1. Remove 2 piece rivet—use chisel or metal cutting torch to remove rivet collar (far side) then remove rivet pin.

2. Hammer the L.H. strut sideways in direction of the L.H. head as shown by the arrow.

3. Roll the strut left or right to reinstall the nose to the bar as shown.

4. Put the tail of the new strut against the angle and hammer in the same direction as when it was removed.

5. Hammer until the holes line up.


Alternate fastener:
- 5/8 dia grade 5 bolt & hex nut
- Torque to 120 to 125 ft-lb
- Tack weld nut to bolt or peen bolt to prevent nut from loosening.

**Tools Required**
1. Cold chisel or metal cutting torch
2. Huck installation equipment
3. 5-8 lb. hammer

**Miner Enterprises, Inc.**
Powertrac Corp. Removal, Wisconsin

**Procedure for Changing Strut on Miner Brake Beams**
1. REMOVE 2 PIECE RIVET—USE CHISEL OR METAL CUTTING TORCH TO REMOVE RIVET COLLAR (FAR SIDE) THEN REMOVE RIVET PIN.

2. HAMMER THE L.H. STRUT SIDEWAYS IN DIRECTION OF THE L.H. HEAD AS SHOWN BY THE ARROW

3. ROLL THE STRUT LEFT OR RIGHT TO REINSTALL THE NOSE TO THE BAR AS SHOWN

4. PUT THE TAIL OF THE NEW STRUT AGAINST THE ANGLE AND HAMMER IN THE SAME DIRECTION AS WHEN IT WAS REMOVED

5. HAMMER UNTIL THE HOLES LINE UP

6. RIVET IN PLACE USING 5/8 DIA HUCK PIN P/N C50LR-BR20-8 HUCK COLLAR P/N 3LC-2R20G

ALTERNATE FASTENER:
5/8 DIA GRADE 5 BOLT & HEX NUT
TORQUE TO 120 TO 125 ft-lb
TACK WELD NUT TO BOLT OR PEEN BOLT TO PREVENT NUT FROM LOOSENING.

TOOLS REQUIRED
1. COLD CHISEL OR METAL CUTTING TORCH
2. HUCK INSTALLATION EQUIPMENT
3. 5–8 LB. HAMMER