

INSTALLATION INSTRUCTIONS FOR GATE GASKETS

1. If your gasket is in a 4-pack box, remove the gasket from the box and lay it flat in a clean area to allow the gasket to relax.
2. Inspect the hopper car gate flanges for cleanliness. The sealing surface of the flanges must be free of dirt, rust, scale or any other foreign material that can compromise the gasket seal. If debris is present, clean the flanges to an acceptable finish.
3. Place the gasket onto the flange of the gate.
4. Utilizing ½" bolts that are longer (approx. 5" – 6" long), hang the gate from the outlet by the corners. (**Note:** Longer bolts are for installation only and will be replaced once the gate is bolted up.)
5. Position the gasket holes to be in line with the outlets' bolting holes. Raise the gate closer to the outlet by tightening the corner bolts.
6. Insert the bolts and washers (remembering to replace corner bolts) and tighten the nuts hand tight, leaving enough room to adjust the gasket so the interior edge is as close as possible to the interior radius of the outlet gate without protruding into the load.
7. Bolts should be tightened to the torque specified below. When using Nord-Lock washers, two Nord-Lock washers are required per bolt. Salco's recommendation is to tighten the bolts in a pattern similar to Figure 1. **DO NOT TIGHTEN IN A CONTINUAL FASHION!** This will create an uneven seal. Customers may develop their own pattern provided they have performed testing to ensure that an even seal has been achieved.
 - a) Standard Washers: 30 – 45 ft-lbs.
 - b) Nord-Lock Washers: 35 – 50 ft-lbs.

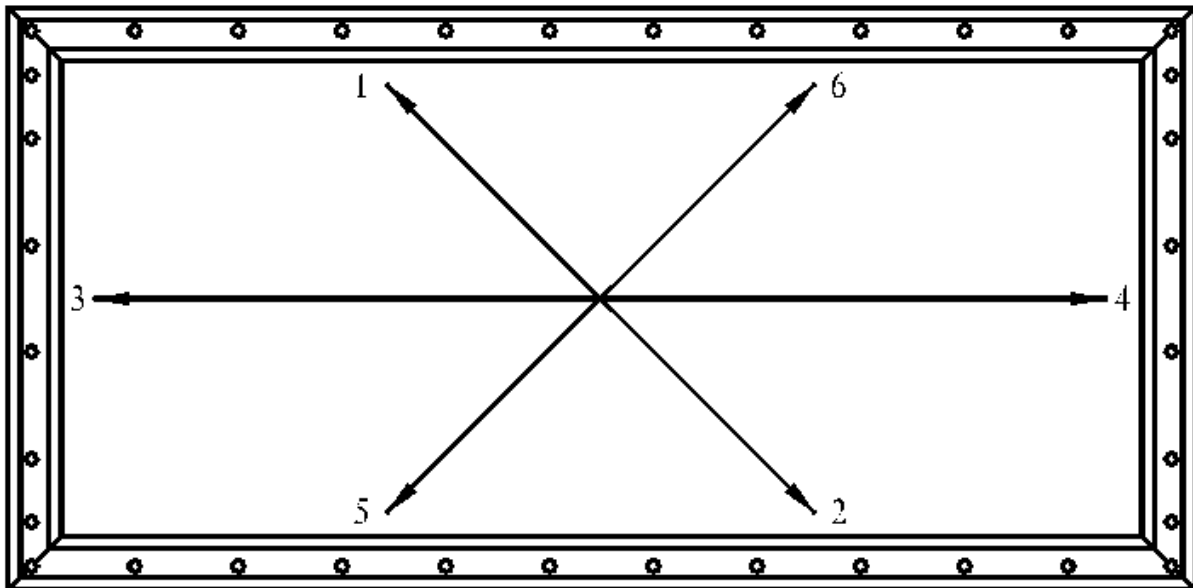


Figure 1