

INSTRUCTIONS FOR FIELD WELDED TUBE SPLICES



NOTE TO INSTALLER: These instructions assume the damaged tube has already been disassembled from the rest of the tarp system. It's also assumed the installer knows how to reassemble the tarp upon completion of the splicing process.

Refer to the following pages for instructions to splice tubes for:

Page 1 and 2.....SRT 2 Systems 3” Aluminum Tubes	Page 4All Systems 1” Steel Tubes
Page 3EZLOC Systems 2” Aluminum Tubes	Page 4Sidlock System 2” Steel Tubes
Page 3Autolock Systems 3” Aluminum Tubes	

SRT-2® System Instructions Aluminum Tube

NOTE: If splice will be closer than 34 inches from either end of tube, you will need to buy enough tube to make sure the splice will be at least 34 inches in from the end. Before ordering material, see page 2 for information about splice location and removing and reinstalling a cartridge inside the roll tube.

- 1 Measure the length of roll tube requiring replacement. Purchase a piece of aluminum roll tube same length as measured. Also purchase a roll tube splice and rivets for reattaching tarp to roll tube.
 - a. 3” roll tube.....p/n 10263
 - b. 3” splicep/n 50064
 - c. 3” roll tube tarp/rivet.....p/n 60786 (qty. 2)
- 2 Cut original roll tube length off as measured in step 1 above. Try to make the cut as square and straight as possible.
- 3 Drill ¼” holes into existing roll tube and new roll tube with holes spaced as shown on diagram (8 locations) at right. Drill ¼” hole through both layers of tubes. Then use ½” bit and widen out top hole (outer layer only) to ½” inch hole.

10" 10" 2" 2" 1st Drill 1/4" Holes 2nd Drill 1/2" Holes Through Outer Layer Only

FIRST DRILL 1/4" Hole through both layers of tube (8 Holes)
SECOND DRILL 1/2" Hole through outer splice tube only (8 Holes)
- 4 Insert one half of splice tube into existing roll tube and other half into new roll tube. Lay roll tubes on flat floor to ensure straightness and with splice butted tight, plug weld splice where the ½” holes were drilled. (8 locations) Then **grind weld smooth**.

4 locations on this side 4 locations on this side

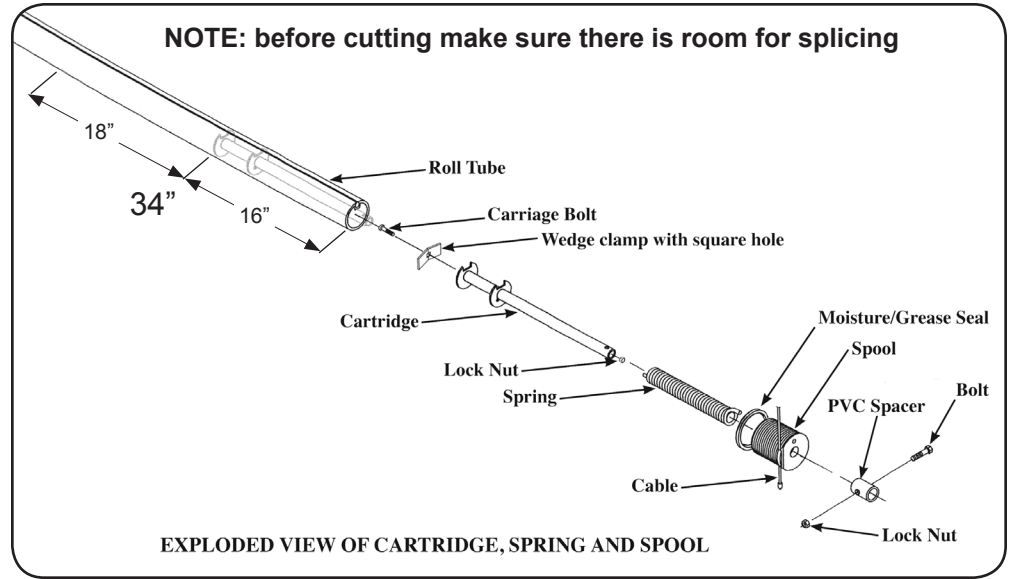
Plug Weld Each Hole--Grind Weld Smooth (8 Holes)
- 5 Reinstall tarp to roll tube with rivets.

SRT 2® Systems continued, Cartridge Removal/Assembly

(follow these instructions only if removal of cartridge is needed to splice roll tube)

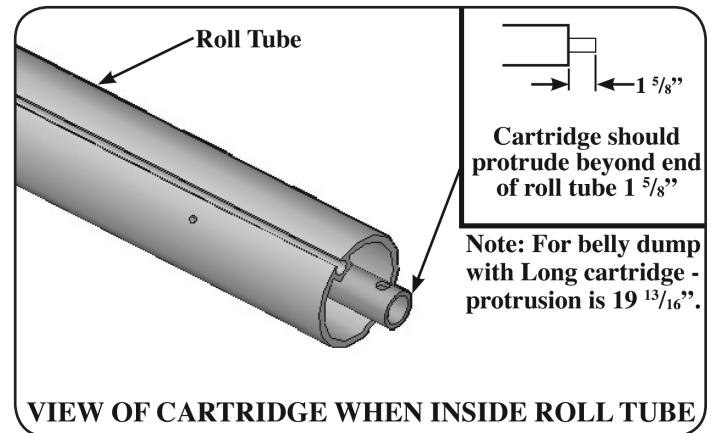
Suggested Tools:

- a) ratchet
- b) 1/2" deep socket
- c) 18" long extension
- d) torque wrench ft. lb.
- e) 1/2" box wrench
- f) protective eyewear



TO REMOVE EXISTING CARTRIDGE:

- 1) Release cable tension with ratchet.
- 2) Unwrap cable-note orientation of wrap for reassembly.
- 3) Remove lock nut, bolt and PVC spacer that hold spool on.
- 4) Remove spool- clean inside of spool and outer side of roll tube area that spool turns on. Apply teflon on grease to inside of spool for reassembly later.
- 5) Note orientation of torsion spring and mark exposed tab end for reassembly. Then remove spring.
- 6) Use long extension with 1/2" deep socket and loosen existing bolt inside cartridge. Then pull assembly out.



ASSEMBLE REPLACEMENT COMPONENTS/ CARTRIDGE:

- 1) Purchase new wedge clamp #10331
- 2) Assemble wedge clamp to cartridge. Make sure wedge clamp is positioned as shown in exploded view. Turn lock nut just tight enough to prevent carriage bolt from spinning.
- 3) Place cartridge assembly inside roll tube and adjust it to protrude out as shown. Tighten lock nut to 20 ft. lbs. This will expand the wedge clamp securing cartridge in its proper position.
- 4) Insert spring -with end marked when removed- to outside.
- 5) Slide freshly greased spool on roll tube and turn until spring tab engages hole on spool.
- 5) Replace PVC spacer with its bolt and tighten lock nut. Push moisture grease seal up against spool.
- 6) Wrap cable around spool. Apply tension with ratchet. Watch cable groove on spool, as tension is applied, the spool turns. Proper tension is when the spool makes about 1/4 to 1/3 of a turn.

TIP: For best tarp performance - periodically clean and grease spools at both ends.

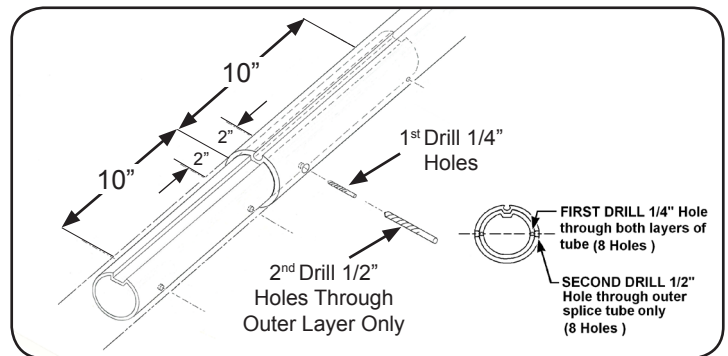
EZ-LOC® and Autolock® System Instructions Aluminum Tube

NOTE : For EZLOC systems, it is important to note the splice procedure below is for a splice at least 13 feet from end of tube with bunji return components inside of tube (at front end on hand crank systems and rear end on electric systems). For Autolock systems, splice must be at least 34 inches in from motor end.

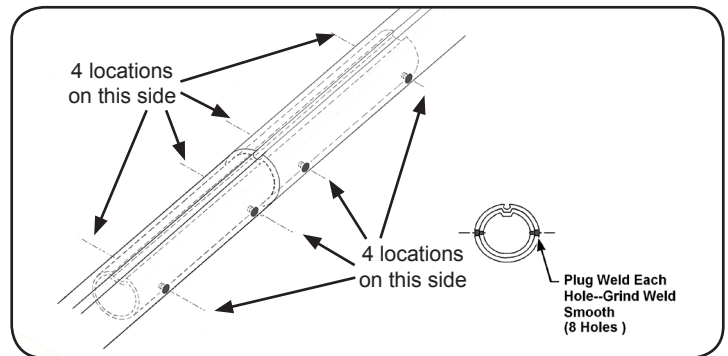
- 1 Measure the length of roll tube requiring replacement. Purchase a piece of aluminum roll tube same length as measured. Also purchase a roll tube splice and rivets for reattaching tarp to roll tube.
 - a) 2" roll tube.....p/n 60950
 - b) 3" roll tube.....p/n 10263
 - c) 2" splicep/n 50050
 - d) 3" splicep/n 50064
 - e) 2" roll tube / tarp rivet.....p/n 60793 (qty. 2)
 - f) 3" roll tube / tarp rivet.....p/n 60786 (qty. 2)

- 2 Cut original roll tube length off as measured in step 1. Try to make the cut as square and straight as possible.

- 3 Drill 1/4" holes into existing roll tube and new roll tube with holes spaced as shown on diagram (8 locations) at right. Drill 1/4" hole through both layers of tubes. Then use 1/2" bit and widen out top hole (outer layer only) to 1/2" inch hole. (note: diagram shows a 3 inch tube, use same procedures for 2 inch tube)



- 4 Insert one half of splice tube into existing roll tube and other half into new roll tube. Lay roll tubes on flat floor to ensure straightness and with splice butted tight, plug weld splice where the 1/2" holes were drilled. (8 locations) Then **grind weld smooth**. (note: diagram shows a 3 inch tube, use same procedures for 2 inch tube.



- 5 Reinstall tarp to roll tube with rivets.

All Systems Instructions (1" Stationary Tube SST & Galv. Steel)

- 1 Measure the length of stationary tube requiring replacement. If splice will be in middle of roll tube, go to step 3. Purchase new rivets to attach tarp to stationary tube.
 - a. SST tube.....p/n 20905
 - b. Galv. steel tube.....p/n 40870
 - c. Tarp Rivet.....p/n 60793
- 2 Purchase a piece of stationary tube in appropriate to make up an original length stationary tube **with one end of tube swedged**. Then go to step 4.
- 3 Purchase a piece of stationary tube in appropriate size to make up an original length stationary tube **with both ends of tube swedged**.
- 4 Cut the original stationary tube length based on measurement from step 1.
- 5 Insert new piece of swedged stationary tube into original stationary tube.
- 6 Lay tubes on flat floor to ensure straightness and tack weld tubes together at the splice. Weld all the way around the tube. Then grind weld smooth. If a section of stationary tube was removed in middle of original stationary tube, spot weld all 3 pieces of stationary tube and grind smooth as previously described.

SIDELOCK System Instructions (2" Steel Roll Tube)

- 1 Measure the length of roll tube requiring replacement. *If splice will be in middle of roll tube, go to step 3.*
- 2 Purchase a piece of 2" steel roll tube in appropriate length to make up an original length roll tube with one end swedged. May want/need to purchase replacement nylon clamps and screws for reattaching the tarp to the roll tube. Then go to step 3.

a. Nylon U Clampp/n 60326	e. 2" Roll Tube, 24' Swedged 1 end.....p/n 60715
b. Screw.....p/n 60650	f. 2" Roll Tube, 16' Swedged 1 end & spline 1 end.....p/n 60732
c. 2" Roll Tube, 16' Swedged 1 endp/n 60708	g. 2" Roll Tube, 20' Swedged 1 end & spline 1 end.....p/n 60738
d. 2" Roll Tube, 20' Swedged 1 endp/n 60711	g. 2" Roll Tube, 24' Swedged 1 end & spline 1 end.....p/n 60744
- 3 Cut the original roll tube length based on measurement from step 1.
- 4 Insert new piece of swedged roll tube into original roll tube.
- 5 Lay tubes on flat floor to ensure straightness and tack weld tubes together at the splice. Weld all the way around the roll tube. Then grind weld smooth. If a section of roll tube was removed in middle of original roll tube, weld all 3 pieces of roll tube and grind smooth as previously described.