

Technical Instruction TI-NA001

Drag Link Clamp Pinch Nut Torques

Introduction:

This Technical Instruction has been issued to advise suitably qualified and experienced personnel on the correct procedure to ensure that the clamp pinch nuts have been correctly torqued.

Preparation:

Due to the location of the drag link, the vehicle will need to be either over a pit or in the air by using a suitable set of vehicle lifts. The draglink is located to the drivers-side of the front axle. (*Figure 1*).

All relevant workshop safety procedures should be followed

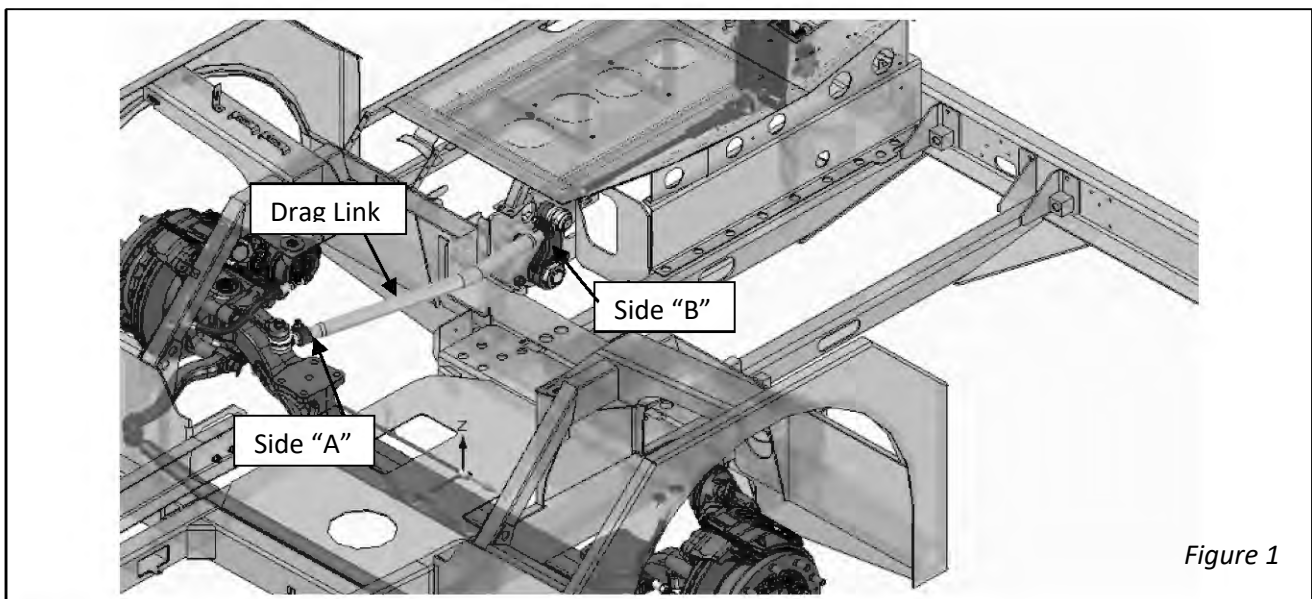


Figure 1

Instruction:

1. The full procedure should be carried out on both ends of the drag link. (*See Figure 2*)
2. With a calibrated torque wrench set to 70Nm, with appropriately sized attachment torque the nut.
3. If the nut is found to rotate prior to reaching 70Nm, then the complete drag link arm should be replaced.
4. The removed drag link should then be quarantined and made available for collection by ADI.
5. If the nut does not rotate at the 70Nm setting, repeat with the wrench reset to 90Nm.
6. Once the nut has been torqued to 90Nm, the draglink installation will be at design intent. A blue paint strike must be added across the bolt and thread to visually demonstrate the relative position of the nut and bolt at design intent torque.
7. Upon completion of Step 6, the draglink should have a date applied using the same paint marker in the format YY/MM/DD
8. A blue "dot" mark should then be added to the inside of washer bottle refill flap, to allow ease of identification.

9. The attached record of inspection sheet must then be completed for **each vehicle**, in full, and scanned/electronically submitted to Anthony.Fasano@alexander-dennis.com for records.

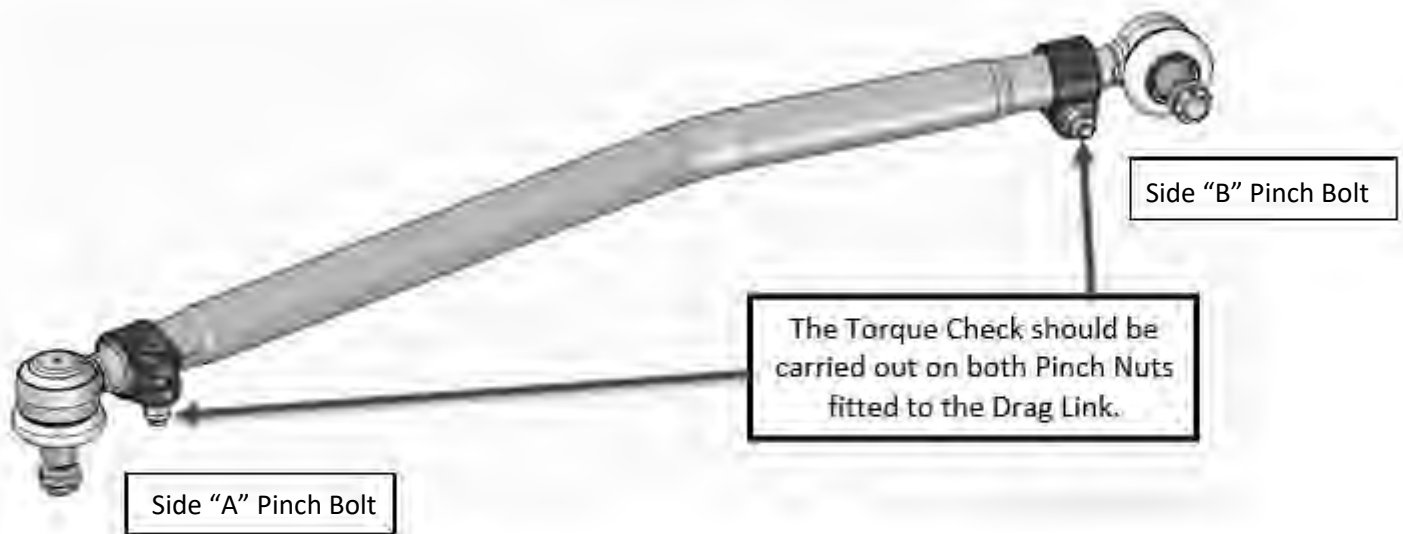


Figure 2

Note: To ensure the front and rear drag link clamps are correctly torqued, secure the head of the bolt with a spanner when the torque wrench is used.

INSPECTION SHEET
Drag Link Clamp Pinch Nut Torque

NOTE: This Sheet should be photocopied so one sheet is filled in for each vehicle inspected

Inspection Date:

Fleet Number:

Operator Name:

Vehicle Mileage:

Technician Name:

Position Held:

Employer:

Torque Check Pinch Nut Side A:

Did Nut Turn at 70Nm

Torqued to 90Nm

If Turned at 70Nm, was drag Link replaced?

Y or N?

Y or N?

Y or N?

Torque Check Pinch Nut Side B:

Did Nut Turn at 70Nm

Torqued to 90Nm

If Turned at 70Nm, was drag link replaced?

Y or N?

Y or N?

Y or N?

Markings Completion

Added Torque Stripe to Pinch Nut A and B

Added Completion date to drag link

Added "Dot" marking to washer filler flap

Y or N?

Y or N?

Y or N?

Signed: _____

Date: _____