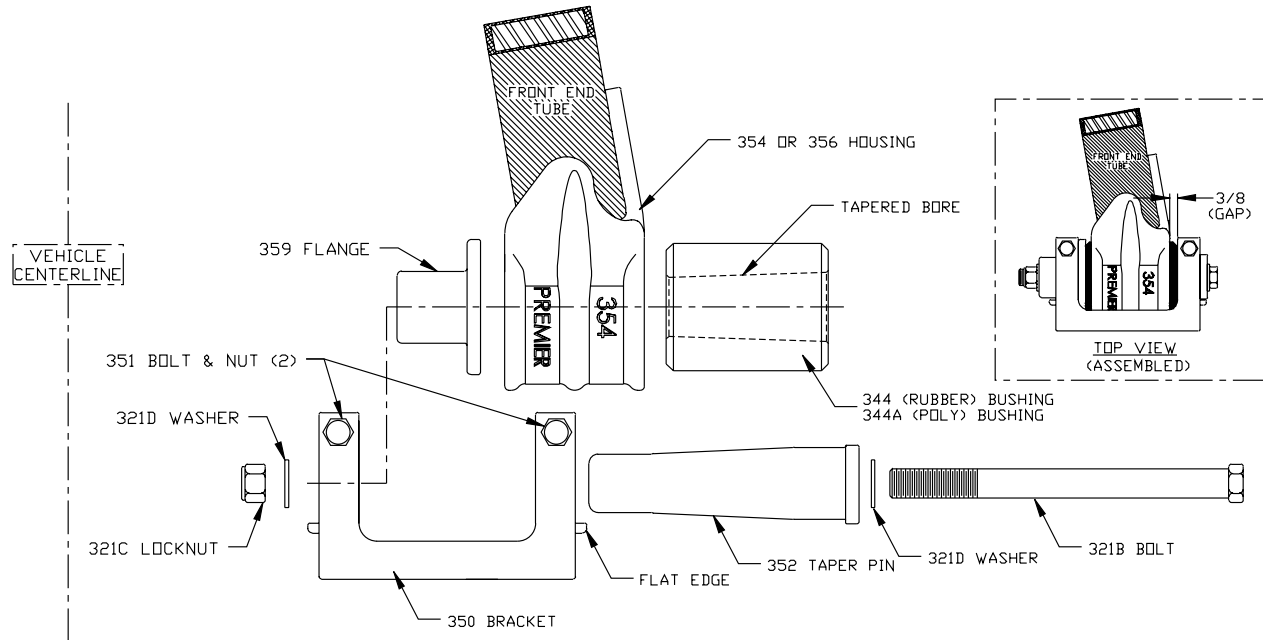




PREMIER MANUFACTURING COMPANY

THE FIRST NAME IN QUALITY COUPLINGS

320/320A & 330/330A HINGE ASSEMBLY - SERVICE GUIDE



This document is to assist in the replacement of the 320/320A and 330/330A Hinge Assembly components that had previously been installed. For new hinge assembly installation instructions, please contact us.

Because the 320/320A and 330/330A Hinge Assemblies operate in pairs, the service instructions below are to be simultaneously followed for each hinge assembly.

ASSEMBLY:

1. Place the 359 Flange into the bore on the vehicle centerline side of the 350 Bracket. Make certain that the slit in the flange lines up with the slit in the bracket.
2. Slide the 344/344A Bushing into the 354/356 Housing, making sure that the smaller diameter end of the tapered bore in the bushing is towards the 359 Flange. Place the housing into the 350 Bracket, aligning the bores as much as possible.
3. Slide the 352 Taper Pin into the 350 Bracket bore from the opposite end of the 359 Flange. Make certain the flat on the taper pin is aligned with the flat edge on the bracket. Using a rubber mallet only, tap the taper pin into the bracket until the head of the taper pin is flush against the bracket.
4. Place one 321D Washer onto the 321B Bolt and slide it through the 352 Taper Pin. Place the second 321D Washer and 321C Locknut onto the end of the 321B Bolt. Prior to tightening, check to make sure the 3/8" gap between the 354/356 Housing and 350 Bracket exists.
5. Torque the 321C Locknut to 60 ft-lbs. Test the hinge assemblies for desired rotational stiffness. If a stiffer hinge is desired, tighten the 321C Locknut in 10-20 ft-lb increments. DO NOT EXCEED 200 ft-lbs of TORQUE.
6. Tighten the 351 Bolts to 80 ft-lbs of torque. These bolts compress the 350 Bracket, clamping both the 359 Flange and 352 Taper Pin. Note: Both 351 Bolts must be loosened prior to any future adjustment of the of the 321B Bolt for hinge stiffness. After adjustment, the 351 Bolts must be re-torqued to 80 ft-lbs.