

BIRRANA A-FRAME HITCH PIN ASSEMBLY

Truck	Serial No.	Part No.	
		Without Caps	With Caps
CAT 777 A/B/C/D	All Models	A4684	A4972
CAT 785 A/B/C	All Models		
CAT 789A	9ZC1 - 441	A5620	A5913
CAT 789A	9ZC442 - Up	A5620	A5635
CAT 789B	7EK1 - Up		
CAT 789C	2BW1 - Up		

Most accidents involving machine operation or maintenance are caused by failure to observe basic safety rules or safety precautions. Read and understand all safety precautions and warnings, before attempting installation and operation of this component.

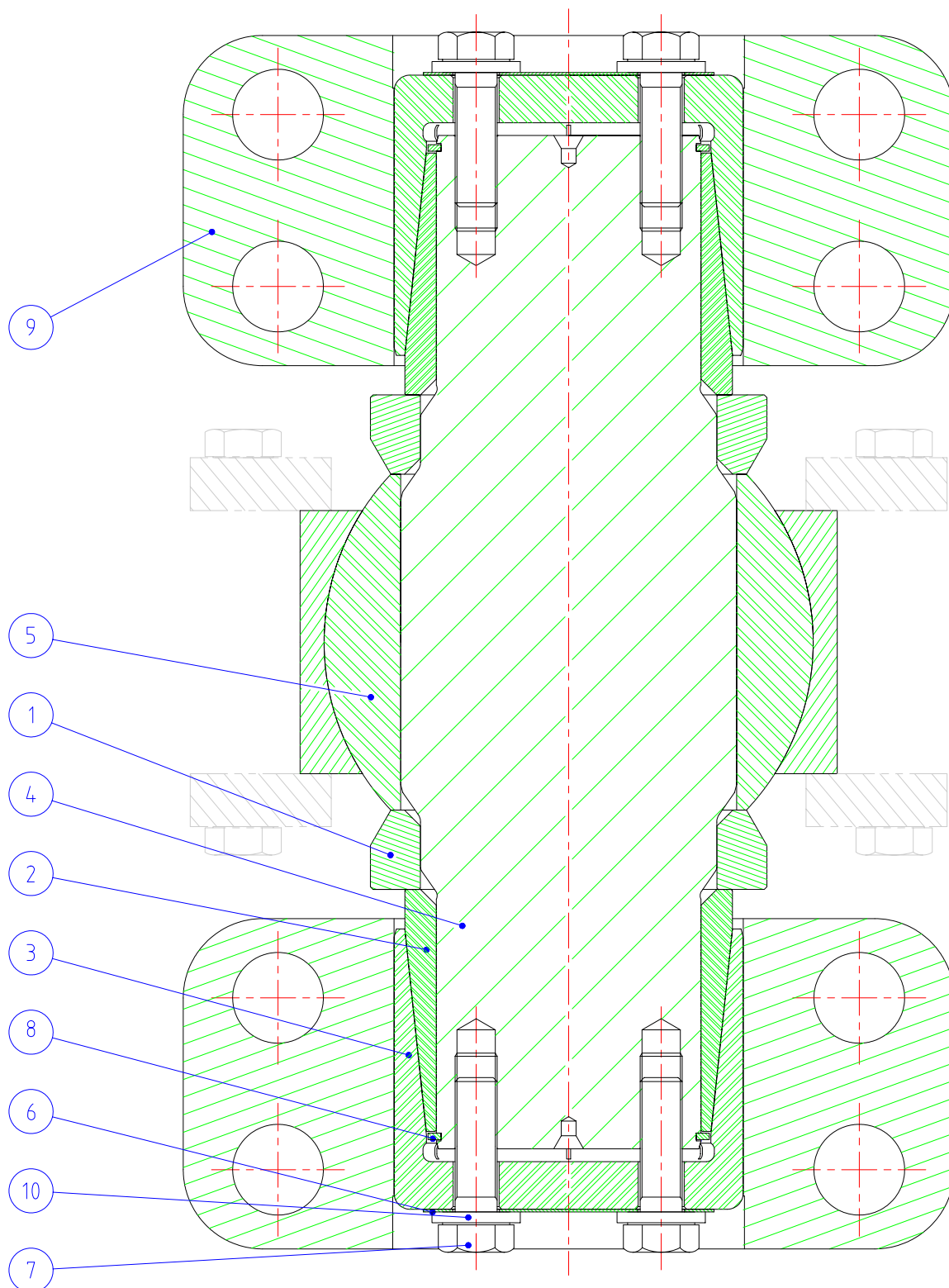
Birrana Engineering cannot anticipate every possible circumstance that may involve a potential hazard. You must comply with all mine-specific safety procedures, and satisfy yourself that any procedure, tool or operation method used is safe for yourself and others.

Refer to the truck manufacturer's repair and maintenance instructions in conjunction with these instructions where applicable. Obey all recommended safety instructions or warnings.

Before working on any equipment make sure that the work area is safe, and that the equipment is tagged and locked out in accordance with mine safety procedures.

- Remove and disassemble the original pin, bearing and caps as per manufacturer's instructions.
- Ensure that the pin components, the A-frame bore and the surrounding area are clean. The chassis cap bores (item 9) must measure $\varnothing 132.10/132.00$. The A-frame bore must measure $\varnothing 203.175/203.100$. Install the bearing assembly (item 5) and retaining plates to the axle housing A-frame as per manufacturer's instructions. Pre-lubricate the bearing with grease.
Suggested grease for bearing pre-lubrication is extreme pressure (EP) Grease containing molybdenum disulphide.
- Apply "Never-seize" (or similar product) to the inside and outside diameters of the sleeves.
Do NOT use "Never-seize" on the outside of the collets (item 3) or in the bore of the chassis caps (item 9). These surfaces must be clean and dry.

Assemble the pin (item 4) through the bearing (item 5) and fit spacers (item 1), sleeves (item 2) and circlips (item 8).
- Loosely fit chassis caps (item 9) and collets (item 3) to the pin assembly ensuring that the chassis cap face stamped "outside" (ie counterbored side) is facing towards the end of the pin.
- Lubricate the collet bolts (item 7) with "never-seize". Install bolts with washers (item 10) & shield (item 6) and tighten finger tight only. DO NOT tighten the bolts at this stage, as the caps will need to be accurately positioned later. Keep the pin positioned centrally in the bearing.
- Offer the A-frame up to the chassis and align the chassis caps (item 9). Fit the original chassis cap bolts (4 per cap) and tighten as per manufacturer's instructions.
- Tighten the collet bolts (item 7) **evenly** and **incrementally** on each end of the pin in turn to ensure that the pin remains positioned roughly central in the bearing. The final torque should be 220 – 250 Nm (160 – 180 ft lb).
- Ensure that the collets are properly seated by re-torquing the bolts until there is no further collet movement.
- Liberalily lubricate the bearing with grease prior to operation.
- At the next service interval, check the collet bolt torques. If below 220 Nm (160 ft lb), use the procedure in step 7 to re-torque the bolts.



*If you require any further assistance with this procedure please contact your local Birrana representative.
Adelaide (08 8445 7755) Perth (08 9370 5048) Mackay (07 4952 5422) Singleton (02 6571 4488)*