

The Baier Rail Single Bolt Manway

Installation, Maintenance, and Operation Manual

Updated as of 04/26/2021





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1. General

a. Introduction

Please read this manual prior to using the product, and follow the proper operation, inspection, and maintenance.

b. Safety First



i. All BTRB Manway installations must be performed at an Association of American Railroads (AAR) certified tank car facility and by trained personnel. The following instructions should only be used as a supplemental guide and in no way supersede the operating, safety, welding, or quality assurance procedures of the tank car facility.

ii. Although the manway cover includes a lift-assist spring, maintenance personnel should use extreme caution when interacting with the BTRB manway cover assembly while it is in the open position to avoid injury from accidental closure.

c. Warranty

i. Go to <https://baierrail.com/documents/#documents-warranty>

2. Product Description

a. Models

MODELS	DESCRIPTION	DIM "A"
COVER ASSEMBLIES		
BTSB	Cover Assy, carbon steel construction with stainless steel o-ring sealing surfaces	N/A
BTSB-SS	Cover Assy, stainless steel on all surfaces in contact with commodity (internally)	N/A
NOZZLES		
BNTZ-R-5	Nozzle, Retrofit, stainless steel on all surfaces in contact with commodity (internally)	5.5
BNTZ-SS-9.625	Nozzle, New Construction, DOT-111, stainless steel on all surfaces in contact with commodity (internally)	9.625
BNTZ-SS-12.5	New Construction, DOT-117, stainless steel on all surfaces in contact with commodity (internally)	12.5

b. Envelope Dimensions and Part Identification

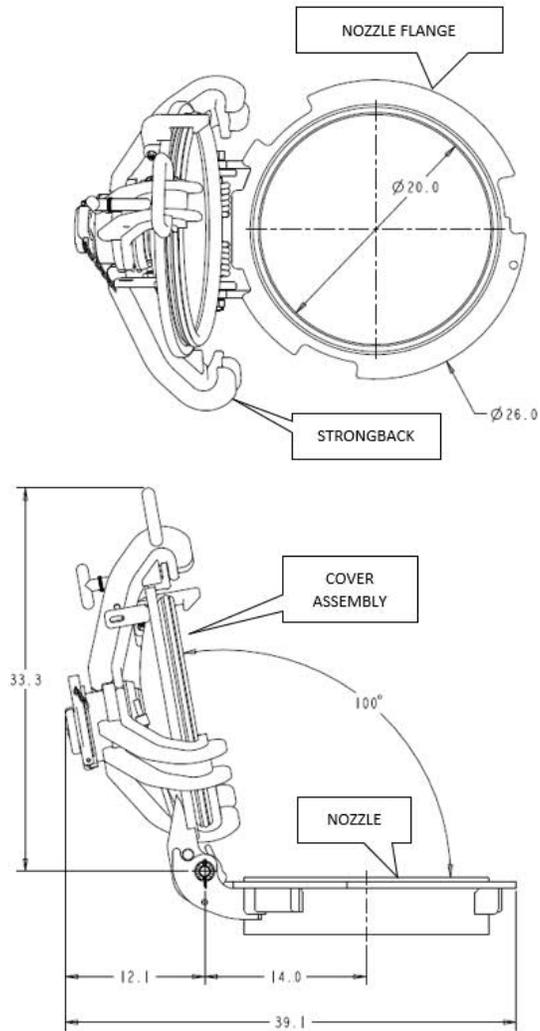


Figure 1A - Envelope Dimensions – Shown in Open-Lock-Position

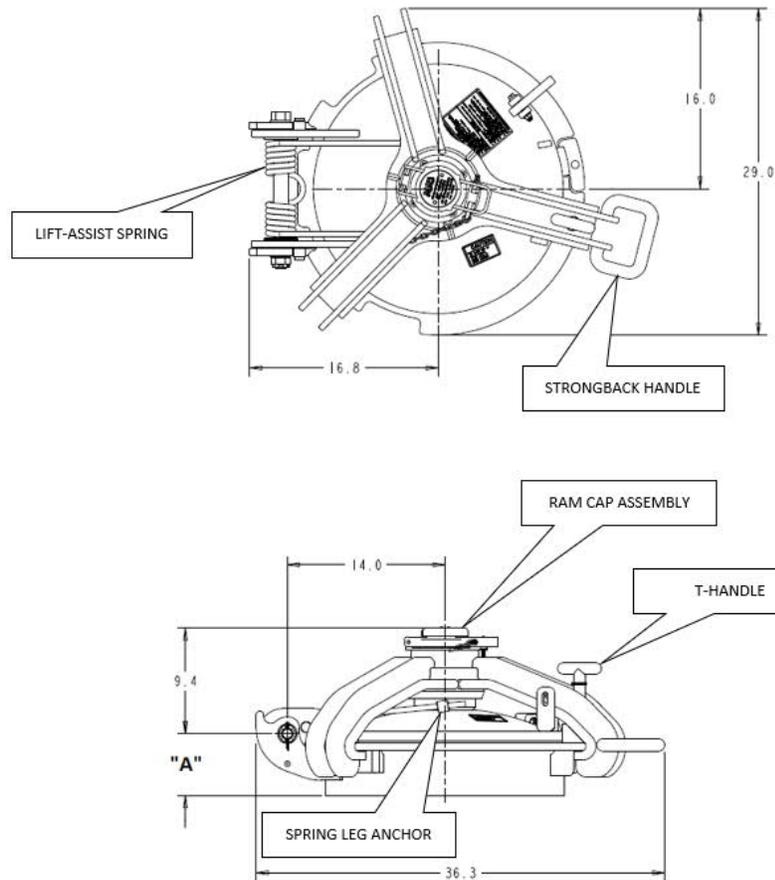


Figure 1B - Envelope Dimensions – Shown in Closed-Lock-Position

- c. Shipping
 - i. Nozzles and cover assemblies are shipped separately. This allows the cover assemblies to be safely stored while the nozzles are being welded to the tank car. All Baier Rail cover assemblies and nozzles are interchangeable.
- 3. Inspection of Sealing Elements (Inspect before adding to tank car)
 - a. Nozzle Sealing Surface
 - i. The nozzle sealing surface must be free from damage, debris or defects. If the sealing surface needs to be repaired or cleaned follow the instructions in section 5.b.ii.2.a.
 - b. Cover O-ring Channel
 - i. The cover o-ring channel must be free from damage, debris or defects. If the sealing surface needs to be repaired or cleaned follow the instructions in section 5.b.ii.2.a.
 - c. Cover O-ring
 - i. Inspect the cover o-ring for defects such as cuts, tears, debris, or raised areas. If any defects are found, the o-ring must be replaced before using the BTSB manway.

4. Installing the Cover Assembly
 a. Cover Assembly Position



- i. The cover assembly should be installed in the open position, when there is no tension on the Lift-assist spring. See Figure 2.
- ii. Use an appropriate means to lift and support the weight of the cover assembly, then align the hinge holes of the cover with the hinge holes of the nozzle.
- iii. Insert the two legs of the lift assist spring into the corresponding anchors on the top of the cover.
- iv. Note the orientation of the center loop of the spring in figure 2. This orientation is necessary to ensure when the cover assembly is closed, the center loop comes to rest on the nozzle in a manner which provides spring lift assist.
- v. Insert the hinge hardware according to Figure 2, with the bolt inserted from left to right.

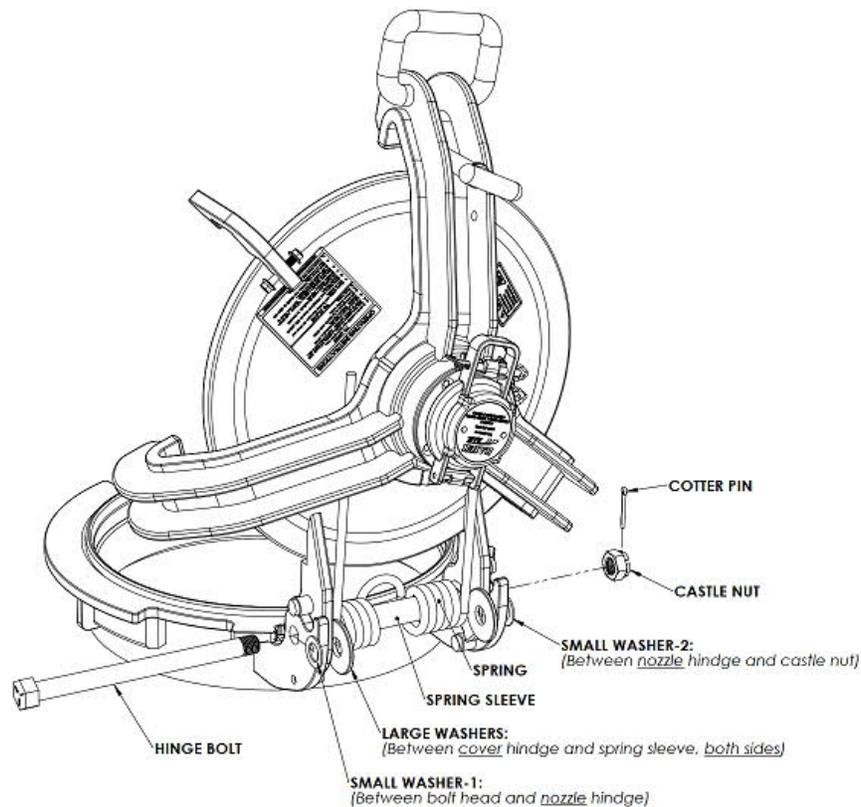


Figure 2 – Lift Assist Spring Orientation and Hinge Hardware Arrangement

- vi. Install the castle nut on to the bolt and thread it until the crown of the bolt passes the hole location on the bolt.
- vii. Using pliers, insert the cotter pin into the hole on the bolt, and bend the cotter pin end back to prevent disengagement.
- viii. Install the o-ring. Align the o-ring into the channel and pull until it snaps into place.



- ix. Close the cover. The loop of the spring should now come into contact with the nozzle flange so that the spring supports the weight of the cover. **IMPORTANT:** Keep hands and other body parts away from the nozzle opening at all times to avoid risk of injury.
- b. Closing the Cover Assembly
 - i. Note that the strongback is locked in relation to the cover by means of a spring-loaded T-handle locking pin. This is called the open-lock-position. With one hand pushing the cover assembly down on the strongback's main handle, pull the T-handle up, and turn the strongback clockwise. Release the T-handle and continue to turn until the spring-loaded pin of the T-handle releases and fully engages the corresponding hole in the nozzle flange. This is called the closed-lock-position. If the strongback does not freely move from one position to another it is due to contact between the surfaces of the strongback arms and the nozzle flange. To eliminate this contact, turn the ram so that the nozzle flange is equally positioned between the strongback "claws" and "wedges" (See figure 3).

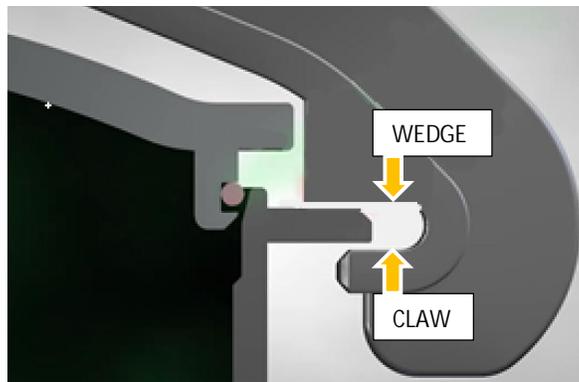


Figure 3 - Strongback in Neutral Position

Note: The claws bear up against the bottom side of the nozzle flange when closing the cover assembly. The wedges bear down against the upper side of the nozzle flange, applying to force to lift the cover assembly out of the nozzle containment.

- ii. With the strongback in the closed-lock-position turn the ram clockwise, approximately 5 ½ turns, using a ¾ - inch drive until the cover is fully seated, which is when the ram will no longer turn. A breaker bar or impact drive may be used to turn the ram. 100 ft-lbs. of torque is recommended. Do not exceed 200 ft-lbs. This will ensure the cover is not difficult to open.

For more detailed instructions see instructional videos at <https://baierrail.com/videos/>.

c. Ram Cap Assembly

- i. The ram cap assembly has dual functions. First, it acts as a cover for the ram to help keep dirt, water, and debris from entering the threaded area and interfering with the ram function. Second, the square boss on the underside of the ram cap cover helps restrict the ram from back-driving when closed. The cap movement is limited to a $\frac{1}{4}$ turn, effectively keeping the cover and strongback in a locked and sealed position.
- ii. The cover assembly must be in the down, locked and sealed position for the ram cap assembly to properly close and for its locking pin to pass freely through the features that lock it into place. If the locking pin cannot pass through freely, it is an indication that the cover assembly is not down, locked, and sealed. See following illustrations in Figure 4 for details.

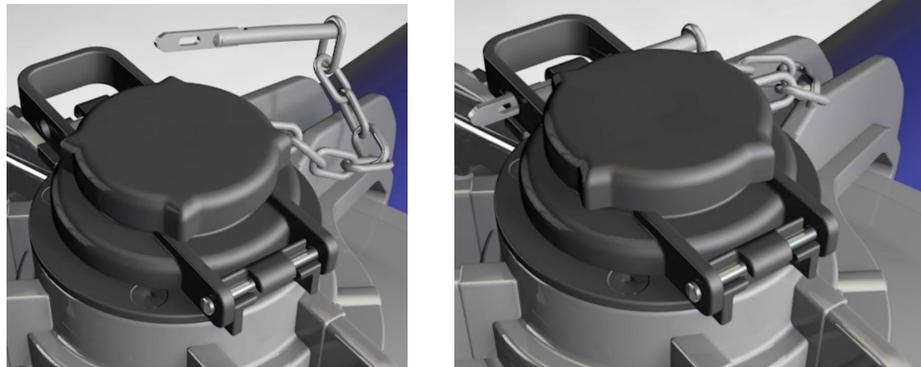


Figure 4 - Cap Assembly and Locking Pin

- d. Opening the Cover Assembly
 - i. Remove the lock-pin and open the ram cap assembly.
 - ii. Using a $\frac{3}{4}$ - inch drive, turn the ram counter-clockwise (approximately $5\frac{1}{2}$ turns) until it stops to release any residual pressure present in the tank car. Then turn the ram clockwise $\frac{1}{2}$ turn to allow the strongback to swing freely to the open-lock-position.
 - iii. Lift the T-handle and rotate the strongback counter-clockwise. Release the T-handle and continue to turn until the spring-loaded pin of the T-handle releases and fully engages the corresponding hole in the nozzle flange. The strongback is now in the open-lock-position. If the strongback does not freely move from one position to another it is due to contact between the surfaces of the strongback arms and the nozzle flange. To eliminate this contact, turn the ram so that the nozzle flange is equally positioned between the strongback claws and wedges (See figure 3). Note: The claws bear up against the bottom side of the nozzle flange when closing the cover assembly. The wedges bear down against the upper side of the nozzle flange when opening the cover assembly.
 - iv. Lift the cover assembly up by the strongback handle until the safety latch engages.
 - v. Release safety latch.

- vi. Continue lifting the cover assembly until fully opened and resting in the over center open position.
5. Maintenance and Part Replacement
- a. Greasing the Single-Bolt Ram
 - i. The ram is pre-greased at the factory; however, it can be re-greased as needed by pushing grease through a Zerk fitting at the bottom of the ram square socket.
 - 1. Fill grease through the Zerk fitting until grease begins to exit through the vent location at the front of the cap assembly, directly under the locking pin channel, as indicated in the following illustration.
 - 2. Continue to purge until exiting grease is free of discoloration due to wear or contaminants.

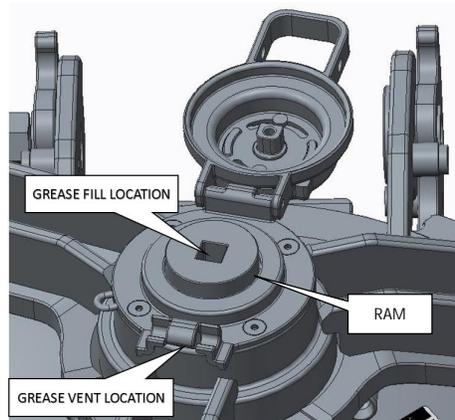


Figure 5 - Grease Fill and Vent Locations

3. To maintain warranty and maximize product life, use a performance synthetic grease of lithium or lithium complex type thickener, with a service temperature range of -25 to 266°F (-32 to 130°C).

b. Replacing the Cover O-ring

i. Removal



1. The seal is an encapsulated o-ring, consisting of a silicone core encased by a Teflon® jacket. When removing the o-ring, be careful not to damage or puncture the jacket. DO NOT use a screwdriver or knife to remove o-ring. Use a dull, flat tool, such as a tire lever iron, as shown below (not included). If the jacket becomes damaged by a tool, or has excessive wear, it must be replaced.



ii. Installation



1. Use only Baier Rail encapsulated o-rings. Using unauthorized o-rings will void the warranty and may produce unintended results, including non-accidental release of commodities (NARs). No tools are required for installation. Insert a section of the o-ring into the cover assembly o-ring retaining groove. Run the o-ring around and pull into the groove until it snaps into place.



2. Seal surface damage
 - a. The nozzle and cover surfaces that come into contact with the o-ring must be clean and visually inspected for defects. These surfaces should be smooth, although very minor machining marks, gouges, nicks, and other defects should not prevent sealing. Seal surface defects suspected of impairing sealing, must be repaired by welding and / or machining. Corroded surfaces and debris must be cleaned to expose a clean, smooth profile.

c. Replacement Parts

REPLACEMENT PARTS LIST (Includes mounting hardware where applicable)	
DESCRIPTION	PART NO.
O-RING, COVER	08867-705A
CAP ASSEMBLY	08867-102A
LIFT ASSIST SPRING ASSEMBLY	08867-191A
SAFETY LATCH	08867-192A
T-HANDLE	08867-190A



O-Ring, Cover 08867-705A



Cap Assembly 08867-102A



Lift-Assist Spring Assembly 08867-191A



Safety Latch 08867-192A



T-Handle 08867-190A

- d. For replacement of cap Assembly, lift-assist spring assembly, safety latch and T-Handle see these and other helpful videos at <https://baierrail.com/videos/>.

