

MODIFICATION OF R-450 REAR MOUNTING BRACKETS FOR SPRING HANGER BOLT REMOVAL/REPLACEMENT

SAFETY PRECAUTIONS

If any problems are encountered, please call G&B Specialties for technical assistance before continuing with the process.



- Failure to heed to any of the following warnings could result in severe bodily injury and/or equipment damage.
- Read and understand this manual completely before attempting any modifications of the equipment.
- Modifications provided below only address the Rafna railgear equipment. Applicable railway company procedures and policies must be adhered to.
- Before performing any work under the vehicle or railgear, ensure the engine is turned off and the parking brake is set.
- Do not start the vehicle with the power steering hoses disconnected. Reconnect all hoses and secure the power steering cooler if the vehicle is started.
- Ensure all removed components are given to the vehicle owner after the modification of the railgear. These components must be re-installed if the railgear is removed from the vehicle.
- Always disconnect the vehicle's battery when welding on the vehicle or railgear to protect the vehicle's electrical system.
- Railway Company rules governing rail travel must be observed at all times.
- Never operate the vehicle if the Gross Vehicle Weight Rating (GVWR), Gross Axle Weight Rating Front or Rear (GAWR), or the wheel or tire load ratings are exceeded.

MODIFICATION OF REAR MOUNTING BRACKETS

The following procedure details the modification of the R-450 Rear Mounting Brackets.

1. Remove any cover, shroud etc. needed to gain access to the rear mounting bracket.
2. From the rear of the bracket, measure 17.94" in, and from the top of the bracket measure 5.91" down. Place a mark where these two dimensions intersect. (Refer to Figure 1)
3. Visually inspect the mark made looks to line up with the head of the spring hanger bolt.
4. Once mark is confirmed, drill a 1 3/4" hole at the marked location. Stepping drill bits, uni-bits, etc. are all acceptable. Torching is not a recommended method for modification.
5. With hole made, ensure socket will fit through and go over the head of the bolt. Reaming the hole may be necessary upon inspection to get proper fit based on installation location etc. of the railgear.
6. After the hole is verified and proper access to the bolt head is determined, repeat process for the other bracket. **NOTE:** Dimensions and measurement locations are the same and apply to both brackets.
7. Clean any metal shavings from the gear after drilling.
8. Paint any newly exposed metal surfaces to prevent rusting.

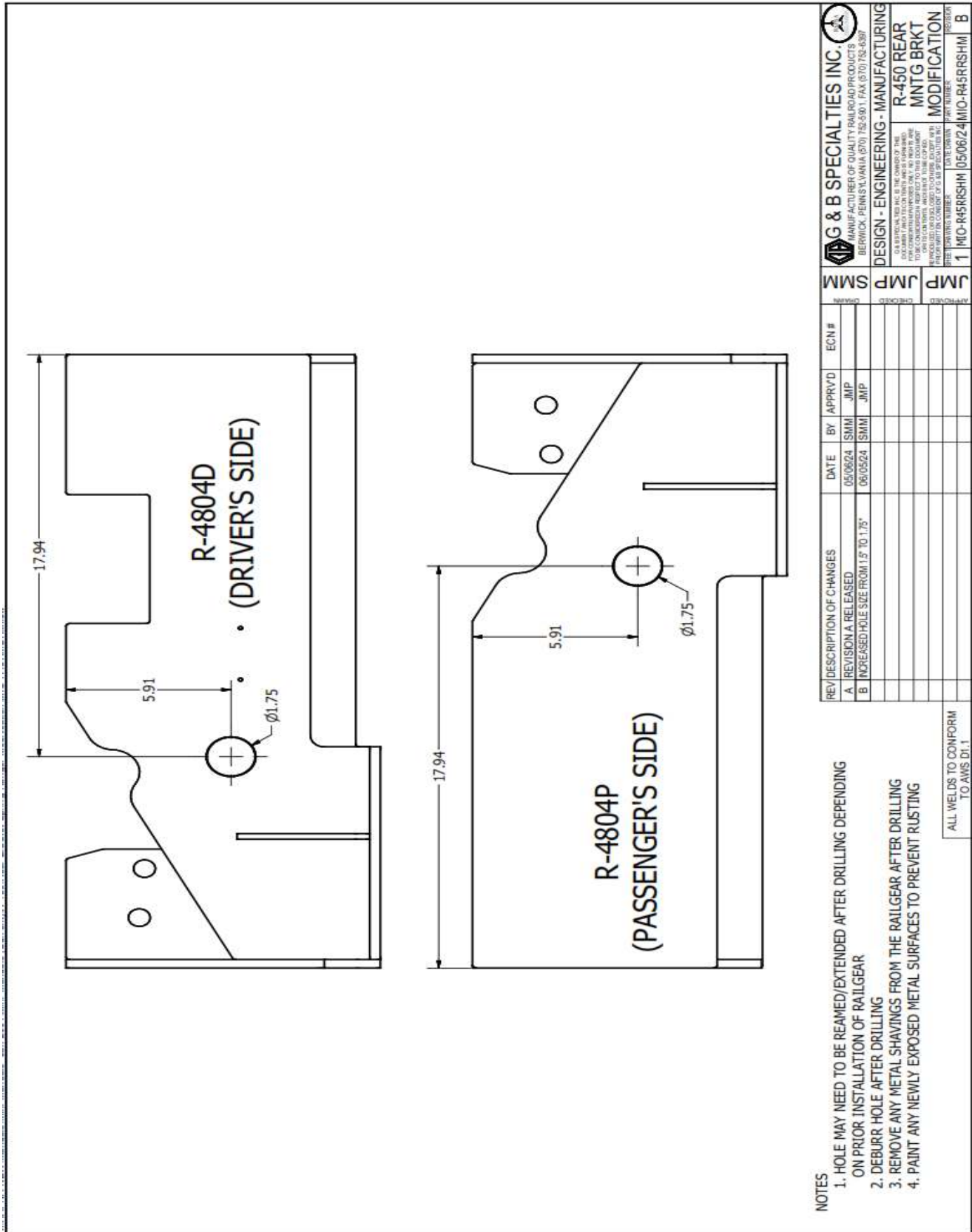


Figure 1: Bracket Modification