



STANDARD WORK INSTRUCTION

PROCESS NAME	STATION	QUALITY GATE	OPERATION #	DOCUMENT #	REVISION	DATE	BY:
CLASS A LIPPERT 8K TORQUE SPECIFICATION PROCESS	CHASSIS PREP			SW00005	2	5/15/2020	MHANKILA
OPERATION: CLASS A LIPPERT 8K TORQUE SPECIFICATION PROCESS							
OPERATION CONDITIONS: N/A							

SYMBOLS

	SAFETY		SUPPLIER CTQ		CUSTOMER CTQ		WC	WORK CONTENT
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VISUAL PROCESS FLOW

CAUTION

Safety glasses required



MECHANICS GLOVES



1A) PPE - Throughout the entire installation process.



EXAMPLE FROM PLANT 450



LCI #360231
MA, CH, OL

ITEM	PART NO.	DESCRIPTION	QTY.
2	118620	NUT - 1/2" X 3.18" HEX G8E ZINC	6
3	346280	BOLT - 1/2" X 3.18" X 1.5" GR 8.8 ZN TYP ST	6
4	122802	WASHER - 1/2" BSW VILKIN 03/07 1055 HT	6
5	566254	PLATE - 7" X 3.18"	6

TORQUE TO 75 FT LBS

Plant 450 - Class A
Lippert 8K Hitch Torque Specification
Rev 7/13/15

1B) Refer to your plants manufacturer Torque Specification



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VISUAL PROCESS FLOW

PROCEDURE



1C) Safely lift receiver into place and start one bolt on each side. Use two people or a lift if necessary

Ensure neck of carriage bolt is fully seated in the square hole of the supplied plate.

Add lock washer and nut, tighten finger tight.

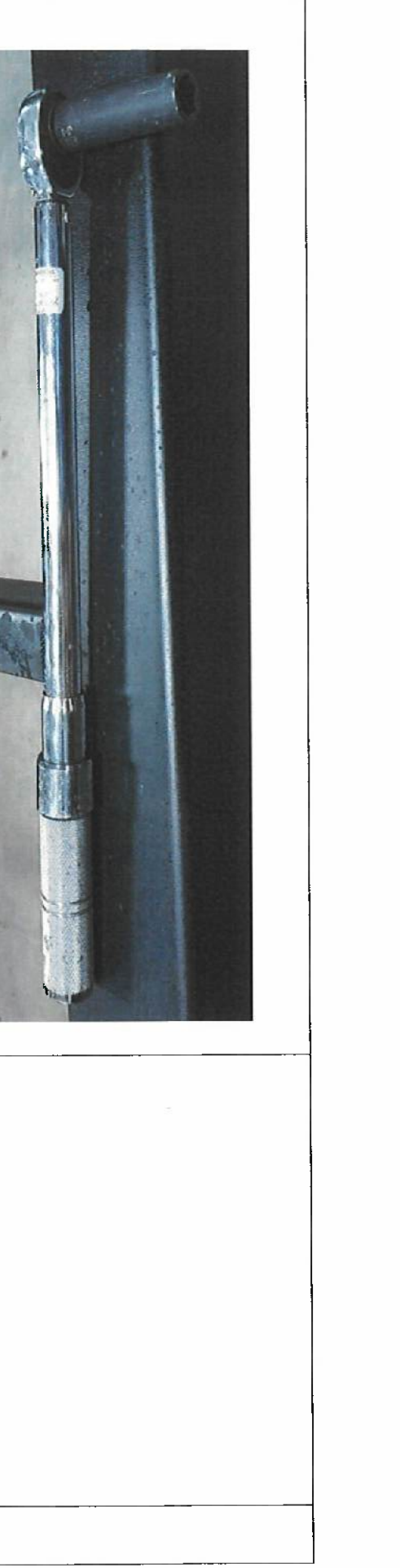
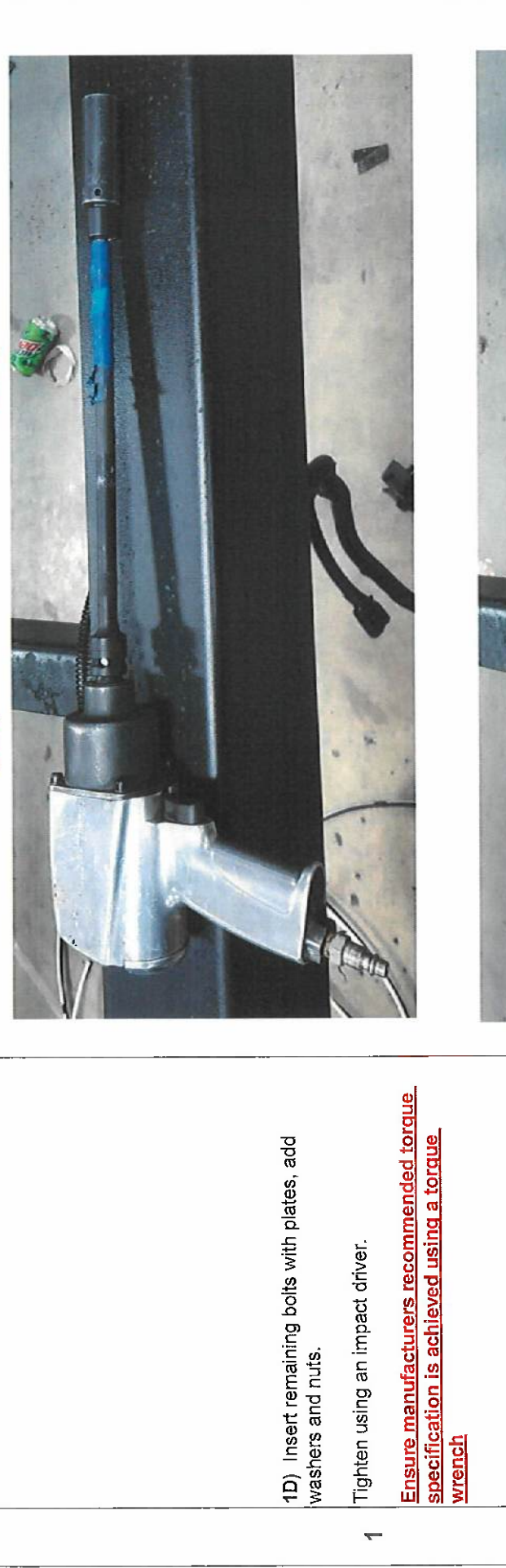


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PROCEDURE

1D) Insert remaining bolts with plates, add washers and nuts.
Tighten using an impact driver.



Ensure manufacturers recommended torque specification is achieved using a torque wrench



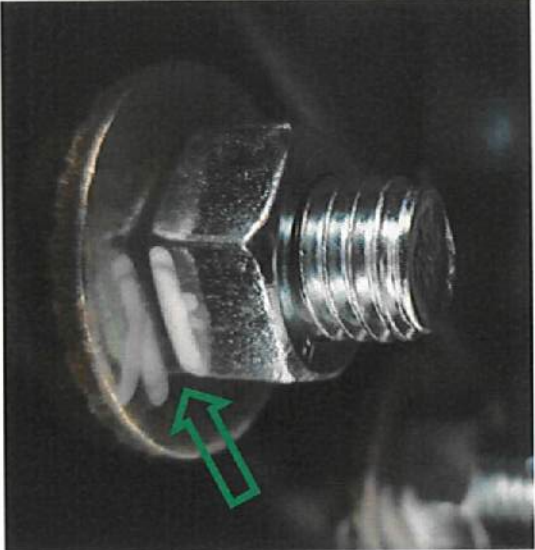

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OPERATION CONDITIONS: N/A							WORK CONTENT

PROCEDURE

1

1E) After ensuring manufacturer recommended torque is achieved, mark each nut/washer and mark and top of plates or carriage bolts to show that work was completed

COMPLETE ALL REQUIRED PAPERWORK

MATERIALS FOR SOW			EQUIPMENT/TOOLS		
DESCRIPTION	PART NUMBER	QTY	UNIT OF MEASURE	DESCRIPTION	SETTING
Hitch	mult	1	EACH	Impact driver	
Hardware kit (if sold separately)	mult	1	EACH	Torque wrench	SEE TORQUE SPEC
				Paint marker	



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DATE	REV	DESCRIPTION	STATION	QUALITY GATE	OPERATION #	DOCUMENT #	REVISION	DATE	BY:
5/15/2020	-	ORIGINAL RELEASE	CHASSIS PREP			SW00005	2	5/15/2020	MHANKILA
11-Jun-20	1	Added pic of nut/washer. "Mark each nut/washer and mark and initial the rear of the receiver to show that work was complete". Added paint marker to equipment list							
23-Feb-24	2	STEP 1E - end of plates or carriage bolts to show that work was completed WAS and mark and initial the rear of the receiver to show that work was complete. ADDED COMPLETE ALL REQUIRED PAPERWORK							



Standard Work Instruction Approvals

DATE:		
SUBJECT:		HITCH INSTALL TORQUE SPEC PROCESS
TRAINING MATERIALS:		SW00005 REV 2 HITCH INSTALL
DEPARTMENT	PRINT	SIGN
PROCESS OWNER		
PLANT MANAGER		
OPS DIRECTOR		
QUALITY		
OPEX		

