

A BOLT SOLUTION TO A RIVETING ISSUE!

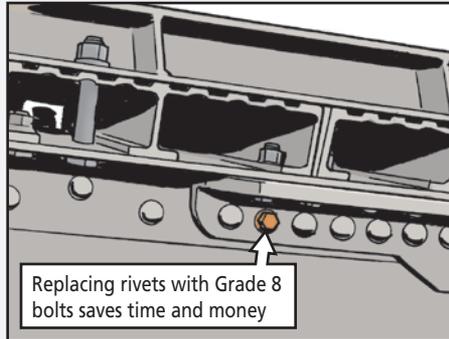
Dear Editor,

Here at Ft Leonard Wood's Engineer School, students give our seven AVLBs a lifetime of use every training cycle.

We started having issues with broken rivets on bridge panels. Because replacing rivets is a depot-level repair, we replaced the panels instead. That costs a *lot* of money.

PM Bridging gave us permission to replace the broken rivets with Grade 8 bolts as a field-level maintenance fix. That saves money and greatly reduces down time.

Here are the bridge panels you can use Grade 8 bolts on:



Replacing rivets with Grade 8 bolts saves time and money

Panel Name	NSN 5420-
MLC 60 panel assembly, center male	00-542-3116
MLC 60 panel assembly, center female	00-542-3115
MLC 60 panel ramp, male	00-542-3117
MLC 60 panel ramp, female	00-542-3118
MLC 70/85 panel assembly, male	01-420-1684
MLC 70/85 panel assembly, female	01-419-9478

Follow these rules when replacing broken rivets with Grade 8 bolts:

1. No more than 15 bolts per section.
2. No more than two bolts in any one hinge.
3. On the bottom base frame support, no more than five bolts in a row.

Here's a list of bolts, nuts, flat washers and lock washers we purchased online at: <http://www.fastenal.com>

Grade 8 flat head socket cap screws

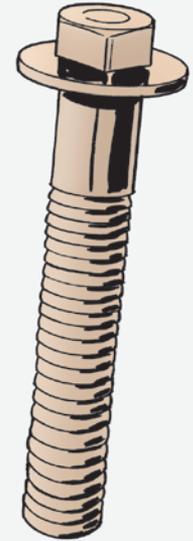
Screw Size	Part Number
3/4 x 10 x 3.5	1124450
3/4 x 10 x 4.5	24452
3/4 x 10 x 5	24453
3/4 x 10 x 5.5	24454
3/4 x 10 x 6	24455
3/4 x 10 x 6.5	13003-00009
3/4 x 10 x 7	24456
3/4 x 10 x 7.5	13003-00010

Grade 8 hex cap screw

Screw Size	Part Number
3/4 x 10 x 4.5	0137868
3/4 x 10 x 7.5	0137869
3/4 x 10 x 8	0137870
3/4 x 10 x 6	0137871
3/4 x 10 x 6.5	0137872
3/4 x 10 x 7	0137873
3/4 x 10 x 7.5	0137874
3/4 x 10 x 8	0137875
3/4 x 10 x 10.5	15384

Other hardware

Item	Size	Part Number
Button head bolt	3/4 x 10 x 3.5	13003-00008
Nut	3/4 x 10	1136416
Lock washer	3/4	0157755
Flat washer	3/4	1133864



Torque bolts to 150-180 lb-ft

Refer to TM 5-5420-203-14 (Jun 91, w/Ch 2, Jun 97) for removing rivets. Torque the bolts 150-180 lb-ft.

James S. Carmack
Ft Leonard Wood, MO

Editor's note: Thanks for the great information. This should be a big help to Soldiers in the field who have problems with broken AVLB rivets.

