

INSTALLATION, MAINTENANCE & SERVICE BULLETIN

DRAWBAR EYES

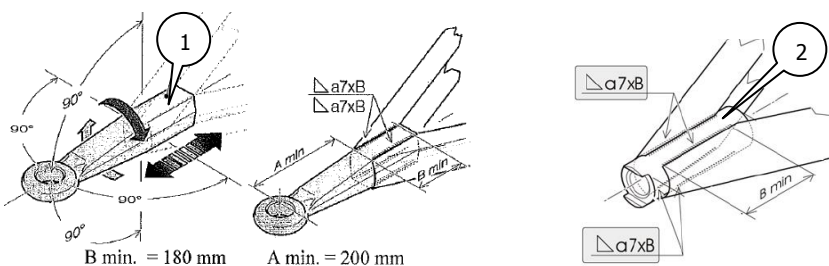


Installation

Weldable drawbar eyes

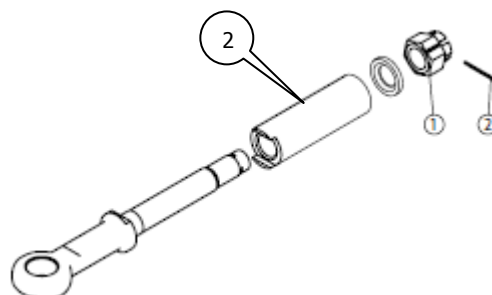
Part Number	D Value	Type of welding	Welding dimensions	Min. length of fillets	Number of fillets
FM50W01	190kN	MIG	10mm x 10mm	160mm	4
FM50W05	314kN	Note the welding instructions below			

- Make sure that the drawbar / tow eye block (1 / 2) and drawbar side-members to be welded are perfectly clean.
- Position the drawbar perfectly within the axis of the drawbar.
- Preheat the welding areas to 250°C. (200°C min to 300°C max)
- Weld on four points (see table) conforming to the standards ISO4063 and UNI EN22553, by utilising filler metal ISO E515B12020H.
- Welding Specification: Please refer to page 3 of the KT Air Suspension Bulletin: KPM-001-0712.



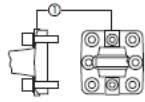
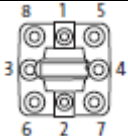
Removable drawbar eyes

Part Number	Nut Torque	Insert split pin
FM50R10	750-1000Nm	yes



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Flanged drawbar eyes

Part Number	Label position	Washer type	Qty	Bolt type	Qty	Min. Bolt length	Plate Positioning (pos 1)	Qty	1 st torque Setting Nm	Final torque setting Nm	Torque sequence
FM51F8E	Label facing upwards	Grower B16 UNI 9195	8	M16 CL 10.9	8	60mm		2	90-110	220-260	

Note: Slightly lubricate the bolts. After 2500km in service, check the torque setting of all the bolts.

Part Number	FM50W01	FM50W05	FM50R10	FM51F8E
Drawing No.	993031	993141	993583	993653
CRN	44610	44611	44612	44613

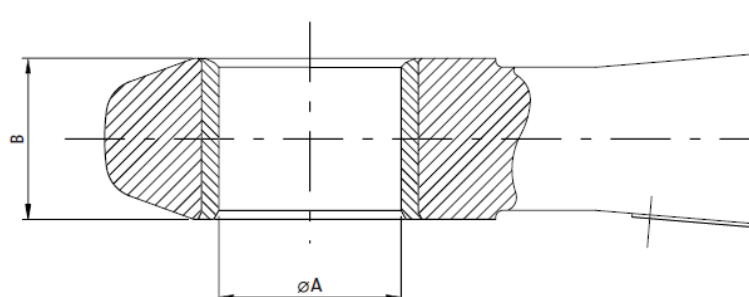
Maintenance

Note: Also consult the NHVR Vehicle Standards Guide VSG4 (Bulletin 20160-0304) for more service information (on FKH web site).

The following checks must be done minimum annually (more if required).

a) Make sure that the eye dimensions do not exceed the following wear limits.

	40 mm	50 mm
A	41.5	51.5
B	28	41.5



b) Weldable drawbar eyes:

Check all the welds for any signs of cracking

c) Removable drawbar eyes:

Remove the split pin and check the torque of the nut, then refit the split pin.

d) Flanged drawbar eyes:

Check if all the mounting bolts are tight as per the final torque. Replace any loose bolts.