



Service Bulletin 1610

Manway T-bolt Replacement



The following instructions apply to the Kelso One-bolt Manway System. They should only be used as a guide for manway system part replacement and do not supersede the installing facilities operating, safety or quality assurance procedures

Removal and replacement of One-bolt Manway T-bolt:

1. Parts Required:
 - a. T-bolt
 - b. T-bolt top retainer bracket
 - c. Retainer bolts (2)
 - d. Loctite 242
2. The T-bolt can be replaced without opening the cover
3. Disengage T- bolt from strap screw nut
4. Remove the 2 bolts from the top retainer bracket and remove bracket
5. Swing the T- bolt counter clock-wise outwards until almost perpendicular to the tank car side
6. Lift the T- bolt from the remaining retainer bracket
7. Apply new T- bolt with retainer, apply Loctite to the retainer bolts and torque bolts to 50 inch-lbs.

For parts or additional information,
Please call 1-903-583-9200 or email sales@kelsotech.com for assistance.