

# MOUNTING KIT

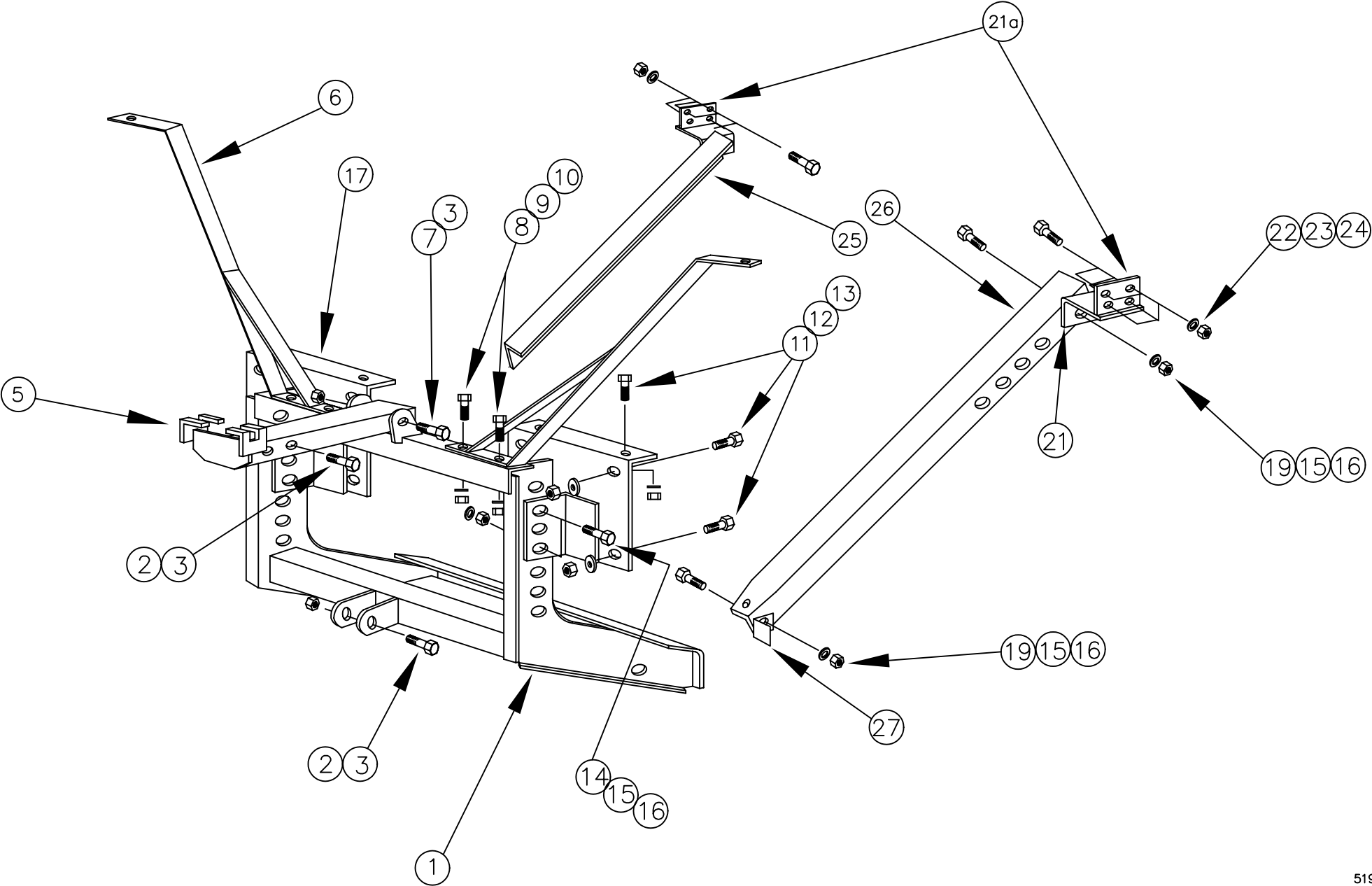
Heavy Trucks, Frame Supported, Low Profile

## 51957-M

# MOUNTING KIT

Heavy Trucks, Frame Supported, Low Profile

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Heavy Trucks Mounting Kit 51957-M			
Item	Part Number	Description	Qty
1	51916-E	Lift Frame	1
2	HH-00972-190	1"x4.1/2" Capscrew	2
3	HH-00540-009	1" Locknut	3
5	51109-B	Lift Channel	1
6	51920-C	Light Support	2
7	HH-00972-191	1"x5" Capscrew	1
8	HH-00972-128	5/8"x1.1/2" Capscrew	4
9	HH-00457-003	5/8" Lockwasher	4
10	HH-00460-001	5/8" Hex Nut	4
11	HH-00972-090	1/2"x1.1/2" Capscrew	12
12	HH-00457-001	1/2" Lockwasher	12
13	HH-00460-002	1/2" Hex Nut	12
14	HH-00972-181	1"x2" Capscrew	4
15	HH-00457-009	1" Lockwasher	8
16	HH-00460-010	1" Hex Nut	8
17	51945-C	Bumper Bracket	2
19	HH-00972-181	1"x2" Capscrew	4

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Item	Part Number	Description	Qty
21a	51213-01-B	Thrust Arm Mounting Bracket Top	
21	51213-B	Thrust Arm Mounting Bracket	2
22	HH-00972-147	3/4"x2" Capscrew	6
23	HH-00457-008	3/4" Lockwasher	6
24	HH-00540-003	3/4" Hex Nut	6
25	51212-B	Thrust Arm Curb Side	1
26	51211-B	Thrust Arm Driver Side	1
27	51214-A	Mounting Clip	2
28	HH-00293-006	1/4"x1" UNC Capscrew	4
29	HH-00457-006	1/4" Lockwasher	4
30	HH-00341-002	1/4" Flatwasher	4
31	HH-00294-001	1/4" UNC Hexnut	4

This mounting kit is designed to be adapted to most single axle or tandem axle trucks. The following instructions are general guides. Installation will require drilling and in some cases alteration to the parts to provide the necessary clearances.

GENERAL

**Customer must be aware of following:**

Arctic Equipment Manufacturing Limited (Arctic) does not assume liability for damage to your motor vehicle resulting from the attachment or use of an Arctic snowplow. The purchaser assumes all vehicle risk associated with the attachment and

operation of this snowplow.

The Arctic snowplow you purchase must be used only on vehicles equipped with the manufacturer's snow plow preparation packages. Snow plowing without the original plow preparation package may damage your vehicle. The added weight may impair the operation and control of your vehicle. Snow plowing with a vehicle not recommended for that purpose by the manufacturer may void your new vehicle warranty. If your vehicle is not equipped with an original snow plow preparation package, additional equipment may be necessary before snow plowing. Please consult your vehicle and snowplow dealers prior to the purchase and installation of the snowplow. The installation of such parts however is not a full substitute for the original equipment snowplow preparation package.

CAUTION: Always disconnect battery before beginning installation.

Before drilling holes in vehicle firewall or frame, move brake lines and electrical wiring from path of drill. Brake lines must be clear of fasteners.

All bolts have to be inserted from the inside of the truck so that lockwashers and nuts are accessible for retightening.

If slotted hole in vehicle frame is used, put flatwasher under the bolt head. Never use flatwashers under lockwashers.

Do not tighten bolts and nuts until all fasteners are in place and installation is complete, unless otherwise specified.

Read installation instructions before proceeding.

#### INSTALLATION INSTRUCTIONS

1. With the bumper mounting brackets (17) mounted to the lift frame (1), centre the lift frame on the truck bumper. Using six prepunched holes in each bumper bracket as a guide, drill twelve 9/16" holes through the bumper. Location of the prepunched holes in some trucks may interfere with bumper mounts. If this is the case, new holes will have to be drilled in the bumper mounting brackets. If the bumper is contoured, flatwashers used as shims will have to be placed between the bumper and bumper mounting brackets. Install the bolts, lockwashers and nuts and tighten.

2. At this point it will be necessary to measure the lift frame height. The distance between the centre line of the A-frame mounting holes and the ground should be  $15" \pm 1"$ . If necessary, adjust the lift frame height using the prepunched holes in the lift frame main plates. When completed tighten the four 1"x2.1/2" bolts. It is desirable that the bolts be spaced with one hole between them as shown on the diagram.
3. Locate the thrust arm mounting brackets (21) on the truck frame, choosing a position that is clear of engine mounts, brake lines or other obstructions. Clamp the mounting brackets to the chassis and check that the thrust arms have adequate clearance to avoid interfering with the steering and suspension components. Keep in mind that the thrust arms will be attached to the lift frame by means of the mounting clips (27).
4. After determining a suitable position for the mounting brackets, mark and drill three 13/16" holes per side.  
NOTE: Before drilling, check the inside of the frame for brake lines, wiring, etc.

Install and fasten the brackets with the proper hardware as shown on the diagram.

5. With the mounting clips loosely mounted to the thrust arms, position the thrust arm such that the mounting clip is flush against the lift frame rear plate and that a thrust arm mounting hole is aligned with the frame mounting plate hole. Insert a 1"x2" bolt through the thrust arm and mounting plate and tighten by hand. With the thrust arm in place, mark the position of the mounting clip on the lift frame rear plate.  
NOTE: Make sure the spacing between the thrust arms at the lift frame is the same as that at the frame mounting brackets. If other than the end hole is used, excess material should be cut off.
6. Once positioned, weld the mounting clips to the lift frame rear plate with a 1/4" weld, all around, minimum.
7. Mount the light support brackets as shown in the diagram using the appropriate hardware and tighten.
8. Bolt the lift channel and hydraulic cylinder to the lift frame using the appropriate 1" fasteners.  
NOTE: Do not over tighten the bolt assemblies in Step 8, as this will limit the pivoting actions of the components.
9. Check all bolt assemblies to make sure they are tight.