Ideally, the Safelok clip is fully driven when the base of the clip contacts the shoulder casting as shown in the sketch at (A). As a minimum, the ends of the clip prongs must be driven at least 2 mm (0.08") past the face of the cast shoulder. This ensures that the prongs will lock in place on the rail side of the shoulder casting. The spacing can be readily checked with a 2 mm thick piece of material.
INSTRUCTIONS for MANUAL INSTALLATION of SAFELOK SPRING CLIPS

STEP 1 – Center rail in rail seat using a P/N 36220 Rail Manipulator (details in Section 6) and place both insulators.

1.) When rail is centered in rail seat place insulators into position before driving clips.

2.) For large rail misalignment place insulators and drive clip into side with gap; then use manipulator to slide rail before fitting insulator into tight side.
INSTRUCTIONS for **MANUAL INSTALLATION** of SAFELOK SPRING CLIPS

STEP 2 – *Place and pull on both Safelok Spring Clips using a P/N 36749 Pull-On Tool (details in Section 6).*

1.) **PLACE CLIP BY HAND INTO DRIVING POSITION.**

2.) **PLACE PULL ON TOOL CRADLE OVER RAIL HEAD WITH PIN EXTENDING THROUGH CENTER OF CLIP.**

3.) **PLACE HANDS BELOW COLLAR ON HANDLE AND PULL DOWNWARD UNTIL CLIP ENGAGES INSULATOR.**

4.) **STOP WHEN CLIP TOES PASS FRONT FACE OF SHOULDER, AS SHOWN.**
INSTRUCTIONS for **MANUAL INSTALLATION** of SAFELOK SPRING CLIPS

STEP 2 (ALTERNATE) – Place and drive on both Safe Lok Spring Clips using a sledge hammer.

1. **PLACE CLIP INTO DRIVING POSITION.**

2. **LIFT SLEEPER AGAINST RAIL AND DRIVE CLIP INTO POSITION BY A 12 lb HAMMER STARTING WITH A LIGHT TAP FOLLOWED BY A SOLID, SHARP HORIZONTAL BLOW. STOP WHEN CLIP TOES PASS LOCKING FACE.**

**ALWAYS WEAR SAFETY GLASSES**
INSTRUCTIONS for **MECHANIZED INSTALLATION** of SAFELOK SPRING CLIPS

**STEP 1** – Center rail in rail seat and place both insulators, as shown on page S1.1.3b.

**STEP 2** – Ahead of the clipping machine and on each rail seat, place both clips by hand into driving position as shown above.

**STEP 3** – Lift the tie up against the rail base and drive the clips into final position with the clipper machine. Stop when clip toes pass by a minimum of 2 mm, front face of shoulder as shown in sketch at above left. Customer's representative must check the adjustment of clipper paddles daily to avoid over-driving the clips. Over-driving will prematurely and permanently yield the clips (sketch at above right) and must be avoided. By watching the clipping operation carefully, over-driving can be seen as the clip body springs back slightly as the clipper paddles are backed away. If noticed, the paddles must be readjusted immediately or toe load may be adversely affected.
INSTRUCTIONS for **NORMAL MANUAL REMOVAL** of SAFELOK SPRING CLIPS

STEP 1 -- **Remove both SafeLock Spring Clips using a P/N 38478 Universal Removal Tool (details in Section 6) as shown.**

1.) **OPEN ARMS AND DROP OVER CLIP.**

2.) **CLOSE ARMS**

3.) **PULL HANDLE DOWN**