

**TECHNICAL SERVICE BULLETIN
RAFNA RAILGEAR**

ISSUE DATE: April 22, 2008

TSB NUMBER: TSB178

HAZARD / URGENCY RATING

X	DANGER - Physical harm is possible if TSB is not observed or followed
X	WARNING - Equipment damage is possible if TSB is not observed or followed
	CAUTION - Essential issue affecting operation, service, parts or installation
	INFORMATIONAL - Advisory which may be of interest

APPLICABLE EQUIPMENT:

G&B Specialties R-450 Rotating Rear Railgear installed on Ford F450/F550 Chassis Cab Trucks

SUMMARY:

In certain situations, excess dirt and debris can accumulate on rear axle lock-up plate assembly. This may cause rear lock-up pins to become inoperable. If the rear lock-up does not engage in road lock-up position, there is a possibility that excess stress can cause failure of the threaded rods, possibly causing the lower axle to separate from the guide tubes.

IMPACT:

The installation of the chain kit can be used for a safety precaution in the event of a failure.

ACTION:

Follow the steps below for proper installation of the safety chain kit.

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Installation of Rear Safety Chain Kit

The following procedure details the installation of the Safety Chain Kit on the R-450 rear railgear. The hardware required for this installation is listed in Table 1.

Table 1: Rear Safety Chain Kit Installation Parts		
Part Number	Description	Quantity
R-18060	Chain, Steel Poly-Coated (7 Links)	2
-	Screw, UNC, 0.3125" x 1.50" Hex Cap Z/Y	4
-	Washer, Flat 0.3125" Type-A Z/Y	8
-	Nut, 0.3125" Reg Hex Nylon Insert Lock Z/Y	4

1. Drill 5/16" hole on the inside of both Outer Guide Tube Assemblies shown in Fig 1.1
2. Drill 5/16" hole on the inside of both Inner Clevis Assemblies shown in Fig 1.1.
3. Clean and deburr holes of all sharp edges and contaminates.
4. Attach chain with a 5/16" bolt, two washers, and a lock nut at all holes as shown in Fig 1.2.
5. Do not over tighten nuts. Ensure that chain is able to move freely.

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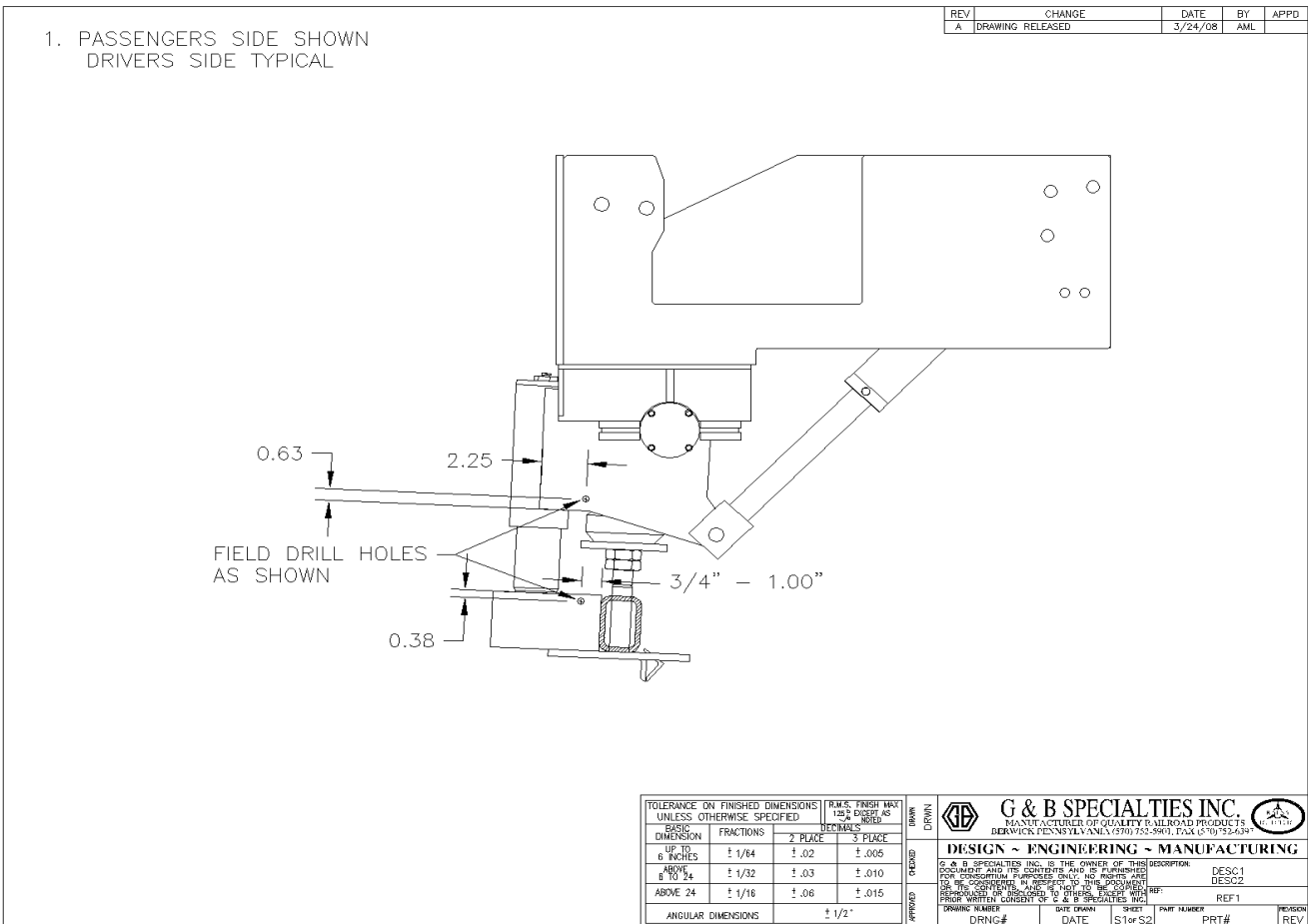


Figure 1.1

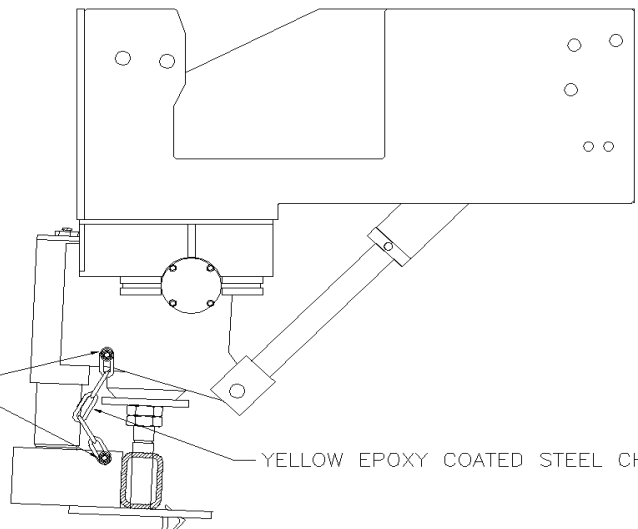
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1. PASSENGERS SIDE SHOWN
DRIVERS SIDE TYPICAL



ASSEMBLE WITH SUPPLIED CHAIN AND GR. 8 HARDWARE (BOLTS, FLAT WASHERS NYLOCK NUTS)

YELLOW EPOXY COATED STEEL CHAIN

CHAIN SHOWN IN OPTIMAL LOCATION TO MINIMIZE INTERFERENCE WITH MOVING PARTS

REV	CHANGE	DATE	BY	APPD

TOLERANCE ON FINISHED DIMENSIONS UNLESS OTHERWISE SPECIFIED		R.M.S. FINISH MAX 125 μ INCHES AS DECIMALS	
BASIC DIMENSION	FRACTIONS	2 PLACES	3 PLACES
UP TO 6 INCHES	± 1/64	± .02	± .005
ABOVE 6 TO 24	± 1/32	± .03	± .010
ABOVE 24	± 1/16	± .06	± .015
ANGULAR DIMENSIONS		± 1/2°	

G & B SPECIALTIES INC.
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DRAWING NUMBER	DATE DRAWN	SHEET	PART NUMBER	REVISION
MIO-R45RXFR001	3/24/08	2 OF 2	MIO-R45RXFR001	A

Figure 1.2

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