

## BIRRANA A9622 STRUT PIN TO SUIT CAT 784/785 TRUCKS AND TRACTORS

### ASSEMBLY INSTRUCTIONS

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.

1. Remove the original pin as per manufacturer's instructions.
2. Ensure that the pin components, the chassis and axle housing bores, and the surrounding areas are clean. The chassis and axle housing bores must measure  $\varnothing 114.30/114.45$ . If the bores do not measure within specification, the bores must be reworked.
3. Assemble the pin through the bearing.  
***It is essential that an anti-seize compound (ie "Never-seize" or similar product) is used on the collet bores and tapers of the pin.***  
***Do NOT use "Never-seize" on the outside of the collets, or in the chassis and axle housing bores. These surfaces must be clean and dry.***
4. Fit the collet *without* the grease nipple or jacking holes, to the axle housing bore closest to the tyre.
5. Loosely fit the collet with the grease nipple and jacking holes, to the axle housing bore furthest from the tyre. Tap the collet inwards, using a soft-faced hammer to engage the taper on the pin.
6. Apply Loctite 262 to the bolt thread. Ensuring that it is finger tight only, install bolt with shield and washer.
7. Ensure the pin is positioned centrally in the bearing, and tighten the 7/8" bolt to a torque of 450 ft.lb (610 Nm).
8. Fit the grease nipple into the end of the collet.
9. Use the grease nipple to slowly fill the collet with grease, until the grease can be seen at position illustrated.  
*Note: The purpose of the grease is not to lubricate the pin, but simply to prevent corrosion, and make disassembly at a later stage easier.*
10. At the next service interval, check the bolt torque. If below 450 ft.lb (610 Nm), use the procedure in step 7 to re-torque the bolt.

*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)*

## DISASSEMBLY INSTRUCTIONS

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.

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*Note: If the collets are undamaged, they may be used again. However, it is advisable that they are replaced with new ones. The old pin should not be reused and should always be replaced with a new pin.*

1. Undo the 7/8" bolt, and remove from the centre of the pin.
2. Use either the three 5/8" UNF jacking holes, or the central 1"UNS extraction hole to extract the collet furthest from the tyre.
3. Extract the remaining collet from it's bore, using the central extraction hole.

*Note: If when attempting to remove the collet, the pin moves instead of the collet, remove the pin. If the existing collets are to be reused, the second collet can then be left in it's bore.*

4. If not previously removed, remove the pin.
5. Remove the strut assembly as per manufacturer's instructions.
6. If the second collet was not successfully removed previously, and the collet is to be replaced, it can now be removed with a soft drift.

