

SERVICE PLATE INSTALLATION

TOOLS NEEDED

3/8" & 1/8" Drill Bit
9/16" Socket w/ Ratchet
9/16" Wrench
Clamps
Drill & Cutoff Wheel

HARDWARE SUPPLIED

3/8"-16 x 1" Bolts
3/8"-16 Nuts
3/8" Washers

Kit #: 21700145

1. Remove huck fastener by either grinding the head off or cutting with a cutoff wheel. Use caution to prevent gouging or grinding the frame rail.
2. Stop drill ends of cracks using a 1/8" drill bit (Figure 1).
3. Clamp the service plate to the frame and attempt to center (Figure 2) with the fastener hole in the rail. Some applications may require the service plate to be off center (Figure 3 & 4) depending on location of spring hangers.
4. Some applications may require temporary removal of tank hanger self tapping screws if they interfere with the service plate.
5. With the plate clamped to the frame, match drill the crossmember fastener hole from the inside of the frame.
6. Match drill the six rail mounting bolt holes from the outside of the frame.
7. Attach the service plate to the frame rail using the supplied fasteners and torque to 30 ft*lbs.
8. Reinstall self tapping screws if removed.

Figure 1

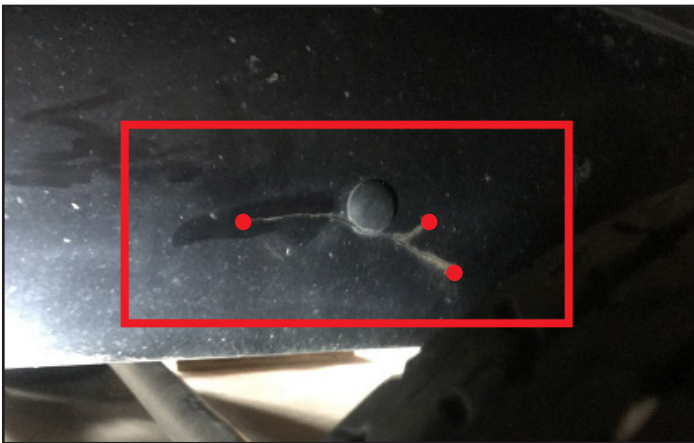


Figure 2

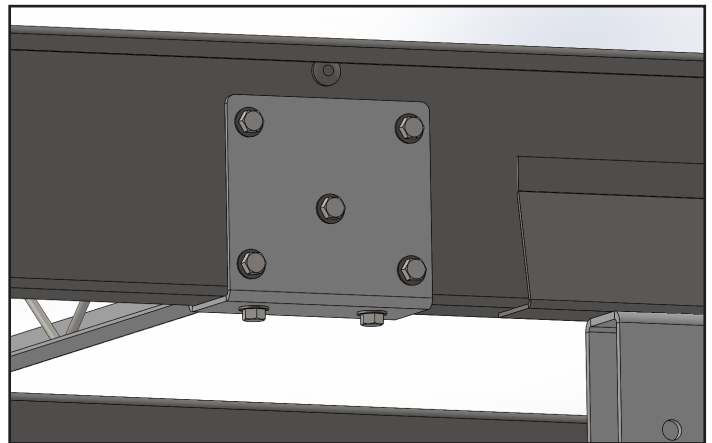


Figure 3

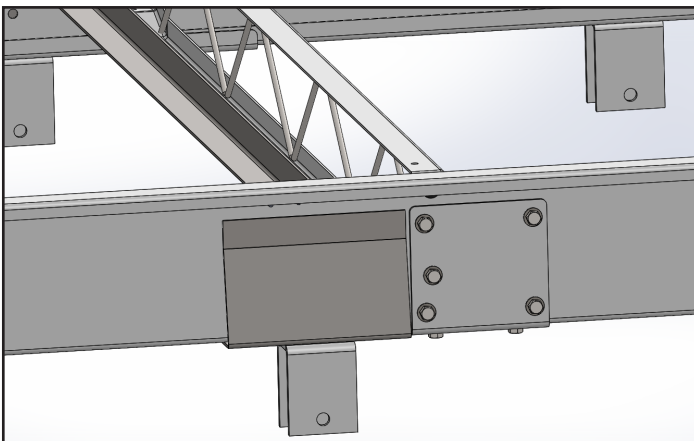


Figure 4

