



# OPERATION & SERVICE MANUAL



**Model: A003819D**  
**Boeing 737 Towbar**

11/2016 – Rev. 03

**For Spare Parts, Operations & Service Manuals or Service Needs**  
**Scan the QR code or visit [Tronair.com/aftermarket](http://Tronair.com/aftermarket)**



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REVISION	DATE	TEXT AFFECTED
01	12/2014	Original release
02	07/2016	Modified 4.2 Attaching to Aircraft, 5.2 Retainer Bolt Tightening and Parts Lists
03	11/2016	Modified Parts Lists
04	11/2022	Major revision

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Tronair towbars/heads must only be used with matching Tronair heads/towbars, and Tronair shear pins.

This product can not be modified without the written approval of Tronair, Inc. Any modifications done without written approval voids all warranties and releases Tronair, Inc., its suppliers, distributors, employees, or financial institutions from any liability from consequences that may occur. Only Tronair OEM replacement parts shall be used.

## **1.0 PRODUCT INFORMATION**

### **1.1 DESCRIPTION**

This towbar is designed for towing B737 100-900 aircraft. The following operational instructions are only intended to familiarize the operator with the basic functions of the towbar. They are not intended to teach actual pushback procedures or techniques.

### **1.2 MODEL & SERIAL NUMBER**

Reference nameplate on unit

### **1.3 MANUFACTURER**

**TRONAIR, Inc.**  
1 Swanton Cargo Pkwy East  
Swanton, Ohio 43558 USA

Telephone: (419) 866-6301 or 800-426-6301  
Fax: (419) 867-0634  
E-mail: [sales@tronair.com](mailto:sales@tronair.com)  
Website: [www.tronair.com](http://www.tronair.com)

## **2.0 SAFETY INFORMATION**

### **2.1 USAGE AND SAFETY INFORMATION**

To insure safe operations please read the following statements and understand their meaning. Also refer to your equipment manufacturer's manual for other important safety information. This manual contains safety precautions which are explained below. Please read carefully.



**WARNING!** — Warning is used to indicate the presence of a hazard that **can cause severe personal injury, death, or substantial property damage** if the warning notice is ignored.

**CAUTION!** — Caution is used to indicate the presence of a hazard that **will or can cause minor personal injury or property damage** if the caution notice is ignored.

## **3.0 TRAINING**

### **3.1 TRAINING REQUIREMENTS**

The employer of the operator is responsible for providing a training program sufficient for the safe operation of the towbar.

### **3.2 OPERATOR TRAINING**

The operator training should provide the required training for safe operation of the towbar.

**NOTE: Maintenance and Trouble Shooting are to be performed by a skilled and trained technician.**

## 4.0 OPERATION

### 4.1 PREPARATION FOR USE

The towbar has been lubricated and adjusted at the factory and no additional preparation is required.

A general inspection should be made to determine if any damage was sustained in transit. If any damage was sustained the transportation company should be notified immediately.

### 4.2 AIRCRAFT ATTACHMENT

It is recommended that you attach the towbar to the aircraft first, and then connect it to the tug to avoid potential aircraft damage.

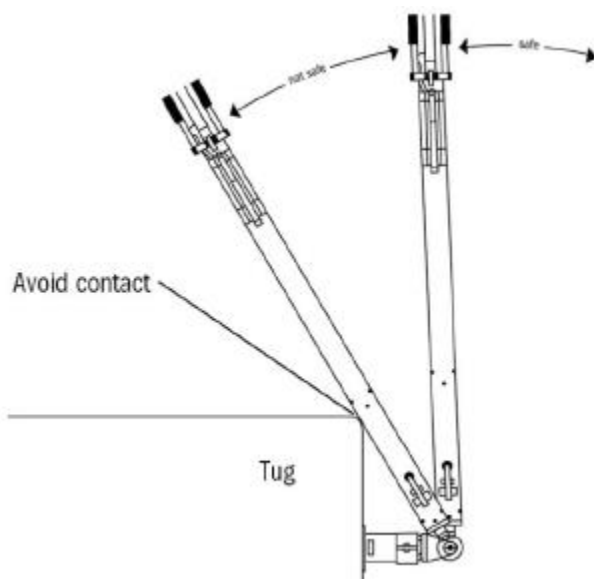
### 4.3 TOWING

Damage to the towbar or aircraft can result from pushing an aircraft at too sharp of an angle between the tug and the aircraft. Contact between the tug and towbar tube must be avoided.



#### WARNING!

**DO NOT EXCEED 90° angle between the tug and towbar.**



#### WARNING!

**A damaged or bent towbar should not be used, the towbar should be repaired or replaced. The tube may not be bowed more than 1/2 in (13 mm) over its length or have any damage creating a dent more than 1/2 in (13 mm) deep. BENT TOWBARS CAN NOT BE REPAIRED AND MUST BE REPLACED.**

### 4.4 TOWING SPEED

A maximum towing speed of 10 mph (16 kph) is recommended.



#### CAUTION!

**Exceeding the maximum towing speed may result in damage to the aircraft, tug, or towbar.**

### 4.5 BOLT TORQUE

Torque Values of Grade 5 Fine Thread (SAE) Fasteners  
(all torque specified in ft-lbs)

BOLT DIAMETER	1/4-28	5/16-24	3/8-24	7/16-20	1/2-20	5/8-18	3/4-16	7/8-14	1-12
INSTALL TORQUE	9	20	35	55	90	90	90	90	90

**Do Not Follow** the above torque value chart for **Shear Bolt** and/or **Retention Bolts**.

**Replacing Shear Bolt / Retention Bolt Instructions:** tighten bolts only enough to remove slack or until nut reaches the end of the threads, and then loosen one half turn. Bolts should turn freely with hand wrench.

## 5.0 MAINTENANCE

### 5.1 DAILY INSPECTION

- Visually check towbar for physical damage. Repair or replace parts if necessary.
- Check head for proper operation, damaged parts, binding, etc. Readjust or replace as necessary.

### 5.2 BI-YEARLY INSPECTION

- Check shear bolts by turning heads with a hand wrench. Any binding indicates a partial sheared bolt, replace if necessary.
- Grease the axle lift pivots with the provided grease zerks.
  - Use Lithium EP2 or equivalent
- Check hydraulic hand pump for proper operation and adequate oil level
  - Add ATF Fluid if necessary
  - For extreme cold 5606 oil is acceptable
- Check tire pressure. Pressure should be 24 psi
- Check lunette ring for excessive wear. Measure ring at the thinnest point, ring cross section should be no less than 1.25 inches. Replace if necessary.
- If so equipped, check lunette and head retention bolt cushions for cracking, replace if necessary.

### 5.3 YEARLY INSPECTION

- The wheels should be removed and the hub bearings repacked with grease.
  - Use Lithium EP2 or equivalent

### 5.4 AS REQUIRED

When replacing shear bolts and/or retention bolt, tighten bolts only enough to remove slack and then loosen one half turn. Bolts should turn freely with hand wrench.



#### CAUTION!

**Over tightening of shear bolts and/or retention bolt will cause bolts to shear at a higher load than desired.**

### 5.5 TOWBAR DAMAGE AND REPAIR

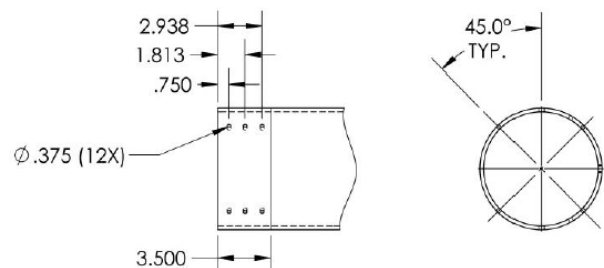
**Mounting Holes:** If the lunette or head mounting holes are damaged they can be repaired by shortening the tube and re-drill the holes. This may be done once per each end. Approximately 3.5" will need to be cut off to allow new holes to be drilled. Use the mating part as a guide in marking the (12)  $\varnothing$ .375 holes. Torque hardware to 35 ft-lbs.

**Bowing:** The tube may not be bowed more than 1/2" over its length.

**Dents:** Any dent in the aluminum tube may not be any deeper than 1/2" deep.

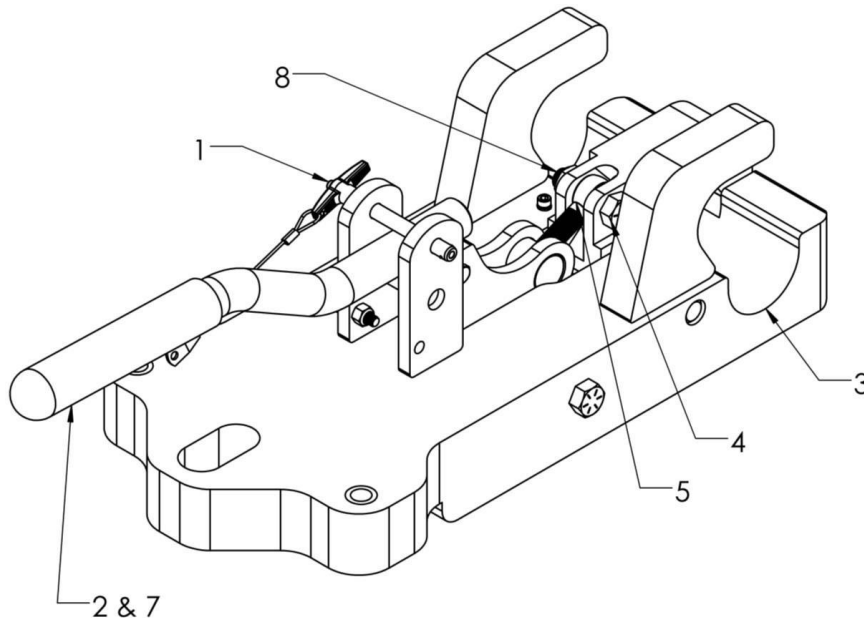
**Gouges:** Any gouge in the aluminum tube may not be any deeper than 1/8" deep x 1" long.

**Any tube with damage that does not fit the above must be replaced.**



## 5.6 JAW ADJUSTMENT PROCEDURE

1. Remove "T" pin from upright ears.
2. Pull handle upward to fully open jaw.
3. Place a 2-1/4" dia. Pin in bottom jaws.
4. Remove nylok jam nut and bolt holding eye-bolt to upper jaw.
5. Turn eyebolt counter-clockwise 1/2 turn (increasing length).
6. Re-assemble eyebolt to upper jaw and replace bolt without nut.
7. Actuate handle downward - if a definite "over-centering" is not felt, repeat steps 4, 5 & 6. Pin should still be free to turn in jaws.
8. When proper tension is achieved, re-install nylok jam nut. **DO NOT OVER-TIGHTEN!** Ensure that nylok is engaged in threads but bolt **MUST** be able to be turned by hand once nut is installed.



## 5.7 PLACARDS

**SHEAR BOLT REPLACEMENT**  
WHEN REPLACING SHEAR BOLT DO NOT  
TORQUE THE NUTS DOWN TIGHT. THE BOLTS  
SHOULD ROTATE WITH VERY LITTLE EFFORT OR THE NUT  
IS TOO TIGHT. THIS INCLUDES THE RETENTION BOLT.

15O5751

**CAUTION**  
BALL LOCK PIN MUST BE  
ENGAGED OVER HANDLE  
WHEN TOWING AIRCRAFT

15O6476

**SHEAR BOLT**  
USE P/N #15O5387

15L19811

**SHEAR BOLT**  
USE P/N #15O5388

15L22232

**B737 100-900**

15O6006

## 6.0 PROVISION OF SPARES

### 6.1 SOURCE OF SPARE PARTS

Spare parts may be obtained from the manufacturer:

**TRONAIR**, Inc.

1 Air Cargo Pkwy East

Swanton, Ohio 43558 USA

Telephone: (419) 866-6301 or 800-426-6301

Fax: (419) 867-0634

E-mail: sales@tronair.com

Website: www.tronair.com

For Spare Parts, Operations & Service Manuals or Service Needs:

Scan the QR code or visit Tronair.com/aftermarket



### 6.2 RECOMMENDED SPARE PARTS LISTS

Reference the following page(s) for Replacement Parts and Kits available.

Recommended Spares to be kept on hand:

K-5581.....Kit, Shear Bolt Replacement

15F3288.....Tie & Hub Assembly

15O6017 .....Kit, Cylinder Seal

15O6235 .....Kit, Handle Pin

## 7.0 IN SERVICE SUPPORT

Contact Tronair, Inc. for technical services and information. See Section 1.3 – Manufacturer.

## 8.0 GAURANTEES/LIMITATION OF LIABILITY

Tronair products are warranted to be free of manufacturing or material defects for a period of one year after shipment to the original customer. This is solely limited to the repair or replacement of defective components. This warranty does not cover the following items:

- a) Parts required for normal maintenance
- b) Parts covered by a component manufacturers warranty
- c) Replacement parts have a 90-day warranty from date of shipment

If you have a problem that may require service, contact Tronair immediately. Do not attempt to repair or disassemble a product without first contacting Tronair, any action may affect warranty coverage. When you contact Tronair be prepared to provide the following information:

- a) Product Model Number
- b) Product Serial Number
- c) Description of the problem

If warranty coverage is approved, either replacement parts will be sent or the product will have to be returned to Tronair for repairs. If the product is to be returned, a Return Material Authorization (RMA) number will be issued for reference purposes on any shipping documents. Failure to obtain a RMA in advance of returning an item will result in a service fee. A decision on the extent of warranty coverage on returned products is reserved pending inspection at Tronair. Any shipments to Tronair must be shipped freight prepaid. Freight costs on shipments to customers will be paid by Tronair on any warranty claims only. Any unauthorized modification of the Tronair products or use of the Tronair products in violation of cautions and warnings in any manual (including updates) or safety bulletins published or delivered by Tronair will immediately void any warranty, express or implied.

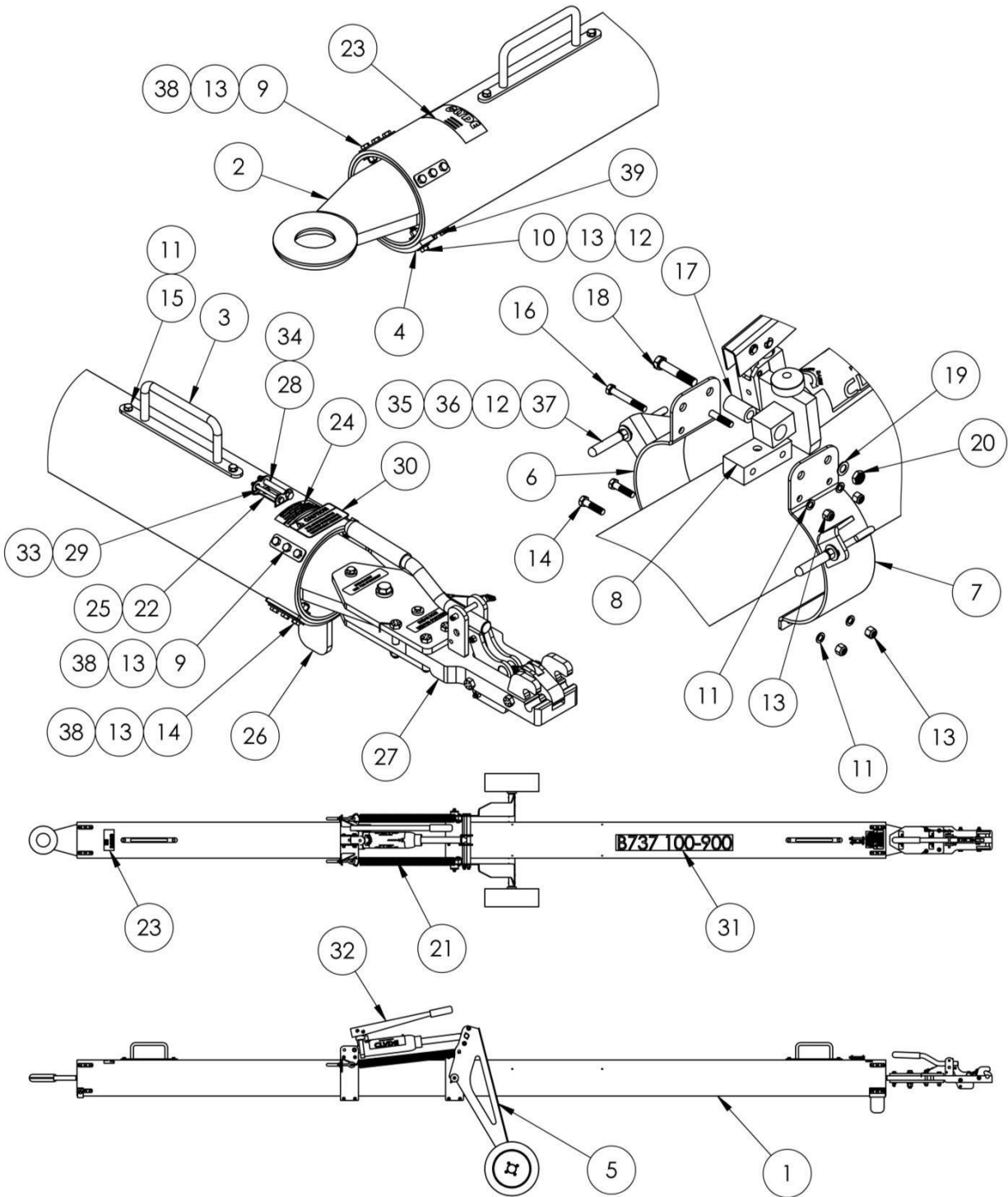
The obligations of Tronair expressly stated herein are in lieu of all other warranties or conditions expressed or implied. **Any unauthorized modification of the Tronair products or use of the Tronair products in violations of cautions and warnings in any manual (including updates) or safety bulletins published or delivered by Tronair will immediately void any warranty, express or implied and Tronair disclaims any and all liability for injury (WITHOUT LIMITATION and including DEATH), loss or damage arising from or relating to such misuse.**



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## Parts List

When ordering replacement parts/kits, please specify model, serial number and color of your unit.



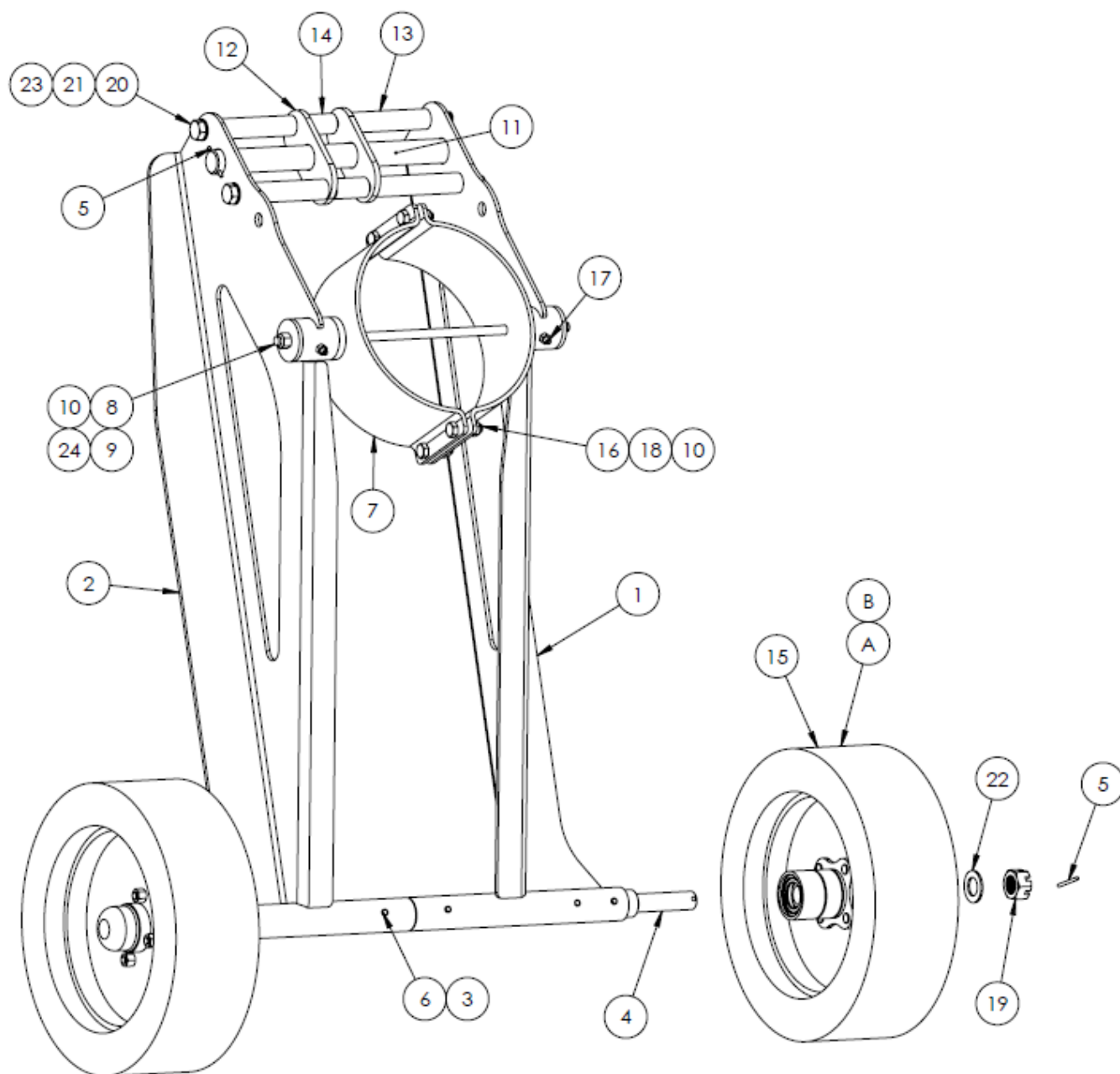
## Parts List

When ordering replacement parts/kits, please specify model, serial number and color of your unit.

Item	Part Number	Description	Qty
1	15L16835	TOWBAR TUBE	1
2	15W4565	LUNETTE WELD	1
3	15W5484	HANDLE WELD	2
4	15L19014	RUB PLATE	1
5	15F190	AXLE LIFT ASSEMBLY	1
6	15W186	SPRING BRKT & ATTACH ANGLE WELD R.H.	1
7	15W2495	SPRING BRKT & ATTACH ANGLE WELD L.H.	1
8	15W308	KEEPER BLOCK & PIN WELD	1
9	15O310	3/8-24 x 1-1/4" LG. C.S.	16
10	15O719	3/8-24 x 1-3/4" LG. C.S.	2
11	15O309	3/8" AN WASHER	8
12	15O246	3/8" WASHER	4
13	15O308	3/8-24 NYLOK NUT	28
14	15O337	3/8-24 x 1-1/2" LG. C.S.	8
15	15O307	3/8-24 x 1" LG. C.S.	4
16	15O306	3/8-24 x 2-3/4" LG. C.S.	2
17	15L506	CYLINDER END SLEEVE	1
18	15O300	1/2-20 x 2-3/4" LG. C.S.	1
19	15O302	1/2" AN WASHER	1
20	15O660	1/2-20 NYLOK JAM NUT	1
21	15L2726	EXTENSION SPRING	2
22	15L22990	SHEAR BOLT HOLDER, SMALL	1
23	15O4099	SERIAL NUMBER PLATE	1
24	15O5751	PLACARD, SHEAR BOLT REPLACEMENT	1
25	15O3323	1/4-20 x 3/4" LG. SELF TAPPING	2
26	15W5732	SKEG, TOWBAR	1
27	15F3496	COMPLETE HEAD ASSEMBLY	1
28	15O5387	SHEAR BOLT	1
29	15O5388	SHEAR BOLT	1
30	15O6476	PLACARD, CAUTION	1
31	15O6006	B737 100-900 PLACARD	1
32	15O6016	HYDRAULIC COMBO PUMP	1
33	15O1689	1/4-28 NYLOK JAM NUT	1
34	15O3400	3/8-24 NYLOK JAM NUT	1
35	15O5867	3/8-16 x 4-1/4 LG. EYE BOLT	2
36	15O588	3/8-16 UNC NYLOK NUT	2
37	15L26242	THREAD PROTECTOR	2
38	15L27012	3 HOLE WASHER	14
39	15L27013	2 HOLE WASHER	2
N/S	K-5581	KIT, SHEAR BOLT REPLACEMENT	

## Parts List

When ordering replacement parts/kits, please specify model, serial number and color of your unit.



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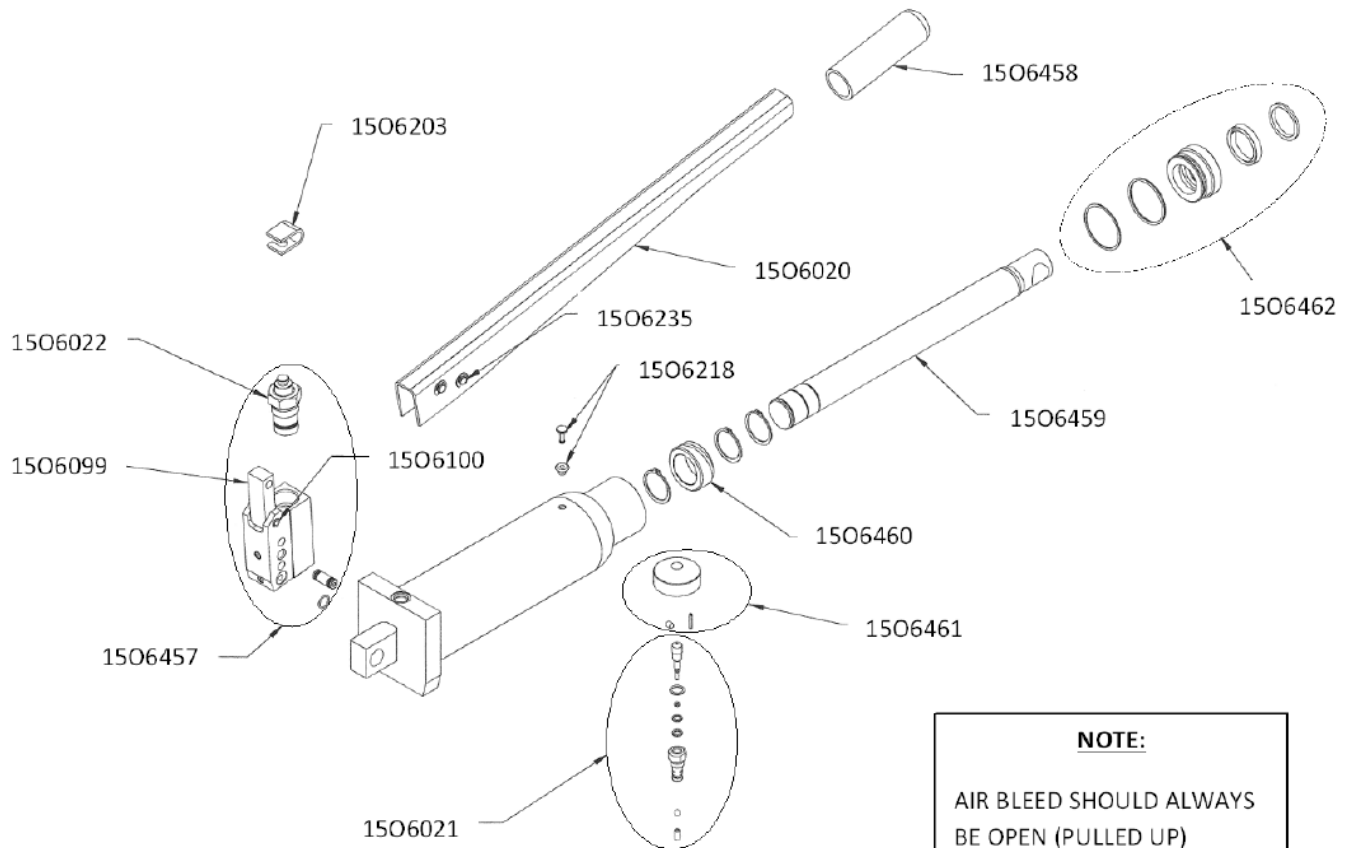
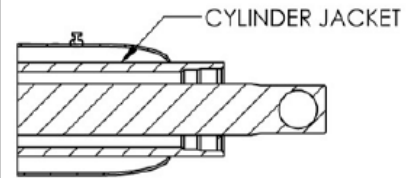
Item	Part Number	Description	Qty
	<b>15F190</b>	<b>4 AXLE LIFT ASSEMBLY</b> ; consists of:	
1	15W6615	LIFT AXLE WELDMENT RH	1
2	15W6614	LIFT AXLE WELDMENT LH	1
3	15L504	AXLE ATTACHMENT TUBE CONNECTOR	1
4	15L502	AXLE	2
5	15O269	1/8" x 1-1/2" LG. COTTER KEY	4
6	15O590	1/4 x 1-1/2" LG. ROLL PIN	6
7	15W181	AXLE PIVOT SPINDLE & BRACKET WELD.	2
8	15L498	AXLE PIVOT TIE-ROD	1
9	15L499	PIVOT SPINDLE WASHER	2
10	15O308	3/8-24 NYLOK NUT	6
11	15L491	CYLINDER ATTACHMENT ROD	1
12	15L482	SPACER FLAT	2
13	15L493	OUTER SPACER	4
14	15L494	INNER SPACER	2
15	15F3288	TIRE & HUB ASSEMBLY	2
16	15O337	3/8-24 x 1-1/2" LG. C.S.	4
17	15O5865	ZERK, GREASE	2
18	15O309	3/8" AN WASHER	4
19	15O3113	3/4-16 SLOTTED NUT	2
20	15O3711	1/2- 13 UNC x 12" LG. C.S.(WAS 15L492)	2
21	15O1718	1/2-13 UNC NYLOK NUT (WAS 15O660)	2
22	15O321	3/4" AN WASHER	2
23	15O302	1/2" AN WASHER	4
24	15O1289	OILITE BEARING	4

## Parts List – 1506016

When ordering replacement parts/kits, please specify model, serial number and color of your unit.

### FILL PROCEDURE:

- REMOVE THE BRASS VENT PLUG THEN THE RUBBER GROMMET.
- FILL TILL THE ATF FLUID JUST COVERS THE CYLINDER JACKET.
- DO NOT OVER FILL. OVER FILLING WILL
- CAUSE OIL TO LEAK OUT THE AIR BLEED.
- REPLACE THE RUBBER GROMMET
- THEN THE BRASS VENT PLUG.



### NOTE:

AIR BLEED SHOULD ALWAYS  
 BE OPEN (PULLED UP)  
**EXCEPT** DURING SHIPPING

1506017 SEAL KIT

### AIR BLEED PROCEDURE

1. Elevate the towing eye end of towbar until combo pump is pointing downward (handle end raised).
2. Extend cylinder fully by pumping handle.
3. Retract cylinder SLOWLY by opening release knob SLIGHTLY.
4. Repeat step 3 until no sign of air is noticeable.

## Parts List – 1506016

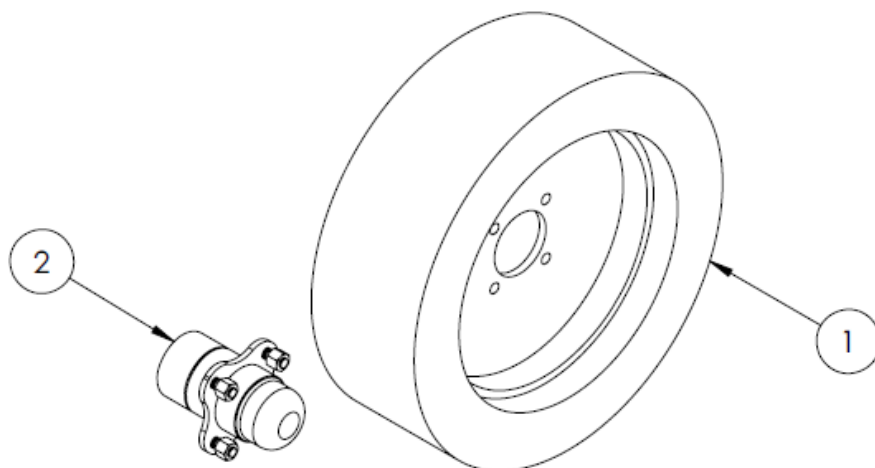
When ordering replacement parts/kits, please specify model, serial number and color of your unit.

Part Number	Description	Qty
<b>1506017</b>	<b>CYLINDER SEAL KIT</b> ; consists of:	
	SPRING	1
	O-RING	1
	O-RING	4
	B/U WASHER	4
	BALL	1
	O-RING	1
	O-RING	1
	B/U WASHER	1
	O-RING	1
	SCREEN	1
	ROD SEAL	1
	ROD WIPER	1
	O-RING	1
	B/U WASHER	1
	RETAINING RING	3
	WIPER	1
	SEAL, U-CUP	1
<b>1506020</b>	<b>REPLACEMENT HANDLE KIT</b> ; consists of:	
	HANDLE	1
	PIN	2
	RETAINING RIN	4
	GRIP	1
<b>1506021</b>	<b>RELEASE VALVE KIT</b> ; consists of:	
	SPRING	
	RELEASE VALVE BODY	
	O-RING	
	O-RING	
	B/U WASHER	
	BALL	
	O-RING	
	RELEASE VALVE SCREW	
<b>1506022</b>	<b>PUMPING STATION KIT</b> ; consists of:	
	B/U WASHER	1
	O-RING	1
	PISTON	1
	PISTON RETAINER	1
	WIPER	1
	SEAL, U-CUP	1
<b>1506218</b>	<b>VENT VALVE/FILL PULG KIT</b> ; consists of:	
	VENT PLUG	1
	VENT VALVE	1

Part Number	Description	Qty
<b>1506457</b>	<b>PUMP KIT</b> ; consists of:	
	PUMP BLOCK	1
	CHECK VALVE	3
	EXPANDER PLUG	2
	HANDLE LINK	1
	SPRING PIN	1
	PISTON RETAINER	1
	PISTON	1
	O-RING	1
	B/U WASHER	1
	WIPER	1
	SEAL, U-CUP	1
	PLUG SAE	1
	RELIEF VALVE TUBE	1
	RELIEF VALVE SEAT	1
	BALL	1
	RELIEF VALVE GUIDE	1
	WASHER	1
	COMPRESSION SPRING	1
	B/U WASHER	3
	O-RING	3
	BUSHING	1
<b>1506464</b>	<b>RELEASE KNOB KIT</b> ; consists of:	
	KNOB	1
	PIN	1
	SET SCREW	1
<b>1506462</b>	<b>RETAINER NUT KIT</b> ; consists of:	
	RETAINER NUT	1
	ROD SEAL	1
	ROD WIPER	1
	O-RING	1
	B/U WASHER	1
<b>1506235</b>	<b>HANDLE PIN KIT</b> ; consists of:	
	PIN	1
	RETAINING RING	2
1506099	HANDLE LINK	1
1506100	SLOTTED SPRING PIN	1
1506203	U-CLIP PISTON TAB	1
1506458	HANDLE GRIP	1
1506459	PISTON ROD	1
1506460	PISTON, CYLINDER BEARING	1
1506015	PLACARD	1

### Parts List

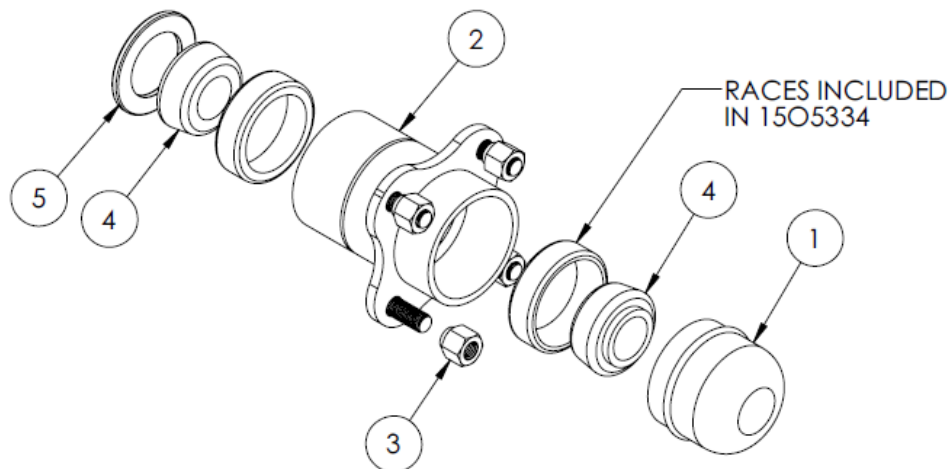
When ordering replacement parts/kits, please specify model, serial number and color of your unit.



Item	Part Number	Description	Qty
	<b>15F3288</b>	<b>TIRE &amp; HUB ASSEMBLY</b> ; consists of:	
1	15O6471	12 X 4 SOLID TIRE WITH 4 BOLT RIM	1
2	15O6475	HUB ASSEMBLY	1

### Parts List

When ordering replacement parts/kits, please specify model, serial number and color of your unit.



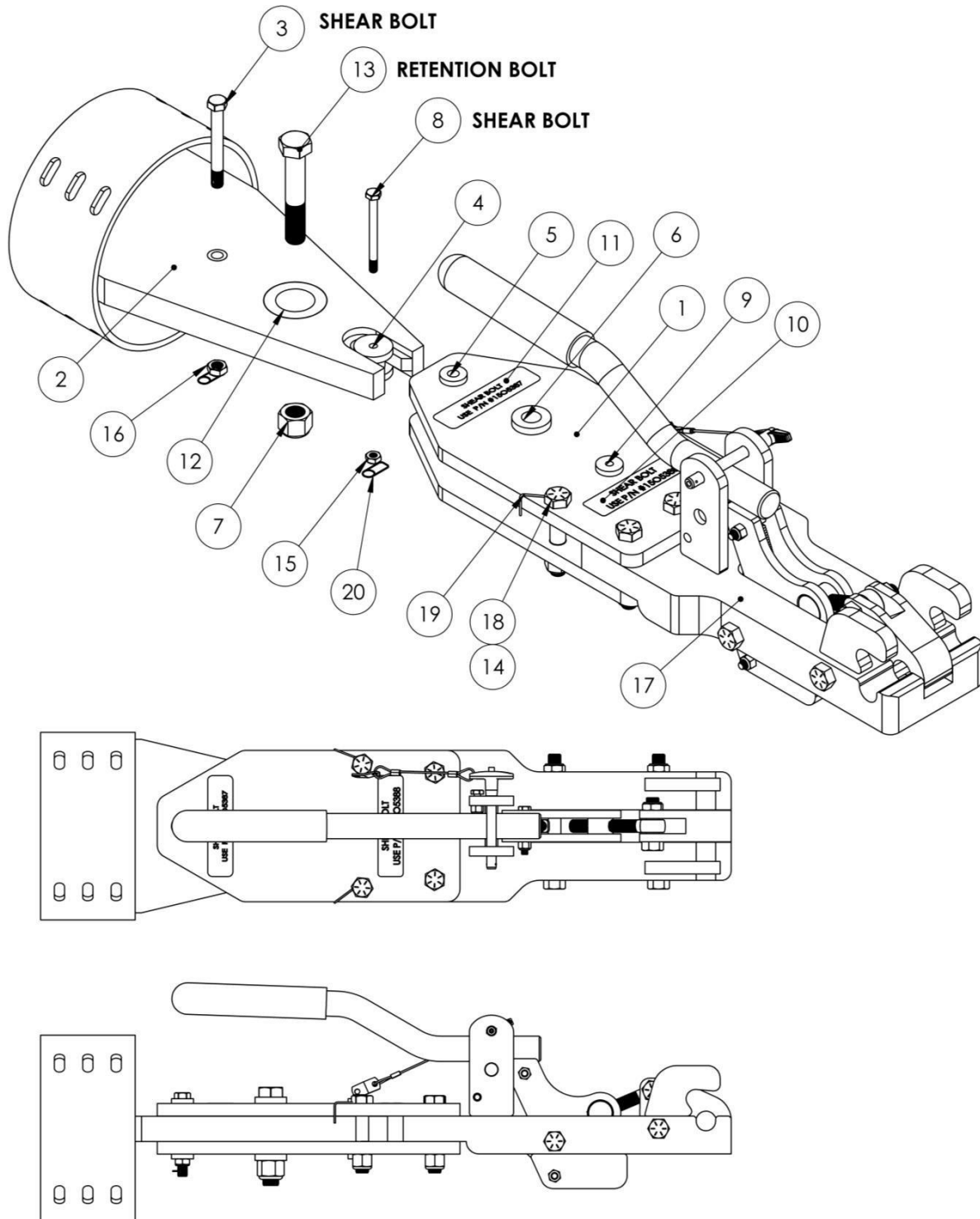
Item	Part Number	Description	Qty
	<b>15O6475</b>	<b>HUB ASSEMBLY</b> ; consists of:	
1	15O5335	DUST CAP	1
2	15O5334	HUB	1
3	15O5747	5/16-24 LUG NUT	4
4	15O5332	.750 BORE TAPERED BEARING	2
5	15O5333	GREASE SEAL	1



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## Parts List

When ordering replacement parts/kits, please specify model, serial number and color of your unit.



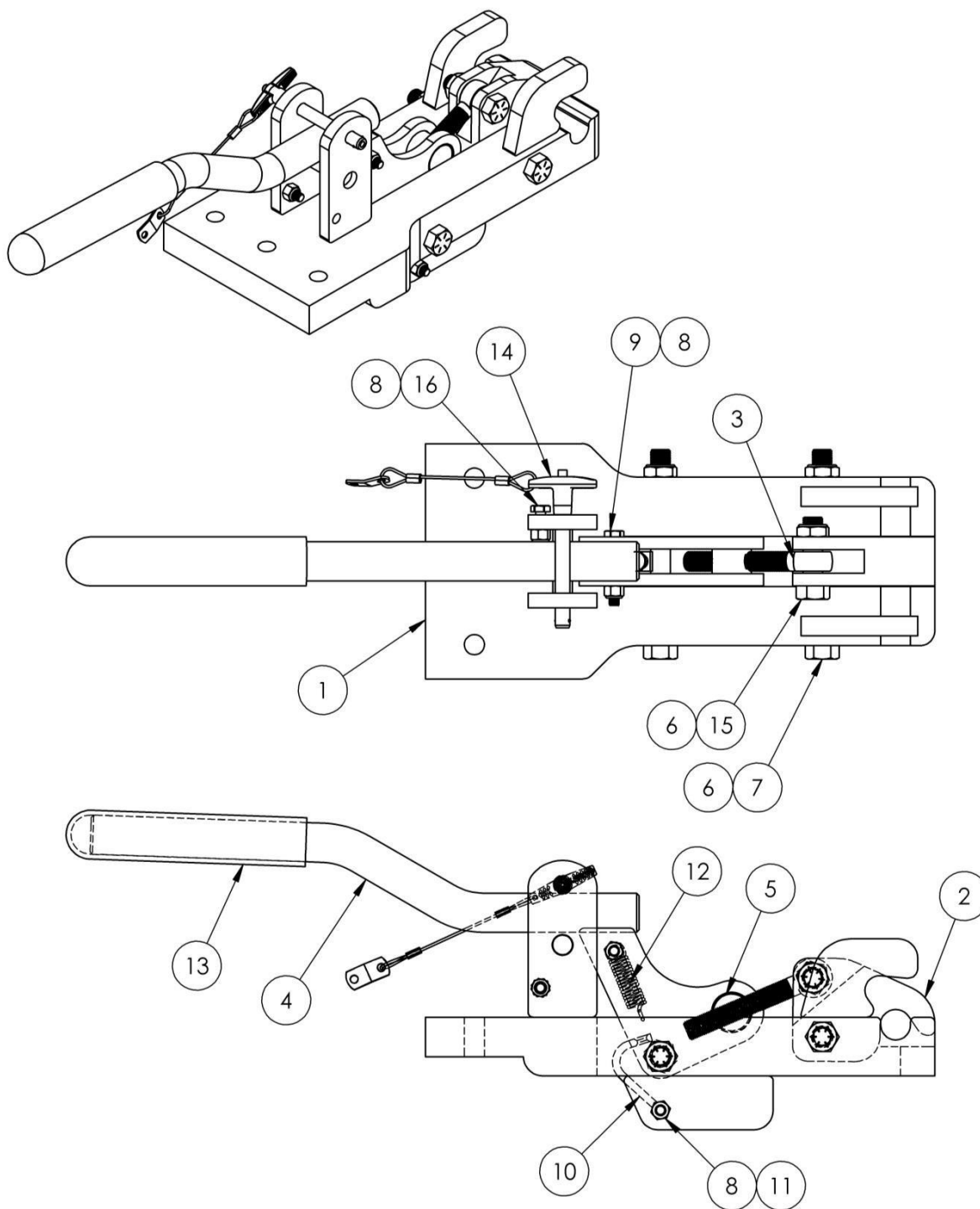
## Parts List

When ordering replacement parts/kits, please specify model, serial number and color of your unit.

Item	Part Number	Description	Qty
	<b>15F3496</b>	<b>HEAD &amp; MOUNT ASSEMBLY</b> ; consists of:	
1	15L20360	MOUNTING PLATE	2
2	15F2483	HEAD MOUNT BUSHING ASSEMBLY	1
3	15O5387	SHEAR BOLT	1
4	15L18568	BUSHING	1
5	15O5038	BUSHING	2
6	15O5419	BUSHING	2
7	15O462	5/8-18 NYLOK NUT	1
8	15O5388	SHEAR BOLT	1
9	15O5037	BUSHING	2
10	15L22232	PLACARD	1
11	15L19811	SHEAR BOLT PLACARD	1
12	15L22176	BUSHING (POLY)	1
13	15O1913	5/8-18 x 3-1/2" LG. C.S.	1
14	15O586	1/2-20 NYLOK NUT	5
15	15O1689	1/4-28 NYLOK JAM NUT	1
16	15O3400	3/8-24 NYLOK JAM NUT	1
17	15F3139	HEAD ASSEMBLY	1
18	15O6526	1/2-20 x 2-3/4" LG. C.S. GRADE 8	5
19	15O6041	NYLON LANYARD	2
20	15O6042	CLIP RETAINING PIN	2
N/S	K-5581	KIT, SHEAR BOLT REPLACEMENT	

## Parts List

When ordering replacement parts/kits, please specify model, serial number and color of your unit.



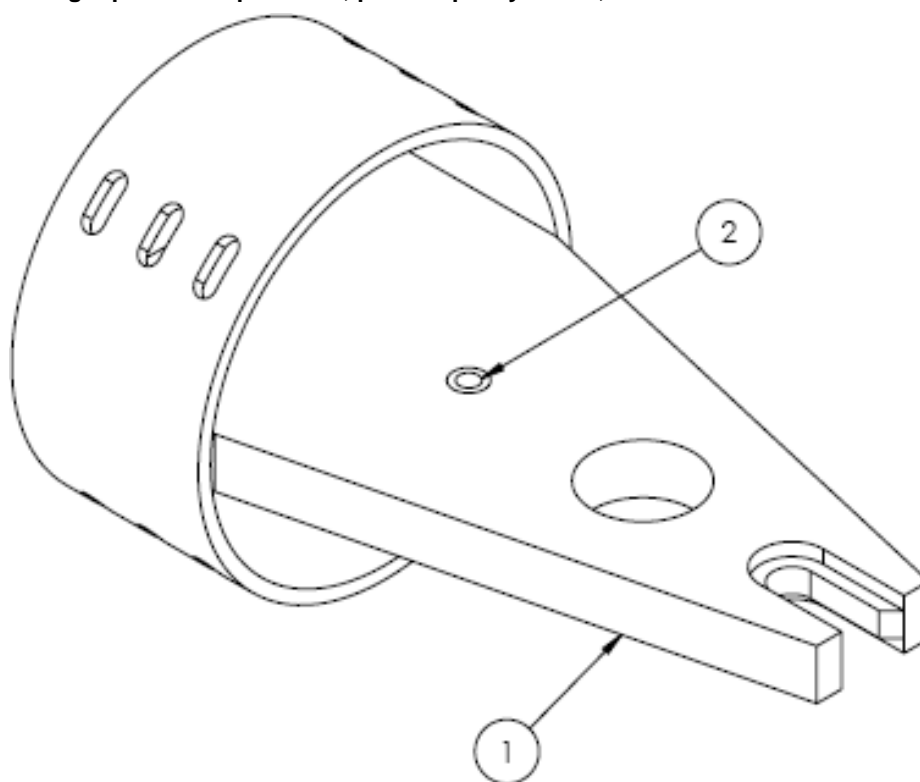
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Item	Part Number	Description	Qty
	<b>15F3139</b>	<b>HEAD ASSEMBLY</b> ; consists of:	
1	15W6294	HEAD WELDMENT	1
2	15L25524	CAM, 737 HEAD	1
3	15O6225	SOLID ROD END	1
4	15W6295	HANDLE WELDMENT	1
5	15L25531	PIVOT	1
6	15O660	1/2-20 NYLOK JAM NUT	3
7	15O6445	1/2-20 x 5" GR8 HHCS	2
8	15O298	1/4-28 NYLOK NUT	3
9	15O746	1/4-28 x 1-3/4" LG. C.S.	1
10	15W6297	SPRING PIVOT WELD	1
11	15O3604	1/4-28 x 3-1/4" LG. C.S.	1
12	15O6234	EXTENSION SPRING	1
13	15O6243	HAND GRIP	1
14	15O2976	BALL LOCK PIN	1
15	15L26253	1/2-20 x 1-3/4 GR 8 HHCS (MOD)	1
16	15O748	1/4-28 x 1 LG. C.S.	1

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Item	Part Number	Description	Qty
	<b>15F2438</b>	<b>HEAD MOUNT ASSEMBLY</b> ; consists of:	
1	15W5053	HEAD MOUNT WELD	1
2	15O5036	HEADLESS DRILL BUSHING	1