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

---

**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

* 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**

---

**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

---

**Recommended Maximum Bolt Torque:**

<table>
<thead>
<tr>
<th>SAE GRADE 2 OR 304 STAINLESS STEEL</th>
<th>METRIC ISO GRADE 5.8</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bolt Diameter</td>
<td>in. lbs.</td>
</tr>
<tr>
<td>1/4&quot;</td>
<td>72</td>
</tr>
<tr>
<td>5/16&quot;</td>
<td>156</td>
</tr>
<tr>
<td>3/8&quot;</td>
<td>276</td>
</tr>
<tr>
<td>1/2&quot;</td>
<td>684</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
</tbody>
</table>

---

**Maximum Recommended Bolt Torque:**

<table>
<thead>
<tr>
<th>SAE GRADE 2 OR 304 STAINLESS STEEL</th>
<th>METRIC ISO GRADE 5.8</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bolt Diameter</td>
<td>in. lbs.</td>
</tr>
<tr>
<td>1/4&quot;</td>
<td>72</td>
</tr>
<tr>
<td>5/16&quot;</td>
<td>156</td>
</tr>
<tr>
<td>3/8&quot;</td>
<td>276</td>
</tr>
<tr>
<td>1/2&quot;</td>
<td>684</td>
</tr>
<tr>
<td></td>
<td></td>
</tr>
</tbody>
</table>

---

**Safety Precautions:**
- **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