**LIFT BRACKET INSTALLATION**

**ASSEMBLY PROCEDURE**

1. **PREPARE THE SEAM SURFACE**
   - Refuse to show all details of attaching and weld as indicated by the shaded area.
   - Remove the excess.

2. **WELDING THE SEPARK BODY**
   - Work or score a line through the center of the small oval, left of the convergence of the small oval and small oval, at 30 degrees to both sides, and parallel to the bottom line of the seam.

3. **INSTALLING THE LIFT BRACKET**
   - Locate lift bracket (item 6, item 7 or item 9) to laminae using one (1) 0.5 diameter rivet or bolt (item 8) below laminae and to brackets (item 10) using one (1) 0.5 diameter rivet or bolt (item 11) below brackets and parallel to the top line of the seam.

4. **PROTECT THE LIFT BRACKET**
   - Wrap the lift bracket, repair the small oval, and bend the lift bracket to brackets, as indicated by the shaded area.

5. **REPLACE THE LIFT BRACKET**
   - Replace the lift bracket by welding the large oval into the bracket to the seam, into a 0.5 diameter rivet or bolt (item 12) below brackets, and parallel to the top line of the seam. The lift bracket is then put into the small oval.

6. **INSTALLING THE LIFT BRACKET**
   - Fasten the lift bracket (item 6, item 7 or item 9) to the laminae using one (1) 0.5 diameter rivet or bolt (item 8) below laminae and to brackets (item 10) using one (1) 0.5 diameter rivet or bolt (item 11) below brackets and parallel to the top line of the seam.

7. **FINAL PASS**
   - After the lift bracket (item 6, item 7 or item 9) is installed, the lift bracket is then put into the small oval.

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**STEPS 1 & 2**

- Prepare the seam surface.
- Welding the separations body.
- Installing the lift bracket.

**STEPS 3 & 4**

- Protecting the lift bracket.
- Replacing the lift bracket.

**STEPS 5 & 6**

- Installing the lift bracket with a final pass.
- Final pass.

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**DETAIL E**

- Small slot weld.
- Full suit correctly.

**DETAIL F**

- Triple-pass weld sequence.

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**SECTION B-B**

- See detail F.

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**STEP 1**

FRONT BRACKET ASSEMBLY PROCEDURE

1. Position the front bracket in place, making sure that all mounting holes in the bracket are aligned with holes in the frame bracket.

2. Insert the mounting bolts into the mounting holes and tighten the nuts until the bracket is securely fastened to the frame bracket.

3. Ensure all mounting bolts are tightened securely.

**STEP 2**

MODIFICATIONS NECESSARY IF FRAME BRACKETS ARE NOT EQUIPPED WITH MOUNTING HOLES

1. Position the front bracket in place, making sure that all mounting holes are aligned with holes in the frame bracket.

2. Insert the mounting bolts into the mounting holes and tighten the nuts until the bracket is securely fastened to the frame bracket.

3. Ensure all mounting bolts are tightened securely.

**STEP 3**

- Ensure all mounting bolts are tightened securely.

**STEP 4**

HOLE LOCATIONS

- 2x (1/8)
- 4x (3/32)
- 6x (3/32)
- 4x (1/8)

ALTERNATE INSTALLATION:

- UNDER BUMPER LIFT

- UNDER BUMPER BOLT

- UNDER BUMPER WELD

- UNDER BUMPER SCREW

- UNDER BUMPER NUT

- UNDER BUMPER WRENCH

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