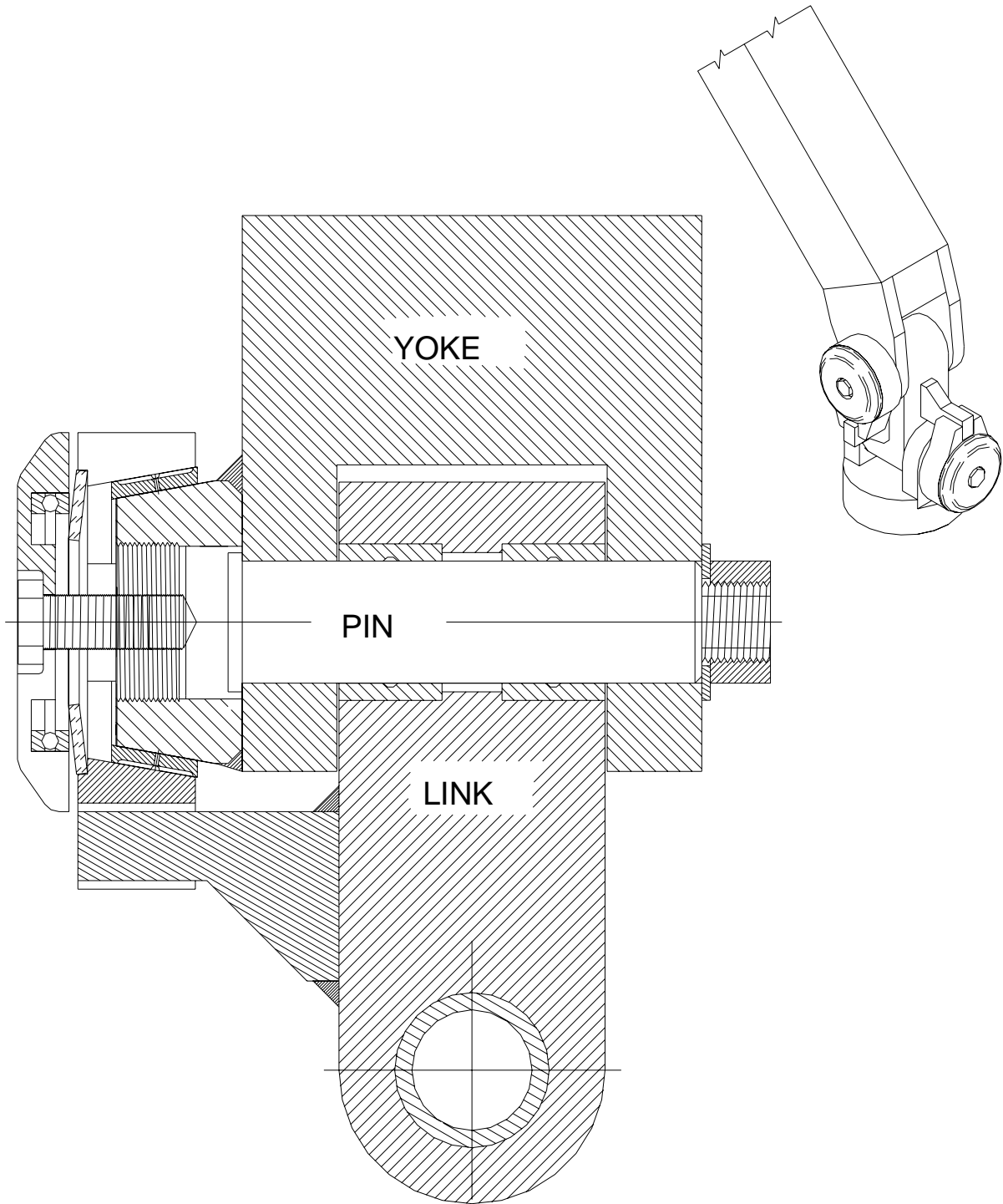


SECTION 3
300 SERIES

| | |
|-----|-------------------------------------------------|
| 3-2 | <u>Snubber Assembly - Parts</u> |
| 3-3 | <u>O.E.M. Pinhead Styles</u> |
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| 3-5 | <u>Service and Adjustment</u> |
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| 3-8 | <u>B3300-2</u> |

SNUBBER ASSEMBLY – PARTS

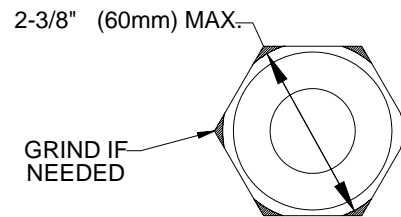


MOUNTING AND OPERATIONAL INSTRUCTIONS

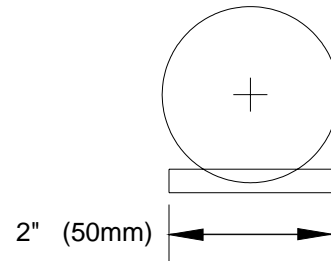
O.E.M. PINHEAD STYLES

Original pin heads must be smaller than 2 1/2" (63 mm.) to allow passage of the pin through core during attachment disassembly.

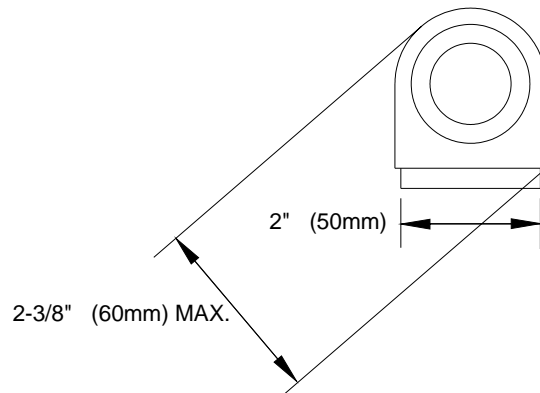
- A)** Hex style pin heads 2 1/2" across corners or larger must have corners of hex ground to 2 3/8" (60 mm) or less.



- B)** Pin heads with a milled flat area rest against external key stock to prevent pin from turning during assembly. This key stock must be short enough, 2" (50 mm) maximum, to fit under the core when core is welded into position.



- C)** Pin heads with a flat anchor larger than 2 1/2" (63 mm.) can be trimmed and ground. *NOTE* a flat portion must be retained to stop pin from turning during assembly. Key stock maximum 2" (50 mm.) long allowing the core to be welded into position.

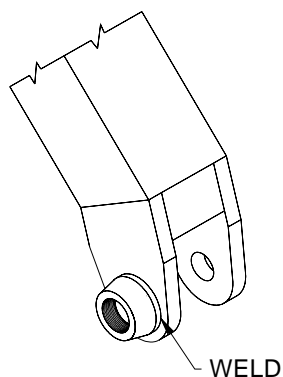


EXTERNAL MOUNT

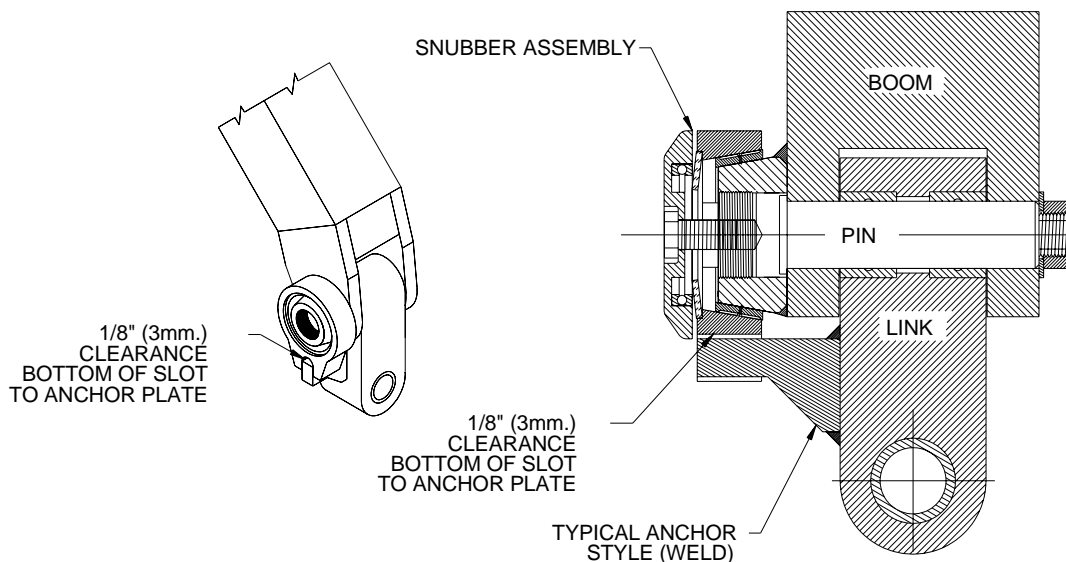
MOUNTING AND OPERATIONAL INSTRUCTIONS

STICK BOOM MOUNT

- 1) Center snubber core around head of pin and tack weld into position. Ensure head of pin can travel through center of the core without interference. Protect taper surface of core from weld splatter and weld core to boom with 7018 low hydrogen rod, or ARCTEC 223 XC - minimum 2 passes.



- 2) Assemble snubber with slot style housing facing down parallel to link. An anchor must be cut from 1" (NORTH AMERICA) 25 mm. (EUROPE) steel, plate and welded to link. Maintain 1/8" (3 mm.) clearance, between bottom of housing slot and top of anchor, allowing full engagement of anchor.
**Ensure anchor does not interfere with rotate yoke & crane nose ensuring side to side travel of attachment.

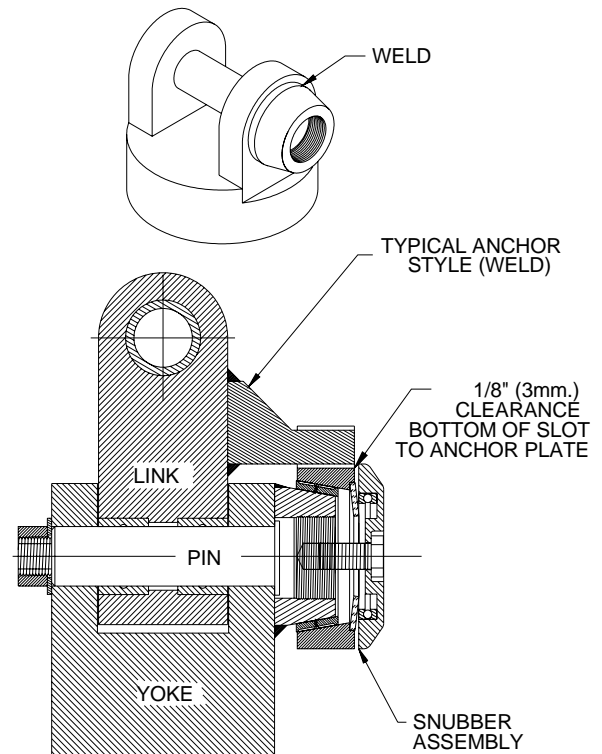


MOUNTING AND OPERATIONAL INSTRUCTIONS

ROTATE YOKE MOUNT

- 3) Center snubber core around head of pin and tack weld into position, ensure head of pin can travel through center of core as in step 1. Protect core taper surface and weld to rotate yoke with 7018 low hydrogen rod or ARCTEC 223 XC - minimum 2 passes.

- 4) Assemble snubber with slot style housing facing up parallel to link. An anchor must be cut from 1" (NORTH AMERICA) or 25 mm. (EUROPE) steel plate and welded to link, maintain 1/8" (3 mm.) clearance, between bottom of housing slot and bottom of anchor, allowing full engagement of anchor.



SERVICE AND ADJUSTMENT

- During final assembly of snubber apply LOCTITE 620, or equivalent, to core and inner surface of friction sleeve and install.
- Apply liberal amount of MOLY based grease to outer surface of friction sleeve and thrust bearing.
-
- **For B3T-1175 composite sleeve, install dry.
- To set tension, tighten end-cap bolt.

CAUTION:

Only tension snubber to maintain adequate control of attachment, dependant upon application and attachment weight.
Over tensioning of snubber reduces friction sleeve life.

IMPORTANT: All service points on the snubber should be greased every 10 hours.
(friction sleeve: grease B3T-1015 only)

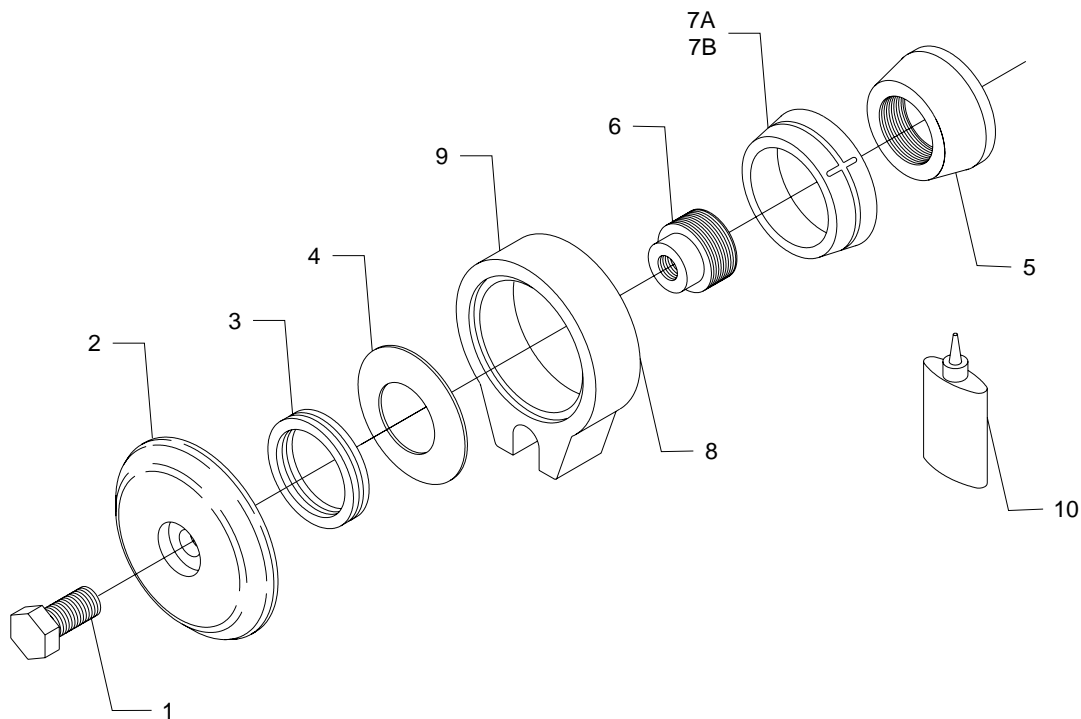
Greases with 5% - 6% MOLY are recommended:
Military Spec. MIL G23549C
-Lubriplate 176 5⁰F./-15⁰C.
-Lubriplate 3000 15⁰F./-9.5⁰C.
-Lubriplate 3000w -30⁰F./-34.5⁰C.
-or EQUIVALENT

EXTERNAL MOUNT

300 SERIES

B3300

USE WITH INDEXATOR / VALMET ROTATORS
CRANE NOSE OF MACHINE
NORTH AMERICA ONLY



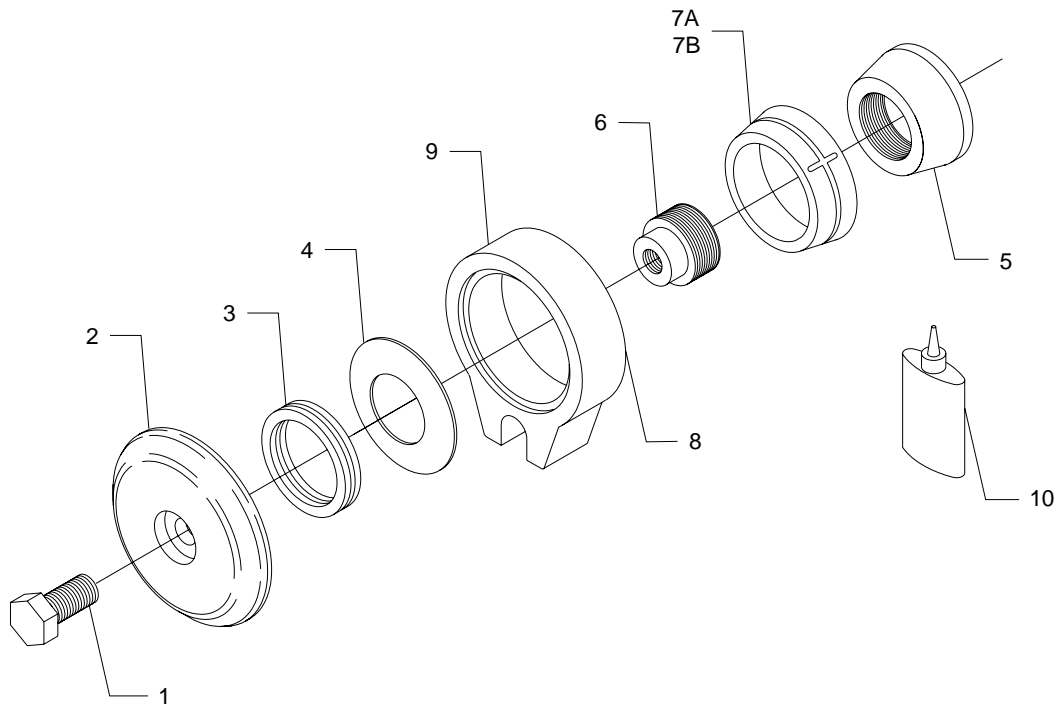
| ITEM | PART# | DESCRIPTION | QTY |
|------|-----------|-------------------------------------------------------------------------------------|-----|
| 1 | B3T-440 | BOLT (M16 x 1.5 x 50 mm LNG. -10.9) | 1 |
| 2 | B3T-430 | END CAP | 1 |
| 3 | B3T-1035 | BEARING | 1 |
| 4 | B3T-1030 | SPRING WASHER, INSTALL 1 ST CONCAVE TO HOUSING 2&3 CONCAVE- FACE TO FACE | 3 |
| 5 | B3T-320 | CORE | 1 |
| 6 | B3T-495 | PLUG (16 mm) | 1 |
| 7 | B3T-1015G | FRICITION SLEEVE (ZINC ALLOY ZA12) | 1 |
| OPT. | B3T-1175 | FRICITION SLEEVE (COMPOSITE MATERIAL) | 1 |
| 8 | B3T-1020 | HOUSING (1.032" SLOT) | 1 |
| 9 | B3T-1130 | ZERK | 2 |
| OPT. | B3T-1190 | PLUG, USE WITH B3T-1175 (COMPOSITE SLEEVE) | 2 |
| 10 | B3T-575 | SLEEVE RETAINER LOCTITE 620 OR EQUIVALENT | 1 |

EXTERNAL MOUNT

300 SERIES

B3300-1

USE WITH ROTATORS (WHERE ACCEPTABLE) & CRANE NOSES
EX: INDEXATOR IR10, ROTOBEC
NORTH AMERICA ONLY



| ITEM | PART# | DESCRIPTION | QTY |
|------|-----------|-------------------------------------------------------------------------|-----|
| 1 | B3T-120 | BOLT (3/4"-16 x 2" LONG - GR.8 ZN) | 1 |
| 2 | B3T-435 | END CAP | 1 |
| 3 | B3T-1035 | BEARING | 1 |
| 4 | B3T-1030 | SPRING WASHER, INSTALL 1ST CONCAVE TO HOUSING, 2&3 CONCAVE FACE TO FACE | 3 |
| 5 | B3T-320 | CORE | 1 |
| 6 | B3T-525 | PLUG (3/4" BOLT) | 1 |
| 7 | B3T-1015G | FRICITION SLEEVE (ZINC ALLOY ZA12) | 1 |
| OPT. | B3T-1175 | FRICITION SLEEVE (COMPOSITE MATERIAL) | 1 |
| 8 | B3T-1020 | HOUSING (1.032" SLOT) | 1 |
| 9 | B3T-1130 | ZERK | 2 |
| OPT. | B3T-1190 | PLUG, USE WITH B3T-1175 COMPOSITE SLEEVE | 2 |
| 10 | B3T-575 | SLEEVE RETAINER LOCTITE 620 OR EQUIVALENT | 1 |
| | | | |

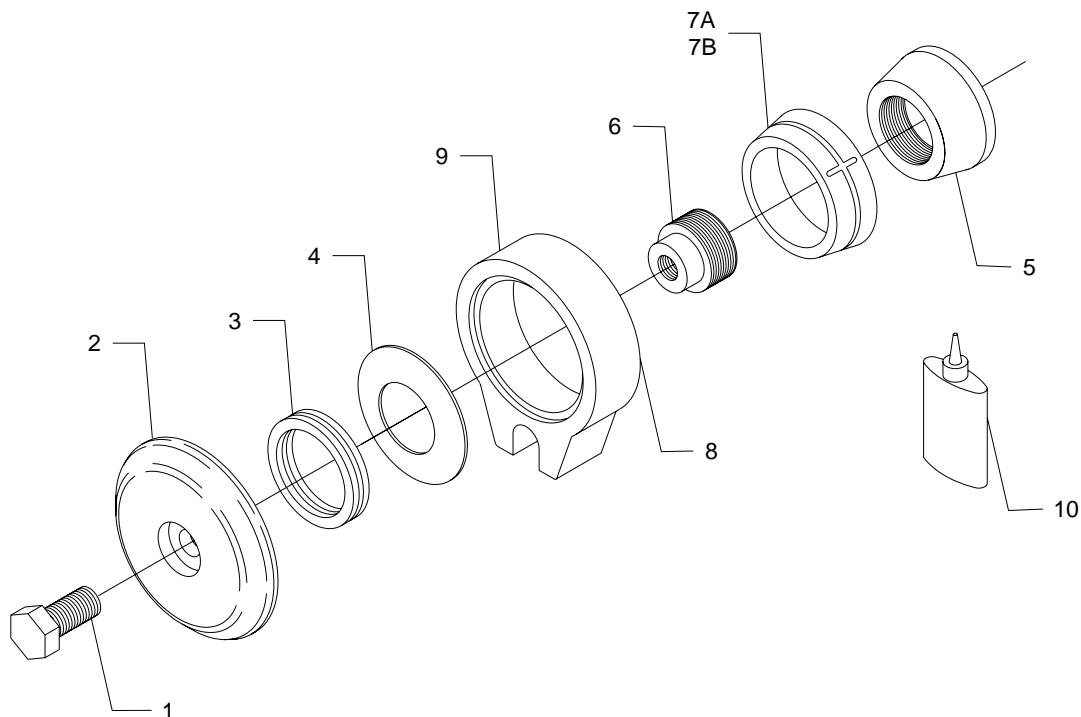
PROLENC[®]
MANUFACTURING INC.

EXTERNAL MOUNT

300 SERIES

B3300-2

USE WITH INDEXATOR / VALMET ROTATORS
CRANE NOSE OF MACHINE
EUROPE – AUSTRALIA - SOUTH AMERICA - AFRICA



| ITEM | PART# | DESCRIPTION | QTY |
|------|-----------|-------------------------------------------------------------------------------------|-----|
| 1 | B3T-440 | BOLT (M16 x 1.5 x 50 mm LNG. –10.9) | 1 |
| 2 | B3T-430 | END CAP | 1 |
| 3 | B3T-1035 | BEARING | 1 |
| 4 | B3T-1030 | SPRING WASHER, INSTALL 1 ST CONCAVE TO HOUSING, 2&3 CONCAVE FACE TO FACE | 3 |
| 5 | B3T-320 | CORE | 1 |
| 6 | B3T-495 | PLUG (16 mm) | 1 |
| 7 | B3T-1015G | FRICITION SLEEVE (ZINC ALLOY ZA12) | 1 |
| OPT. | B3T-1175 | FRICITION SLEEVE (COMPOSITE MATERIAL) | 1 |
| 8 | B3T-520 | HOUSING (25 mm SLOT) | 1 |
| 9 | B3T-1130 | ZERK | 2 |
| OPT. | B3T-1190 | PLUG, USE WITH B3T-1175 COMPOSITE SLEEVE | 2 |
| 10 | B3T-575 | SLEEVE RETAINER LOCTITE 620 OR EQUIVALENT | 1 |