may ask for the nut to be tack welded to the bolt or the threads of the bolt to be chisel checked. If necessary, follow your customer's requirements for cable sealing the Ireco latch.

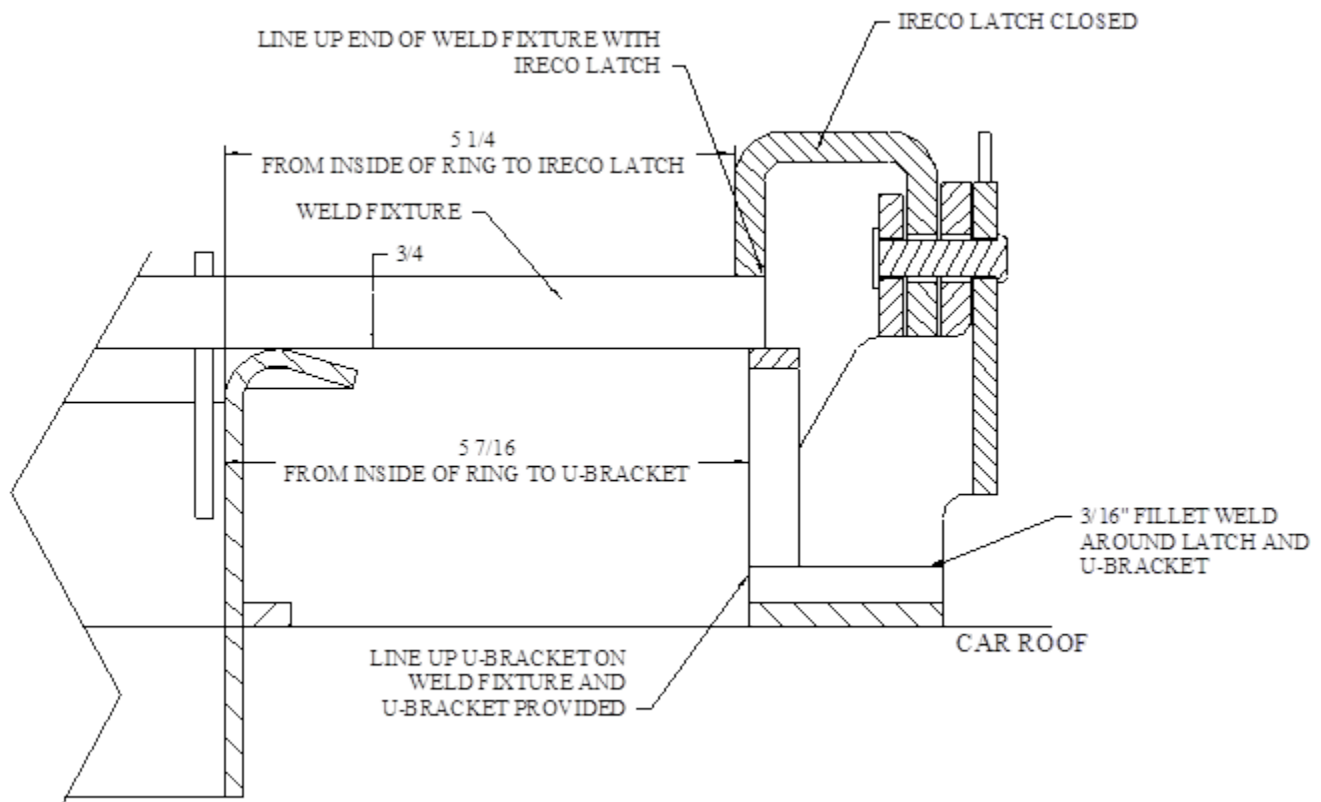


Figure 1