


NOTE: If either the Lock Pin or the Tie Bar Rivet need to be removed, replace them with new pins of the same part numbers.

LOCK PIN REPLACEMENT INSTRUCTIONS:

- To remove the Lock Pin, grind the bottom end of the Lock Pin taking care not to take much, if any, parent material off the bottom of the Lock, until the Lock Pin can be driven out of the top of the Lock without much force.
- To install a new Lock Pin, slide the new Lock Pin into the Lock, Retainer, and Lock Spring. Then with the bottom of the Lock and the bottom end of the Lock Pin sitting on a solid flat surface, like the flat of an anvil, peen the top end of the Lock Pin until it mushrooms sufficiently to retain the Lock Pin on that end. Then flip the assembly over, so the top end of the Lock Pin is sitting on the solid flat surface. The bottom end of the Lock Pin should protrude enough from the bottom of the Lock to then peen the bottom end of the Lock Pin until that side mushrooms sufficiently to retain the Lock Pin on that end. If the bottom end of the Lock Pin does not protrude enough to complete this installation, then the top end of the Lock Pin was over-peened, and the Lock Pin will need to be replaced.

TIE BAR RIVET REPLACEMENT INSTRUCTIONS:

- To remove the Tie Bar Rivet, grind the peened end of the Tie Bar Rivet taking care not to take much, if any, parent material off the Tie Bar, until the Tie Bar Rivet can be driven out of the Tie Bar without much force.
- To install a new Tie Bar Rivet, slide the new Tie Bar Rivet into the Tie Bar and Body Half - either the Left Body or Right Body. Then with the head end of the Tie Bar Rivet sitting on a solid flat surface, like the flat of an anvil, peen the peened end of the Tie Bar Rivet until it mushrooms sufficiently to retain the Tie Bar Rivet on that end.

DO NOT SCALE DWG		HEAT TREATMENT		LIST OF MATERIALS	
UNLESS OTHERWISE SPECIFIED		NONE		 P.O. Box 192 4450 Highway 6 Clifton, Texas 76634	
(1) DIMENSIONS ARE IN INCHES		SURFACE TREATMENT			
(2) TOLERANCES		NONE		TITAN TUBING ELEVATOR RIVET REPLACEMENT INSTRUCTIONS	
DECIMAL: .XX + .002		EST. WT.			
.XXX + .0005		63.269 Lbs		DOWN BY BCS 3/3/2025	
ANGLES ± .1°-30'		CHECKED BY			
(3) REMOVE ALL BURRS AND SHARP EDGES 0.005 MAX.		KDC 3/12/2025		PART # TEA-RIVET	
(4) FILED RADIUS .005 MAX.		APVD BY			
(5) SURFACE FINISH = 125 MICRONS/CH		Patj 3/12/2025		REV D A	
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