

TECHNICAL BULLETIN



Subject:			
AIRLOCK FASTENER TORQUE SPECIFICATIONS			
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	Product Lines:	Transportation Equipment: <input type="checkbox"/> Pneumatic Equipment: <input checked="" type="checkbox"/>	

To ensure all components are properly positioned, secured, and sealed and that the assembled airlock will function properly, the fasteners used to assemble the airlock must meet the torque requirements outlined in **Table 1** through **Table 9** for each specific airlock model and style (Blow Through [BT] vs Drop Through [DT]). Reference **Figure 1** through **Figure 9** for a visual representation of the location of each fastener.

* NOTE: There is no defined torque specification for the rotor shaft lock nut. The lock nut should be tightened evenly until the rotor turns harder. However, it must be tighter than the specified minimum torque value.

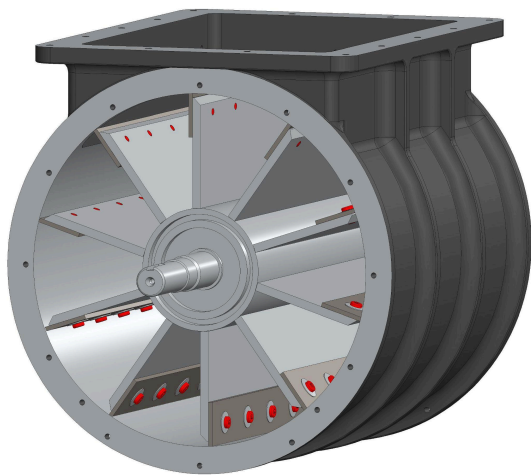


Figure 1: Rotor Blade Tip Bolts

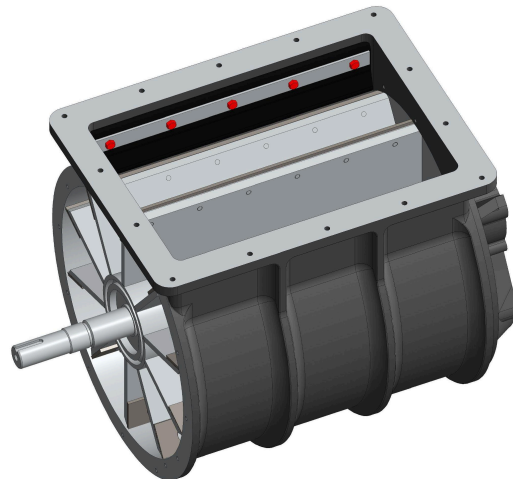


Figure 2: Wiper Blade Bolts

TECHNICAL BULLETIN



Subject:
AIRLOCK FASTENER TORQUE SPECIFICATIONS

Bulletin #:
144289

Rev:
A

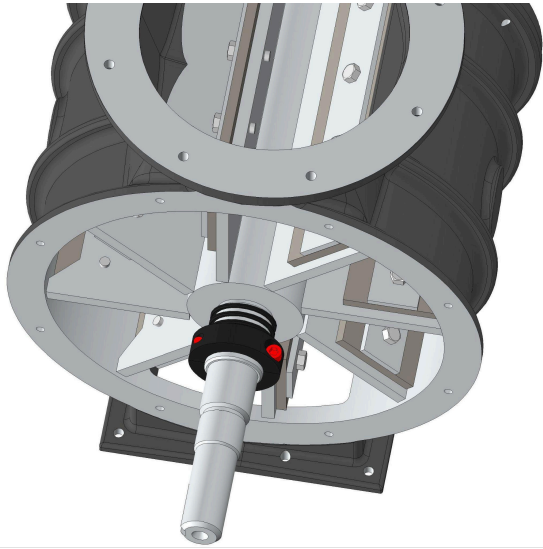


Figure 3: Rotor Shaft Lock Collar

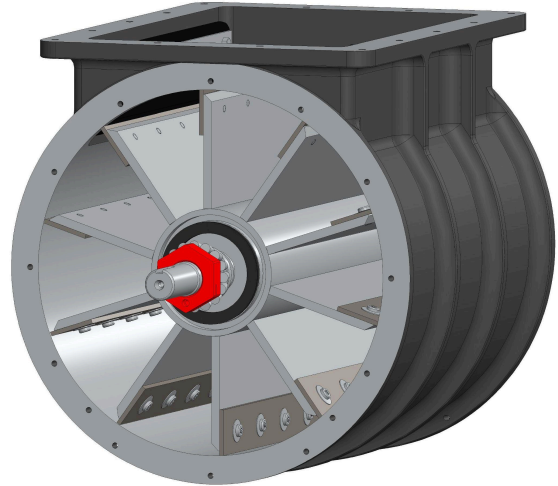


Figure 4: Rotor Shaft Lock Nut

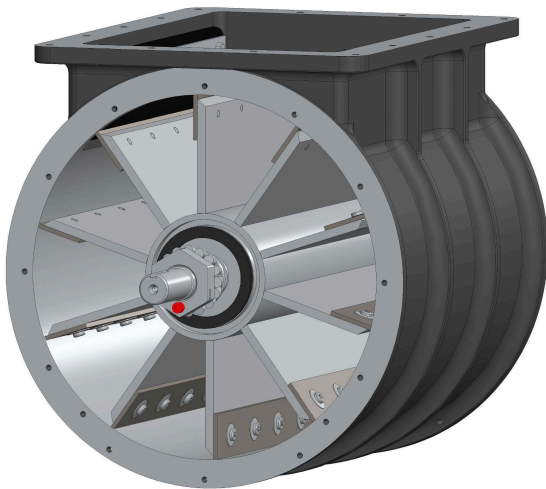


Figure 5: Lock Nut Set Screw

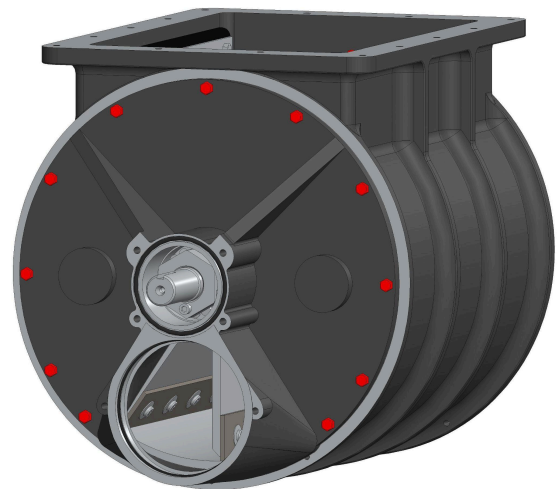


Figure 6: End Plate Bolts

TECHNICAL BULLETIN



Subject:
AIRLOCK FASTENER TORQUE SPECIFICATIONS

Bulletin #:
144289

Rev:
A

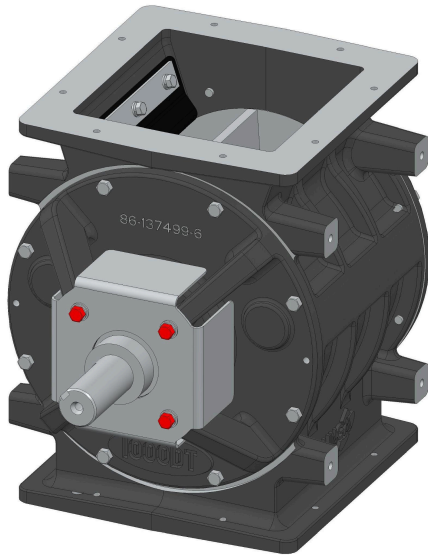


Figure 7: Shaft Guard Bolts

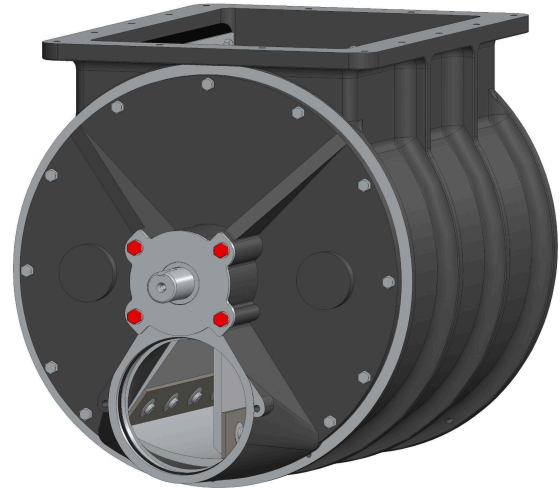


Figure 8: Seal Plate Bolts

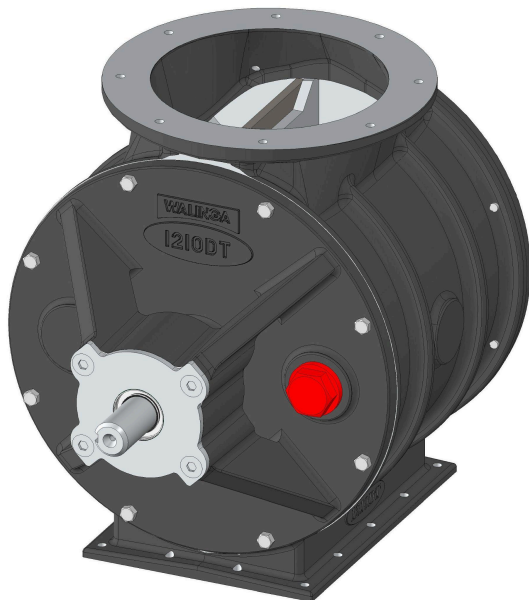


Figure 9: Plug

TECHNICAL BULLETIN



Subject:
AIRLOCK FASTENER TORQUE SPECIFICATIONS

Bulletin #:
144289

Rev:
A

Table 1: 1008 DT airlock fastener torque specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 2	Wiper Blade Bolts	1/4-20-1	94-05281-6	3	External 7/16 hex	1/2	12 ft-lb
Fig 3	Rotor Shaft Lock Collar	1/4-28-3/4	94-14744-6	2	Internal 3/16 hex	3/8	16 ft-lb
Fig 6	End Plate Bolts	5/16-18-1	94-05284-6	16	External 1/2 hex	1/2	24 ft-lb
Fig 7	Shaft Guard Bolts	5/16-18-1	94-05284-6	8	External 1/2 hex	1/2	24 ft-lb

Table 2: 1210 DT airlock fastener torque specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Rotor Blade Tip Bolts	5/16-18-1/2	94-08478-6	32	Internal T40 torx	3/8	28 ft-lb
Fig 3	Rotor Shaft Lock Collar	5/16-18-1	94-00176-6	2	Internal 1/4 hex	1/2	28 ft-lb
Fig 4	Rotor Shaft Lock Nut	1 3/8-12	30-91304-6	2	External 2 5/8 hex	3/4	<i>min</i> 40 ft-lb*
Fig 5	Lock Nut Set Screw	5/16-18-3/4	94-96975-6	2	Internal 1/4 hex	1/2	29 ft-lb
Fig 6	End Plate Bolts	5/16-18-1	94-05284-6	16	External 1/2 hex	1/2	24 ft-lb
Fig 8	Seal Plate Bolts	3/8-16-1 3/8-16-1 1/4	94-05317-6 94-05318-6	4 4	External 9/16 hex	1/2	24 ft-lb
Fig 9	Plug	SAE 20	30-49200-4	2	External 1 1/2 hex	1/2	24 ft-lb

TECHNICAL BULLETIN



Subject:
AIRLOCK FASTENER TORQUE SPECIFICATIONS

Bulletin #:
144289

Rev:
A

Table 3: 1314 BT airlock fastener torque specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Rotor Blade Tip Bolts	5/16-18-1/2	94-08478-6	50	Internal T40 torx	3/8	28 ft-lb
Fig 2	Wiper Blade Bolts	5/16-18-1	94-05284-6	4	External 1/2 hex	1/2	24 ft-lb
Fig 4	Rotor Shaft Lock Nut	1 3/8-12	30-91304-6	2	External 2 5/8 hex	3/4	min 40 ft-lb*
Fig 5	Lock Nut Set Screw	5/16-18-3/4	94-96975-6	2	Internal 1/4 hex	1/2	29 ft-lb
Fig 6	End Plate Bolts	5/16-18-1 1/4	94-05286-6	16	External 1/2 hex	1/2	24 ft-lb
Fig 8	Seal Plate Bolts	3/8-16-1 3/8-16-1 1/4	94-05317-6 94-05318-6	4 4	External 9/16 hex	1/2	24 ft-lb
Fig 9	Plug (Square Head)	1 1/4	58-01173-6	2	15/16 Wrench		N/A

Table 4: 1314 DT airlock fastener torque specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Rotor Blade Tip Bolts	5/16-18-5/8	94-61715-6	50	External 1/2 hex	1/2	24 ft-lb
Fig 2	Wiper Blade Bolts	5/16-18-1	94-05284-6	4	External 1/2 hex	1/2	24 ft-lb
Fig 6	Rotor Shaft Lock Nut	1 3/8-12	30-91304-6	2	External 2 5/8 hex	3/4	min 40 ft-lb*
Fig 5	Lock Nut Set Screw	5/16-18-3/4	94-96975-6	2	Internal 1/4 hex	1/2	29 ft-lb
Fig 6	End Plate Bolts	5/16-18-1 1/4	94-05286-6	16	External 1/2 hex	1/2	24 ft-lb
Fig 8	Seal Plate Bolts	3/8-16-1 3/8-16-1 1/4	94-05317-6 94-05318-6	4 4	External 9/16 hex	1/2	24 ft-lb
Fig 9	Plug	SAE 20	30-49203-5	2	External 1 1/2 hex	3/4	24 ft-lb

TECHNICAL BULLETIN



Subject:
AIRLOCK FASTENER TORQUE SPECIFICATIONS

Bulletin #:
144289

Rev:
A

Table 5: 1618 BT airlock fastener torque specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Rotor Blade Tip Bolts	5/16-18-5/8	94-08781-6	60	Internal T40 torx	3/8	28 ft-lb
Fig 2	Wiper Blade Bolts	5/16-18-1	94-05284-6	5	External 1/2 hex	1/2	24 ft-lb
Fig 4	Rotor Shaft Lock Nut	1 1/2-12	30-91305-4	2	External 2 5/8 hex	3/4	min 60 ft-lb*
Fig 5	Lock Nut Set Screw	5/16-18-3/4	94-96975-6	2	Internal 1/4 hex	1/2	29 ft-lb
Fig 6	End Plate Bolts	5/16-18-1 1/4	94-05286-6	22	External 1/2 hex	1/2	24 ft-lb
Fig 8	Seal Plate Bolts	3/8-16-1 1/4 3/8-16-1	94-05318-6 94-05317-6	4 4	External 9/16 hex	1/2	24 ft-lb

Table 6: 1618 DT airlock fastener torque specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Rotor Blade Tip Bolts	5/16-18-5/8	94-61715-6	60	External 1/2 hex	1/2	24 ft-lb
Fig 2	Wiper Blade Bolts	5/16-18-1	94-05284-6	5	External 1/2 hex	1/2	24 ft-lb
Fig 4	Rotor Shaft Lock Nut	1 1/2-12	30-91305-4	2	External 2 5/8 hex	3/4	min 60 ft-lb*
Fig 5	Lock Nut Set Screw	5/16-18-3/4	94-96975-6	2	Internal 1/4 hex	1/2	29 ft-lb
Fig 6	End Plate Bolts	5/16-18-1 1/4	94-05286-6	24	External 1/2 hex	1/2	24 ft-lb
Fig 8	Seal Plate Bolts	3/8-16-1 1/4 3/8-16-1	94-13518-6 94-05317-6	4 4	External 9/16 hex	1/2	24 ft-lb
Fig 9	Plug	SAE 20	30-49203-5	2	External 1 1/2 hex	3/4	24 ft-lb

TECHNICAL BULLETIN



Subject:
AIRLOCK FASTENER TORQUE SPECIFICATIONS

Bulletin #:
144289

Rev:
A

Table 7: 2018 BT airlock fastener torque specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Rotor Blade Tip Bolts	5/16-18-3/4	94-101608-6	60	Internal T40 torx	3/8	28 ft-lb
Fig 2	Wiper Blade Bolts	3/8-16-1	94-05317-6	5	External 9/16 hex	1/2	24 ft-lb
Fig 4	Rotor Shaft Lock Nut	2 1/2-12	30-84179-6	2	External 3 1/2 hex	3/4	<i>min</i> 85 ft-lb*
Fig 5	Lock Nut Set Screw	5/16-18-1	94-00176-6	2	Internal 1/4 hex	1/2	29 ft-lb
Fig 6	End Plate Bolts	3/8-16-1 1/2	94-05319-6	24	External 9/16 hex	1/2	24 ft-lb
Fig 8	Seal Plate Bolts	3/8-16-1 3/8-16-1 1/4	94-05317-6 94-05318-6	4 4	External 9/16 hex	1/2	24 ft-lb

TECHNICAL BULLETIN



Subject:
AIRLOCK FASTENER TORQUE SPECIFICATIONS

Bulletin #:
144289

Rev:
A

Table 8: 2224 BT airlock fastener torque specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Rotor Blade Tip Bolts	5/16-18-3/4	94-101608-6	56	Internal T40 torx	3/8	28 ft-lb
Fig 4	Rotor Shaft Lock Nut	2 1/2-12	30-84179-6	2	External 3 1/2 hex	3/4	min 85 ft-lb*
Fig 5	Lock Nut Set Screw	5/16-18-1	94-00176-6	2	Internal 1/4 hex	1/2	29 ft-lb
Fig 6	End Plate Bolts	3/8-16-1 1/2	94-05319-6	24	External 9/16 hex	1/2	24 ft-lb
Fig 8	Seal Plate Bolts	3/8-16-1	94-05317-6	8	External 9/16 hex	1/2	24 ft-lb
Fig 9	Plug (Square Head)	1 1/4	58-01173-6	2	15/16 Wrench		N/A

Table 9: 2224 DT airlock fastener torque specifications

REF	DESCRIPTION	SIZE	PART NUMBER	QTY	TOOL BIT	DRIVE	TORQUE
Fig 1	Rotor Blade Tip Bolts	5/16-18-5/8	94-61715-6	72	External 1/2 hex	1/2	24 ft-lb
Fig 6	End Plate Bolts	3/8-16-1 3/4	94-04292-6	24	External 9/16 hex	1/2	24 ft-lb
Fig 8	Seal Plate Bolts	3/8-16-1 1/4	94-05318-6	12	External 9/16 hex	1/2	24 ft-lb