

Huck 360 Grade 8 Hex Head Track Bolt Assy



Huck Part #: 360HA-DT44X#### *(360HA-DT44X1600 Shown Here)*

Primary Features and Benefits

The Huck 360® Track Bolt is a high fatigue strength, vibration resistant, bolting system with Grade 8 mechanical properties. It has a unique shallow thread form that provides 5X to 10X fatigue improvement. The 360 is free spinning during fit up and the nut thread is very forgiving to any bolt thread damage caused by hole misalignment. The 360 can easily be installed and removed with either conventional hydraulic impact tools or with other high performance continuous drive torquing systems. For those times when track maintenance is required, this unique fastener can, in many cases, be removed and reused with reliable results

Installation Instructions

Verify that the tool being used has the capability of producing the correct torque and that all settings are adjusted correctly. Always refer to the manufacturer's documentation for the correct settings and safe operating procedures of the installation equipment.

Begin installation, insert bolt into hole, add washer onto protruding threaded end. Free spin nut onto bolt with round bearing surface of nut oriented toward the track surface. Apply torque of 2250 ft. lbs. to nut side while holding bolt head with track wrench or head lock washer. Continue tightening until tool stalls, socket and nut should come to a complete stop while tool is energized. Move to next bolt in the local set. Apply torque until the tool stalls. Repeat as needed. When the last fastener in the set is tightened, start again at first fastener in the local set and apply torque to each nut a second time to verify that all nuts have stopped turning when torque is applied.

The application of torque from the nut side is always preferred. The nuts have a lubricated surface that assures better transference of torque into joint clamp. As a last resort, if tooling clearance conditions exist, adjust torque to 2500 ft. lbs. and tighten from bolt head side using same sequence as above.

An alternative and preferred solution to torquing from the bolt head is to use a 360 Thread Head (Stud). The Thread Head (Stud) assures that a nut will always be accessible to the torque tool. 360 Thread Heads are also helpful in the narrow crotch of low angle diamonds or when bolt ends are almost touching. Refer to Huck part number 360THA-DT44X#### and 360THAP-DT44X## for further details.

Note: Huck 360 Nuts are pre-coated with high performance Huck Guard coating and require no additional lubrication.

Recommended Maintenance

One maintenance retightening is recommended on bolts installed in diamonds and frogs that are new from factory. This re-tightening should be scheduled between one and two months after the diamond or frog enters service.

This maintenance retightening is meant to help compensate for the surface wear (fretting) that commonly occurs between the mating surfaces of the castings, track, and misc. components of frogs and diamonds that are newly in service.

A maintenance retightening is not as likely to be needed in aftermarket repairs where the frogs and diamonds have already accumulated service life sufficient to wear in the components.

Selection of Correct Bolt Length and Assembly Part Number

To determine the correct bolt length to use, measure the thickness of all track components that are to be fastened, Add 2.2" to that number. Round that result up to the next whole number. Insert that number in the ##### place holder in the part number format below.

The part number is formatted as follows: **360HA-DT44X#####**

For example:

A 9" bolt will be 360HA-DT44X900. A 16" bolt will be 360HA-DT44X1600.

Notes:

The number, 2.2" is equal to the height of the 1-3/8" Huck 360 nut plus two of the bolt thread pitches.

This part has two trailing zeros at the end of the number in anticipation of a future need for fractional increments.

Each assembly will include one hex bolt (360H-DT44X#####), one flat washer (SW-R44X), and one square nut (360NS-R44).

Ordering Information

Direct all order inquiries to:

Howmet Fastening Systems and
Rings Industrial Fastener Division
8001 Imperial Drive
Waco, Texas 76712

Toll Free: 1-800-388-4825 (Choose Option 6 for Customer Service)

When ordering Huck 360 track bolts please make note of how you would like your parts packaged during shipping. Would you like them palletized in bulk or would you like them packaged in small kits of 2 to 6 pieces for easy handling and unloading?

Stock Number	Short Description	Long Description
	360HA-DT44X900	1-3/8" X 9" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X1000	1-3/8" X 10" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X1100	1-3/8" X 11" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X1200	1-3/8" X 12" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X1300	1-3/8" X 13" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X1400	1-3/8" X 14" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X1500	1-3/8" X 15" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X1600	1-3/8" X 16" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X1700	1-3/8" X 17" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X1800	1-3/8" X 18" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X1900	1-3/8" X 19" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X2000	1-3/8" X 20" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X2100	1-3/8" X 21" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X2200	1-3/8" X 22" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds

TRACK STANDARDS
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Effective: Dec. 2015

	360HA-DT44X2300	1-3/8" X 23" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X2400	1-3/8" X 24" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X2500	1-3/8" X 25" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X2600	1-3/8" X 26" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X2700	1-3/8" X 27" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X2800	1-3/8" X 28" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X2900	1-3/8" X 29" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X3000	1-3/8" X 30" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X3100	1-3/8" X 31" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds
	360HA-DT44X3200	1-3/8" X 32" Huck 360 Grade 8 Track Bolt Nut and Washer Assembly for use in frogs turnouts interlockers and diamonds