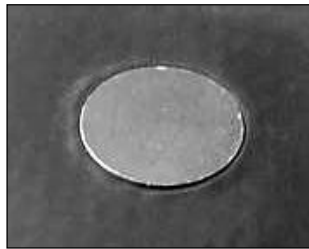


⚠️ Rotating machinery can cause serious injury or death, always lockout and tagout the machine prior to installation.

1. Fender washers are recommended for buckets with flat holes.
2. Domed washers are recommended for buckets with recessed holes.
3. Standard hex nuts and split ring lock washers are recommended for #1 Norway bolts. Nylock nuts should only be used with Fanged or Easifit elevator bolts since the bolt is held in place during installation.
4. Tighten the elevator bolt until the head is drawn just below the surface of the belt (Image A).
5. Do not exceed the bolt's maximum recommended torque (see table below).
6. Inspect the bucket assembly periodically and re-tighten bolts as necessary.

Image A - Bolt Head Drawn Just Below Belt Surface



#1 Norway Bolt Installation Shown

Recommended Bolt Configurations:

#1 Norway Bolts:

- Hex Nut
- Split Ring Washer
- Fender Washer*
- Bucket
- Belt
- Bolt Head



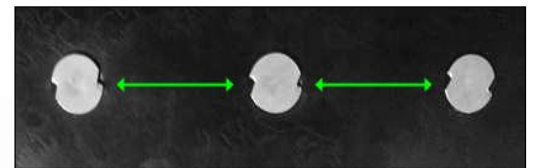
Easifit Bolts:

- Nylock Nut
- Fender Washer*
- Bucket
- Belt
- Bolt Head



Fanged Bolts:

- Nylock Nut
- Fender Washer*
- Bucket
- Belt
- Bolt Head



Install fanged bolts with fang tips in-line across the width of the belt to minimize the stress of the flat head going around the curved pulley.

* Use domed washer for recessed holes.

For metal buckets with flat holes, small flat washers are normally used.

⚠️ Use anti-galling lubricant when installing stainless steel nuts/bolts

⚠️ Do NOT use Fanged Bolts on PVC 250 or Lighter Belting

⚠️ Do NOT use Nylock Nuts with Temperatures Over 250 ° F

⚠️ Do NOT re-use Nylock Nuts

Maximum Recommended Bolt Torque:

SAE GRADE 2 OR 304 STAINLESS STEEL			
Bolt Diameter	in. lbs.	ft. lbs.	Nm
1/4"	72	6	8
5/16"	156	13	18
3/8"	276	23	31
1/2"	684	57	77

METRIC ISO GRADE 5.8			
Bolt Diameter	in. lbs.	ft. lbs.	Nm
M6	72	6	8
M7	115	10	13
M8	168	14	19
M10	336	28	38
M12	588	49	66