



1074 Kenran Industrial Dr.
St. Louis, MO 63137
Phone: 1-800-381-9968

HUMCO DECK FITTINGS

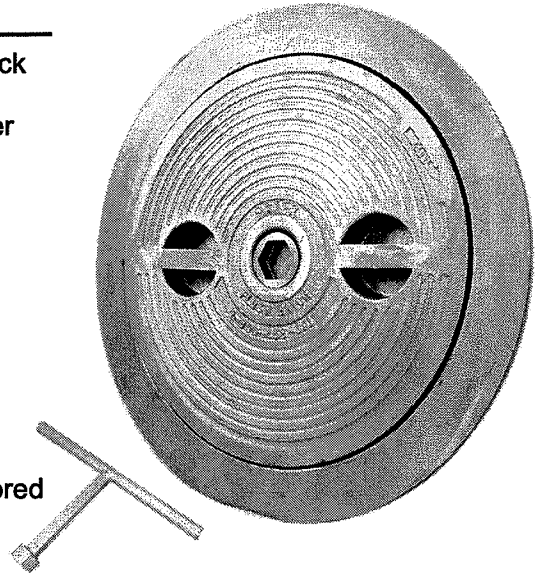
Baier Classic HEX-Bolt Strongback Hatches

BFHR Series Round - Lift Out

The popular "Classic" Baier Flush Hatch™ is the flush-mounted, quick release, lift-out hatch with grab handles as shown. It has long been standard equipment on fishboats, tugs, barges, workboats, and other marine vessels, as well as many U.S. Navy and U.S. and Canadian Coast Guard vessels.

FEATURES

- Cast Hatch Cover
- Cast Strongback
- Stainless Steel Hex Centerbolt and hardware
- Neoprene Cover Gasket and Washers (Buna-N optional)
- Cast / fabricated matching Deck Ring
- Every unit shipped with an underside escape turning bar for safety (turning wheel optional)
- Detachable Hex wrench used for quick operation, can be stored separately for security

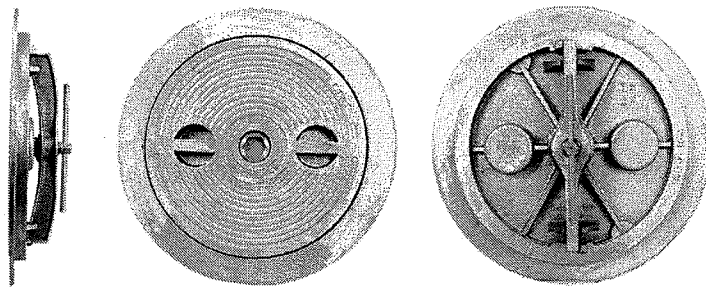


STRENGTH, SIMPLICITY and SECURITY

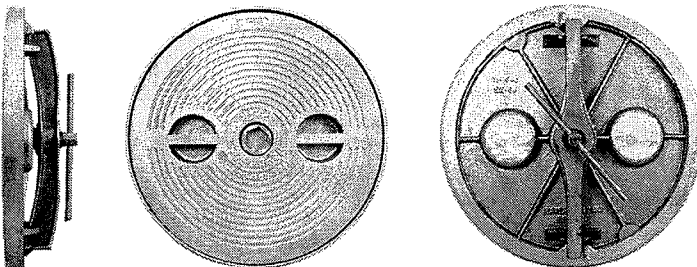
The ultimate in strength and simplicity, Baier's original patented strongback system has only two moving parts to secure the hatch cover to the deck. It is superior to other more complicated hatch closure systems in that it is simpler, stronger, more reliably watertight, infinitely adjustable from topside, and more easily serviced (parts are readily available and replaced in the field). Importantly, the recessed hex centerbolt and grab handles offer no snags for nets, lines or hardware.

MATERIALS

The majority of the Classic Model BFH hatch cover product line is available in both cast aluminum and cast steel. Steel Cover assemblies and deck rings are hot dip galvanized for superior corrosion resistance. No other flush hatch is available in cast steel (which is stronger, more durable, and more impact resistant when compared to iron hatches, especially in cold climates). The deck ring is available in galvanized mild steel (for welding into steel decks), or cast aluminum (for welding into aluminum decks or bolting to fiberglass or wood decks). Cast stainless steel hatches and fabricated stainless deck rings are available by special order.



BFHR16A/A with Cast Aluminum Deck Ring



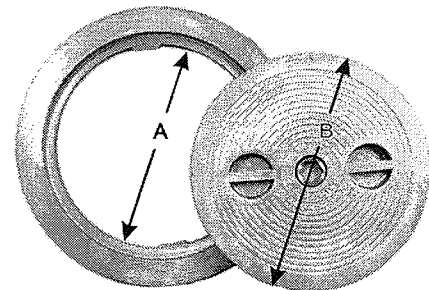
BFHR16A/S with Galvanized Steel Deck Ring

Hatch Model	Clear (A) Opening	Cover (B) Diameter	Technical Drawing
BFHR14	14" (356mm)	16" (406mm)	#286-1
BFHR16	16" (406mm)	18" (457mm)	#286-1
BFHR18	18" (457mm)	20" (508mm)	#286-1
BFHR20	20" (508mm)	22" (559mm)	#286-1
BFHR24	24" (610mm)	26" (660mm)	#630

When ordering, please specify:

Cover Material:
cast aluminum or
cast steel

Ring Material:
cast aluminum or
galvanized steel



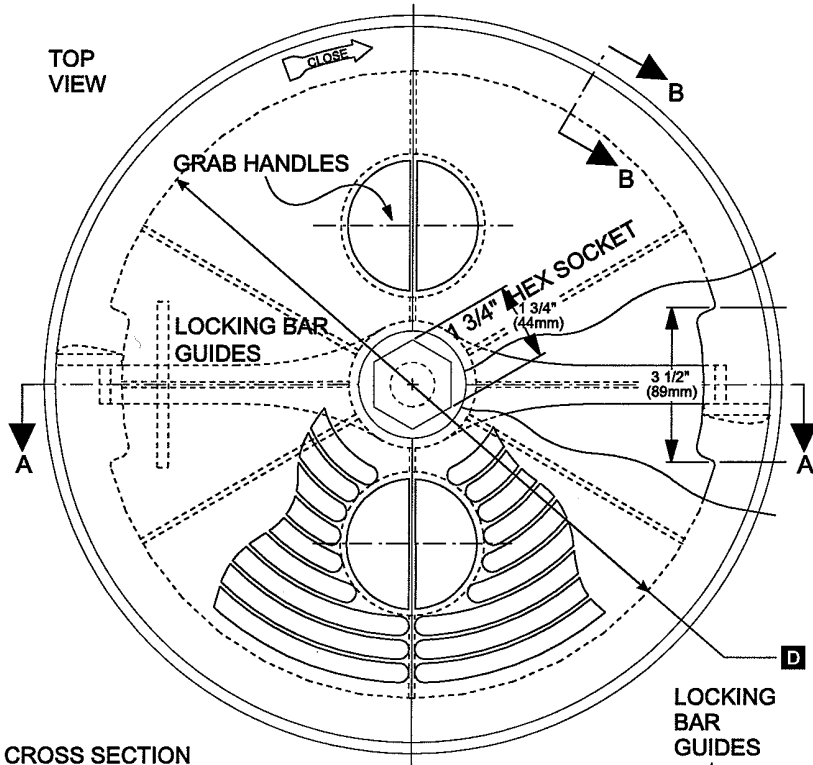
Hatch Covers Available Separately



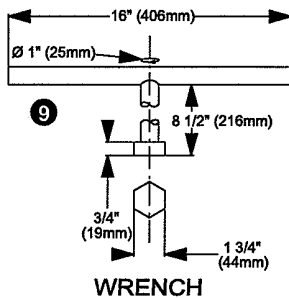
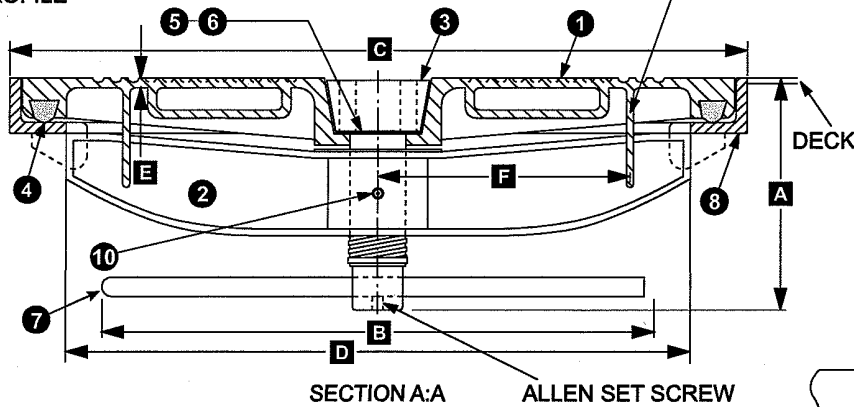
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HUMCO DECK FITTINGS

Baier Classic HEX-Bolt Strongback Hatches



CROSS SECTION PROFILE

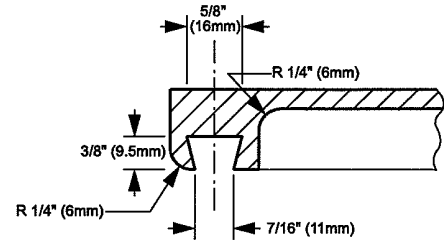


IMPORTANT:
WHEN ORDERING, PLEASE SPECIFY OUTSIDE DIAMETER (C) OR CLEAR OPENING (D).
UNITS ARE IDENTIFIED BY CLEAR OPENING.

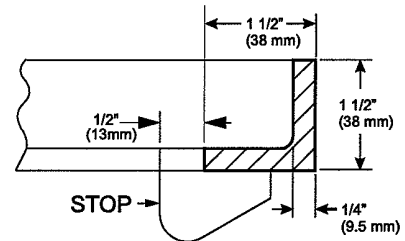
BILL OF MATERIAL: #286-1

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	***
2	STRONGBACK	***
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	WRENCH	GALVANIZED STEEL
10	LUBE ZERK	ANODIZE STEEL

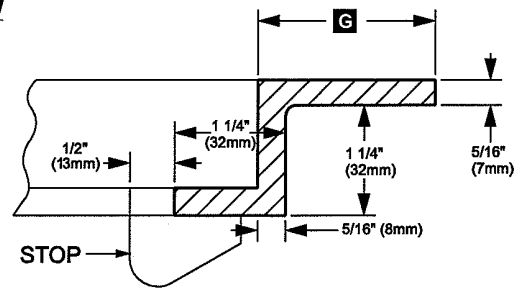
NOTE:
*** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL



GASKET GROOVE, SECTION B:B



GALVANIZED STEEL DECK RING



CAST ALUMINUM DECK RING



BAIER FLUSH HATCH
LIFT-OUT PLAIN DOGGED TYPE
WITH GRAB HANDLES
TYPE "C" POSITIVE LOCKING
MODEL BFHR20, 18, 16, AND 14

DWG. NO. 286-1

HATCH WEIGHTS LBS. (KGMS)								
Model Number	BFHR20		BFHR18		BFHR16		BFHR14	
Material	AL	ST	AL	ST	AL	ST	AL	ST
Cover	30 (13.6)	81 (36.7)	27 (12.2)	62 (28)	22 (10)	56 (25.4)	20 (9.1)	53 (24)
Deck Ring	11 (5)	11 (5)	10 (4.5)	10 (4.5)	8 (3.6)	9 (4.1)	7 (3.2)	8 (3.6)

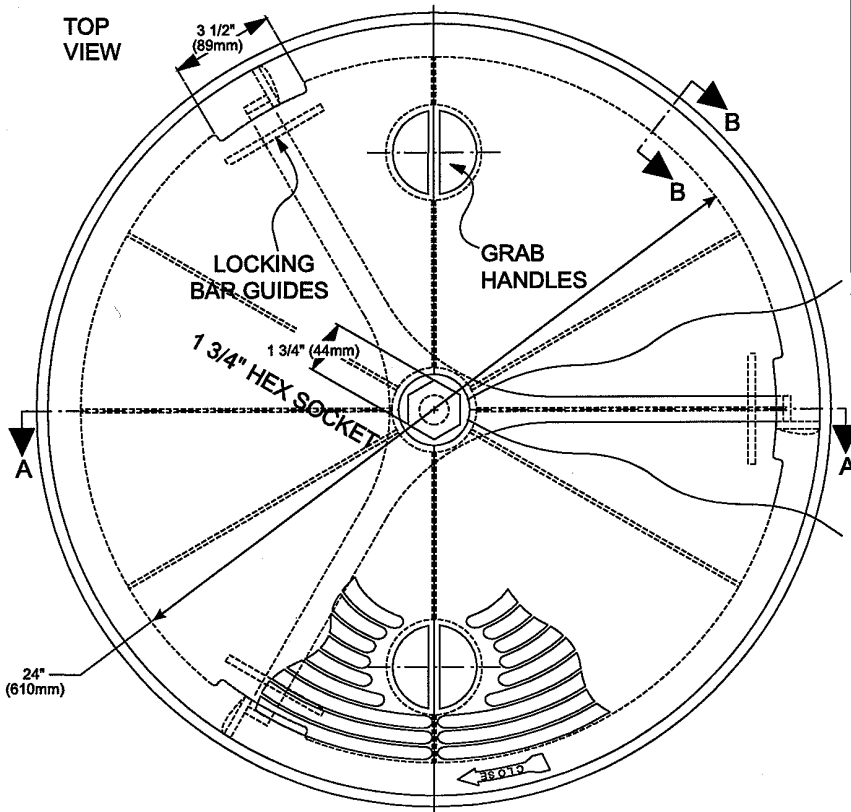
DIMENSIONS INCHES (mm)								
Model Number	A	B	C	D	E	F	G	
BFHR20	5 1/4 (133)	12 1/2 (318)	22 11/16 (576)	20 (508)	7/32 (5.6)	8 1/2 (216)	2 (51)	
BFHR18	5 1/4 (133)	12 1/2 (318)	20 11/16 (525)	18 (457)	7/32 (5.6)	7 1/4 (184)	2 (51)	
BFHR16	5 1/4 (133)	12 1/2 (318)	18 11/16 (475)	16 (406)	7/32 (5.6)	6 1/4 (159)	2 1/2 (64)	
BFHR14	5 1/4 (133)	12 1/2 (318)	16 11/16 (424)	14 (356)	7/32 (5.6)	6 1/4 (159)	2 1/2 (64)	



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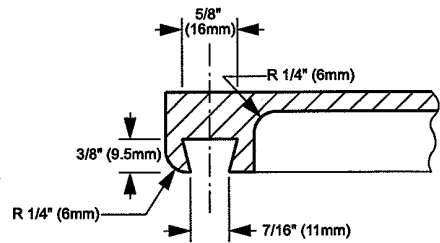
HUMCO DECK FITTINGS

Baier Classic HEX-Bolt Strongback Hatches

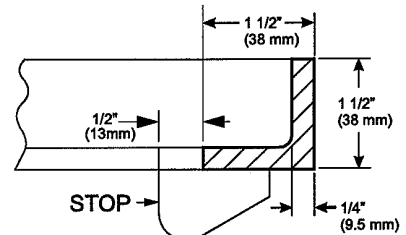


BILL OF MATERIAL: #630		
PC.NO.	DESCRIPTION	MATERIAL
1	COVER	***
2	STRONGBACK	***
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	WRENCH	GALVANIZED STEEL
10	LUBE ZERK	ANODIZED STEEL
11	SPRING	STAINLESS STEEL

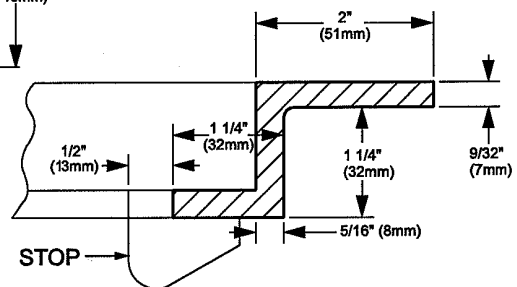
NOTE:
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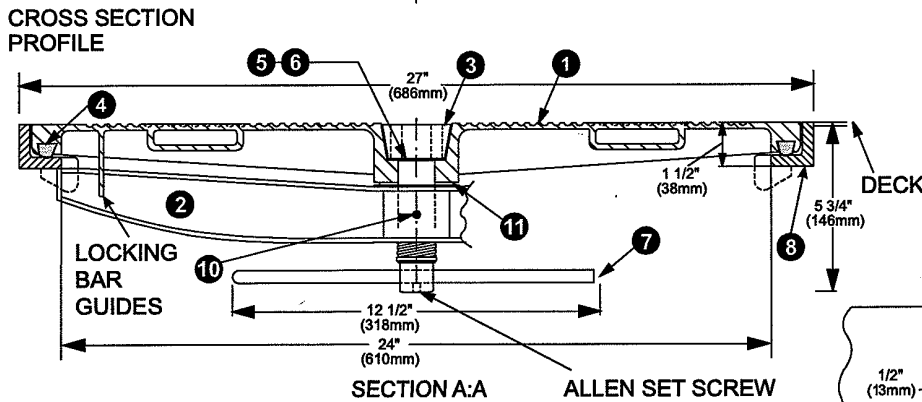
GASKET GROOVE,
SECTION B:B



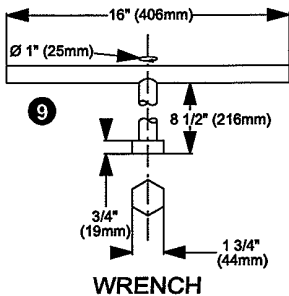
GALVANIZED STEEL
DECK RING



CAST ALUMINUM
DECK RING



SECTION A:A ALLEN SET SCREW



WRENCH

IMPORTANT:
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DIAMETER (C) OR CLEAR OPENING (D).
UNITS ARE IDENTIFIED BY CLEAR OPENING.

HATCH WEIGHTS LBS.(KGMS)	
Model Number	BFHR24
Material	AL ST
Cover	45 (20.4) 127 (57.5)
Deck Ring	15 (6.8) 15 (6.8)

BAIER FLUSH HATCH
LIFT-OUT PLAIN DOGGED TYPE
WITH GRAB HANDLES
TYPE "C" POSITIVE LOCKING
MODEL BFHR24

DWG. NO. 630



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HUMCO DECK FITTINGS

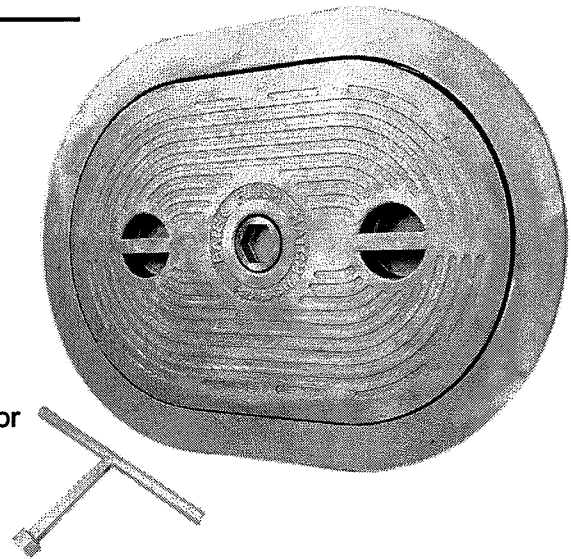
Baier Classic HEX-Bolt Strongback Hatches

BFHO Series Oval - Lift Out

The popular "Classic" Baier Flush Hatch™ is the flush-mounted, quick release, lift-out hatch with grab handles as shown. It has long been standard equipment on fishboats, tugs, barges, workboats, and other marine vessels, as well as many U.S. Navy and U.S. and Canadian Coast Guard vessels.

FEATURES

- Cast Hatch Cover
- Cast Strongback
- Stainless Steel Hex Centerbolt and hardware
- Neoprene Cover Gasket and Washers (Buna-N optional)
- Cast / fabricated matching Deck Ring
- Every unit shipped with an underside escape turning bar for safety (turning wheel optional)
- Detachable Hex wrench used for quick operation, can be stored separately for security



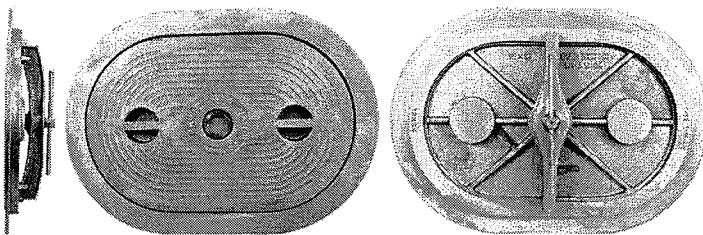
STRENGTH, SIMPLICITY and SECURITY

The ultimate in strength and simplicity, Baier's original patented strongback system has only two moving parts to secure the hatch cover to the deck. It is superior to other more complicated hatch closure systems in that it is simpler, stronger, more reliably watertight, infinitely adjustable from topside, and more easily serviced (parts are readily available and replaced in the field). Importantly, the recessed hex centerbolt and grab handles offer no snags for nets, lines or hardware.

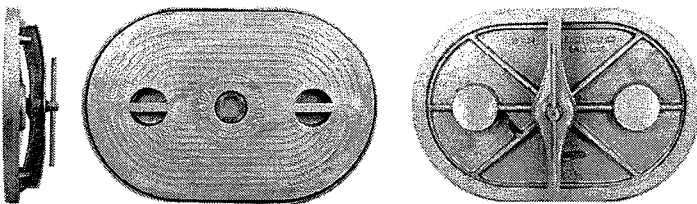
MATERIALS

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Canadian Patent 772,905. United States Patent 3,209,663



BFHO15X24A/A with Cast Aluminum Deck Ring



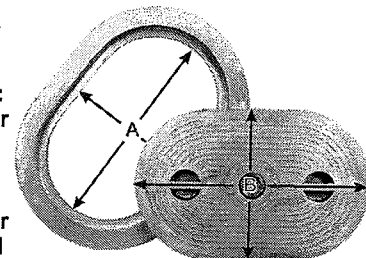
BFHRO15X24A/S with Galvanized Steel Deck Ring

Hatch Model	BFHO15x24
Clear (A) Opening	15" x 24" (381 mm x 610 mm)
Cover (B) Dimension	17" x 26" (432 mm x 660 mm)
Technical Drawing	#541

When ordering, please specify:

Cover Material:
cast aluminum or cast steel

Ring Material:
cast aluminum or galvanized steel



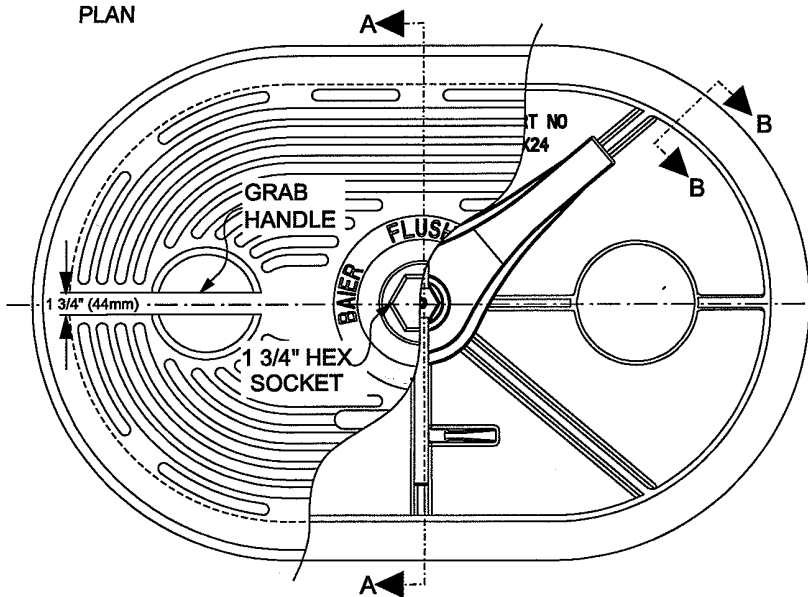
Hatch Covers Available Separately



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HUMCO DECK FITTINGS

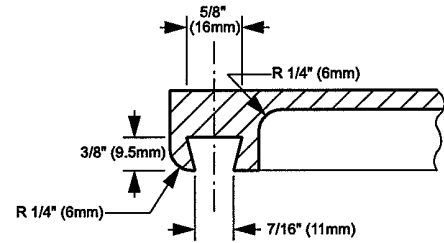
Baier Classic HEX-Bolt Strongback Hatches



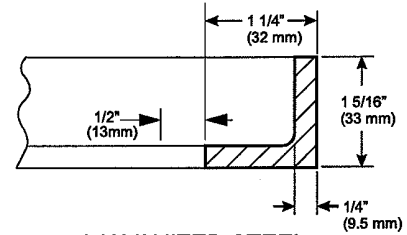
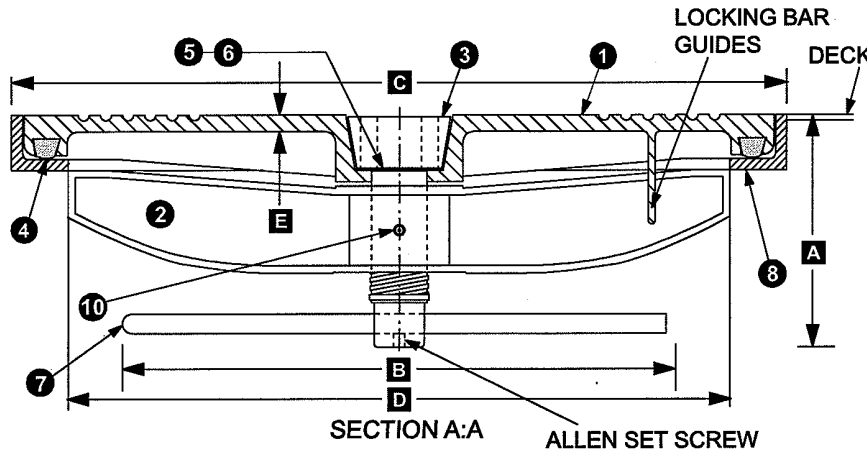
BILL OF MATERIAL: #541

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	***
2	STRONGBACK	***
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	WRENCH	GALVANIZED STEEL
10	LUBE ZERK	ANODIZE STEEL

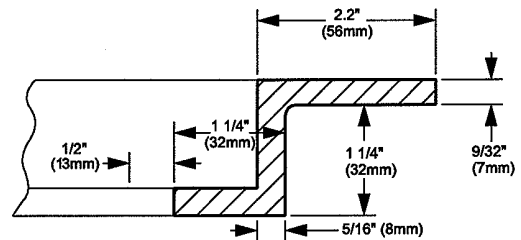
NOTE:
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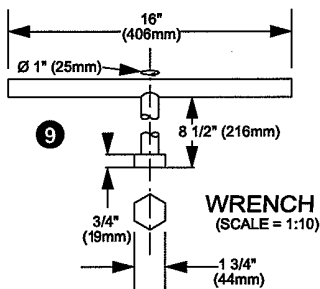
GASKET GROOVE,
SECTION B:B



GALVANIZED STEEL
DECK RING



CAST ALUMINUM
DECK RING



HATCH WEIGHTS LBS. (KGMS)	
Model Number	BFHO15x24 BFHO13.5x20.5
Material	AL ST AL ST
Cover	31 (14) 79 (35.8) 25 (11.3) 64 (29)
Deck Ring	9 (4.1) 12 (5.4) 8 (3.6) 8 (3.6)

IMPORTANT: WHEN ORDERING,
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DIAMETER (C) OR CLEAR
OPENING (D). UNITS ARE
IDENTIFIED BY CLEAR OPENING.

Model Number	DIMENSIONS INCHES (mm)						
	A	B	C(L)	C(W)	D(L)	D(W)	G
BFHO15X24	5 1/4 (133)	12 1/2 (318)	26 1/2 (673)	17 1/2 (445)	24 (610)	15 (381)	7/16 (11)

BAIER FLUSH HATCH
LIFT-OUT PLAIN DOGGED TYPE
WITH GRAB HANDLES
TYPE "C" POSITIVE LOCKING
MODEL BFHO15X24

DWG. NO. 541



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HUMCO DECK FITTINGS

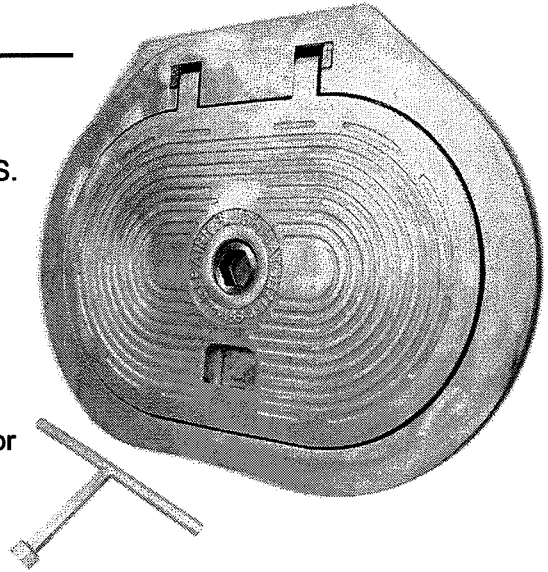
Baier Classic HEX-Bolt Strongback Hinged Hatches

BFHHR Series Round - Hinged BFHHO Series Oval - Hinged

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FEATURES

- Cast Hatch Cover
- Cast Strongback
- Stainless Steel Hex Centerbolt and hardware
- Neoprene Cover Gasket and Washers (Buna-N optional)
- Cast / fabricated matching Deck Ring
- Every unit shipped with an underside escape turning bar for safety (turning wheel optional)
- Detachable Hex wrench used for quick operation, can be stored separately for security



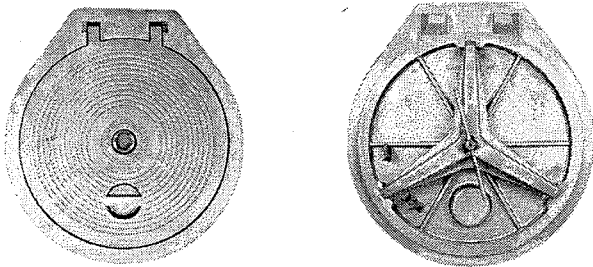
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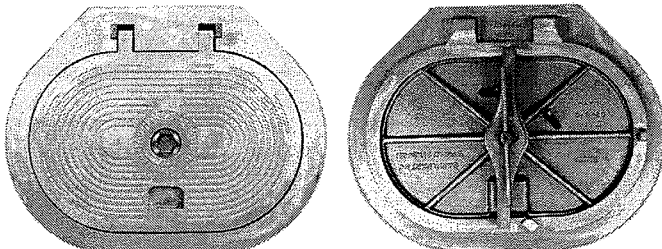
MATERIALS

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Canadian Patent 772,905. United States Patent 3,209,663

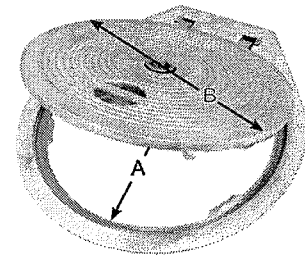


BFHR22A/A with Cast Aluminum Deck Ring

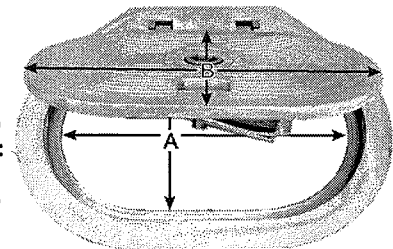


BFHHR15X24A/A with Cast Aluminum Deck Ring

Hatch Model:
BFHHR22
Clear Opening (A):
22" Ø (559 mm)
Cover Diameter (B):
24" Ø (610 mm)
Technical Drawing:
#625



Hatch Model:
BFHHR15x24
Clear Opening (A):
15" x 24"
(381 mm x 610 mm)
Cover Dimension (B):
17" x 26"
(432 mm x 660 mm)
Technical Drawing:
#543



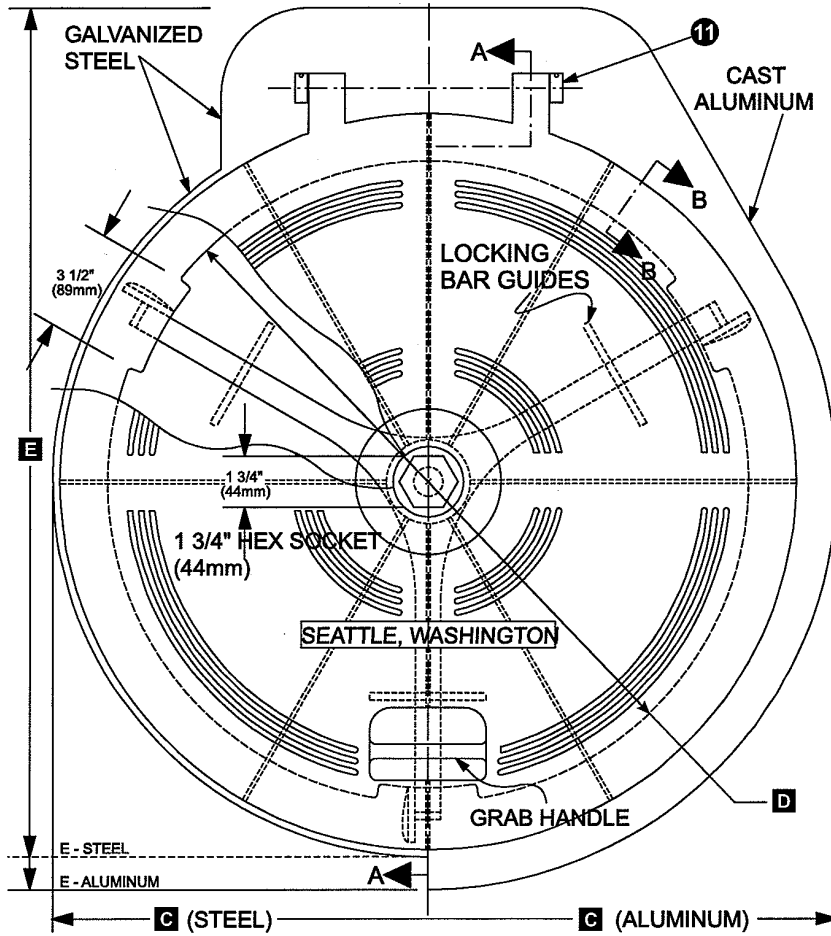
Hatch Covers Available Separately



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HUMCO DECK FITTINGS

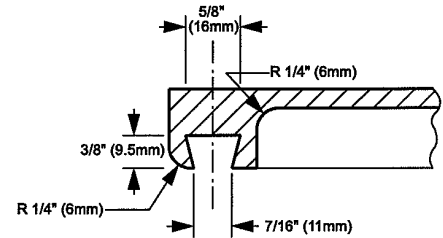
Baier Classic HEX-Bolt Strongback Hinged Hatches



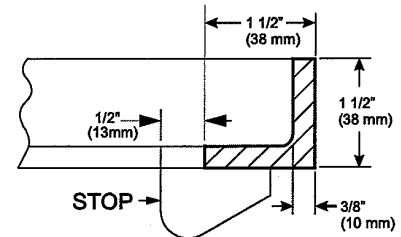
BILL OF MATERIAL: #625

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	***
2	STRONGBACK	***
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	WRENCH	GALVANIZED STEEL
10	LUBE ZERK	ANODIZED STEEL
11	HINGE PIN	STAINLESS STEEL
12	SPRING	STAINLESS STEEL

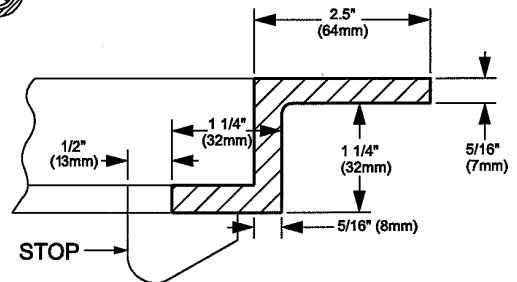
NOTE:
*** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL



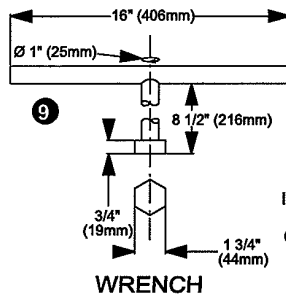
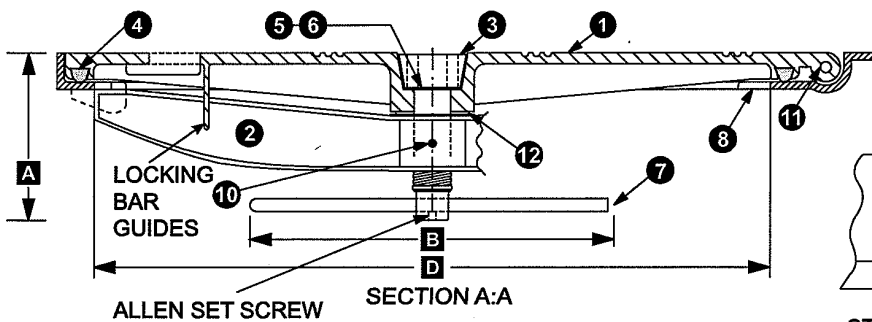
GASKET GROOVE, SECTION B:B



GALVANIZED STEEL DECK RING



CAST ALUMINUM DECK RING



HATCH WEIGHTS LBS. (KGMS)	
Model Number	BFHHR22
Material	AL ST
Cover	37 (16.8) 99 (44.8)
Deck Ring	13 (5.9) 27 (12.2)

NOTE: BUTT WELD ON STEEL AND ALUMINUM DECKS. BOLT DOWN ON WOOD AND FIBERGLASS DECKS (FLANGES SUPPLIED BLIND - SHIPYARD TO DRILL TO SUIT).

Model Number	DIMENSIONS INCHES (mm)					
	A	B	C (ST)	C (AL)	D	E (AL)
BFHHR22	5 3/4 (146)	12 1/2 (318)	25 3/4 (654)	28 (711)	22 (559)	30 1/4 (768)

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BAIER FLUSH HATCH
LIFT-OUT PLAIN DOGGED TYPE
WITH GRAB HANDLES
TYPE "C" POSITIVE LOCKING
MODEL BFHHR22

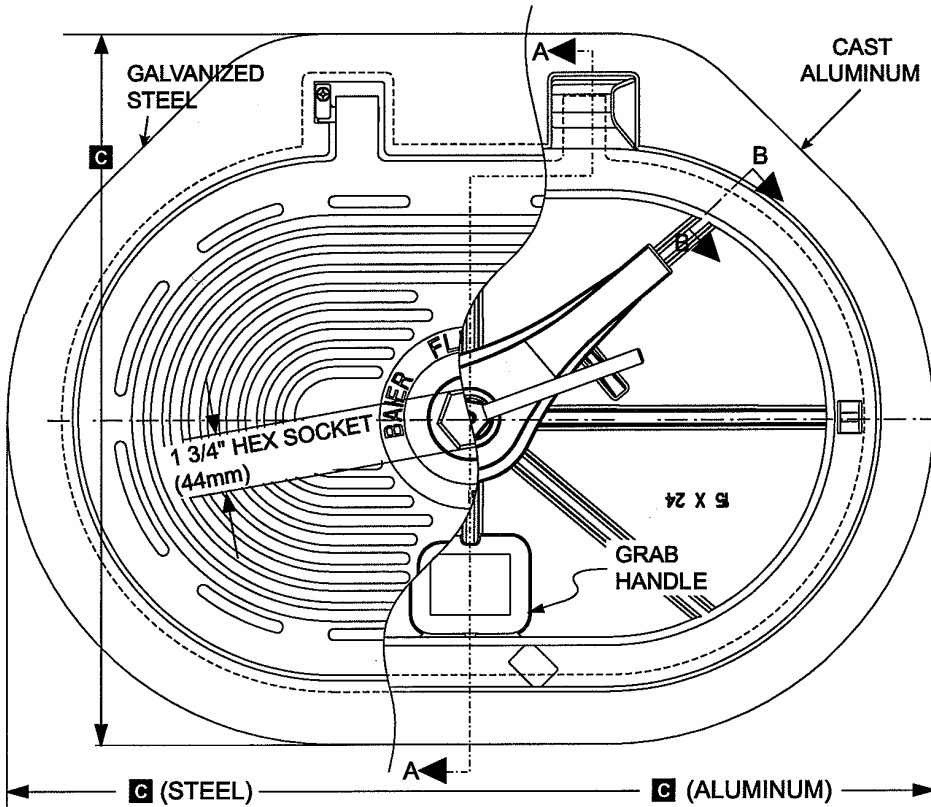
DWG. NO. 625



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HUMCO DECK FITTINGS

Baier Classic HEX-Bolt Strongback Hinged Hatches

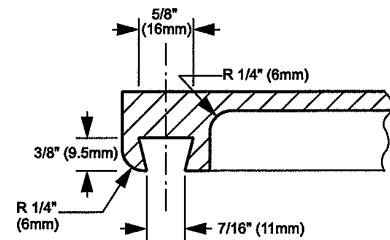


BILL OF MATERIAL: #543-1

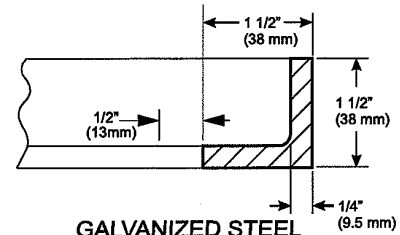
PC.NO.	DESCRIPTION	MATERIAL
1	COVER	***
2	STRONGBACK	***
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	WRENCH	GALVANIZED STEEL
10	LUBE ZERK	ANODIZED STEEL
11	HINGE PIN	STAINLESS STEEL

NOTE: *** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL

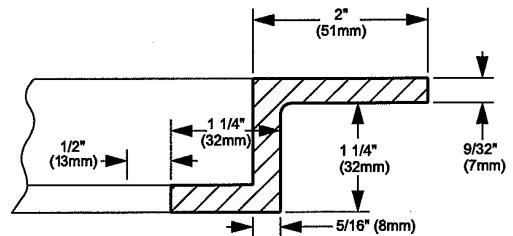
NOTE: BUTT WELD ON STEEL AND ALUMINUM DECKS. BOLT DOWN ON WOOD AND FIBERGLASS DECKS (FLANGES SUPPLIED BLIND - SHIPYARD TO DRILL TO SUIT)



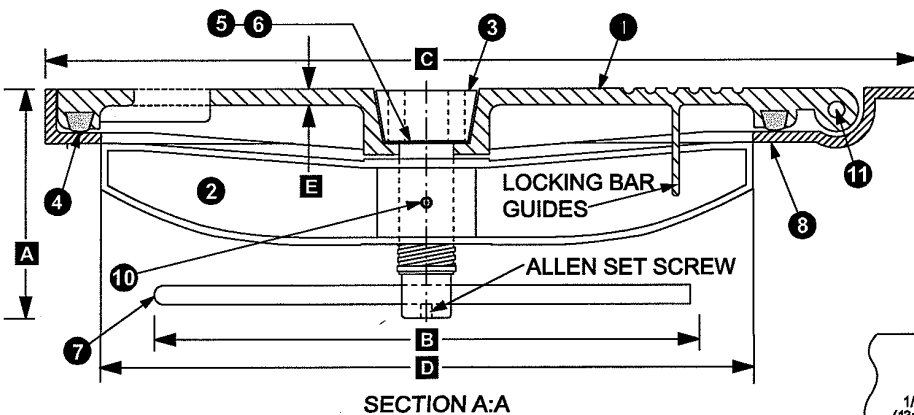
GASKET GROOVE, SECTION B:B



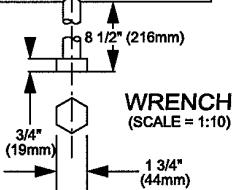
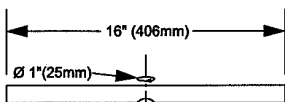
GALVANIZED STEEL DECK RING



CAST ALUMINUM DECK RING



SECTION A:A



HATCH WEIGHTS (LBS.)	
Model Number	BFHHO15x24
Material	AL ST
Cover	32 (14.5) 76 (34.4)
Deck Ring	10 (4.5) 27 (12.2)

IMPORTANT: WHEN ORDERING, PLEASE SPECIFY OUTSIDE DIAMETER (C) OR CLEAR OPENING (D). UNITS ARE IDENTIFIED BY CLEAR OPENING.

Model Number	DIMENSIONS INCHES (mm)					
	A	B	C (ST)	C (AL)	D	E
BFHHO15X24	5 1/4 (133)	12 1/2 (318)	30 7/8 x 22 7/16 (784 x 570)	30 1/2 x 23 3/8 (775 x 593)	24 x 15 (610 x 381)	7/32 (5.6)

BAIER FLUSH HATCH
HINGED DOGGED TYPE WITH GRAB HANDLES
TYPE "C" POSITIVE LOCKING
MODEL BFHHO15X24

DWG. NO. 543-1



1074 Kenran Industrial Dr.
St. Louis, MO 63137
Phone: 1-800-381-9968

HUMCO DECK FITTINGS

Baier T-Handle Strongback Hinged Hatches

BFHHOTH Series Oval - Hinged BFHHSQ Series Square - Hinged

This popular strongback hinged hatch design series adds the convenience of a built-in recessed Stainless Steel T-handle to the flush-mounted, quick release, hinged hatch. The design is especially popular on aluminum boats, fishing and other workboats, as well as many U.S. Navy and U.S. and Canadian Coast Guard vessels.

FEATURES

Unique:

- Cast Hatch Cover (unique no grab handles)
- Stainless Steel Centerbolt and hardware
- Built-in Stainless Steel T-Handle used for quick engagement as well as lifting

Shares with Classic HEX-Bolt Series:

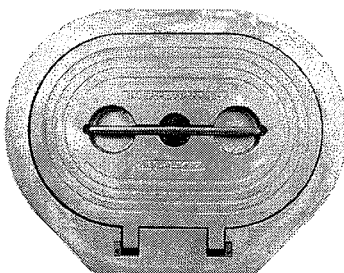
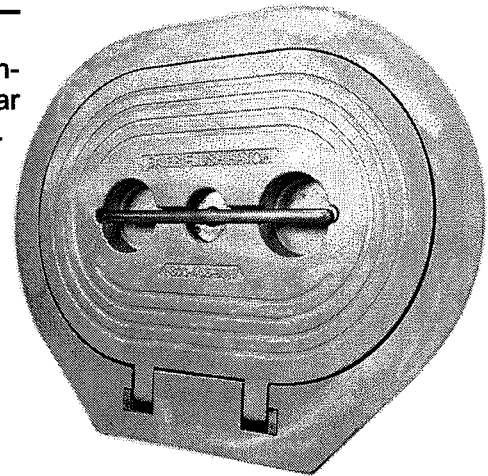
- Cast Strongback
- Cast / fabricated matching Deck Ring
- Neoprene Cover Gasket and Washers (Buna-N optional)
- Every unit shipped with an underside escape turning bar for safety
- Turning wheel optional

STRENGTH, SIMPLICITY and CONVENIENCE

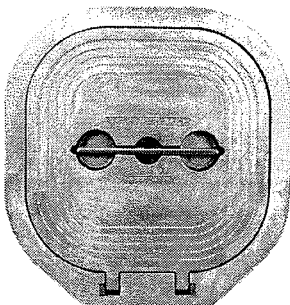
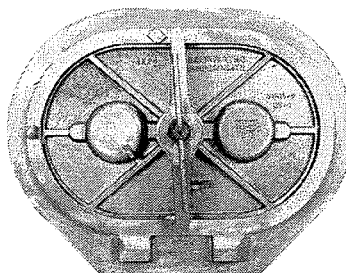
The T-Handle Strongback system has only three moving parts to secure the hatch cover to the deck. Like the Classic HEX it is simple, strong, reliably watertight, infinitely adjustable from topside, and easily serviced (parts are readily available and replaced in the field).

MATERIALS

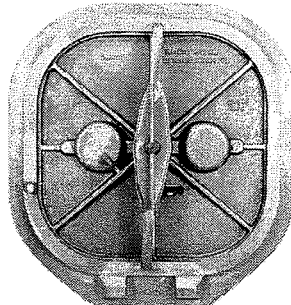
The T-Handle Strongback hatch cover product line is available only in cast aluminum. The deck rings used are the same as the Classic HEX and are available in galvanized mild steel (for welding into steel decks), or cast aluminum (for welding into aluminum decks or bolting to fiberglass or wood decks). Stainless deck rings are available by special order.



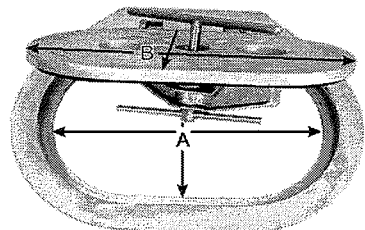
BFHHOTH15X24A/A with Cast Aluminum Deck Ring



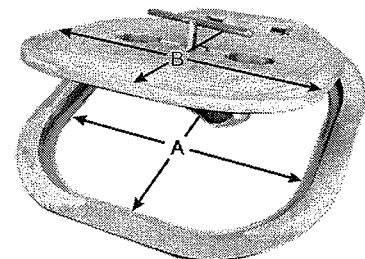
BFHHSQ24X24A/S with Galvanized Steel Deck Ring



Hatch Model:
BFHHOTH15X24
Clear Opening (A):
15" x 24"
(381 mm X 610 mm)
Cover Dimensions (B):
17" x 26"
(432 mm x 660 mm)
Technical Drawing:
#525



Hatch Model:
BFHHSQ24x24
Clear Opening (A):
24" x 24"
(610 mm x 610 mm)
Cover Dimensions (B):
26" x 26"
(660 mm x 660 mm)
Technical Drawing:
#725



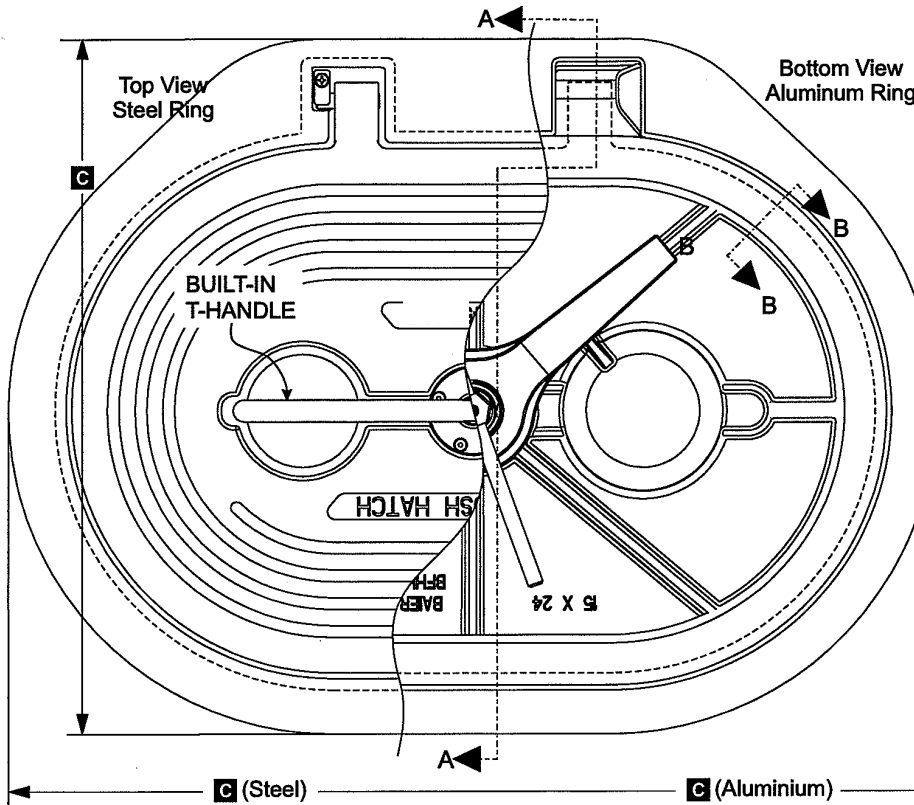
Hatch Covers Available Separately



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St. Louis, MO 63137
Phone: 1-800-381-9968

HUMCO DECK FITTINGS

Baier T-Handle Strongback Hinged Hatches

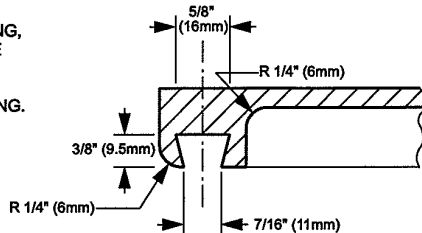
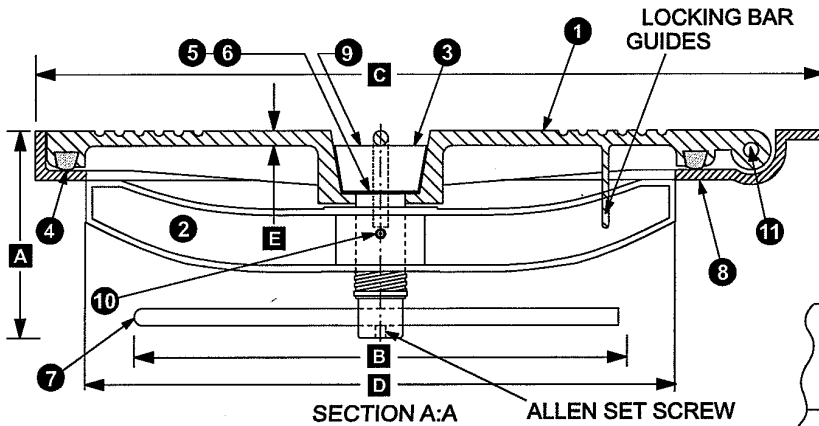
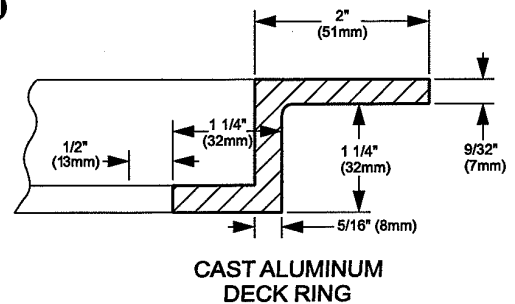
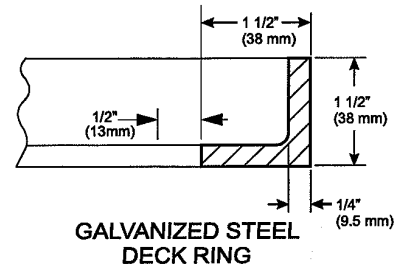


BILL OF MATERIAL: #525

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	ALUMINUM ONLY
2	STRONGBACK	ALUMINUM ONLY
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	WRENCH	GALVANIZED STEEL
10	T-HANDLE	STAINLESS STEEL
11	HINGE PIN	STAINLESS STEEL

NOTE: *** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL

NOTE: BUTT WELD ON STEEL AND ALUMINUM DECKS. BOLT DOWN ON WOOD AND FIBERGLASS DECKS (FLANGES SUPPLIED BLIND - SHIPYARD TO DRILL TO SUIT)



IMPORTANT: WHEN ORDERING, PLEASE SPECIFY OUTSIDE DIAMETER (C) OR CLEAR OPENING (D). UNITS ARE IDENTIFIED BY CLEAR OPENING.

HATCH WEIGHTS (LBS.)	
Model Number	BFHHOTH15X24
Material	AL ST
Cover	32 (14.5) 76 (34.4)
Deck Ring	10 (4.5) 27 (12.2)

Model Number	DIMENSIONS INCHES (mm)					
	A	B	C(ST)	C(AL)	D	E
BFHHOTH15X24	5 1/4 (133)	12 1/2 (318)	30 7/8 x 22 7/16 (784 x 570)	30 1/2 x 23 3/8 (775 x 593)	24 x 15 (610 x 381)	7/32 (5.6)

BAIER FLUSH HATCH
HINGED DOGGED TYPE WITH
BUILT-IN T-HANDLE
TYPE "C" POSITIVE LOCKING
MODEL BFHHOTH15X24

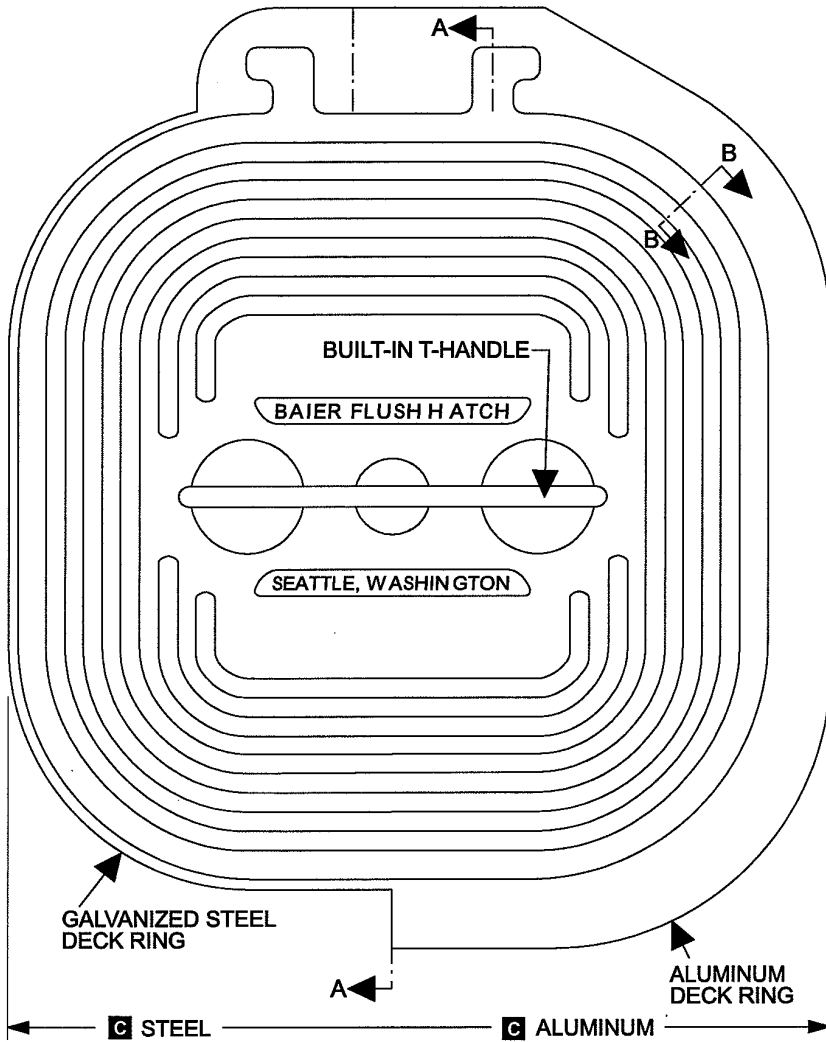
DWG. NO. 525



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Phone: 1-800-381-9968

HUMCO DECK FITTINGS

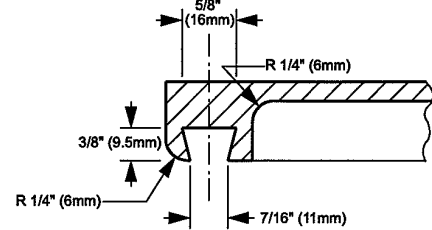
Baier T-Handle Strongback Hatches



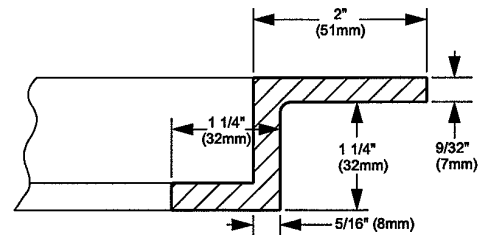
BILL OF MATERIAL: #725

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	ALUMINUM ONLY
2	STRONGBACK	ALUMINUM ONLY
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	T-HANDLE	STAINLESS STEEL
10	LUBE ZERK	ANODIZED STEEL
11	SPRING	STAINLESS STEEL
12	HINGE PINS	STAINLESS STEEL

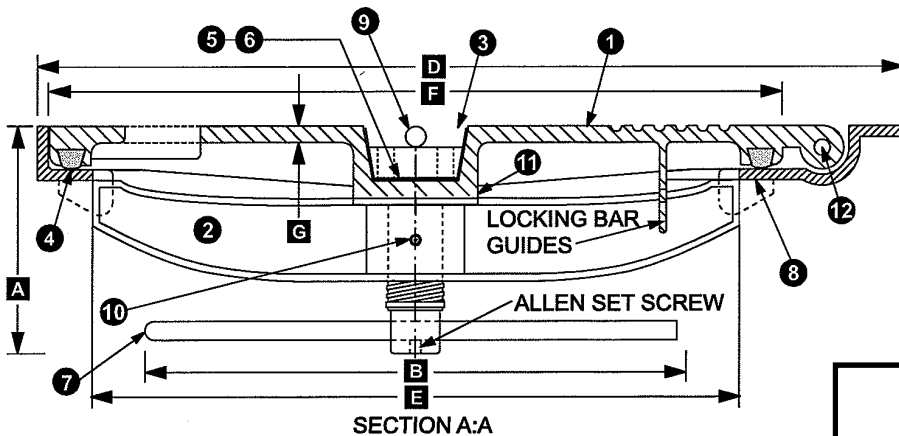
NOTE:
*** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL



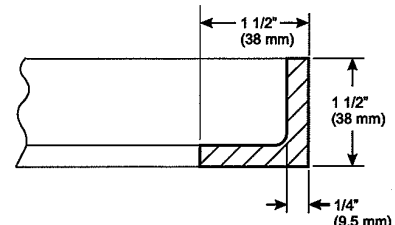
GASKET GROOVE,
SECTION B:B



CAST ALUMINUM
DECK RING



SECTION A:A



GALVANIZED STEEL
DECK RING

HATCH WEIGHTS LBS. (KGMS)	
Model Number	BFSQHTH24X24
Material	AL ST
Cover	51(23.1) N/A
Deck Ring	14 (6.3) 26 (11.8)

IMPORTANT: WHEN ORDERING,
PLEASE SPECIFY OUTSIDE
DIAMETER (C) OR CLEAR
OPENING (D). UNITS ARE
IDENTIFIED BY CLEAR OPENING.

Model Number	DIMENSIONS INCHES (mm)								
	A	B	C (ST)	C (AL)	D(ST)	D(AL)	E	F	G
BFHHSQ24X24	6 (152)	12 1/2 (318)	26 11/16 (677)	30 1/2 (774)	30.5 (774)	32 1/2 (826)	1 1/4 (32)	26 (660)	3/8 (9.5)



BAIER FLUSH HATCH
HINGED DOGGED TYPE WITH
BUILT-IN T-HANDLE
TYPE "C" POSITIVE LOCKING
MODEL BFHHSQ24X24

DWG. NO. 725



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 St. Louis, MO 63137
 Phone: 1-800-381-9968

HUMCO DECK FITTINGS

Baier T-Handle Strongback Hatches

BFHRTS Series Round - Lift Out

This popular strongback hatch design series adds the convenience of a built-in recessed Stainless Steel T-handle to the flush-mounted, quick release, lift-out hatch. The design is especially popular on aluminum boats, fishing and other workboats, as well as many U.S. Navy and U.S. and Canadian Coast Guard vessels.

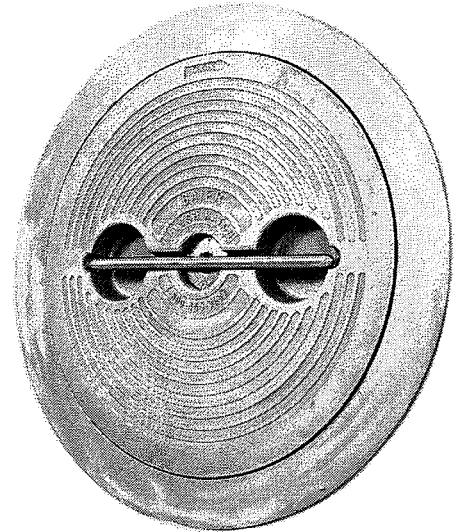
FEATURES

Unique:

- Cast Hatch Cover (unique no grab handles)
- Stainless Steel Centerbolt and hardware
- Built-in Stainless Steel T-Handle used for quick engagement as well as lifting

Shares with Classic HEX-Bolt Series:

- Cast Strongback
- Cast / fabricated matching Deck Ring
- Neoprene Cover Gasket and Washers (Buna-N optional)
- Every unit shipped with an underside escape turning bar for safety
- Turning wheel optional

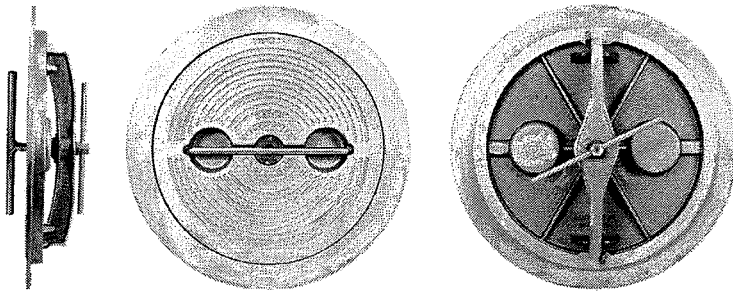


STRENGTH, SIMPLICITY and CONVENIENCE

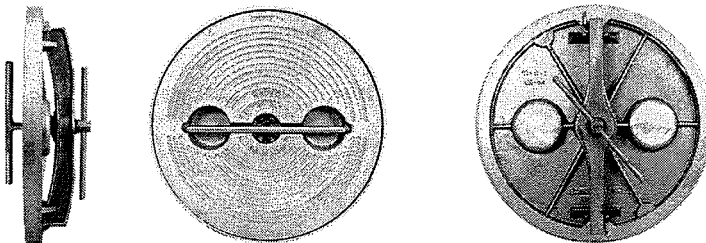
The T-Handle Strongback system has only three moving parts to secure the hatch cover to the deck. Like the Classic HEX it is simple, strong, reliably watertight, infinitely adjustable from topside, and easily serviced (parts are readily available and replaced in the field).

MATERIALS

The T-Handle Strongback hatch cover product line is available only in cast aluminum. The deck rings used are the same as the Classic HEX and are available in galvanized mild steel (for welding into steel decks), or cast aluminum (for welding into aluminum decks or bolting to fiberglass or wood decks). Stainless deck rings are available by special order.



BFHRTS20A/A with Cast Aluminum Deck Ring



BFHRTS20A/S with Galvanized Steel Deck Ring

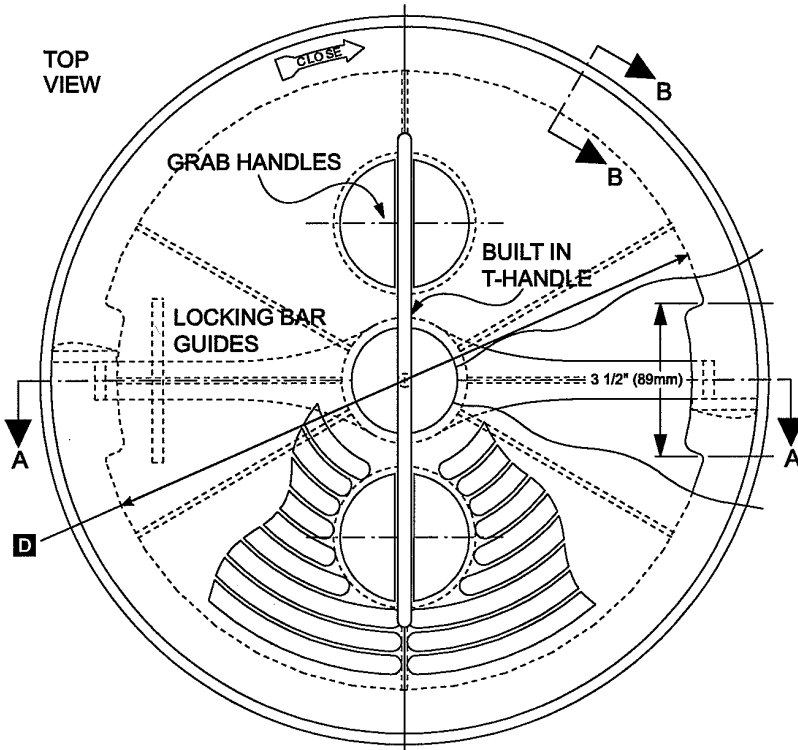
Hatch Model	BFHRTS20
Clear (A) Opening	20" Ø (508 mm) Ø
Cover (B) Diameter	22" Ø (559 mm) Ø
Technical Drawing	#200
<p><u>When ordering, please specify:</u></p> <p>Cover Material: cast aluminum</p> <p>Ring Material: cast aluminum or galvanized steel</p>	<p>Hatch Covers Available Separately</p>



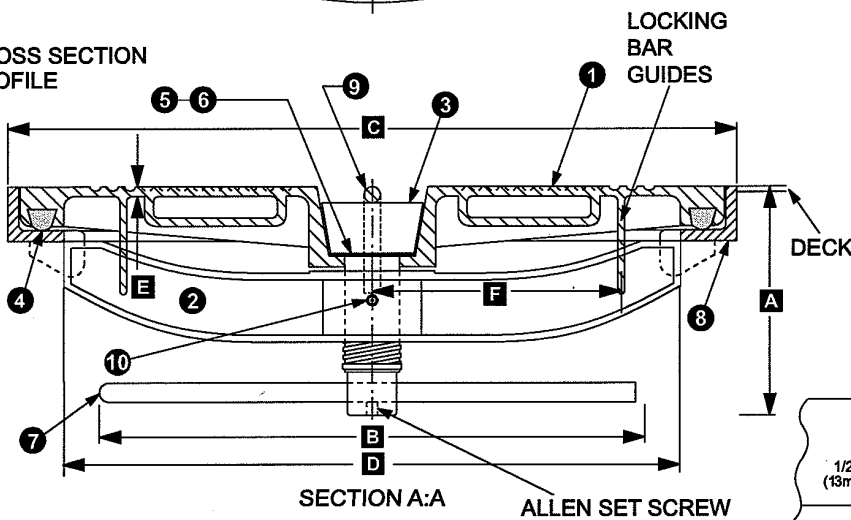
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St. Louis, MO 63137
Phone: 1-800-381-9968

HUMCO DECK FITTINGS

Baier T-Handle Strongback Hatches



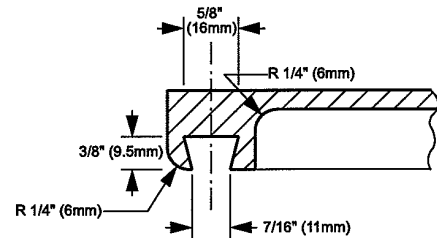
CROSS SECTION PROFILE



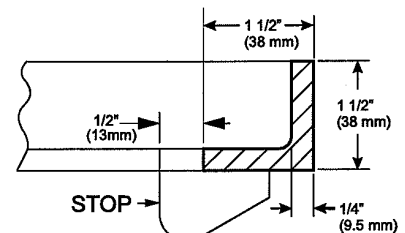
BILL OF MATERIAL: #200

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	ALUMINUM ONLY
2	STRONGBACK	ALUMINUM ONLY
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	T-HANDLE	STAINLESS STEEL
10	LUBE ZERK	ANODIZED STEEL

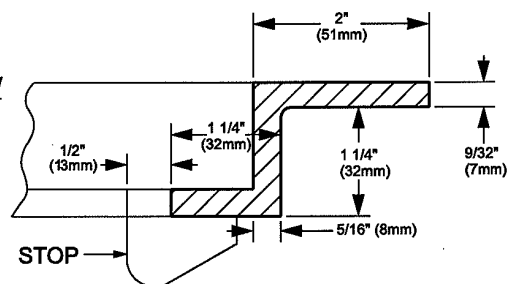
NOTE:
*** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL



GASKET GROOVE, SECTION B:B



GALVANIZED STEEL DECK RING



CAST ALUMINUM DECK RING

HATCH WEIGHTS LBS. (KGMS)		
Model Number	BFHRTH20	
Material	AL	ST
Cover	30 (13.6)	N/A
Deck Ring	11 (5)	11 (5)

IMPORTANT: WHEN ORDERING, PLEASE SPECIFY OUTSIDE DIAMETER (C) OR CLEAR OPENING (D). UNITS ARE IDENTIFIED BY CLEAR OPENING.

Model Number	DIMENSIONS INCHES (mm)					
	A	B	C	D	E	F
BFHRTH20	5 1/4 (133)	12 1/2 (318)	22 11/16 (576)	20 (508)	7/32 (5.6)	8 1/2 (216)



BAIER FLUSH HATCH
LIFT-OUT PLAIN DOGGED TYPE
WITH BUILT-IN T-HANDLE
TYPE "C" POSITIVE LOCKING
MODEL BFHRTH20

DWG. NO. 200



1074 Kenran Industrial Dr.
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Phone: 1-800-381-9968

HUMCO DECK FITTINGS

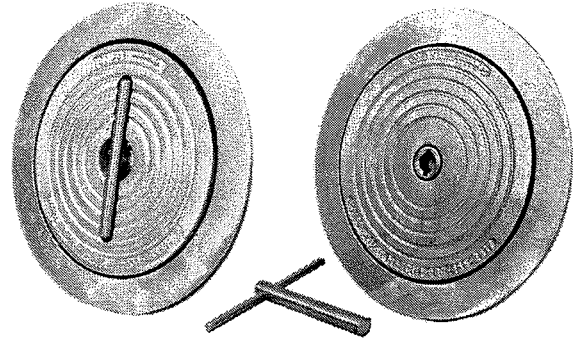
Baier T-Handle Strongback Hatches

BFHRT8 Series Round - Lift Out

This popular strongback hatch design series adds the convenience of a built-in recessed Stainless Steel T-handle to the flush-mounted, quick release, lift-out hatch. This design is especially popular on aluminum boats, fishing and other workboats, as well as many U.S. Navy and U.S. and Canadian Coast Guard vessels.

FEATURES

- Cast Hatch Cover
- Stainless Steel Centerbolt and hardware
- Built-in Stainless Steel T-Handle used for quick engagement as well as lifting
- Cast Strongback
- Cast / Fabricated Matching Deck Ring
- Neoprene Cover Gasket and Washers (Oil Resistant BUNA-N Available)



BFHRT8 - With built-in T-handle. Available in cast Aluminum.

BFHRSR8 - Shown with detachable spanner wrench. Available in Aluminum and Galvanized Steel

STRENGTH, SIMPLICITY and CONVENIENCE

The T-Handle Strongback system has only three moving parts to secure the hatch cover to the deck. Like the Classic HEX it is simple, strong, reliably watertight, infinitely adjustable from topside, and easily serviced (parts are readily available and replaced in the field).

MATERIALS

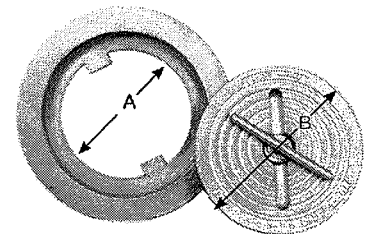
The T-Handle Strongback hatch cover product line is available only in cast aluminum. The BFHRSR8 spanner model in aluminum and Galvanized Steel. The deck rings used are the same as the Classic HEX and are available in galvanized mild steel (for welding into steel decks), or cast aluminum (for welding into aluminum decks or bolting to fiberglass or wood decks). Stainless Steel deck rings are available by special order.

Hatch Model	BFHRT8 / BFHRSR8
Clear (A) Opening	6.6" Ø (168 mm) Ø
Cover (B) Diameter	8" Ø (203 mm) Ø
Technical Drawing	#670

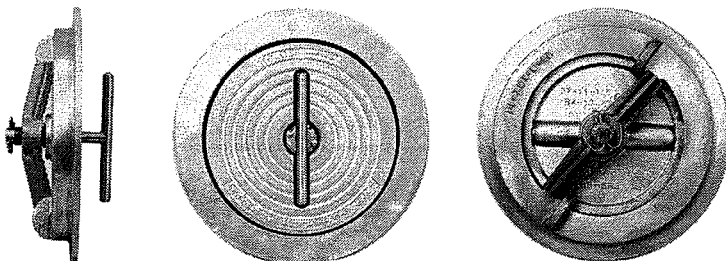
When ordering, please specify:

Cover Material:
cast aluminum or galvanized steel

Ring Material:
cast aluminum or galvanized steel



Hatch Covers Available Separately



BFHRT8A/A with Cast Aluminum Deck Ring

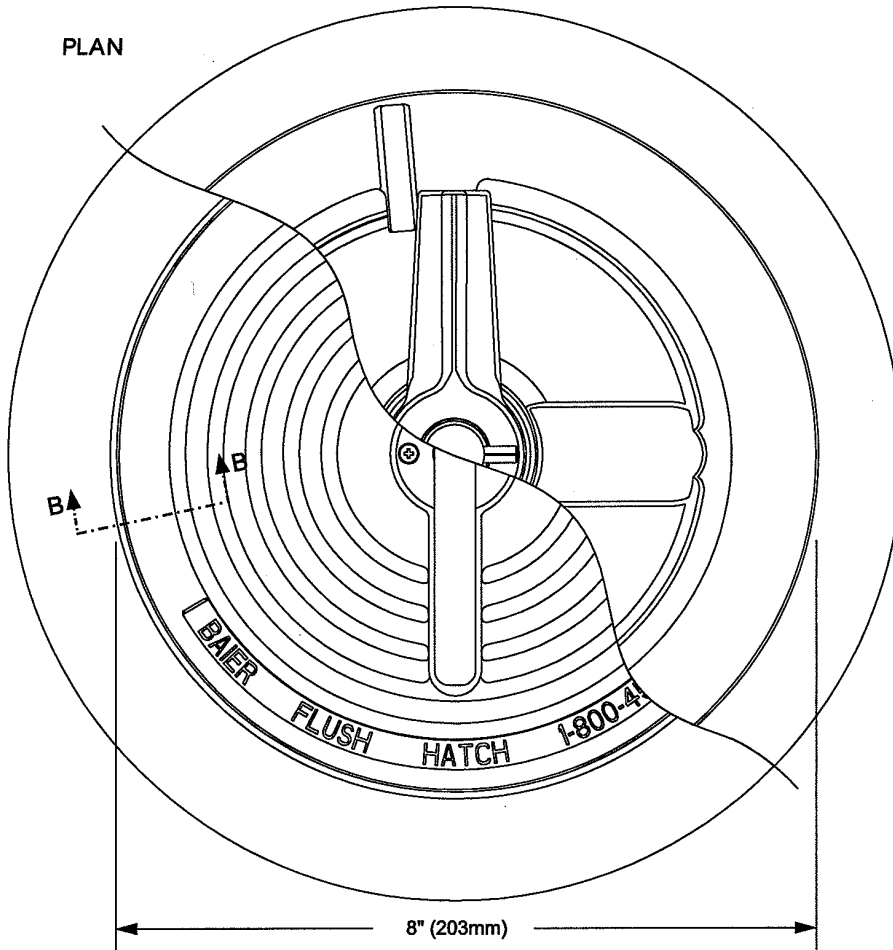


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HUMCO DECK FITTINGS

Baier T-Handle Strongback Hatches

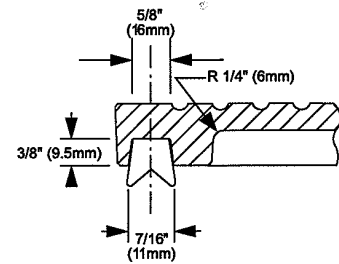
PLAN



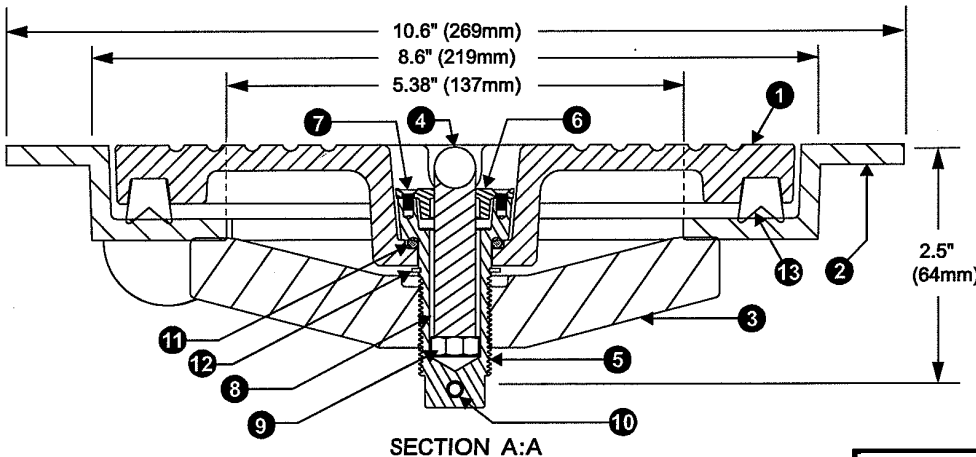
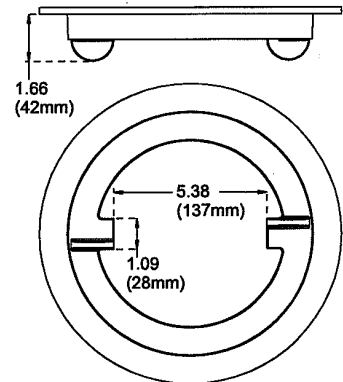
BILL OF MATERIAL: #670

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	ALUMINUM ONLY
2	DECK RING	ALUMINUM
3	STRONGBACK	ALUMINIUM
4	T-HANDLE	STAINLESS STEEL
5	CENTER BOLT	STAINLESS STEEL
6	COVER PLATE	STAINLESS STEEL
7	PAN SCREW (X4)	S.S. (M3 x .5)
8	SPRING PIN	S.S. (3 mm x 12 mm)
9	BOLT M8	S.S. (M8 x 1.25)
10	SPRING PIN	S.S. (5 mm x 35 mm)
11	O-RING	NEOPRENE
12	RETAINER RING	S.S. (22 mm)
13	GASKET	NEOPRENE

NOTE: *** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL



GASKET GROOVE, SECTION B:B



SECTION A:A

HATCH WEIGHTS LBS. (KGMS)	
Model Number	BFHRT8
Material	AL ST
Cover	30 (13.6) N/A
Deck Ring	11 (5) 11 (5)



BAIER FLUSH HATCH
LIFT-OUT PLAIN DOGGED TYPE
WITH BUILT-IN T-HANDLE
TYPE "C" POSITIVE LOCKING
MODEL BFHRT8

DWG. NO. 670



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Phone: 1-800-381-9968

HUMCO DECK FITTINGS

Baier T-Handle Strongback Hatches

BFHOTH Series Oval - Lift Out

This popular strongback hatch design series adds the convenience of a built-in recessed Stainless Steel T-handle to the flush-mounted, quick release, lift-out hatch. The design is especially popular on aluminum boats, fishing and other workboats, as well as many U.S. Navy and U.S. and Canadian Coast Guard vessels.

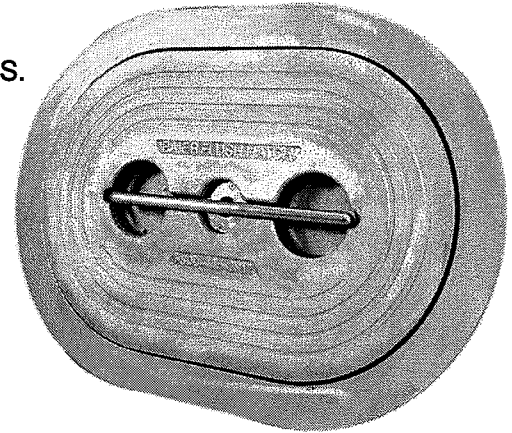
FEATURES

Unique:

- Cast Hatch Cover (unique no grab handles)
- Stainless Steel Centerbolt and hardware
- Built-in Stainless Steel T-Handle used for quick engagement as well as lifting

Shares with Classic HEX-Bolt Series:

- Cast Strongback
- Cast / fabricated matching Deck Ring
- Neoprene Cover Gasket and Washers (Buna-N optional)
- Every unit shipped with an underside escape turning bar for safety
- Turning wheel optional



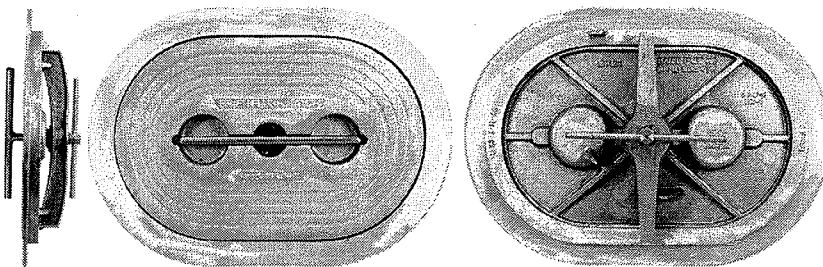
STRENGTH, SIMPLICITY and CONVENIENCE

The T-Handle Strongback system has only three moving parts to secure the hatch cover to the deck. Like the Classic HEX it is simple, strong, reliably watertight, infinitely adjustable from topside, and easily serviced (parts are readily available and replaced in the field).

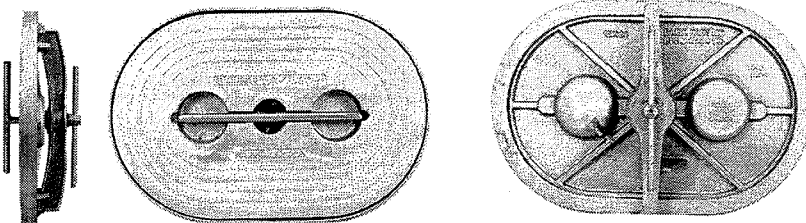
MATERIALS

The T-Handle Strongback hatch cover product line is available only in cast aluminum. The deck rings used are the same as the Classic HEX and are available in galvanized mild steel (for welding into steel decks), or cast aluminum (for welding into aluminum decks or bolting to fiberglass or wood decks). Stainless deck rings are available by special order.

11



BFHOTH15X24A/A with Cast Aluminum Deck Ring



BFHOTH15X24A/S with Galvanized Steel Deck Ring

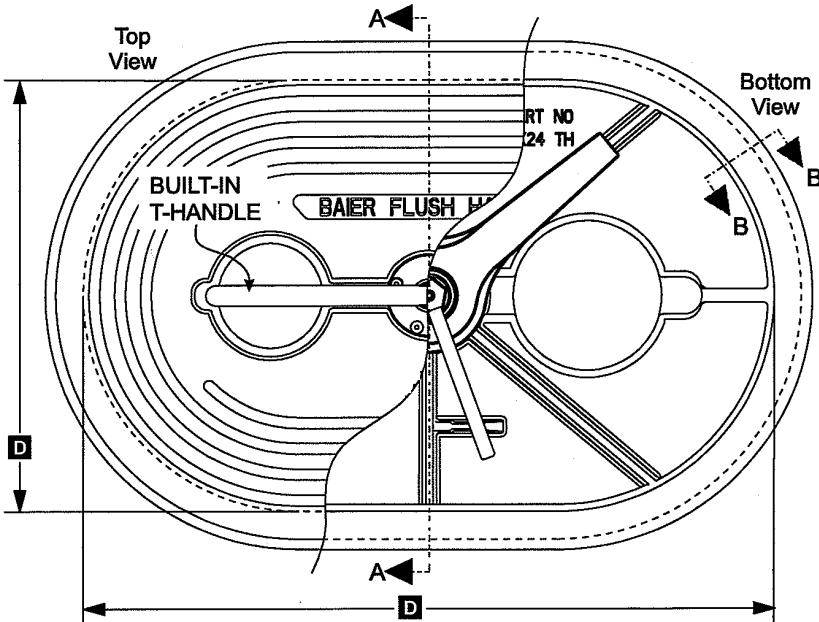
Hatch Model	BFHOTH15x24
Clear (A) Opening	15" x 24" (381 mm x 610 mm)
Cover (B) Dimensions	17" x 26" (432 mm x 660 mm)
Technical Drawing	#500
When ordering, please specify:	
Cover Material: cast aluminum	
Ring Material: cast aluminum or galvanized steel	
Hatch Covers Available Separately	



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HUMCO DECK FITTINGS

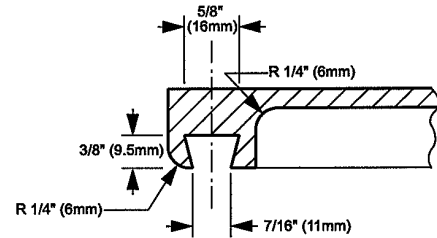
Baier T-Handle Strongback Hatches



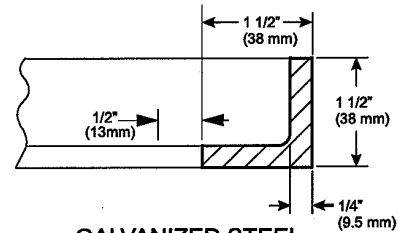
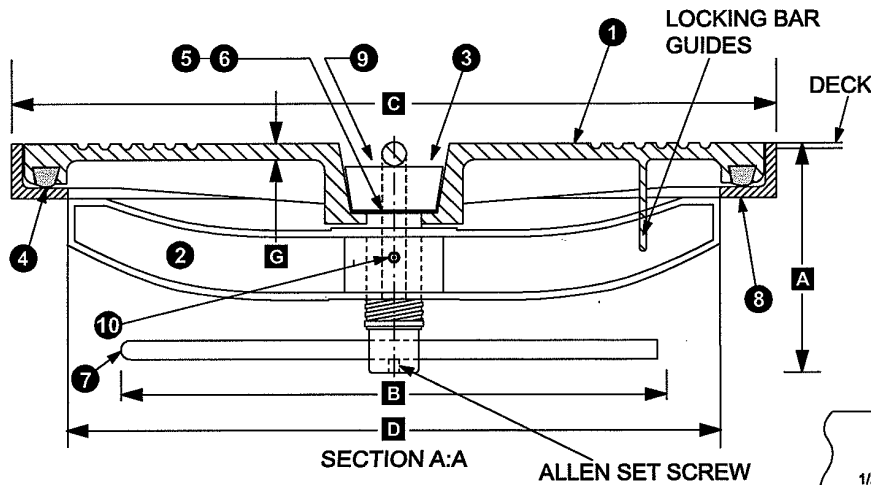
BILL OF MATERIAL: #500

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	ALUMINUM ONLY
2	STRONGBACK	ALUMINUM ONLY
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	T-HANDLE	STAINLESS STEEL
10	LUBE ZERK	ANODIZED STEEL

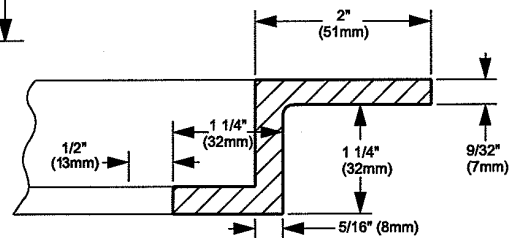
NOTE:
*** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL



GASKET GROOVE,
SECTION B:B



GALVANIZED STEEL
DECK RING



CAST ALUMINUM
DECK RING

HATCH WEIGHTS LBS. (KGMS)	
Model Number	BFHO15X24 TH
Material	AL
Cover	31 (14)
Deck Ring	9 (4.1)

IMPORTANT: WHEN ORDERING,
PLEASE SPECIFY OUTSIDE
DIAMETER (C) OR CLEAR
OPENING (D). UNITS ARE
IDENTIFIED BY CLEAR OPENING.

Model Number	DIMENSIONS INCHES (mm)								
	A	B	C(L)	C(W)	D(L)	D(W)	E	F	G
BFHOTH15X24	5 1/4 (133)	12 1/2 (318)	26 1/2 (673)	17 1/2 (445)	24 (610)	15 (381)	1 1/4 (32)	1/4 (6)	3/8 (9.5)



BAIER FLUSH HATCH
LIFT-OUT DOGGED TYPE WITH
BUILT-IN T-HANDLE
TYPE "C" POSITIVE LOCKING
MODEL BFHOTH15x24

DWG. NO. 500



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HUMCO DECK FITTINGS

Baier T-Handle Strongback Hatches

BFHSQ Series Square - Lift Out

This popular strongback hatch design series adds the convenience of a built-in recessed Stainless Steel T-handle to the flush-mounted, quick release, lift-out hatch. The design is especially popular on aluminum boats, fishing and other workboats, as well as many U.S. Navy and U.S. and Canadian Coast Guard vessels.

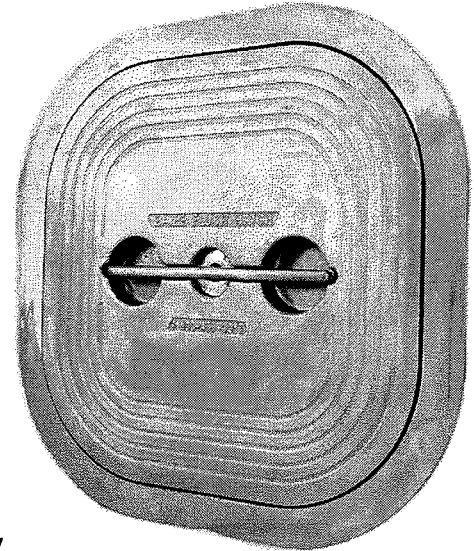
FEATURES

Unique:

- Cast Hatch Cover (unique no grab handles)
- Stainless Steel Centerbolt and hardware
- Built-in Stainless Steel T-Handle used for quick engagement as well as lifting

Shares with Classic HEX-Bolt Series:

- Cast Strongback
- Cast / fabricated matching Deck Ring
- Neoprene Cover Gasket and Washers (Buna-N optional)
- Every unit shipped with an underside escape turning bar for safety
- Turning wheel optional

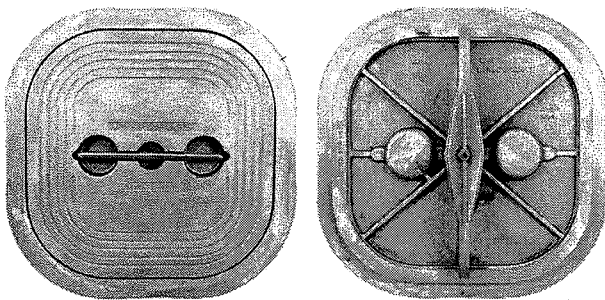


STRENGTH, SIMPLICITY and CONVENIENCE

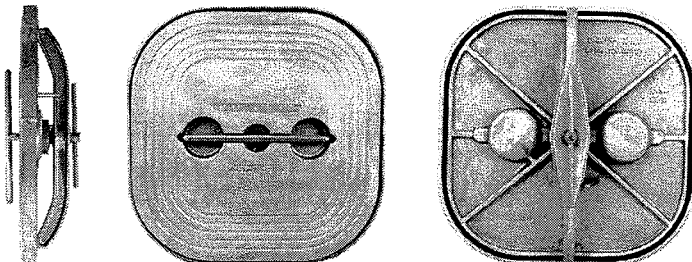
The T-Handle Strongback system has only three moving parts to secure the hatch cover to the deck. Like the Classic HEX it is simple, strong, reliably watertight, infinitely adjustable from topside, and easily serviced (parts are readily available and replaced in the field).

MATERIALS

The T-Handle Strongback square hatch cover product line is available only in cast aluminum. The deck rings used are the same as the Classic HEX and are available in galvanized mild steel (for welding into steel decks), or cast aluminum (for welding into aluminum decks or bolting to fiberglass or wood decks). Stainless deck rings are available by special order.



BFHSQTH24X24A/A with Cast Aluminum Deck Ring



BFHSQTH24X24A/S with Galvanized Steel Deck Ring

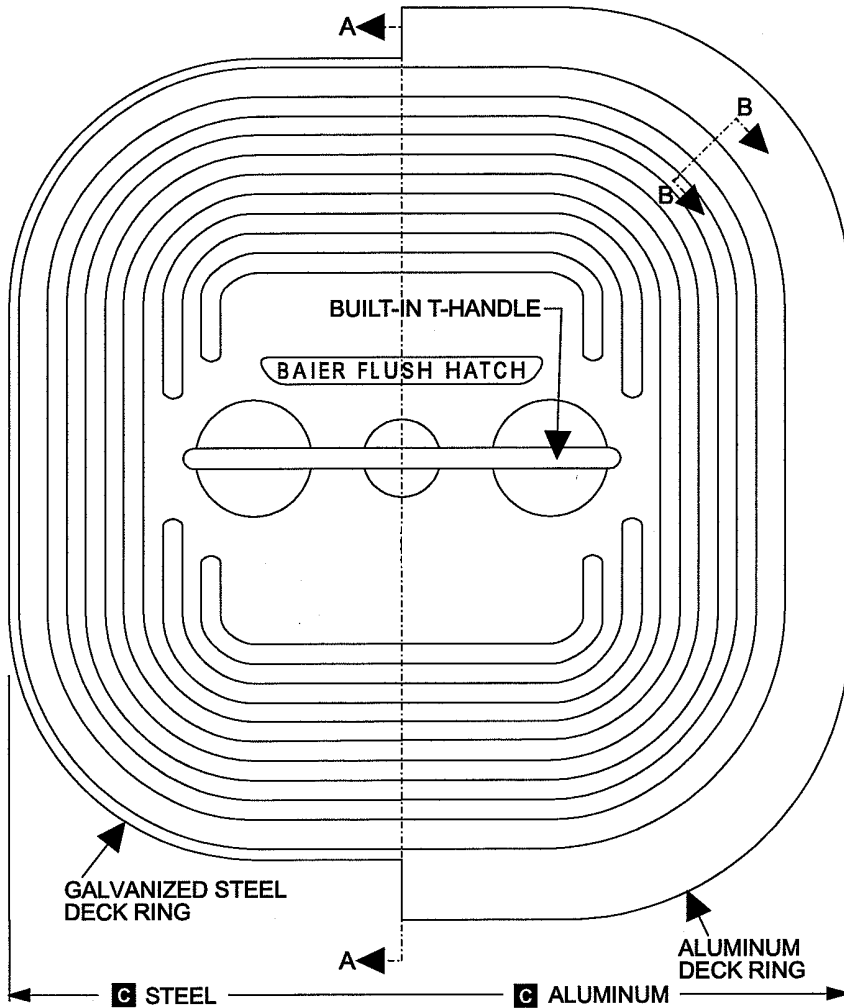
Hatch Model	BFHSQ24X24
Clear (A) Opening	24" x 24" (610 mm x 610 mm)
Cover (B) Dimensions	26" x 26" (660 mm x 660 mm)
Technical Drawing	#700
When ordering, please specify:	
Cover Material: cast aluminum	
Ring Material: cast aluminum or galvanized steel	
Hatch Covers Available Separately	



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HUMCO DECK FITTINGS

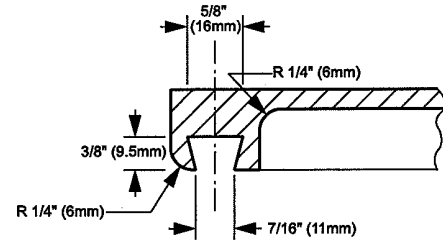
Baier T-Handle Strongback Hatches



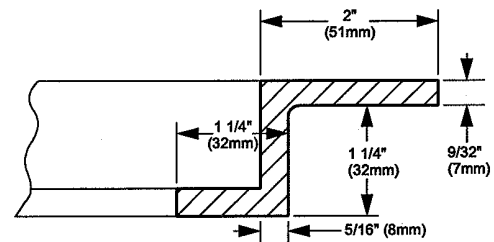
BILL OF MATERIAL: #700

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	ALUMINUM ONLY
2	STRONGBACK	ALUMINUM ONLY
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	T-HANDLE	STAINLESS STEEL
10	LUBE ZERK	ANODIZED STEEL
11	SPRING	STAINLESS STEEL

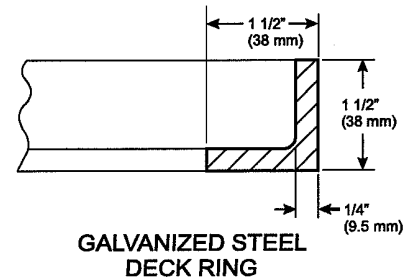
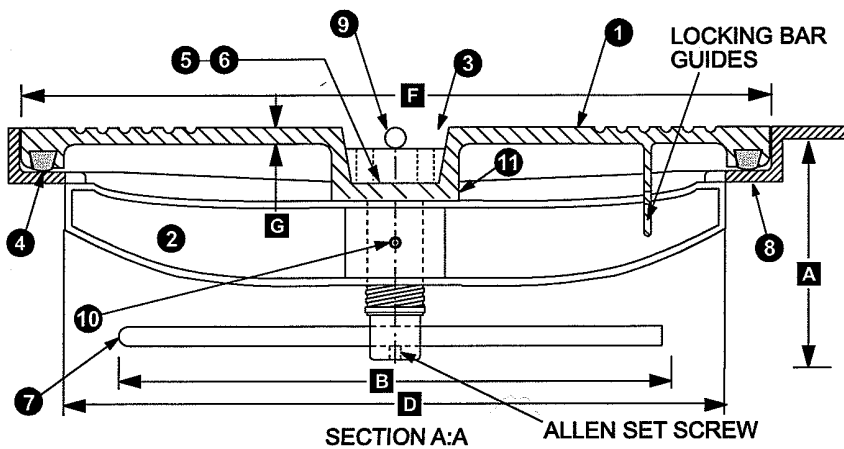
NOTE:
*** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL



GASKET GROOVE,
SECTION B:B



CAST ALUMINUM
DECK RING



HATCH WEIGHTS LBS. (KGMS)	
Model Number	BFHSQTH24X24
Material	AL ST
Cover	50 (22.7) N/A
Deck Ring	12 (5.4) 15 (6.8)

IMPORTANT: WHEN ORDERING,
PLEASE SPECIFY OUTSIDE
DIAMETER (C) OR CLEAR
OPENING (D). UNITS ARE
IDENTIFIED BY CLEAR OPENING.

Model Number	DIMENSIONS INCHES (mm)						
	A	B	C(ST)	C(AL)	D	F	G
BFHSQ24X24	6 (152)	12 1/2 (318)	26 11/16 (677)	30 1/2 (774)	24 (610)	26 (660)	3/8 (9.5)

BAIER FLUSH HATCH
HINGED DOGGED TYPE WITH
BUILT-IN T-HANDLE
TYPE "C" POSITIVE LOCKING
MODEL BFHSQ24X24

DWG. NO. 700



Baier Quick-Acting 4-Dog Hatch

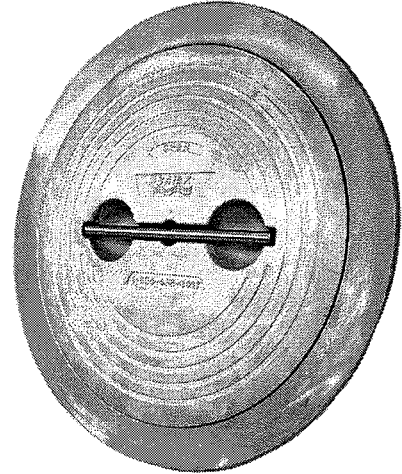
BFHQ Series Round - Lift Out Style

These light-weight, quick-acting 4-dog models are ideal for high-traffic closures where speed and ease are paramount, and/or where positive engagement must be visually verifiable at a glance.

DESIGN

Multi-dog "Cam-Lock" positive engagement locking system features:

- Adjustable Dog Tensioners that provide equal tension on all points, ensure a water-tight seal
- Built-in "Never Lose" handle
- A simple 1/8th-turn of the handle provides smooth, easy and secure engagement
- Thicker Dog Arms for superior strength
- Positive visual verification: When the handle is down, the hatch is secured
- Inside escape bar on all units (optional inside turning wheel available)
- Subtle design improvements make the BFHQ stronger, more water-tight than our competitors' similar units



LIGHTWEIGHT BUT STRONG:

- Cast from high-grade corrosion-resistant 356 aluminum alloy (ASTM B26)
- Maximum durability, stronger deck strength and impact resistance
- Stainless steel T-handle and operating hardware
- Dissimilar metals isolated by neoprene and nylon

WATER-TIGHT:

- Machined surfaces and superior casting processes control tolerances
- Neoprene cover gasket and sealing ring ensure tight seal

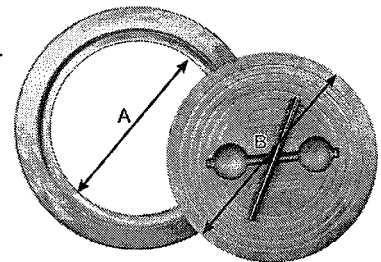
MATERIALS

Currently, the 4-dog BFHQ series hatch cover assemblies are available only in cast aluminum. However, the deck rings for the BFHQ are the same size as the Strongback models, and are available in galvanized mild steel or cast aluminum. Stainless Steel deck rings are available by special order.

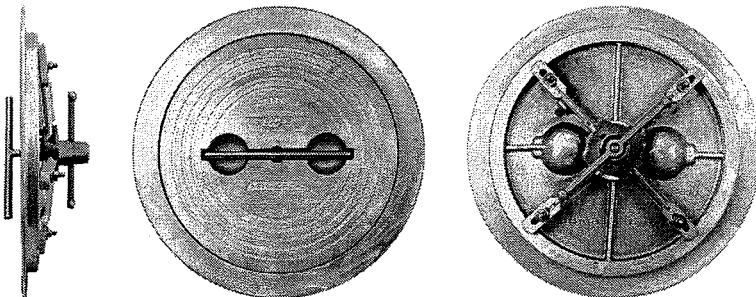
Hatch Model	BFHQTH20
Clear (A) Opening	20" Ø (508 mm) Ø
Cover (B) Diameter	22" Ø (559 mm) Ø
Technical Drawing	#810

When ordering, please specify:

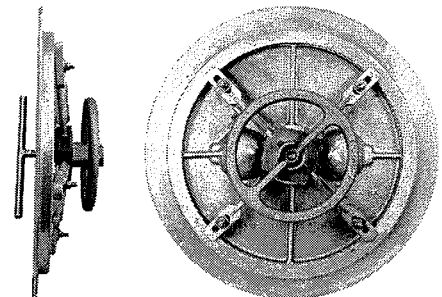
Ring Material:
cast aluminum
or
galvanized steel



Hatch Covers Available Separately



BFHQTH20A/A with Cast Aluminum Deck Ring and Standard Turn-bar



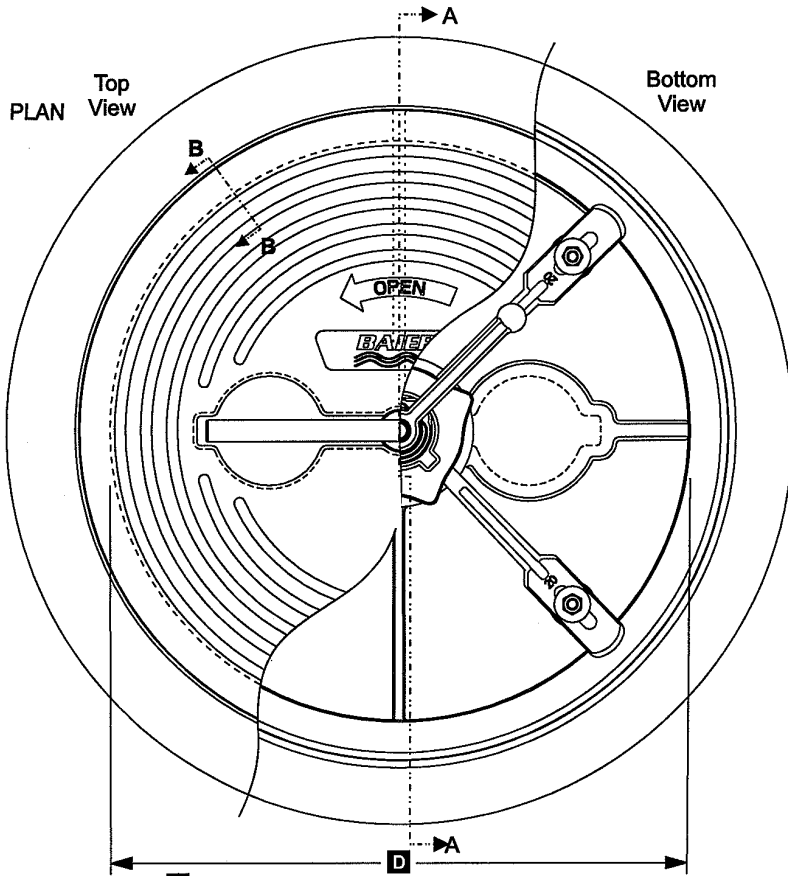
BFHQTH20A/A with Optional Handwheel



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HUMCO DECK FITTINGS

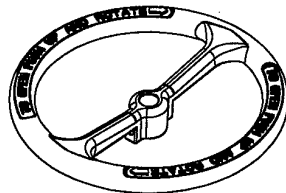
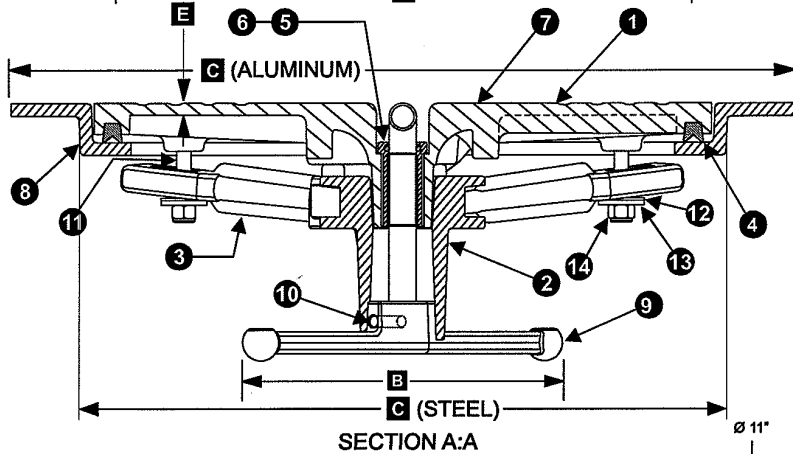
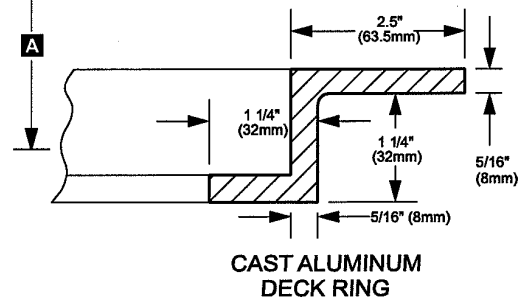
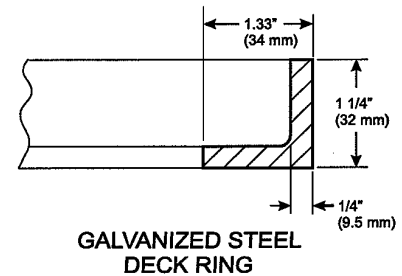
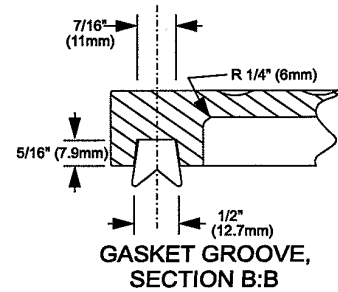
Baier Quick-Acting 4-Dog Hatch



BILL OF MATERIAL: #810

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	ALUMINUM ONLY
2	DOG HUB ASSY	ALUMINIUM
3	DOG ARM	ALUMINIUM
4	GASKET	NEOPRENE
5	BUSHING	S.S. W/ NYLON INSR
6	O-RING	NEOPRENE
7	T-HANDLE	STAINLESS STEEL
8	DECK RING	***
9	ESCAPE HANDLE	ALUMINIUM
10	HANDLE PIN	STAINLESS STEEL
11	THREADED POST	STAINLESS STEEL
12	WASHER	STAINLESS STEEL
13	WASHER	UHMW POLY
14	NYLOCK NUT	STAINLESS STEEL

NOTE: *** CORROSION RESISTANT ALUMINIUM, OR GALVANIZED STEEL



HATCH WEIGHTS LBS. (KGMS)*	
Model Number	BFHQTH20
Material	AL ST
Cover	27 (12.2) N/A
Deck Ring	10 (4.5) 11 (5)

OPTIONAL: ESCAPE HANDWHEEL
(REPLACES ESCAPE HANDLE)

IMPORTANT: WHEN ORDERING, PLEASE SPECIFY
OUTSIDE DIAMETER (C) OR CLEAR OPENING (D).
UNITS ARE IDENTIFIED BY CLEAR OPENING.

Model Number	DIMENSIONS INCHES (mm)					
	A	B	C (ST)	C (AL)	D	E
BFHQTH20	7 1/16 (179)	12 (305)	22 11/16 (576)	27 3/16 (691)	20 (508)	5/16 (8)



BAIER FLUSH HATCH

LIFT-OUT MULTI-DOGGED TYPE
WITH BUILT-IN T-HANDLE
TYPE "D" QUICK ACTING
POSITIVE LOCK
MODEL BFHQTH20

DWG. NO.810



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HUMCO DECK FITTINGS

Baier Quick-Acting 4-Dog Hatch

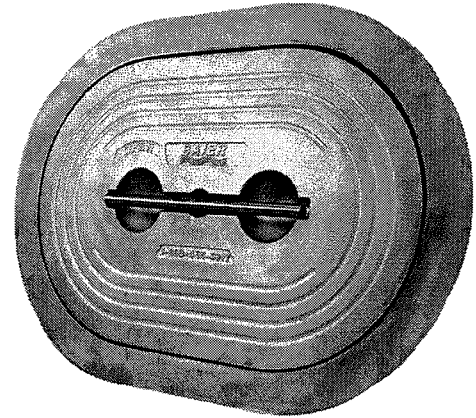
BFHQ Series Oval - Lift Out Style

These light-weight, quick-acting 4-dog models are ideal for high-traffic closures where speed and ease are paramount, and/or where positive engagement must be visually verifiable at a glance.

DESIGN

Multi-dog "Cam-Lock" positive engagement locking system features:

- Adjustable Dog Tensioners that provide equal tension on all points, ensure a water-tight seal
- Built-in "Never Lose" handle
- A simple 1/8th-turn of the handle provides smooth, easy and secure engagement
- Thicker Dog Arms for superior strength
- Positive visual verification: When the handle is down, the hatch is secured
- Inside escape bar on all units (optional inside turning wheel available)
- Subtle design improvements make the BFHQ stronger, more water-tight than our competitors' similar units



LIGHTWEIGHT BUT STRONG:

- Cast from high-grade corrosion-resistant 356 aluminum alloy (ASTM B26)
- Maximum durability, stronger deck strength and impact resistance
- Stainless steel T-handle and operating hardware
- Dissimilar metals isolated by neoprene and nylon

WATER-TIGHT:

- Machined surfaces and superior casting processes control tolerances
- Neoprene cover gasket and sealing ring ensure tight seal

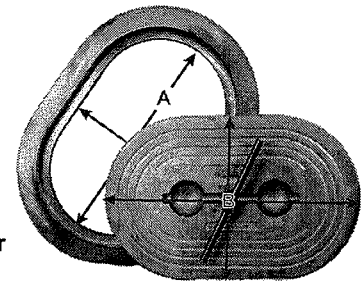
MATERIALS

Currently, the 4-dog BFHQ series hatch cover assemblies are available only in cast aluminum. However, the deck rings for the BFHQ are the same size as the Strongback models, and are available in galvanized mild steel or cast aluminum. Stainless Steel deck rings are available by special order.

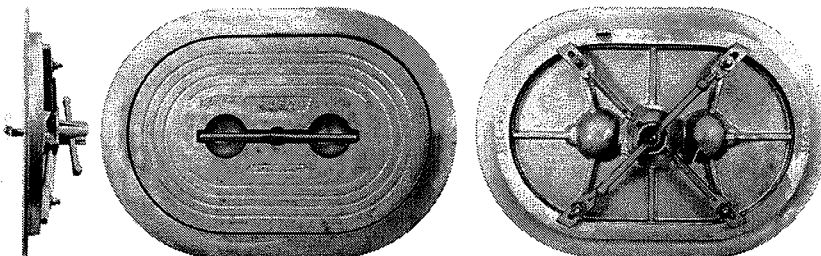
Hatch Model	BFHQTH15x24
Clear (A) Opening	15" x 24" (381 mm x 610 mm)
Cover (B) Dimensions	17" x 26" (432 mm x 660 mm)
Technical Drawing	#800

When ordering, please specify:

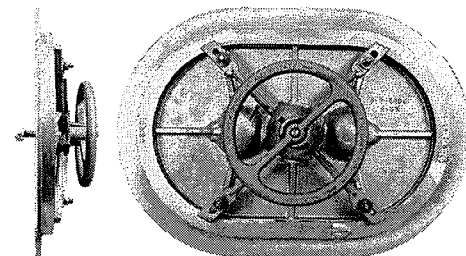
Ring Material:
cast aluminum or galvanized steel



Hatch Covers Available Separately



BFHQTH15X24A/A with Cast Aluminum Deck Ring and Standard Turn-bar



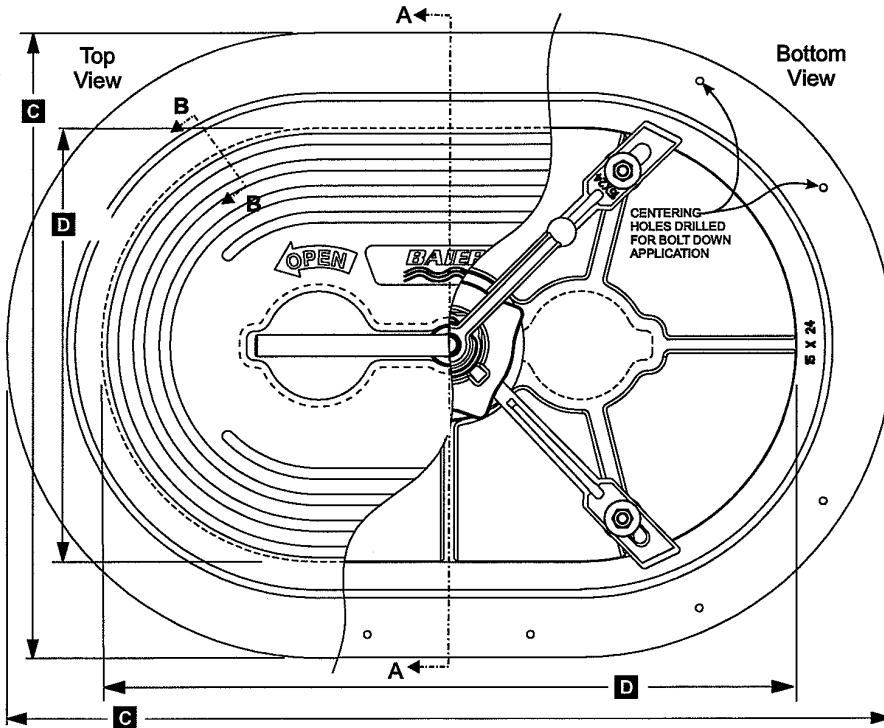
BFHQTH15X24A/A with Optional Handwheel



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HUMCO DECK FITTINGS

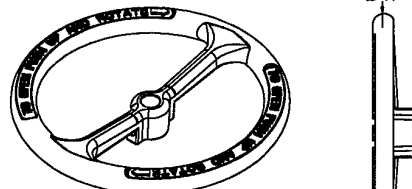
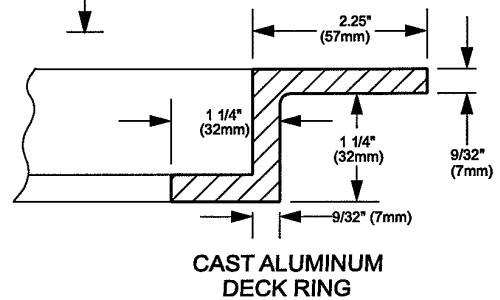
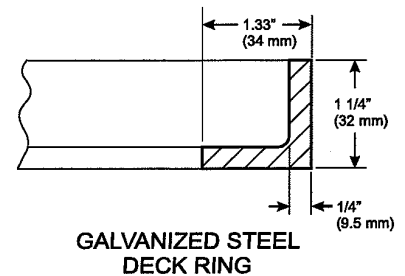
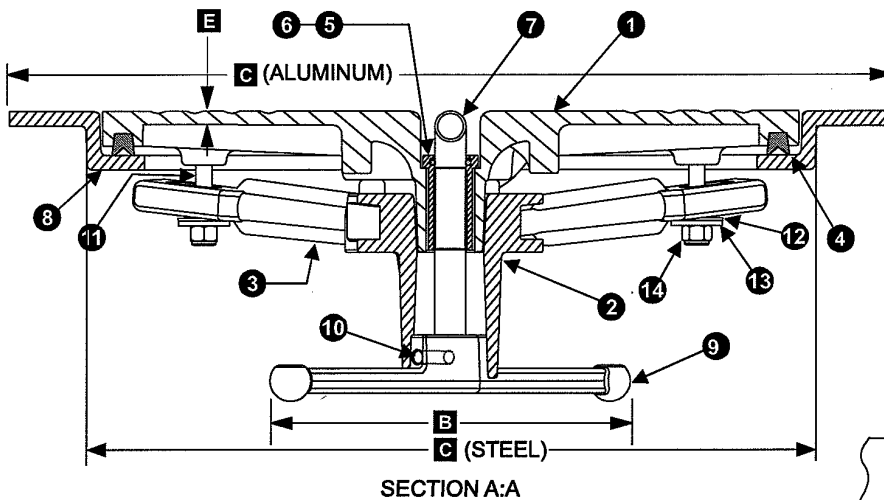
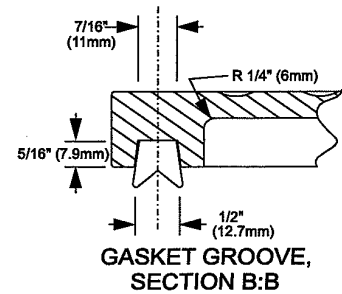
Baier Quick-Acting 4-Dog Hatch



BILL OF MATERIAL: #800

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	ALUMINUM ONLY
2	DOG HUB ASSY	ALUMINIUM
3	DOG ARM	ALUMINIUM
4	GASKET	NEOPRENE
5	BUSHING	S.S. W/ NYLON INSR
6	O-RING	NEOPRENE
7	T-HANDLE	STAINLESS STEEL
8	DECK RING	***
9	ESCAPE HANDLE	ALUMINIUM
10	HANDLE PIN	STAINLESS STEEL
11	THREADED POST	STAINLESS STEEL
12	WASHER	STAINLESS STEEL
13	WASHER	UHMW POLY
14	NYLOCK NUT	STAINLESS STEEL

NOTE: *** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL



OPTIONAL ESCAPE HANDWHEEL (REPLACES ESCAPE HANDLE)

IMPORTANT: WHEN ORDERING, PLEASE SPECIFY OUTSIDE DIAMETER (C) OR CLEAR OPENING (D). UNITS ARE IDENTIFIED BY CLEAR OPENING.

HATCH WEIGHTS LBS. (KGMS)*	
Model Number	BFHQTH15X24
Material	AL ST
Cover	25.8 (11.7) N/A
Deck Ring	9 (4.1) 12 (5.4)

Model Number	DIMENSIONS INCHES (mm)					
	A	B	C (AL)	C (ST)	D	E
BFHQTH15X20	7 1/16 (179)	12 (305)	30 7/16 x 21 7/16 (777 x 548)	26 1/2 x 17 1/2 (673 x 445)	24 x 15 (610 x 381)	1/4 (6)
BFHQTHF15X20 (Cover Assembly Only)	7 1/16 (179)	12 (305)	N/A	N/A	N/A	1/4 (6)



BAIER FLUSH HATCH

LIFT-OUT MULTI-DOGGED TYPE WITH BUILT-IN T-HANDLE TYPE "D" QUICK ACTING POSITIVE LOCK MODEL BFHQTH15X24

DWG. NO. 800



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 Phone: 1-800-381-9968

HUMCO DECK FITTINGS

Baier Coaming Options

COAMINGS

Baier coamings are available in various heights for any of our three lines of flush hatches. Coamings are available for both our lift-out and hinged model hatches. All Coamings are fabricated from mild steel, welded to a galvanized steel deck ring, primed and painted.

COAMING HEIGHTS

Standard height coamings are: 6" 12" 18" 24"
 Custom heights available – Please allow 6-10 working days.

Baier stocks steel coamings for the following hatches:

CLASSIC HEX-BOLT STYLE

BFHR14	BFHR14S	BFHHR22A	BFHHR22S
BFHR16	BFHR14S	BFHO15X24A	BFHO15X24S
BFHR18	BFHR14S	BFHHO15X24A	BFHHO15X24S
BHFR20	BFHR14S		
BFHR24	BFHR14S		

T-HANDLE STRONGBACK STYLE

BFHRTH8A	BFHOTH15X24A	BFHSQ24X24A
BFHRTH20A	BFHHOTH15X24A	NFHHSQ24X24A

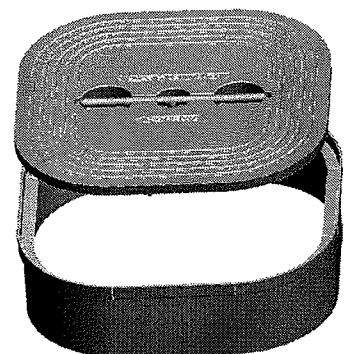
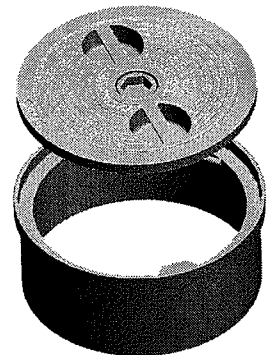
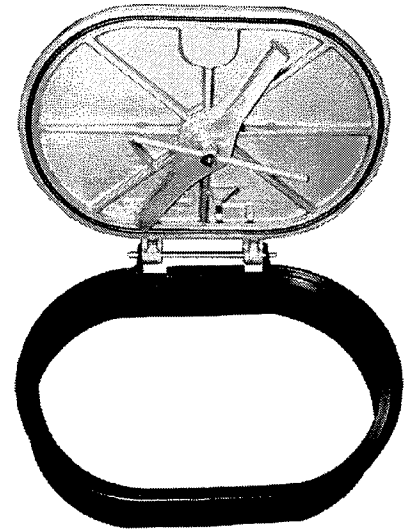
QUICK ACTING 4-DOG STYLE

BFHQA20A	BHFQA15X24A
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STANDARD SIZES:

Several styles and sizes are listed as standard hatch assembly models complete with coaming.

	Aluminum Cover	Steel Cover
6"	BCHHR22A/6S	BCHHR22S/6S
12"	BCHHR22A/12S	BCHHR22S/12S
18"	BCHHR22A/18S	BCHHR22S/18S
24"	BCHHR22A/24S	BCHHR22S/24S
6"	BCHHO15X24A/6S	BCHHO15X24S/6S
12"	BCHHO15X24A/12S	BCHHO15X24S/12S
18"	BCHHO15X24A/18S	BCHHO15X24S/18S
24"	BCHHO15X24A/24S	BCHHO15X24S/24S

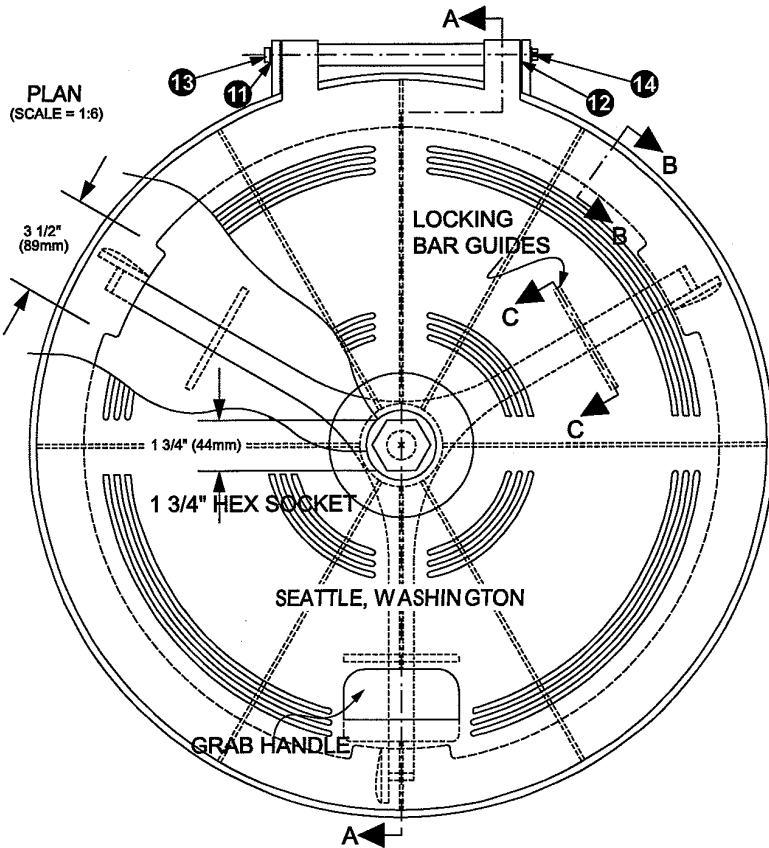




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HUMCO DECK FITTINGS

Baier Round Coaming Hatch

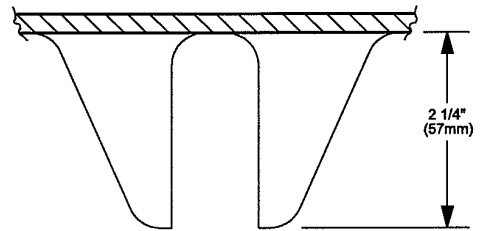


BILL OF MATERIAL: #627

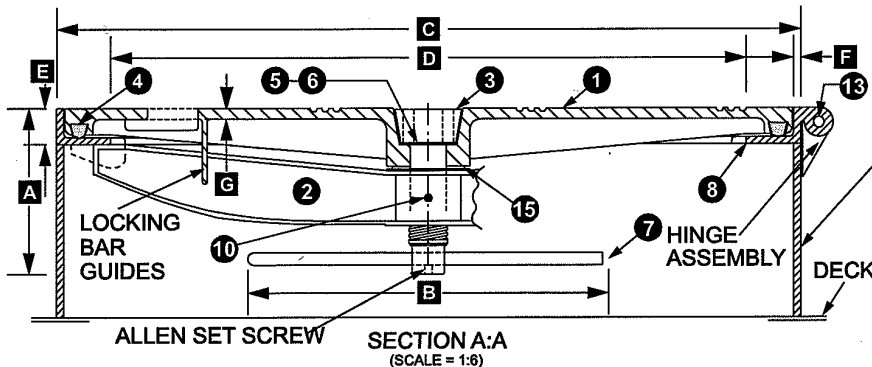
PC.NO.	DESCRIPTION	MATERIAL
1	COVER	***
2	SPIDER	***
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	WRENCH	GALVANIZED STEEL
10	LUBE ZERK	ANODIZED STEEL
11	WASHER	STAINLESS STEEL
12	WASHER	STAINLESS STEEL
13	HING PIN	STAINLESS STEEL
14	COTTER PIN	STAINLESS STEEL
15	SPRING	STAINLESS STEEL

NOTE:
*** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL

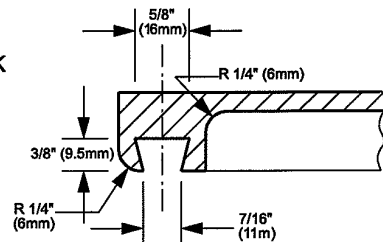
IMPORTANT: WHEN ORDERING, PLEASE SPECIFY
OUTSIDE DIAMETER (C) OR CLEAR OPENING (D).
UNITS ARE IDENTIFIED BY CLEAR OPENING.



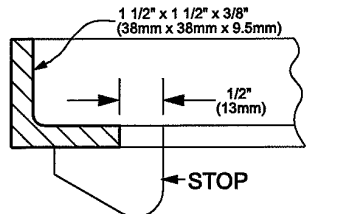
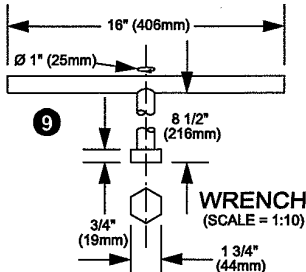
LOCKING BAR GUIDES,
SECTION C:C
(SCALE = 1:2)



COAMINGS AVAILABLE IN:
6" (152mm), 12" (305mm),
18" (457mm), or 24" (610mm)
HEIGHTS



GASKET GROOVE,
SECTION B:B
(SCALE = 1:2)



GALVANIZED STEEL DECK RING
(EXCEPT HINGE)
(SCALE = 1:2)

HATCH WEIGHTS LBS. (KGMS)*	
Model Number	BCHHR22
Material	AL ST
Cover	37 (16.8) 99 (44.8)
Deck Ring	N/A 11(5)

NOTE: * EXCLUDES COAMING

Model Number	DIMENSIONS (mm)						
	A	B	C	D	E	F	G
BCHHR22	5 3/4 (146)	12 1/2 (318)	25 1/2 (648)	22 (559)	1 1/4 (32)	1/4 (6)	3/8 (9.5)



BAIER COAMING HATCH
HINGED DOGGED TYPE WITH
GRAB HANDLES
TYPE "C" POSITIVE LOCKING
MODEL BCHHR22

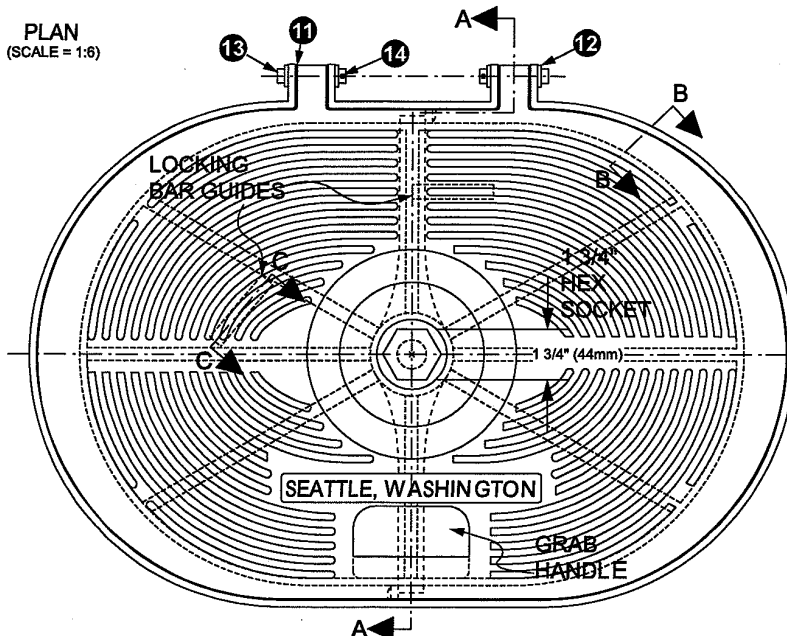
DWG. NO. 627



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Phone: 1-800-381-9968

HUMCO DECK FITTINGS

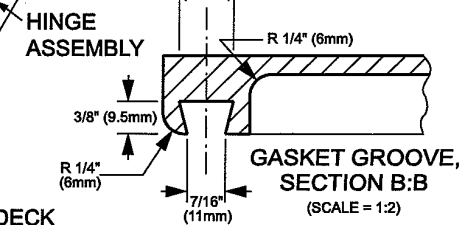
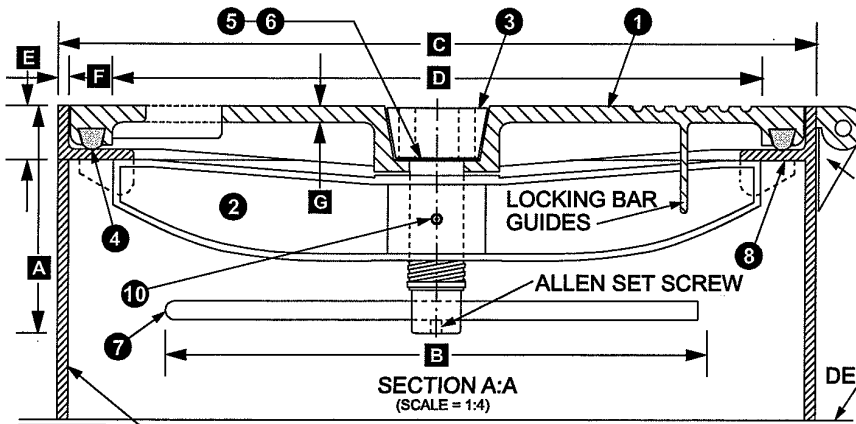
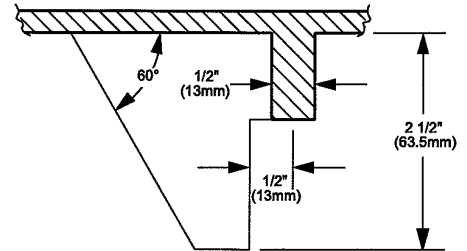
Baier 15 x 25 Coaming Hatch



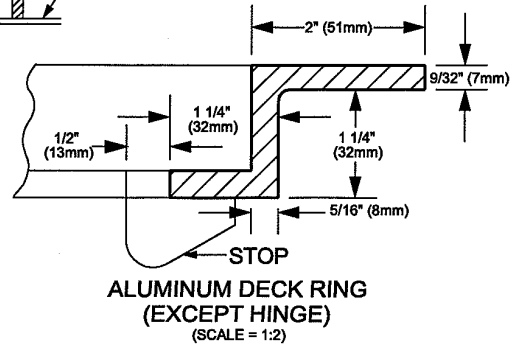
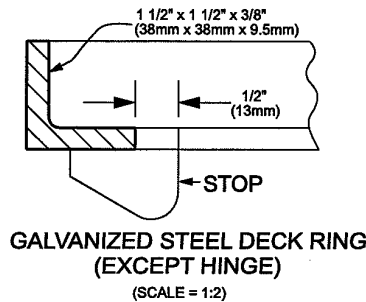
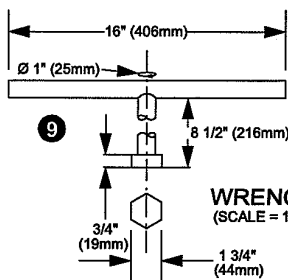
BILL OF MATERIAL: #542-1

PC.NO.	DESCRIPTION	MATERIAL
1	COVER	***
2	SPIDER	***
3	BOLT (1 1/2" Ø)	STAINLESS STEEL
4	GASKET	NEOPRENE
5	WASHER	STAINLESS STEEL
6	WASHER	NEOPRENE
7	ROD (1/2" Ø)	GALVANIZED STEEL
8	DECK RING	***
9	WRENCH	GALVANIZED STEEL
10	LUBE ZERK	ANODIZED STEEL
11	WASHER	STAINLESS STEEL
12	WASHER	STAINLESS STEEL
13	HINGE PIN	STAINLESS STEEL
14	COTTER PIN	STAINLESS STEEL

NOTE:
*** CORROSION RESISTANT ALUMINUM, OR GALVANIZED STEEL



COAMINGS AVAILABLE IN:
6" (152mm), 12" (305mm),
18" (457mm), or 24" (610mm)
HEIGHTS



11

HATCH WEIGHTS LBS. (KGMS)*

Model Number	BCHHO15X24
Material	AL ST
Cover	31 (14) 79 (35.8)
Deck Ring	9 (4.1) 12 (5.4)

NOTE: * EXCLUDES COAMING

IMPORTANT: WHEN ORDERING, PLEASE SPECIFY
OUTSIDE DIAMETER (C) OR CLEAR OPENING (D).
UNITS ARE IDENTIFIED BY CLEAR OPENING.

DIMENSIONS INCHES (mm)

Model Number	A	B	C(L)	C(W)	D(L)	D(W)	E	F	G
BCHHO15X24	5 1/4 (133)	12 1/2 (318)	26 1/2 (673)	17 1/2 (445)	24 (610)	15 (381)	1 1/4 (32)	1/4 (6)	3/8 (9.5)

BAIER

BAIER COAMING HATCH
HINGED DOGGED TYPE WITH
GRAB HANDLES
TYPE C POSITIVE LOCKING
MODEL BCHHO15X24

DWG. NO. 542-1

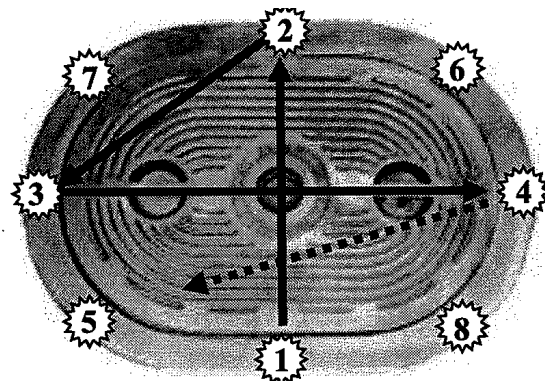
WELDING INSTALLATION TIPS FOR FLUSH-HATCH DECK RINGS

Your **Baier Hatch**, with its unique design, is simple and easily-serviceable. Proper installation will ensure the integrity of the hatch and provide you with long lasting and reliable operation. *Two things we want to prevent are deck-ring cracking and also deck ring distortion, since these will not allow a positive weather-tight seal.*

1. POSITION the HATCH. It is important to install the hatch ring in proper alignment into its location. The ring must remain flat in all applications for the gasket to form a good seal. To find the cut out dimension for your specific hatch, please call Humco.

2. TACK-WELD the DECK RING in a "STAR" SEQUENCE. From below deck, after positioning the ring, uniformly tack-weld the ring to the deck with 1" or shorter welds. These welds *must* be made in the sequence shown here to avoid heat-distortion.

Start your short tack-welds at position #1 (see right). Then tack-weld at position #2 across from #1. Tack at position #3 and so on. Continue tack welding, as far as possible from the last tack and in the order shown at right. Also see note at bottom: BLANK COVER



Tack-weld in a "Star" sequence.

This diagram is an example only — to demonstrate the principle.
Each size hatch will vary.

Heat build-up caused by weld-filling a gap can cause the ring to distort. Tack-welding, a necessary preliminary step in installation of your hatch, performed correctly, can help achieve optimal results from the final weld and can prevent distortion. Each tack should be 1" or less. Tack-welding is complete when the welds are 6" apart along the entire perimeter of the ring. This alternating spacing is critical to prevent distortion of the ring.

3. SKIP-WELD OUTER EDGE of DECK RING to DECK from topside — also using a "star" pattern with your skip-welds to minimize heat-generated distortion. Fully weld the perimeter of the ring on top using skip welds. Many shops will also completely weld the underside of the deck ring as well to ensure deck integrity.

Further NOTES and TIPS:

- Let ring and deck cool naturally. Do not quench with cool water.
- **ALUMINUM RING REPAIR:** If aluminum deck ring should crack for any reason, notch out the crack and use ER 4043 MIG welding wire to effect a repair. The ring is cast from ASTM-B26 Alloy 356 aluminum and will not respond well to a harder (e.g. ER 5356) welding wire which you might be using on deck plate.
- **BLANK COVER:** Some builders will use a "blank" hatch cover with the neoprene outer gasket removed to clamp into the deck ring and keep the ring flatter while it is being tacked into the deck cutout.



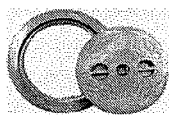

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HUMCO DECK FITTINGS

Baier Flush Hatch Product Matrix



BAIER FLUSH HATCH PRODUCT MATRIX

	LIFT-OUT	HINGED	CENTERBOLT STYLE 		BUILT-IN T-HANDLE STYLE 			DECK RING OPTIONS			COAMINGS		
			HEX		STRONGBACK		QA 4-DOG		MATERIAL				
			L-O	HNGD	AL	ST	AL	ST	AL	ST		/A	/S
OVALS													
15 X 24	L-O		BFHO15X24A	BFHO15X24S	BFHOTH15X24A		BFHQA15X24A			/A	/S	/SS	<input type="checkbox"/>
15 X 24		HNGD	BFHHO15X24A	BFHHO15X24S	BFHHOTH15X24A					/A	/S	/SS	<input type="checkbox"/>
ROUNDS													
8	L-O				BFHRTH8A					/A	/S	/SS	<input type="checkbox"/>
14	L-O		BFHR14A	BFHR14S						/A	/S	/SS	<input type="checkbox"/>
16	L-O		BFHR16A	BFHR16S						/A	/S	/SS	<input type="checkbox"/>
18	L-O		BFHR18A	BFHR18S						/A	/S	/SS	<input type="checkbox"/>
20	L-O		BFHR20A	BFHR20S	BFHRTH20A		BFHQA20A			/A	/S	/SS	<input type="checkbox"/>
22		HNGD	BFHHR22A	BFHHR22S						/A	/S		<input type="checkbox"/>
24	L-O		BFHR24A	BFHR24S						/A	/S	/SS	<input type="checkbox"/>
SQUARES													
24 X 24	L-O				BFHSQ24X24A					/A	/S	/SS	<input type="checkbox"/>
		HNGD			BFHHSQ24X24A					/A	/S		<input type="checkbox"/>

COAMING MODEL HEIGHTS for 15X24:

6"	BCHHO15X24A/6S	BCHHO15X24S/6S
12"	BCHHO15X24A/12S	BCHHO15X24S/12S
18"	BCHHO15X24A/18S	BCHHO15X24S/18S
24"	BCHHO15X24A/24S	BCHHO15X24S/24S

<< COAMINGS available standard heights: 6" 12" 18" 24" >>

COAMING MODELS 22" RND:

6"	BCHHR22A/6S	BCHHR22S/6S
etc	etc	etc

NOTE: MORE COAMINGS AVAILABLE ON MANY SIZES - CALL FOR QUOTATION