



**PREMIER**  
MANUFACTURING

Document #10006363

THE FIRST NAME IN QUALITY COUPLINGS

# Installation, Inspection, Operation & Maintenance Guide



## MODEL 640S FRONT END ASSEMBLY

PART #10000889

## MODEL 640SA FRONT END ASSEMBLY

PART #10000891

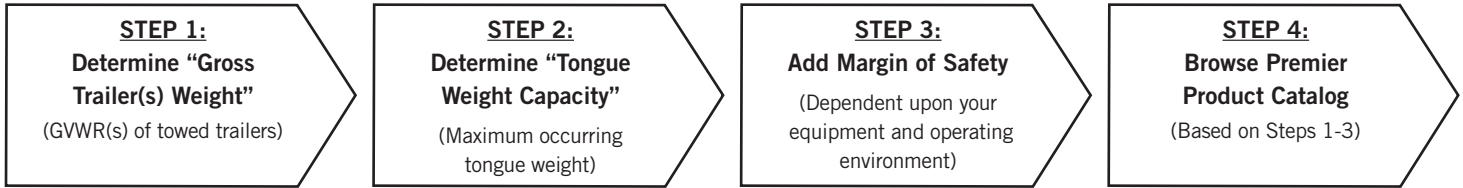
### IMPORTANT

Read these instructions completely before installing, using or attempting to repair this product. If you have any questions, call Premier at (800) 255-5387 or (503) 234-9202

# SELECTING THE RIGHT EQUIPMENT

Whatever your application, selecting the proper equipment for the job is very important. Proper selection along with regular inspection and maintenance will help keep operating costs minimal while providing long life to each component. Below are general guidelines for selecting Premier Coupling and Drawbar Eyes. If you feel that your application is unique, please give Premier a call so that we may help you through the selection process.

Follow these four steps to ensure proper selection of Premier Couplings and Drawbar Eyes.



## STEP 1: Determine "Gross Trailer(s) Weight"

"Gross Trailer(s) Weight" is usually determined by the Gross Vehicle Weight Rating (GVWR). This information is attached to the trailer by the trailer manufacturer.

For "Double Trailer" configurations, only the rear trailer is considered when selecting your Premier Coupling or Drawbar Eye. In this example, a Coupling and Drawbar Eye with a "Gross Trailer Weight" rating of 40,000 lbs. (18,143 kg) would be the minimum rating acceptable for normal, over-the-road applications (see Tongue Weight section below).

### Double Trailer Configuration



Example only, each application may vary and should be considered unique.

For "Triple Trailers", only the two most rearward trailers are considered in selecting your Premier Coupling or Drawbar Eye. In this example, a Coupling and Drawbar Eye with a "Gross Trailer Weight" rating of 80,000 lbs (36,287 kg) would be the minimum acceptable for normal, over-the-road applications. (See Tongue Weight section below).

### Triple Trailer Configuration



Example only, each application may vary and should be considered unique.

## STEP 2: Determine "Tongue Weight Capacity"

"Tongue Weight Capacity" is the maximum expected weight at the drawbar eye. If a hinged drawbar is used, the maximum weight will be approximately 1/2 the overall drawbar weight. If a non-hinged drawbar is used and the actual tongue weight is not known, you can approximate the weight by multiplying the GVWR of the towed trailer by 15%. However, each application is unique and the best practice is to weigh the tongue when the trailer is loaded to GVWR.



## STEP 3: Consider Operating Conditions and Environments

Environments such as rough uneven roads or off-road use can dramatically increase shock loads to both drawbar eyes and couplings. In general, increasing the "Gross Trailer Weight" (Step 1:) and "Tongue Weight Capacity" (Step 2:) by a minimum of 25% will be sufficient for many applications. Even if an application is used off-road occasionally, the minimum increase necessary for Gross Trailer and Tongue Weight is 25%. Certain types of equipment and/or operating practices can also dramatically increase loads through equipment binding and/or improper loading practices. Of special concern is high tongue weight. However, each application is unique and every environment different, therefore your application may require more than 25%.

Once both "Gross Trailers(s) Weight" (Step 1:) and "Tongue Weight Capacity" (Step 2:) have been determined, evaluate your operating conditions and apply an appropriate margin of safety.

## STEP 4: Browse Premier Product Catalog

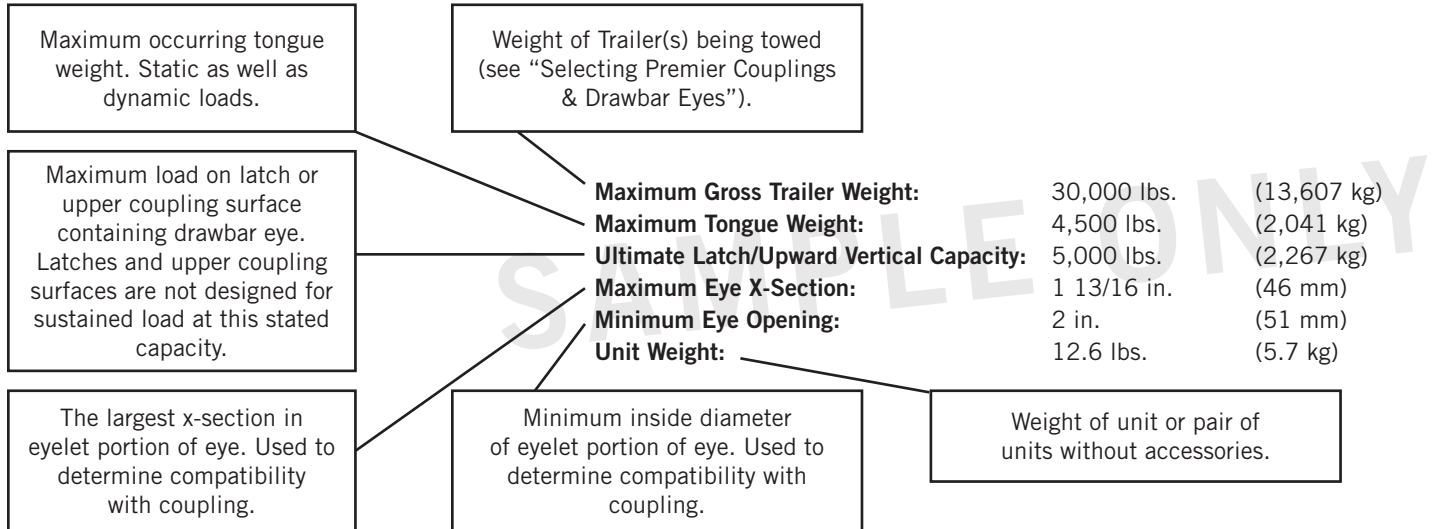
Browse the Premier Product Catalog and refer to the "Specifications" section of each product. Be sure to review the "Understanding Premier Load Specifications" sections and "Coupling to Drawbar Eye Cross-Reference" sheet on the next couple of pages.



# SELECTING THE RIGHT EQUIPMENT

## Understanding Premier Load Specifications

Each Premier product undergoes extensive design and testing prior to being introduced. We use the latest in Computer Aided Design and Analysis Software as well as physical destructive tests. Premier's published load specifications are the maximum load a given product or part will withstand without failure. Premier's testing procedures closely follow the Society of Automotive Engineers (SAE) guidelines of Recommended Practice for testing Couplings and Drawbar Eyes (SAE J847 & J849).



## Importance of Inspection and Maintenance

Whether you use Premier Jacks, Couplings, Drawbar Eyes, Hinge Assemblies or any other Premier product, regular inspection and maintenance are essential for proper function, keeping repair costs to a minimum and above all, safe and efficient operation.

To determine wear limits, Premier created Wear Gages that help judge the useful life of couplings and drawbar eyes (details in catalog). In accordance with Premier and the Federal Motor Carrier Safety Regulations, these were designed to identify wear at the critical percentages of 18% and 20%, by measuring the cross-section of coupling hooks (horn) and drawbar eye loops. 18% wear indicates that the product should be replaced as soon as possible. At 20% wear, the product is no longer in usable condition and must be taken out of service immediately and replaced. The latch gage bar measures the gap space between the top of the coupling hook and the closed latch. If the 3/8" latch gage bar can pass between this region, then the latch components should be considered worn past safe limits and replaced. Please note that these wear gage specifications are in accordance with Premier Mfg. and the Federal Motor Carrier Safety Regulations (refer to other manufacturer's specifications for wear limits on their products).



Premier also provides Installation Guides for each of our major products. These help guide you through installation, inspection, routine maintenance and part replacement. Another resource is our website at [www.premier-mfg.com](http://www.premier-mfg.com). Here you will find Installation Guides, Service Guides, distributor locations, online catalogs, product information, trade show schedules and links to trucking resources.

## Additional Product Resources at Your Fingertips

**Customer Service:** We are always here to support you. Do you need additional information or assistance? Your phone calls are greeted by our courteous receptionist, during business hours. We have exceptional, personable Customer Service Reps for you to rely on. If you have product questions or want to place an order, you can speak directly with one of our experienced and knowledgeable Customer Service Representatives.

**Sales Representatives:** Would you like on site training or assistance? Contact one of our veteran Premier Sales Reps for more information about product training for your staff. Or be sure to visit with them at a Trade Show (see website for schedule).

**[www.premier-mfg.com](http://www.premier-mfg.com):** Our website is an informative resource at your fingertips. In addition to our Installation and Service Guides, you will find Territory Manager contact information, distributor locations, product specifications, product selectors, cross-reference forms, digital product catalog, trade show schedule, and links to trucking resources.



# MODEL 640S / 640SA FRONT END ASSEMBLY

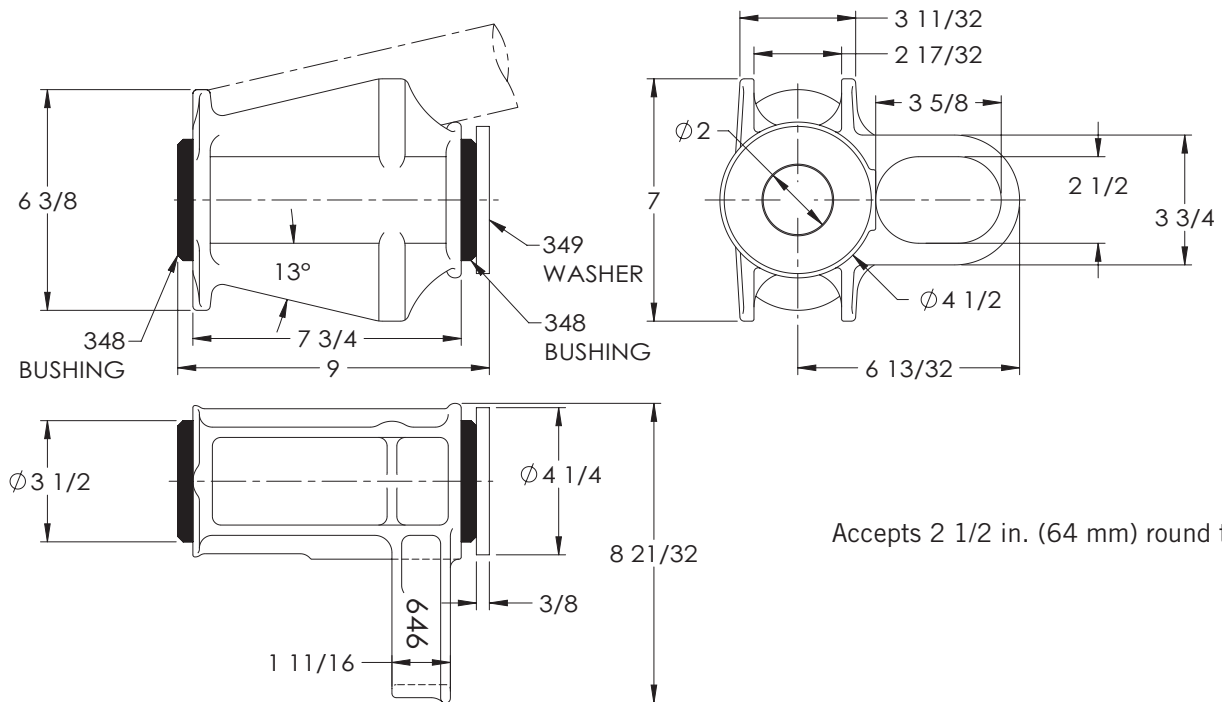
## Specifications and Load Capacities

### SAFETY WARNING

This product is designed for towing under normal conditions within the stated gross trailer weight. Do not overload or abuse this product. Overloading or abuse may lead to property damage, severe injury, or death.

<b>Bushing I.D.:</b>	2 in.	(51 mm)
<b>Bushing O.D.:</b>	3 1/2 in.	(89 mm)
<b>Bushing Length:</b>	3 1/2 in.	(89 mm)
<b>Unit Weight:</b>	19.3 lbs.	(8.8 kg)

## Standard Installation Drawing



Accepts 2 1/2 in. (64 mm) round tubing.

## Parts & Accessories

### Parts Included:

Model #	Part #	Description
646	10000892	Housing
349	10000858	Washer
348	10000857	Rubber Bushing (2)
*348A	10000856	Poly Bushing (2)

\*640SA comes with 348A Poly Bushings

### Bushing Replacements

(Use ONLY Premier's Bushings):

Model #	Part #	Description
348	10000857	Rubber Bushing
348A	10000856	Poly Bushing

### Drawbar Eye is NOT included

(Use ONLY Premier's Drawbar Eyes):

Model #	Part #	Description
207S	10000763	Drawbar Eye
307S	10000804	Drawbar Eye
405S	10004772	Drawbar Eye



# MODEL 640S / 640SA FRONT END ASSEMBLY

## Installation

These instructions are ONLY for Premier 207S, 307S and 405S Drawbar Eyes, and Premier 348 and 348A Bushings, installed in a Premier 640S or 640SA Front End Assembly. Any substitution or use of non-Premier components in the 640S/640SA Front End Assembly VOIDS ALL PRODUCT WARRANTY.

### **Installation Procedure:**

1. The 640S and 640SA Front End Assemblies and accompanying drawbar eye must be installed to comply with the Federal Motor Carrier Safety Regulations. Specifically, Section 393.70, Paragraph C: "Towing of Full Trailers." Prior to install or operation, consult with local, State and Federal agencies, as there may be additional applicable laws governing installation and use of this product.
2. One of the three attached Welding Procedure Specifications; GMAW, SMAW or FCAW, must be followed. Welding should only be performed by a certified welder skilled in structural welding practices.
3. All weld locations must be clean, paint free and void of any moisture, oil, grease, oxides or loose or thick scale.
4. The front end structure that the 646 Housing attaches to must be of sufficient strength to withstand the load rating of the drawbar eye it is used with. The housing accommodates a front end structure consisting of two 2 ½" round tubes with a converging angle of 26° as shown in Figure 1.
5. Fit-up, between both tubes and the mounting surfaces of the 646 Housing, must be flush as failure to have a flush fit prior to welding will cause the capacities to be negatively affected. Figure 1A shows one possible example of an improper fit-up that must be avoided.
6. Attach the 646 Housing to the front end tubes with a minimum 3/8" fillet weld that encompasses the entire interface between the housing and each tube as shown in Figure 1.

### **640S / 640SA Assembly after Welding**

Premier 207S, 307S and 405S Drawbar Eyes only

(640S: Premier 348 Rubber Bushings only)

(640SA: Premier 348A Poly Bushings only)

7. Allow the finished structure to cool.
8. Slide the bushings into each end of the 646 Housing.
9. Using extreme caution to avoid damaging or nicking the threads, slide the drawbar eye all the way through each bushing.
10. Clean and lubricate all visible threads.
11. Slide the 349 Washer onto the threaded end of the drawbar eye.
12. Lubricate the open face of the 349 Washer with 30wt. oil where the 416 Locknut will rotate against it (see Figure 3).
13. Thread the 416 Locknut onto the drawbar eye just far enough to remove any free play from the 349 Washer.
14. If an initial gap exists between the flat flanged base of the drawbar eye and the face of the front bushing (see Figure 2), then slowly tighten the 416 Locknut until the gap just disappears as shown in Figure 3.
15. Note the location of one of the 416 Locknut faces relative to a spot on the 646 Housing (see Figure 3).
16. Tighten the 416 Locknut:
  - Using 348 Rubber Bushings: Turn the 416 Locknut no fewer than three complete revolutions from the position shown in Figure 3.
  - Using 348A Poly Bushings: Turn the 416 Locknut no fewer than four complete revolutions from the position shown in Figure 3.
17. Place the 208 Snap Ring in the groove at the end of the drawbar eye shaft to complete the assembly as shown in Figure 4. Use caution when installing the snap ring and make certain not to over expand it as this will cause permanent damage to the snap ring.



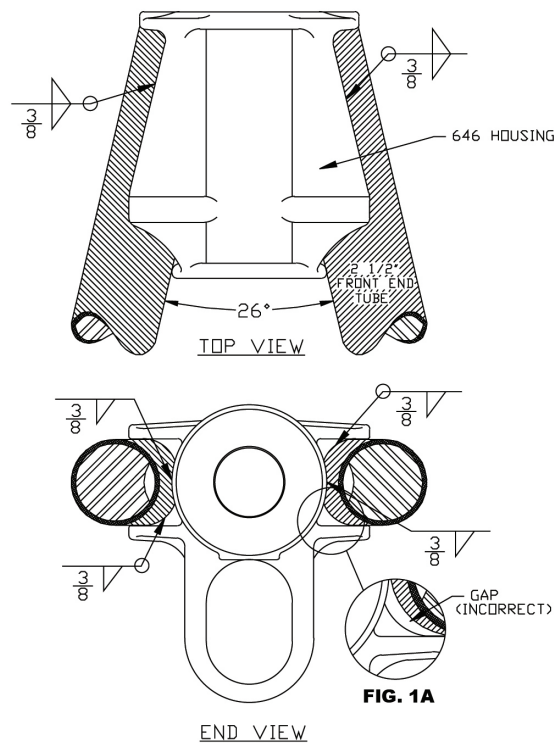
# MODEL 640S / 640SA FRONT END ASSEMBLY

## Installation

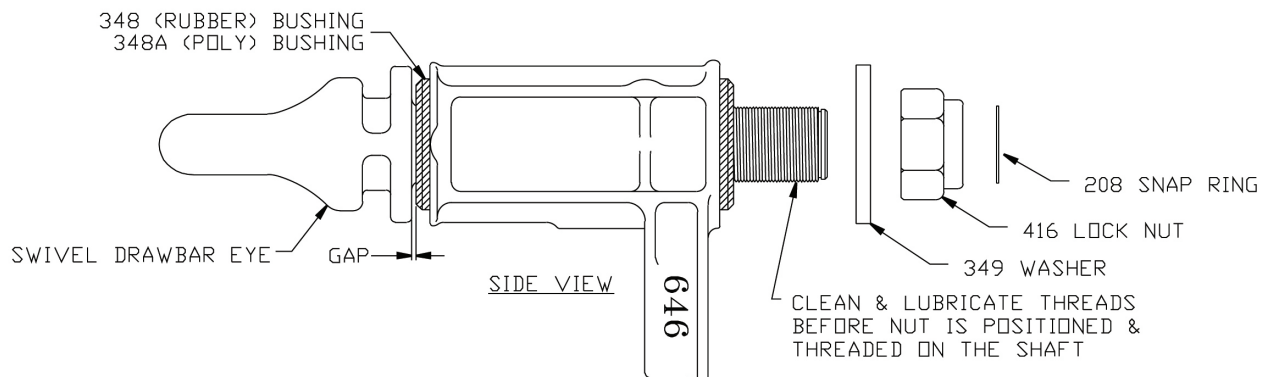
18. For the final installation instructions of the 640S/640SA Front End Assembly using a 405 Swivel Drawbar Eye, reference the drawbar eye's specific Installation, Inspection, Operation and Maintenance Guide. These guides include instructions for attaching Premier's 281 or 282 Air Chamber rod to the 405 Drawbar Eye Pushrod.
19. "IMPORTANT WARNINGS!" sticker was enclosed. This must be attached to the front end, adjacent to the drawbar eye, visible for the end user to read.

**Please note:** All applications vary and this is a recommended install starting point for bushing tightness at 70°F ambient air temperature. Varying conditions and applications may require a different initial set up.

**Figure 1**



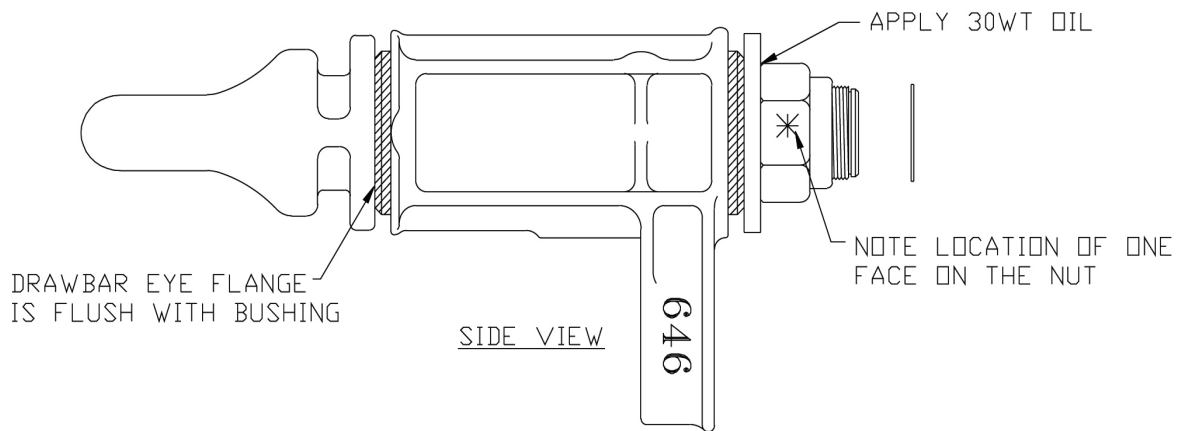
**Figure 2**



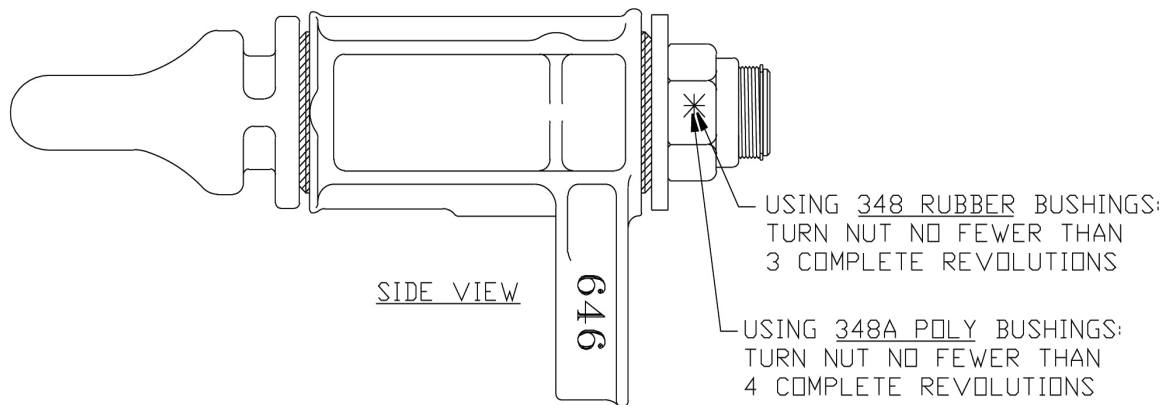
# MODEL 640S / 640SA FRONT END ASSEMBLY

## Installation

**Figure 3**



**Figure 4**



# MODEL 640S / 640SA FRONT END ASSEMBLY

## Inspection/Operation/Maintenance

1. Visually inspect the drawbar eye for cracks, impact damage and/or deformation before each and every use. Do NOT use if any of these conditions exist.
2. If the original cross-section of the eye loop has been reduced by 20% or greater, the drawbar eye is NOT to be used and is considered out-of-service.
3. Over time, slack may develop between the bushings and drawbar eye. Therefore, clean and inspect every 90 days or sooner if your application dictates, and adjust or replace the bushings if slack is noted.
4. This product is designed to be operated within its free rotation limits. It is the responsibility of the vehicle designer/end user to assure that these limits are not exceeded (not binding/jackknife).
5. WARNING: Prior to towing, make certain that adequately rated safety chains have been properly connected.
6. Never weld on any Premier drawbar eye in order to repair damaged or worn areas. Field and/or shop weld repairs are inadequate and may further weaken the drawbar eye.

### **IMPORTANT GUIDELINES that apply to all Premier Front End Assemblies**

- Never attempt weld repair of damaged or worn drawbar eyes or front end assemblies
- Never attempt to use a swivel-type drawbar eye with a swivel-type coupling
- Clean and inspect drawbar eyes and eye assemblies for damage or excessive wear before each and every use
- All welds should be performed by a certified welder skilled in structural welding practices
- Drawbar structure as well as welds attaching front end assembly to drawbar must be of sufficient strength to withstand the load rating of the drawbar eye
- Do not bind-up (Jackknife) any application as stresses can cause damage to products or components, resulting in failure and detachment of the trailer while in use
- Do not apply lubricants to the coupling hook or drawbar eye loop, as they can cover up possible damage and accelerate wear





# MODEL 640S / 640SA FRONT END ASSEMBLY

## Welding Procedures

### WELDING PROCEDURE SPECIFICATION (WPS) Yes (X) PREQUALIFIED (X) QUALIFIED BY TESTING (X) or PROCEDURE QUALIFICATION RECORD (PQR) Yes (X)

<b>GMAW</b>		Identification #: PMEM-1	
Revision 0		Date: 2/1/00	By: PI
Authorized By:		Date:	
Company Name: Premier Manufacturing Co.		Type: Manual:	Semi-Automatic: (X)
Welding Process(es): GMAW		Machine:	Automatic:
Supporting PQR No.(s): N/A Prequalified			
<b>JOINT DESIGN USED</b>		<b>POSITION</b>	
Type: All Fillets, Butts (See Attached)		Position of Groove: 1G, 2G	
Single (X)		Double Weld (X)	
Backling: Yes (X)		No (X)	
Backling Material: M1-P1-S1 Group 1 & 2		LECTRICAL CHARACTERISTICS	
Root Opening: ---		Transfer Mode (GMAW) short-circuiting ( )	
Groove Angle: ---		Globular (X) Spray (X)	
Back Gouging: Yes (X) No (X) Method: Mech/Thermal		Current: AC ( ) DCEP(X) DCEN ( ) Pulsed ( )	
<b>BASE METALS</b>		Other:	
Material Spec.: M1-P1-S1 1026 Carbon Steel		<b>TECHNIQUE</b>	
Type or Grade: Group 1 & 2		Stringer or Weave Bead: String or Weave	
Thickness: Groove: 1/8 - 1 1/8" Fillet: Unlimited		Multi-Pass or Single Pass (per side): Single, Multiple	
Diameter (Pipe): 4" minimum		Number of electrodes: Single	
<b>FILLER METALS</b>		Electrode Spacing:	
AWS Specification: A5.18		Longitudinal: ---	
AWS Classification: E70S-1		Lateral: ---	
<b>SHIELDING</b>		Angle: ---	
Flux:		Contact Tube to Work Distance: 3/4" ±1/8"	
Gas: CO <sub>2</sub>		Peening: Recommended	
Composition: 100%		Interpass Cleaning: Mechanical	
Flow Rate: 30-50 cfh		<b>POSTWELD HEAT TREATMENT</b>	
Gas Cup Size: 1/2" Dia.		Temp.: ---	
<b>PREHEAT</b>		Time: ---	
Preheat Temp.: Min.: 100°F			
Interpass Temp.: Min.: 100°F		Max.: 500°F	

#### WELDING PROCEDURE

Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diam.	Type & Polarity	Amps or Wire Feed Speed			
All	GMAW	E70S-X	0.035	DCEP	190-230	22-31	13 ±1 IPM	See Attached
All	GMAW	E70S-X	0.045	DCEP	260-290	27-31	13 ±1 IPM	

### WELDING PROCEDURE SPECIFICATION (WPS) Yes (X) PREQUALIFIED (X) QUALIFIED BY TESTING ( ) or PROCEDURE QUALIFICATION RECORD (PQR) Yes ( )

<b>SMAW</b>		Identification #: PMSMA-1	
Revision 0		Date: 2/1/00	By: PI
Authorized By:		Date:	
Company Name: Premier Manufacturing Co.		Type: Manual: (X)	Semi-Automatic:
Welding Process(es): SMAW		Machine:	Automatic:
Supporting PQR No.(s): N/A (Pre-Qualified)			
<b>JOINT DESIGN USED</b>		<b>POSITION</b>	
Type: All Fillets-Butts (See Attached)		Position of Groove: All	
Single (X)		Double Weld (X)	
Backling: Yes (X)		No (X)	
Backling Material: M1-P1-S1, Group 1 & 2		LECTRICAL CHARACTERISTICS	
Root Opening: ---		Transfer Mode (GMAW) short-circuiting ( )	
Groove Angle: ---		Globular ( ) Spray ( )	
Back Gouging: Yes (X) No (X) Method: Mech/Thermal		Current: AC ( ) DCEP (X) DCEN ( ) Pulsed ( )	
<b>BASE METALS</b>		Other:	
Material Spec.: M1-P1-S1 1026 Carbon Steel		<b>TECHNIQUE</b>	
Type or Grade: Group 1 and 2		Stringer or Weave Bead: String and Weave	
Thickness: Groove: 1/8"-1 1/2" Fillet: Unlimited		Multi-Pass or Single Pass (per side): Multiple/Single	
Diameter (Pipe): 4" Minimum		Number of electrodes: Single	
<b>FILLER METALS</b>		Electrode Spacing:	
AWS Specification: A5.1 -A5.5		Longitudinal: N/A	
AWS Classification: E7018		Lateral: N/A	
<b>SHIELDING</b>		Angle: N/A	
Flux:		Contact Tube to Work Distance: N/A	
Gas: N/A		Peening: Recommended	
Composition: N/A		Interpass Cleaning: Mechanical Only	
Electrode-Flux (Class)		<b>POSTWELD HEAT TREATMENT</b>	
Flow Rate: N/A		Temp.: N/A	
Gas Cup Size: N/A		Time: N/A	
<b>PREHEAT</b>			
Preheat Temp.: Min.: 100°F			
Interpass Temp.: Min.: 100°F		Max.: 500°F	

#### WELDING PROCEDURE

Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diam.	Type & Polarity	(Amps) or Wire Feed Speed			
All	SMAW	E7018	3/32"	DCEP	70-110	19-22	As Required	See Attached And AWS D1.1
All	SMAW	E7018	1/8"	DCEP	90-150	20-24		
All	SMAW	E7018	5/32"	DCEP	120-190	20-24		

### WELDING PROCEDURE SPECIFICATION (WPS) Yes (X) PREQUALIFIED (X) QUALIFIED BY TESTING ( ) or PROCEDURE QUALIFICATION RECORD (PQR) Yes ( )

<b>FCAW</b>		Identification #: PMFC-1	
Revision 0		Date: 2/1/00	By: PI
Authorized By:		Date:	
Company Name: Premier Manufacturing Co.		Type: Manual: (X)	Semi-Automatic:
Welding Process(es): FCAW		Machine:	Automatic:
Supporting PQR No.(s): N/A (Pre-Qualified)			
<b>JOINT DESIGN USED</b>		<b>POSITION</b>	
Type: All Fillets-Butts (See Attached)		Position of Groove: All	
Single (X)		Double Weld (X)	
Backling: Yes (X)		No (X)	
Backling Material: M1-P1-S1, Group 1 & 2		LECTRICAL CHARACTERISTICS	
Root Opening: ---		Transfer Mode (GMAW) short-circuiting ( )	
Groove Angle: ---		Globular (X) Spray (X)	
Back Gouging: Yes (X) No (X) Method: Mech/Thermal		Current: AC ( ) DCEP(X) DCEN ( ) Pulsed ( )	
<b>BASE METALS</b>		Other:	
Material Spec.: M1-P1-S1 1026 Carbon Steel		<b>TECHNIQUE</b>	
Type or Grade: Group 1 and 2		Stringer or Weave Bead: String and Weave	
Thickness: Groove: 1/8"-1 1/2" Fillet: Unlimited		Multi-Pass or Single Pass (per side): Multiple/Single	
Diameter (Pipe): 4" Minimum		Number of electrodes: Single	
<b>FILLER METALS</b>		Electrode Spacing:	
AWS Specification: A5.20		Longitudinal: N/A	
AWS Classification: E70T-1/E71T-1		Lateral: N/A	
<b>SHIELDING</b>		Angle: N/A	
Flux:		Contact Tube to Work Distance: 3/4" ±1/4"	
Gas: CO <sub>2</sub>		Peening: Recommended	
Composition: 100%		Interpass Cleaning: Mechanical Only	
Electrode-Flux (Class)		<b>POSTWELD HEAT TREATMENT</b>	
Flow Rate: 30-50 cfh		Temp.: N/A	
Gas Cup Size: 1/2" Dia. Min.		Time: N/A	
<b>PREHEAT</b>			
Preheat Temp.: Min.: 100°F			
Interpass Temp.: Min.: 100°F		Max.: 500°F	

#### WELDING PROCEDURE

Pass or Weld Layer(s)	Process	Filler Metals		Current		Volts	Travel Speed	Joint Details
		Class	Diam.	Type & Polarity	(Amps) or Wire Feed Speed			
All	FCAW	E70T-1	0.045	DCEP	180-280	24-28	As Required	See Attached And AWS D1.1
All	FCAW	E71T-1	0.052	DCEP	190-300	24-29		
All	FCAW		0.068	DCEP	210-350	24-29		
All	FCAW		5/64"	DCEP	250-400	26-30		



# ATTENTION!

End Users must read and follow this information.

**DISTRIBUTORS & OEM'S:** Please ensure that your customers are made aware of the following information on this page.

1. VERIFY THAT BOTH COUPLING'S AND DRAWBAR EYE'S RATED CAPACITIES MEET YOUR APPLICATION(S) REQUIREMENTS.
2. DO NOT OVERLOAD COUPLING OR DRAWBAR EYE.
3. INSPECT COUPLING, LATCH AND DRAWBAR EYE FOR CRACKS, BENDING DAMAGE OR EXCESSIVE WEAR.  
**DO NOT USE IF ANY OF THESE CONDITIONS EXIST!**
4. CHECK FOR GAP BETWEEN CLOSED LATCH AND TOP OF HORN OR COUPLING BALL.  
**DO NOT USE IF GAP IS 3/8 IN. OR MORE.**
5. MAKE SURE COUPLING IS LATCHED AND THAT LATCH WILL NOT OPEN.
6. PRIOR TO USE, ALWAYS CONNECT SAFETY CHAINS OF ADEQUATE STRENGTH FOR LOAD(S) BEING TOWED.
7. DO NOT BIND-UP (JACKKNIFE) ANY APPLICATION AS STRESSES CAN CAUSE DAMAGE TO THE COUPLING, DRAWBAR EYE, OTHER COMPONENTS OR ANY COMBINATION OF THEM. JACKKNIFING MAY RESULT IN FAILURE OF PRODUCTS OR COMPONENTS, RESULTING IN DETACHMENT OF THE TRAILER WHILE IN USE.
8. DO NOT APPLY LUBRICANTS TO THE COUPLING HOOK OR DRAWBAR EYE LOOP, AS THEY CAN COVER UP POSSIBLE DAMAGE AND ACCELERATE WEAR.
9. ALWAYS ABIDE BY ALL APPLICABLE STATE AND FEDERAL REGULATIONS GOVERNING SAFE AND PROPER TRANSPORTATION.
10. NEVER STRIKE ANY OF THESE COMPONENTS WITH A HAMMER OR ANY OTHER DEVICE.
11. ALWAYS VERIFY PROPER OPERATION OF LATCHING SYSTEM AND COUPLING COMPONENTS PRIOR TO DRIVE OFF.
12. NEVER USE A COUPLING THAT YOU DO NOT FULLY UNDERSTAND HOW TO PROPERLY OPERATE AND VERIFY SECURE LATCHING OF.
13. **NEVER REPLACE ANY PART IN ANY OF PREMIER'S ASSEMBLIES WITH NON-PREMIER COMPONENTS. DOING SO WILL VOID ALL WARRANTY AND POTENTIALLY COMPROMISE THE UNIT'S INTEGRITY, WHICH COULD RESULT IN PROPERTY DAMAGE, SERIOUS INJURY, OR DEATH.**



# **WARNING!**

This envelope contains important instructions  
**AND MUST REMAIN ATTACHED TO THIS  
PRODUCT.** It may be removed only by the End  
User or by an Original Equipment  
Manufacturer who preserves this envelope and  
instructions and provides it to the end user.



PREMIER MANUFACTURING  
THE FIRST NAME IN QUALITY COUPLINGS  
800-255-5387 (503)234-9202  
[www.premier-mfg.com](http://www.premier-mfg.com)

Model 640S/640SA  
Front End Assembly

**WARRANTY:** We warrant all Premier products to be free from defects in material or workmanship for one year. We will repair or replace, at our option, any Premier product which our examination reveals to be defective, provided that the product is returned to our factory, at Tualatin, Oregon transportation prepaid, within one year of purchase by the first retail purchaser. Our warranty does not extend to products which have been subject to misuse, neglect, improper installation, maintenance or application, nor does our warranty extend to products which have been repaired or altered outside of 3UHPLHU-V facility unless the repair or alteration has been expressly authorized in writing by Premier. **This warranty is in lieu of all other warranties, express or implied, and excludes warranties of merchantability, fitness for a particular purpose and otherwise, and in no event will Premier be liable for incidental, special, contingent or consequential damages.**

**DISCLAIMER:** Although great care has been taken to ensure accurate information throughout this document, Premier Manufacturing must reserve the right to alter any information contained within. These changes include but are not limited to: Dimensional changes, load capacity and availability of any part or assembly.

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