

798L Loading Arm Lockdown Installation and Operations

Updated: 03/14/2025

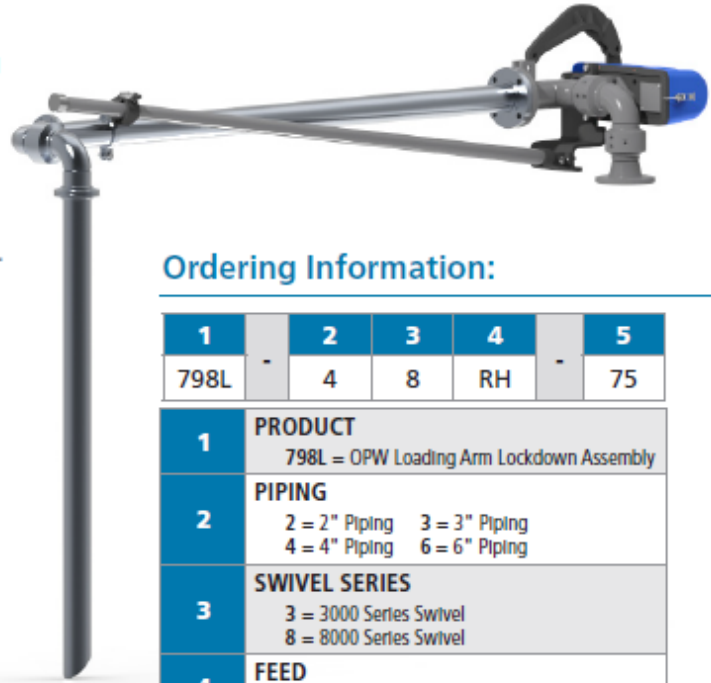
Help Improve Safety During Loading

The Loading Arm Lockdown is designed to secure the loading arm in the down position during loading. Loading safety is improved by preventing the arm from lifting due to filling forces during loading. To engage the loading arm lockdown, locate the loading arm in the desired position and hand-tighten the lockdown handle to secure the arm.

Features and Benefits:

- Designed to be used on 2", 3", 4" and 6" loading arms
- Simple twist-to-tighten locking mechanism—No preset lock positions
- Wide range of loading arm operation angles from +20° to -20°
- For use on loading arms with a 790 Torsion Spring
- Existing loading arms can be retrofitted with the new lockdown*

* Consult the factory for retrofit options



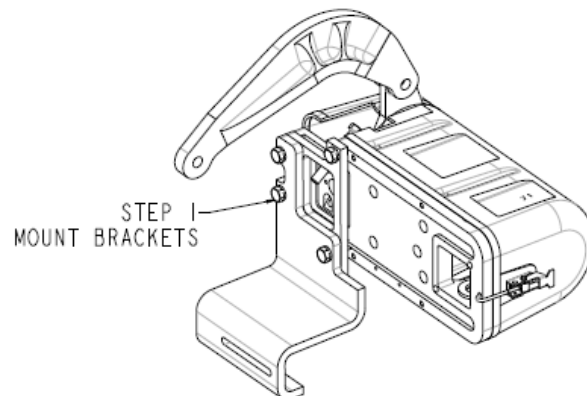
Ordering Information:

1	-	2	3	4	-	5
798L		4	8	RH		75
1	PRODUCT 798L = OPW Loading Arm Lockdown Assembly					
2	PIPING 2 = 2" Piping 3 = 3" Piping 4 = 4" Piping 6 = 6" Piping					
3	SWIVEL SERIES 3 = 3000 Series Swivel 8 = 8000 Series Swivel					
4	FEED RH = Right-Hand LH = Left-Hand					
5	FEED 51 = 48" - 54" Primary Arm Length 57 = 54" - 60" Primary Arm Length 63 = 60" - 66" Primary Arm Length 69 = 66" - 72" Primary Arm Length 75 = 72" - 78" Primary Arm Length 81 = 78" - 84" Primary Arm Length 87 = 84" - 90" Primary Arm Length 93 = 90" - 96" Primary Arm Length 99 = 96" - 102" Primary Arm Length 105 = 102" - 108" Primary Arm Length					

INSTALLING YOUR LOCKDOWN DEVICE

Step 1: Install Mounting Brackets

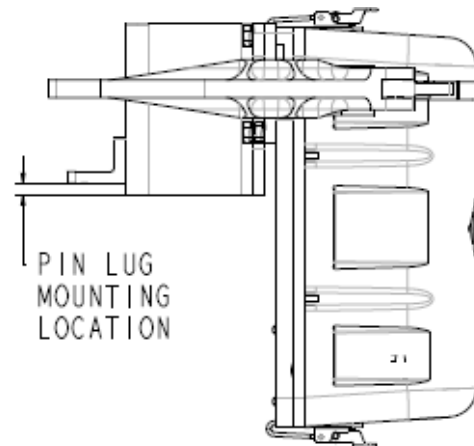
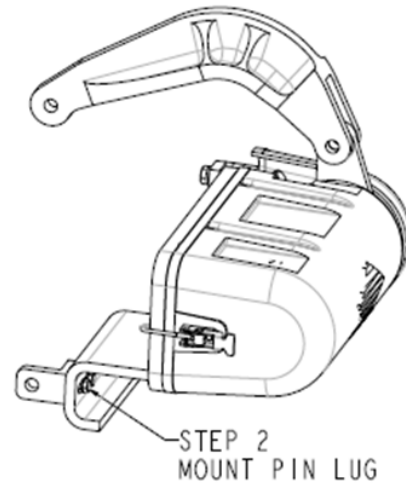
Mount backing plate behind formed mounting bracket to 790 spring baseplate using (4) 1/2-13 Hex Bolts and Lock Washers. NOTE: 2", 3" & 4" Lockdowns use (3) long bolts and (1) shorter bolt. Torque bolts to 75 foot-pounds.



Step 2: Install Pin Lug to Mounting Brackets

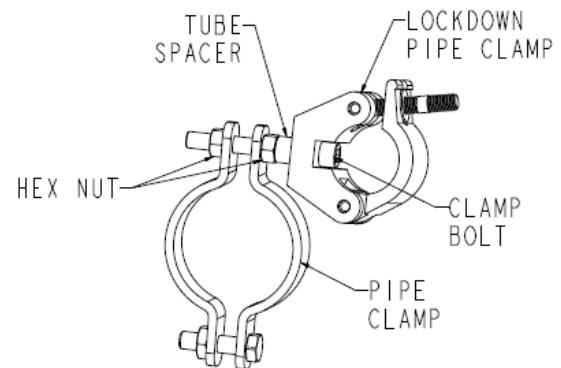
Mount pin lug to formed mounting bracket using (2) 3/8-16 Hex Bolts and Lock Washers. Torque bolts to 25 foot-pounds.

Refer to the 798L Assembly Drawing for proper pin lug location.



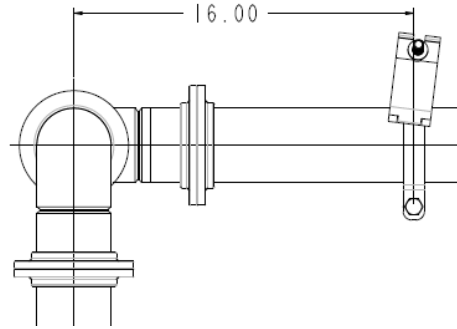
Step 3: Install Lockdown Clamp to Pipe Clamp

Remove existing hardware from Lockdown Pipe Clamp. Remove existing hardware from top of Pipe Clamp. Install Clamp Bolt through Lockdown Pipe Clamp. Install Tube Spacer and Hex Nut behind Lockdown Pipe Clamp. (For 6" Lockdown, install (2) reducer bushings into Pipe Clamp – Not Pictured). Install Clamp Bolt through top Pipe Clamp hole. Install second Hex Nut.



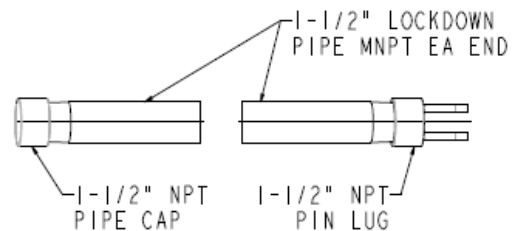
Step 4: Install Pipe Clamp Assembly to Loading Arm

Locate Lockdown Pipe Clamp Assembly 16.00" from the Drop Swivel (Center to Center). Tighten Pipe Clamp Bolts/Nuts.



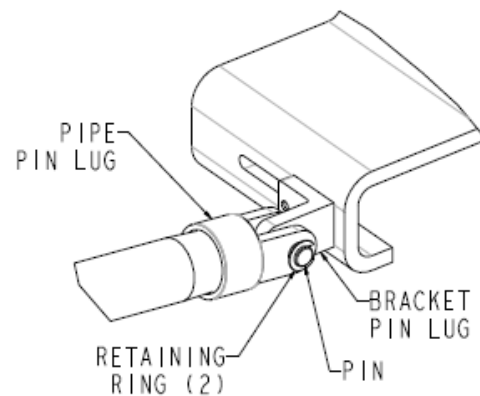
Step 5: Assemble Pipe Pin Lug and Pipe Cap to Lockdown Pipe

Install and tighten the Pin Lug and Pipe Cap to each end of the Lockdown Pipe.



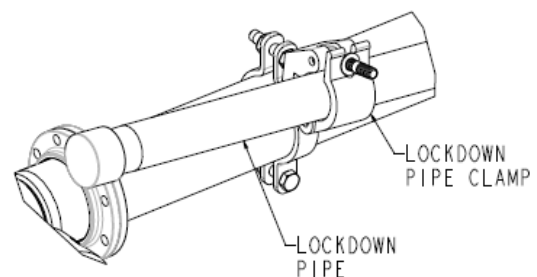
Step 6: Assemble Lockdown Pipe to Bracket Pin Lug

Install Lockdown pipe Pin Lug to the Bracket Pin Lug using Pin and (2) Retaining Rings.



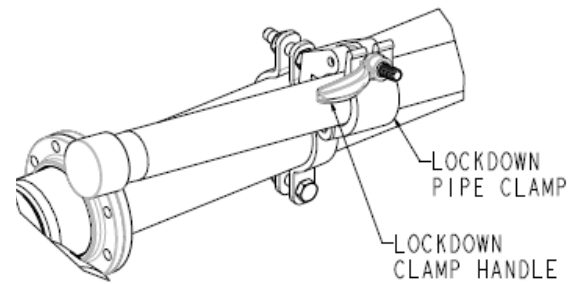
Step 7: Install Lockdown Pipe into Lockdown Pipe Clamp

Install the free end of the Lockdown Pipe into the Lockdown Pipe Clamp.



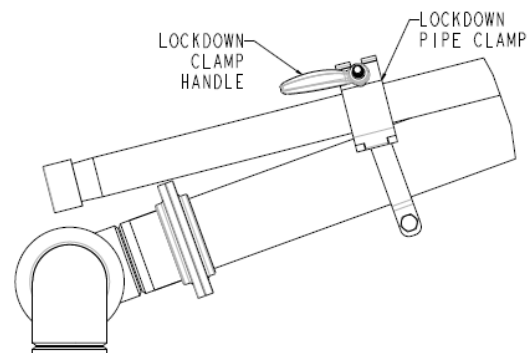
Step 8: Install Lockdown Clamp Handle onto Lockdown Pipe Clamp

Thread the Lockdown Clamp Handle onto the Lockdown Pipe Clamp.



Step 9: Inspect the Loading Arm and Lockdown for proper operation

To Operate the Lockdown, lower the loading arm to the desired loading position. To lock the loading arm in position, tighten the Lockdown Pipe Clamp by turning the Lockdown Clamp Handle clockwise. After loading is completed, loosen the Pipe Clamp by turning the Pipe Clamp Handle counterclockwise. The loading arm can now be raised/moved to the parked position.



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WARNING

Failure to follow these warnings could result in serious personal injury, property damage or product failure.

1) While installing and using the Loading Arm, always wear adequate personal protection, including hard hats, gloves, and steel-toed work boots. Failure to wear adequate personal protection may cause serious personal injury and death.

2) Always follow the procedures prescribed in this document. Failing to follow the procedures prescribed may damage the Loading Arm and cause serious personal injury and death. Consult Loading Arm Installation, Maintenance & Safety Manual for more details.