



# Technical Bulletin

- Place a copy of this bulletin in the front of each Blueprints Manual.
- Redline drawings as needed and include a TB reference note.
- Document TB implementation schedule request and completion:

Date Scheduled \_\_\_\_\_ Date Completed \_\_\_\_\_

Completed by (name) \_\_\_\_\_

**TB Number:** 094  
**Date Issued:** Jan. 15, 2014  
**Expiration Date:** None

<b>Subject/Key Words:</b>	GAMA Carrier Locator Screw Torque Values.			
<b>Classification:</b>	<input checked="" type="checkbox"/> Informational	<input type="checkbox"/> Mandatory	<input type="checkbox"/> Safety Alert	<input checked="" type="checkbox"/> Preventive Maintenance Impact
	<input type="checkbox"/> Warranty Impact	<input type="checkbox"/> Purchase Parts	<input type="checkbox"/> No Charge For Parts expires ___ / ___ / ___. Reference this TB# when ordering NC parts.	

**Issue:** Improper (excessive) tightening of carrier locator screws can result in screw breakage at time of install or failure over time due to high stress.

**Symptoms:** Broken or missing locator screws can lead to loose or misaligned carrier locators and problems with carrier pickup and drop-off.

**Inspection:** Inspect the tank and carrier locators for loose, damaged or missing locator screws on a monthly PM schedule.

**Solution:** Replace any damaged locator screws. Install new screws and/or tighten loose screws to the following torque values:

- Kel-F ¼ -20 screws: 4.5 inch-pounds
- PPS ¼ -20 screws: 8.5 inch-pounds

**DO NOT OVERTIGHTEN.** Note: The inch-pound values listed above are one-half of the torque “breakage” value of the screw.

Refer to the technical drawings supplied with the wet station for specific information on locator screw part numbers and descriptions for specific tank applications.