

Document Version Control		
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AP0005	1	24/10/2016

LOCKJAW LOCK ASSEMBLY PROCEDURE

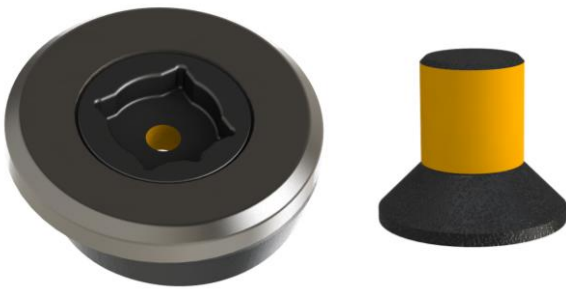
SAFETY NOTICE

Working on heavy equipment is dangerous. Please ensure you have considered your workplace safe work procedures and the following key points before commencing any assembly or installation procedures.

1. Wear correct PPE including:
 - a. Full length clothing and work gloves
 - b. Safety work boots
- Safety glasses
- Hearing protection
2. Good general housekeeping to ensure the work area is safe and free of clutter.
3. Use appropriate lifting apparatus to lift heavy items. Please refer to your work place procedures. Lifting points are provided and weights specified on all parts.
4. Ensure appropriate tags for your work place and work environment are used.

PLEASE NOTE: THIS PROCEDURE WILL REVIEW THE ASSEMBLY OF A LOCKJAW LOCK. THIS GENERAL PROCEDURE MAY BE APPLIED TO ANY LOCKJAW PRODUCT!

1) Clean & or prime the threads of the Lock and the Cap Screw using a high quality compound such as: Loctite 7649 Primer or Equivalent



2) Apply a thick coating of Anti-Seize compound to the inside and outside of the Bush. Then fit the Bush on to the Lock Body.

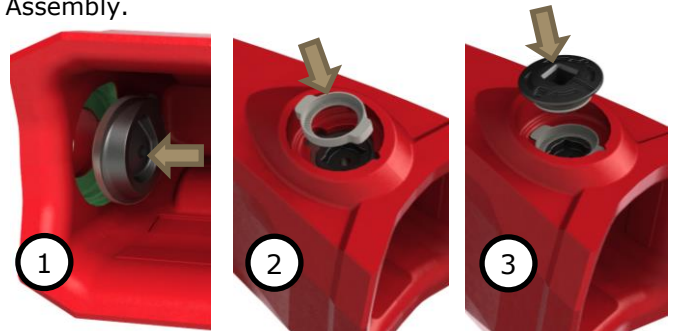


CAUTION do not allow Anti-Seize compound to contact the Lock threads.

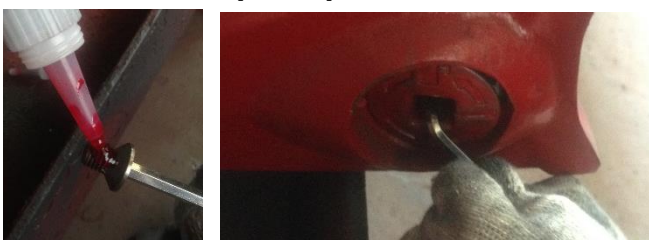
3) Assemble the Rubber Spring and Ratchet Core on to the Activator.



4) Insert the Lock and bush into the Lock Cavity, followed by the Ratchet Body and then the Activator Assembly.



5) Apply a liberal amount of High Strength thread locking compound to the threads of the Cap Screw and attach the Activator to the Lock. Torque the Cap Screw to **44 ft lb (60Nm)** minimum.



- If rebuilding Lock Assembly utilise new Cap Screw

6) Check the internal installation is correct. The Cap Screw should tighten until only one or less threads remain exposed on the lock. Then check the lock is correctly aligned with the lock indicator.



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LOCKJAW LOCK ASSEMBLY BOM

