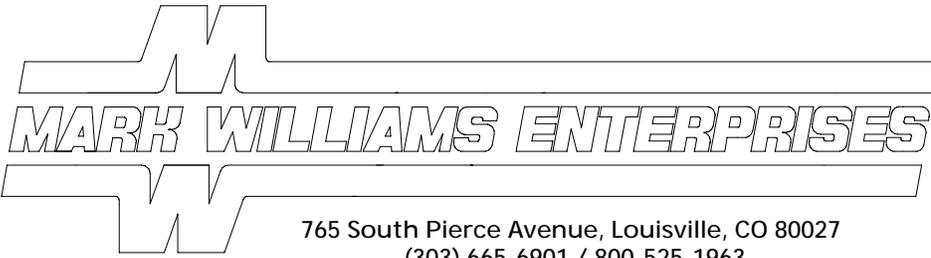


INSTALLATION - SERVICE INSTRUCTIONS



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SERVICE BULLETIN

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MODULAR STEEL TUBES

APRIL 5, 1994

PART NUMBERS : 95500
DESCRIPTIONS : MODULAR HOUSING WITH 4130 TUBES.

PARTS INCLUDED :

1-ALUMINUM MODULAR CENTER SECTION, 2-HOUSING ENDS OF CHOICE, 2-END BELLS WITH 4130 3-1/4" TUBES, 2-END BELL O-RINGS, 2-ANTI ROTATION STUDS, 16-END BELL STUDS WITH WASHERS AND 12 POINT NUTS, 2-TUBE RETAINERS, 10-THIRDMEMBER ATTACHMENT STUDS WITH NUTS AND WASHERS, 1-GASKET, 1-HOUSING VENT, 1-ALUMINUM FILLER CAP WITH O-RING, 1 PUMP COVER WITH O-RING AND 4-MOUNTING SCREWS AND 8-TUBE RETAINER STUDS WITH WASHERS AND NUTS.

PRIMARY APPLICATION :

STREET ROD APPLICATION.

INSTALLATION OVERVIEW :

- 1) WHEN ASSEMBLING MODULAR HOUSING AND TUBES WITH END BELLS BE SURE ALL MOUNTING SURFACES ARE SMOOTH (FREE OF NICKS). <T>IF PAINTING HOUSING ALL MOUNTING SURFACES AND STUDS MUST BE KEPT FREE OF PAINT.
- 2) BE SURE END BELL O-RING (2-045) ARE SEATED AND LUBED LIGHTLY.
- 3) THIRDMEMBER GASKET MUST BE .030 THICK.

TORQUE SPECS :

3/8" - 24 THIRDMEMBER ATTACHMENT STUD NUTS	30-35 FT. LBS.
3/8" - 24 TUBE RETAINER STUD NUTS	30-35 FT. LBS.
1/2" - 20 END BELL STUD NUTS	70-75 FT. LBS.

MAINTENANCE REQUIREMENTS :

PERIODIC INSPECTION OF TORQUE ON END BELL NUTS. PERIODIC INSPECTION OF WELD BETWEEN TUBE RETAINER AND TUBE. MODULAR HOUSING REQUIRES FOUR (4) QUARTS OF GEAR LUBE. M-W RECOMMENDS TORCO SAE 85-140 GEAR OIL. IF REMOVING ANY OF THE STUDS, HEAT AROUND STUD AREA TO SOFTEN LOCTITE BUILDUP.

