



### HEPI BSC Lifting Procedure

APPROVALS	DATE	REV	DCN NO.	BY	CHECK	DCC	DATE
AUTHOR: Oddvar Spjeld	3/2/04	A	E040052	O.S.			
CHECKED: Joe Giaime	3/2/04	A	E040052	J.G.			
APPROVED: R. Abbott, D. Coyne, B. Lantz							
DCC RELEASE							

### 1. SCOPE

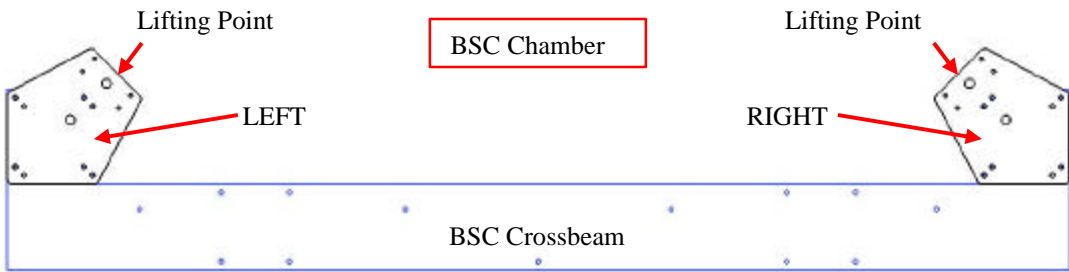
The purpose of this document is to provide step-by-step instructions in preparing the payload lift off the BSC crossbeam.

### 2. APPLICABLE DOCUMENTS

Listed below are all of the applicable and referenced documents for this task procedure:  
E040011 HEPI Assembly and Installation Procedure, Section 9 - Preparation for Installation  
D040078 BSC Lifting Plate

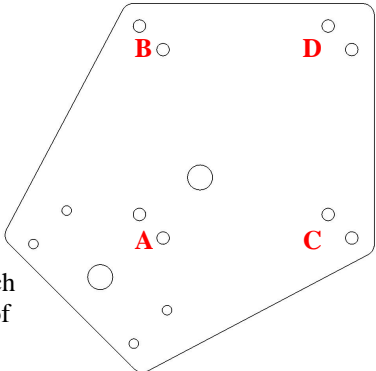
### 3. PREPARING THE LIFT

1. Check and test the gearbox, hardware and load cell for any flaws or damage before proceeding.
2. Attach the gearbox to lifting plate (D040078). Use (4) 3/8-16 x 2.50 high strength steel Hex Head bolts with (4) SAE 3/8 high strength washers and nuts. Torque evenly to 40 ft-lbs (480 in-lbs).
3. Attach the eyebolt and the handles to the lifting plate. Securely fasten.
4. Lift the plate directly above of the corner of the BSC crossbeam in the correct position as shown below.



5. Place a custom made steel washer 1.5" OD and .1875 T on top of the BSC crossbeam corner over the tapped 1/2-13 holes on the crossbeam at positions A and D.
6. Carefully lower the lifting plate down onto the BSC crossbeam, use the handles to align it correctly above the four tapped holes on the crossbeam.

**Caution:** Show extra care when positioning the lifting plate on top of the crossbeam to avoiding shocking the payload.



7. Use (4) 1/2-13 x 3.00 high strength steel Hex Head bolts and attach the lifting plate to the crossbeam. Use (4) steel washers on top of the lifting plate. Torque bolts evenly to 50 ft-lbs (600 in-lbs).
8. Attach a 5/8 shackle on to the head of the screw jack. Carefully bring the crane directly over the screw jack. Use a plumb bob to ensure this location.