

BELLY DUMP SRT-2™ FLEX DRIVE AND HANDLE ASSEMBLY

Use these instructions to replace flex drives bolted to handle and flex drives welded to handle.

NOTICE TO INSTALLER: Even if familiar with product, read instructions prior to installation as improvements may be made without notice. Always handle components with care. When done, these instructions must be given to the consumer.

NOTICE TO CONSUMER: Before using this product, read instructions. Save these instructions for future reference.

PREPARATION

COMPONENTS

- (1 - Options 1 & 2) Flex drive
- (1 - Options 1 & 2) Hex bolt, 5/16" X 2-1/2", stainless steel
- (1 - Options 1 & 2) Hex nut 5/16"
- (1 - Option 1) O-ring seal
- (1 - Option 2) Flex drive adapter

TOOLS NEEDED

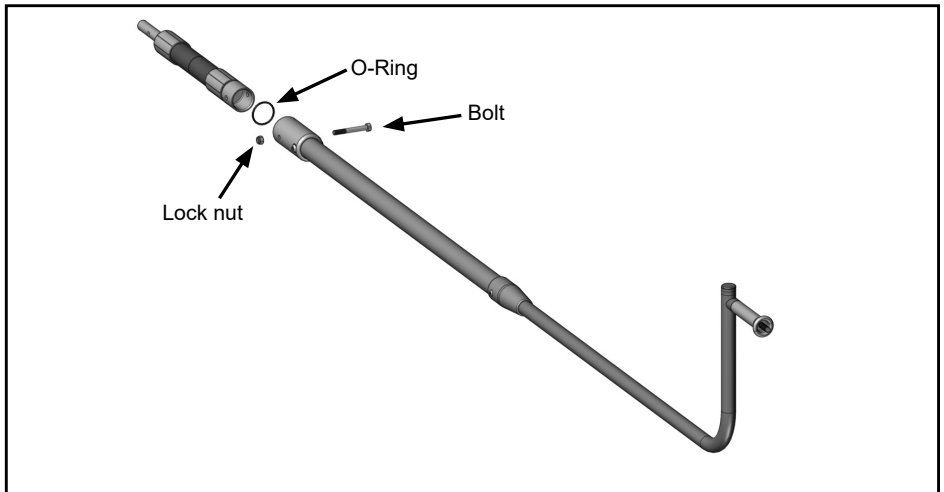
- (2 - Options 1 & 2) 1/2" Wrenches
- (1 - Options 1 & 2) Protective eyewear
- (1 - Options 1 & 2) Foot-pound torque wrench with 1/2" socket
- (1 - Option 2) Tape measure or ruler
- (1 - Option 2) Metal hand saw
- (1 - Option 2) Metal grinding tool
- (1 - Option 2) Welder

DEPENDING ON CRANK HANDLE, PERFORM ONE OF THE FOLLOWING:

OPTION 1 - INSTALLING FLEX DRIVE

(For crank handles produced in 2009 and newer)

- Insert O-ring into open end of crank handle.
- Slide open end of flex drive onto open end of handle.
- Insert bolt through handle and finger tighten nut (see below).
- Torque bolt to 19 ft-lbs.

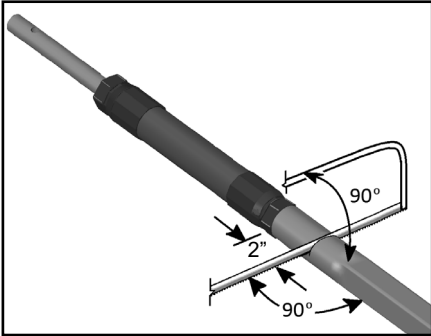


OPTION 2 - WELDED-ON TO BOLT-ON FLEX DRIVE

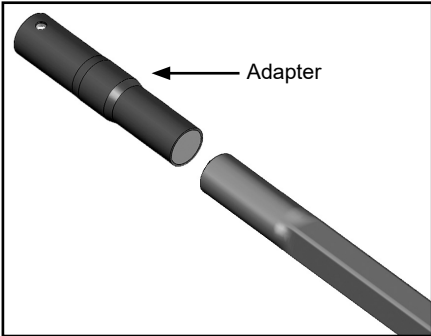
(For crank handles produced before 2009)

A. Measure back 2" and cut existing welded flex drive off of handle.

B. Deburr handle at location of cut.



C. Orient bolt-on style adapter with end of handle as shown, then insert swedge end fully into end of handle.



D. Apply fillet weld around joint of adapter and handle.

E. Bolt replacement flex drive to adapter. Torque bolt to 19 ft-lbs.

