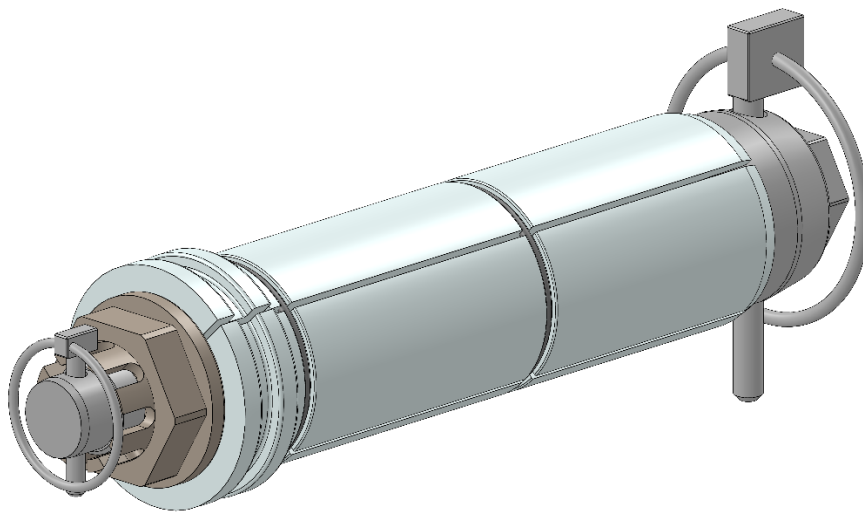


Assembly & Inspection Manual

bondura® Expanding Pins One-Sleeve

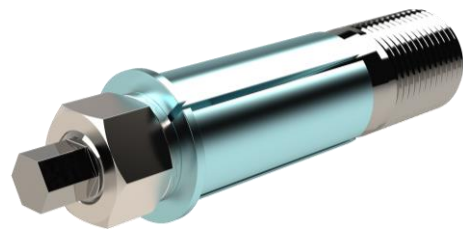
Document Article Number: 111218 Ver. A



This Assembly & Inspection Manual is applicable for the following bondura® pin types:



bondura ® 2.0



bondura ® 4.0



Need assistance?



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1. Installation

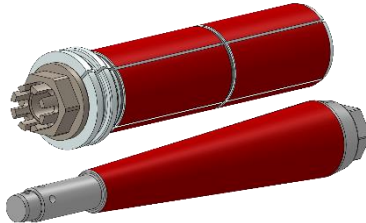
1.1 Preparations



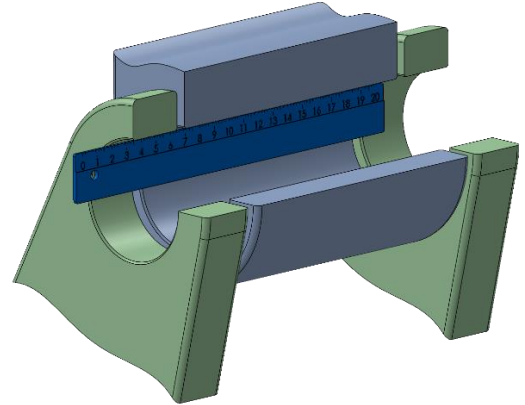
Please ensure to have technical pin drawing(s) available before starting the installation. It may contain important information of pin positioning and torque values to use.

Prepare for installation by centring and cleaning the pin bore.

Grease can be used in the pin bore and on all pin and sleeve surfaces as needed.



To ensure correct friction and avoid damage or galling of the threads, bondura® Assembly Paste is recommended for use on all threads in the pin assembly.

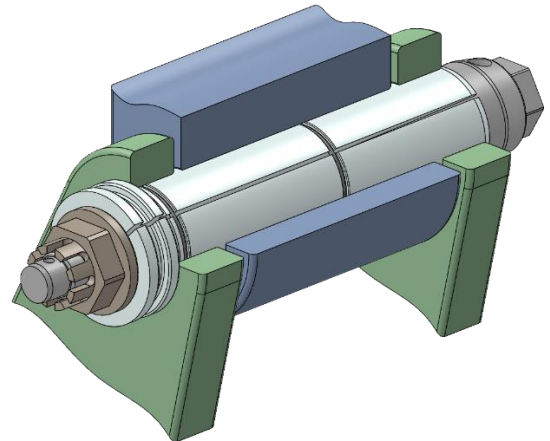


1.2 Insert pin assembly.

Make sure the pin assembly is inserted all the way until it stops against the flange on the sleeve.

Ensure the sleeve is completely retracted and the nut is fully loosened before installing the pin assembly.

Pin drawing may contain more detailed information.



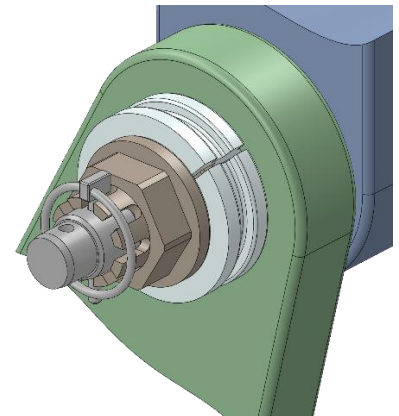
1.3 Use torque wrench to tighten the nut

See drawing for specified torque value.

Use a hexagonal key on the opposite side of the pin to prevent unwanted rotation during tightening of the nut.

If the hole for fitting the linch pin is not aligned with the castellated nut, please increase the torque slightly and turn the nut a bit further until the holes align.

Install the linch pins on both sides if applicable.





2. Inspection

Implementing a maintenance program to check the bondura® pins is recommended. This can be combined with the existing maintenance program and service intervals for the relevant equipment.

#	To be checked	Type of inspection	Control parameter	How to rectify
I-1	Pin condition	Visual	Missing or severe damage to parts.	Replace missing or damaged parts.
I-2	Sideways misalignment of pin	Visual	If the pin has moved sideways in the bore.	Offload and disassemble pin. Check for damage, replace parts if necessary, and re-install.
I-3	Torque values	Measure	Specified torque value.	Re-tighten to correct values.
I-4	Function control	Visual and auditory	Unwanted movement or sound when system is in operation.	Disassemble to find root cause.

3. Disassembly

Remove the linch pins if applicable.

Offload the pin and turn the nut anti-clockwise so the core pin is pushed loose from the sleeve. Use a hexagonal key on the core pin to prevent unwanted rotation during loosening of the nut.

If the nut and sleeve are not interconnected, tap the pin core with a hammer to push the pin core free from the sleeve.

Remove the entire pin assembly.

