

REVISION LETTER	GE ALTERATION NOTICE NUMBER

INSTRUCTION MANUAL IM-220

**Cleaning Procedure of the
Conical Threads on Riverhawk Studs**

GE Power Generation		GENERAL ELECTRIC COMPANY Schenectady, NY	
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1.0 Cautions and Safety Warnings

CAUTION

Personal injury and equipment damage can occur if the proper health and safety codes and procedures are not followed. Contact the site's health and safety office to determine all applicable safety rules and regulations.

WARNING

The proper personal safety equipment must be worn at all times.

2.0 Scope

This document describes the steps necessary to clean the internal, conical thread of a Riverhawk-supplied engineered stud.

GE Purchasing Ordering Part Number	GE Drawing Number	Riverhawk Part Number	Description
	373A4026	GT-4253	Stud Cleaning Kit, 2" [51mm] stud or larger
	373A4027	GT-4354	Stud Cleaning Kit, 1-5/8" [42mm] or smaller

3.0 Required Equipment

3.1 Hand Tools

Compressed air hose with an air blowgun attachment
Variable-speed, electric hand-drill



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3.2 Special Tools

Stud Cleaning Kit: GT-4253 for 2" [51mm] Studs and larger sizes

GT-4354 for 1.625" [42mm] Studs or smaller

4.0 Cleaning Procedure

4.1 Cleaning Riverhawk Locknuts



Sample Picture of a Riverhawk Locknut

For new installations, the nuts should come sealed from the factory and will need no cleaning.

For existing installations, please refer to the Riverhawk installation manual for your specific hardware set.



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4.2 Cleaning Riverhawk Studs

For new installations, the studs should come sealed from the factory and will need no cleaning.

For previously installed studs, a clean conical thread should have a bright and shiny appearance. It must be free from any loose or hardened dirt and/or debris.

If cleaning is required, follow these steps:

1. Blow out the threads with compressed air to remove loose debris and dry conical threads. Do not apply a solvent or other cleaning solution to the threads as this may chemically attack the stud.



Picture of an air hose with an Air Blowgun attachment

2. Use Stud Cleaning Kit, GT-4354 or a similar 1/2" [12mm] diameter Brass power brush for Riverhawk studs that are 1.625" [42mm] or smaller in diameter.

Use Stud Cleaning Kit, GT-4253 or a similar 1" [25mm] diameter Brass power brush for Riverhawk studs that are 2" [51mm] or larger in diameter.



Picture of Brass Power Brush



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Do not use a worn brush. A worn brush can not reach and clean the bottom of the thread root. It can also lead to unintentional damage to the conical thread.



Picture of a slightly worn brush
Replace Soon



Picture of a worn brush
Replace now. Do not use.

3. Insert the brush into an electric drill and set drill to run in a counterclockwise direction at high speed.



Picture of a brush mounted on a drill



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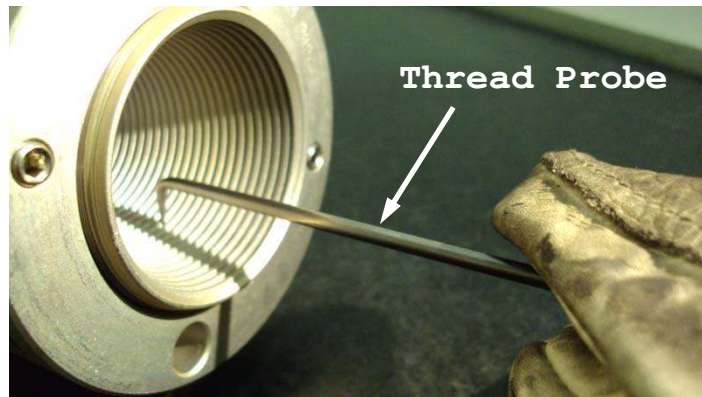
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4. Work the drill in a circular motion while moving the brush in and out to clean all of the threads. Try not to hold the brush in one place too long, so as not to remove the stud's protective coating.



Pictures of brush cleaning of a stud

5. Blow out the threads with compressed air to remove loosened debris.
6. Visually inspect threads for cleanliness. Threads should be bright and shiny.



Picture of a clean thread



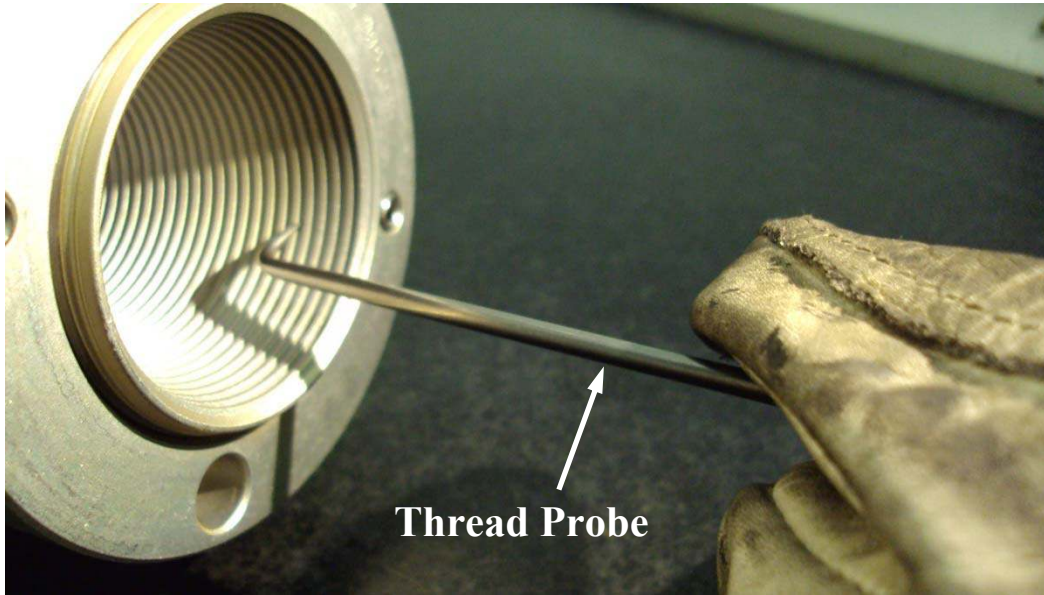
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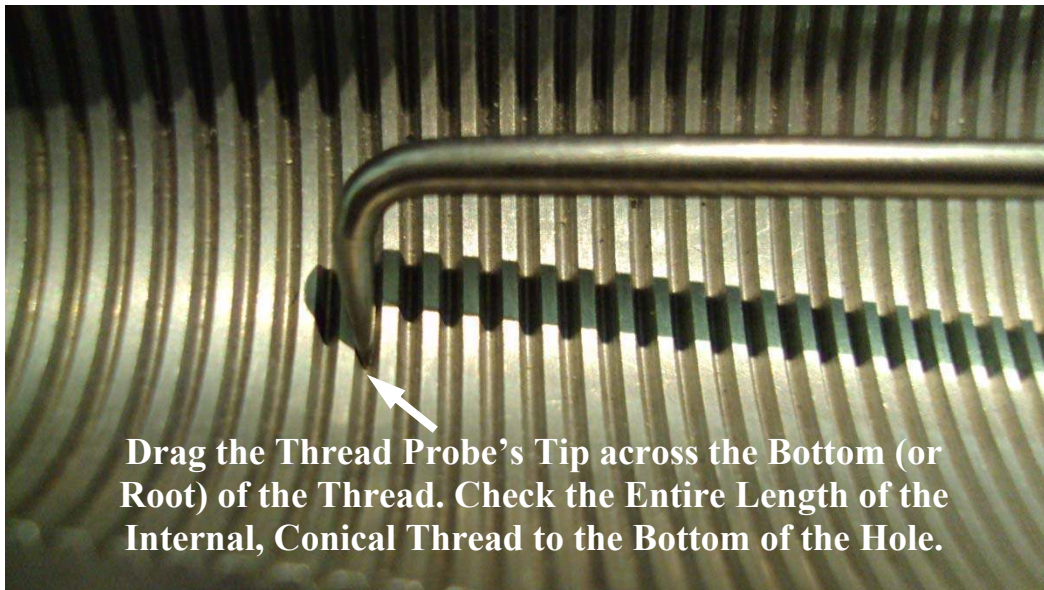
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7. Using a thread probe and flashlight, drag the probe's tip through the thread root to check the cleanliness of the thread by trying to loosen any dirt or debris.

Occasionally, scrap the sides and root of the thread to locate any hardened dirt or debris.



Picture of an Operator using a Thread Probe



Picture of a Thread Probe's Tip Engaging a Thread Root



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8. Repeat if any dirt can be found in the threads.
9. Inspect threads for any damage (i.e. - missing, torn, ripped threads) that may have been caused by previous installation.

5.0 Storage Instructions

Clean the brush with a solvent to remove any dirt or debris. Rinse the brush with acetone and allow to air dry.

Store brushes and instructions in a suitable container and location that will protect them from moisture and dirt.

6.0 Revision History

Revision Letter	Effective Date	Description
B	Jan 24, 2022	Added EC Declaration of Conformity and UKCA Declaration of Conformity
A	July 30, 2010	Section 4.2: Added step 7, renumber subsequent instruction steps
-	Jan 16, 2009	Released



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Appendix A1

EC Declaration of Conformity

Manufacturer: Riverhawk Company
Address: 215 Clinton Road
New Hartford, NY 13413, USA

The hydraulic pump and bolt tensioning tool described in this manual are used for installing and applying tension to large bolts that are specifically designed by Riverhawk Company to be tensioned hydraulically.

All applicable sections of European Directive 2006/42/EC for machinery have been applied and fulfilled in the design and manufacture of the hydraulic pump and bolt tensioning tool described in this manual. Reference also ISO 12100:2010, ISO 4413:2010, and ISO 4414:2010.

Furthermore, this equipment has been manufactured under the Riverhawk quality system per EN ISO 9001:2015

Consult the Declaration of Conformance included with the shipment of this equipment that identifies the authorized Riverhawk representative, applicable serial numbers, and appropriate signature.



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Appendix A2

UKCA Declaration of Conformity

Manufacturer: Riverhawk Company
Address: 215 Clinton Road
New Hartford, NY 13413, USA

The hydraulic pump and bolt tensioning tool described in this manual are used for installing and applying tension to large bolts that are specifically designed by Riverhawk Company to be tensioned hydraulically.

All applicable sections of Supply of Machinery (Safety) 2008 have been applied and fulfilled in the design and manufacture of the hydraulic pump and bolt tensioning tool described in this manual. Reference also ISO 12100:2010, ISO 4413:2010, and ISO 4414:2010.

Furthermore, this equipment has been manufactured under the Riverhawk quality system per EN ISO 9001:2015

Consult the Declaration of Conformance included with the shipment of this equipment that identifies the authorized Riverhawk representative, applicable serial numbers, and appropriate signature.



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