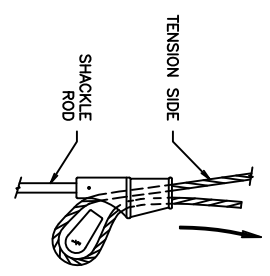
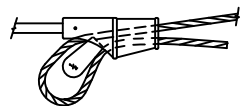


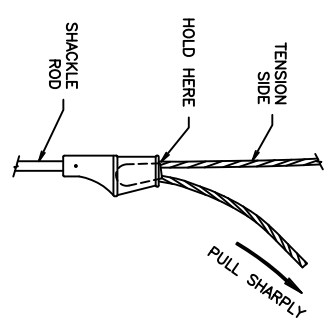
STEP 1 - INSERT THE END OF THE WIRE ROPE THROUGH THE TOP OF THE SHACKLE BODY AS SHOWN. TENSION SIDE OF WIRE ROPE IS ALWAYS TO BE IN LINE WITH THE SHACKLE ROD SIDE OF THE SHACKLE.



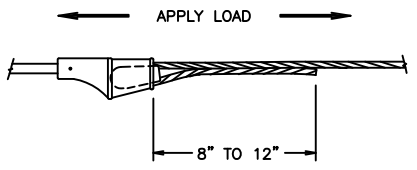
STEP 2 - FORM A LOOP WITH THE END OF THE WIRE ROPE AND INSERT THE END BACK UP THROUGH THE SHACKLE BODY AS SHOWN. LEAVE ENOUGH ROOM IN LOOP FOR WEDGE INSERT.



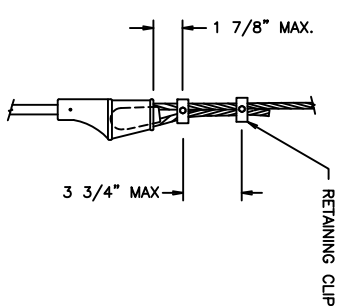
STEP 3 - PLACE THE WEDGE INSERT IN THE LOOP. WEDGE INSERTS ARE MARKED FOR THE ROPE SIZE THEY ARE INTENDED FOR. 12mm ROPE USES THE 1/2 SIZE WEDGE INSERT. SQUARE END OF INSERT WITHOUT ROPE GROOVE IS INSERTED INTO THE SHACKLE BODY. THE LOOPED WIRE ROPE GOES IN THE GROOVE ON THE SIDES AND ROUND END OF THE INSERT.



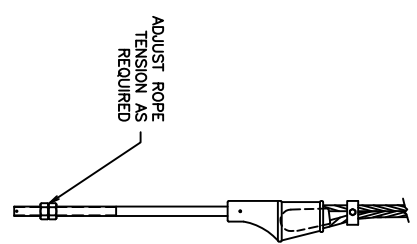
STEP 4 - WHILE HOLDING DOWN ON THE TENSION SIDE OF THE ROPE AND SHACKLE BODY, PULL UP ON THE LOOSE END WITH A QUICK PULL UNTIL THE ROPE LOOP AND INSERT ARE SEALED IN THE SOCKET BODY.



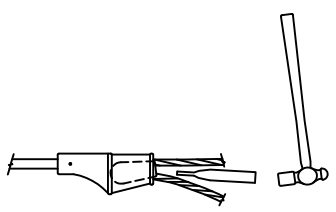
STEP 5 - AFTER ALL ROPES ARE INSTALLED, LET THE WEIGHT OF THE SLING ETC. BE SUSPENDED BY THE ROPES. THE ROPE AND WEDGE INSERT WILL RISE AS MUCH AS 1 INCH TO THE FINAL "SET" UNDER LOAD. AFTER BINDING, CUT ANY SURPLUS ROPE OFF "DEAD END" BUT LEAVE AT LEAST 8 INCHES.



STEP 6 - INSTALL FIRST RETAINER CLIP NO MORE THAN 1 7/8" FROM THE SHACKLE BODY AS SHOWN TO RETAIN DEAD END OF ROPE. INSTALL SECOND CLIP NO MORE THAN 3 3/4" FROM FIRST CLIP.



STEP 7 - TENSION IN ROPES MUST BE EQUAL FOR PROPER OPERATION. CHECK TENSION OF ROPES BY "FEEL". ANY ROPE THAT FEELS LOOSER THAN OTHER ROPES SHOULD BE TIGHTENED BY ADJUSTING NUTS ON THREADED ROD OF SHACKLE ASSEMBLIES ON PIT HITCH ONLY - DO NOT ADJUST CAR HITCH SHACKLES. HOLD SHACKLE BODIES WHILE ADJUSTING NUTS TO PREVENT ROTATION. TURN DOWN ALL ROPE SHACKLES TO PREVENT NORMAL OPERATION.



SHORTEN ROPES WHEN REQUIRED BY TAPPING ON TOP OF WEDGE INSERT WITH A DRIFT PIN UNTIL WEDGE IS LOOSE IN SHACKLE BODY AND "DEAD END" OF ROPE CAN BE PULLED. NEVER LENGTHEN A ROPE INSTALLATION.

IMPORTANT - RETAINER CLIPS ARE TO BE INSTALLED SO AS NOT TO DAMAGE OR DEFORM ROPE IN ANY WAY.

REVISIONS		CANTON ELEVATOR	
DATE	BY	DATE	BY
0806-11-16-99	BY DMIB	DATE XXXX	BY DMIB
DATE 6-14-00	BY DMIB	WEIGHT NA	DATE XXXX
DATE	BY	TIME STUDY NA	DATE XXXX
DATE	BY	QTY. NA	DATE XXXX
DATE	BY	SCALE NONE	DATE XXXX