



**INSTALLATION
&
PARTS MANUAL**

FOR

MOUNTING PACKAGES

99100115 - 25 Series Plows

99100116 - 15 & 24 Series Plows

PLOW SERIAL NUMBERS

(8000 — 15000)

FOR

MOUNTING AUXILIARY LIGHT PACKAGES

99100001

99100198



1. THINK SAFETY, ALWAYS WEAR SAFETY GLASSES WHEN PERFORMING THE OPERATIONS PRESCRIBED IN THESE INSTRUCTIONS
2. READ ALL INSTRUCTIONS CAREFULLY BEFORE ATTEMPTING INSTALLATION
3. BEFORE BEGINNING WORK MAKE SURE TO SET PARKING BRAKE AND CHOCK WHEELS



ASSEMBLY TOOLS NEEDED

Sockets	7/16" — 1-3/8"	Drift	3/16"
Wrenches	7/16" — 1-3/8"	Pliers	
Torque Wrench		Pinch Bar	
Screw Driver		Welder	
Hammer		6" C-clamp- 2 req.	

INSTALLATION NOTES

1. Read all instructions carefully before attempting installation.
2. Remove plow from vehicle.
3. Unless otherwise specified, mount all Components to vehicle before tightening any hardware.
4. Vehicle should be parked on a level surface with a normal vehicle load on the FRONT suspension.
5. Items in parentheses () refer to quantity required for this step. Items in parentheses with a pound sign (#) indicate the part number as found in the parts list on the last page of this document.
Example: (2) 1/2" x 2" Cap Screws (#5).

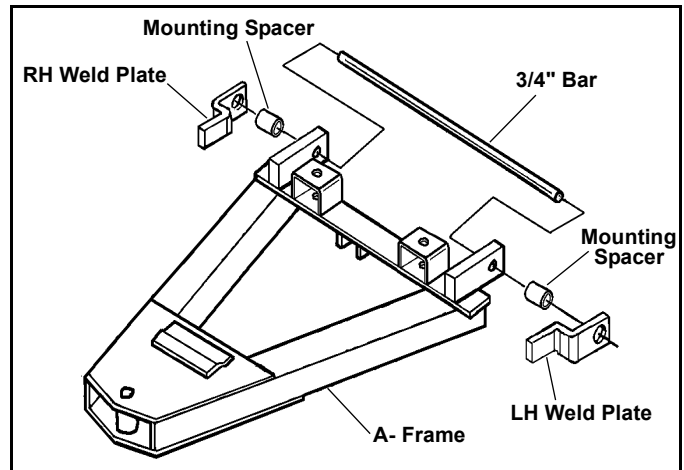
MOUNTING INSTRUCTIONS

Lower Bar Installation:

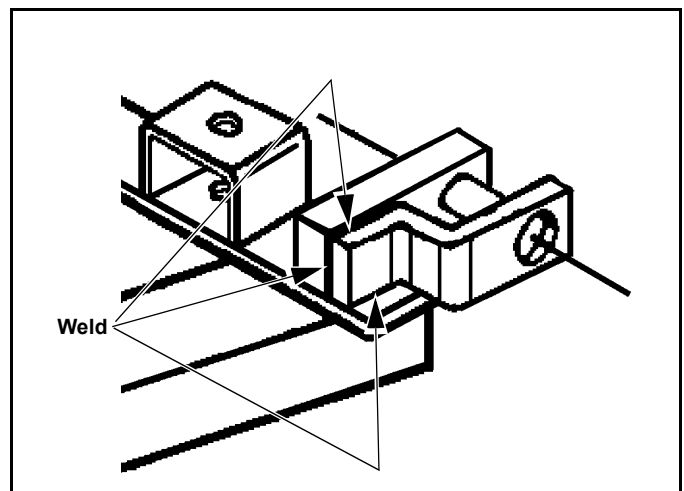
1. Locate the following items:
 - A. Weld Plate RH (#1).
 - B. Weld Plate LH (#2).
 - C. Mounting Spacer (#96100804) (2 required).
2. Insert 3/4" X 36" bar through holes in A-Frame Brackets. Place (2) Mounting Spacers (#96100804) over ends of 3/4" bar and snug to A-Frame Boss. Assemble Weld Plate (#1) RH to right side Mounting Lug on Main Frame. Hole in Weld Plate should fit over Mounting Spacer and outside of Weld Plate should be flush with outside of Mounting Spacers. Use one 6" C-clamp to secure.

NOTE: 3/4" bar and Spacers used as weld fixture. Hitch Pins may be used if 3/4" bar is not available. If Plow is being installed on Older A-Frame, equipped with 1/2" Hitch Pins, the Hitch Pin holes in A-Frame must be drilled out to 25/32".

3. Repeat with Weld Plate (#2) LH on left hand side of A-Frame.



4. Weld both Weld Plates to A-Frame with 1/4" minimum weld on top, bottom and front of Weld Plate.



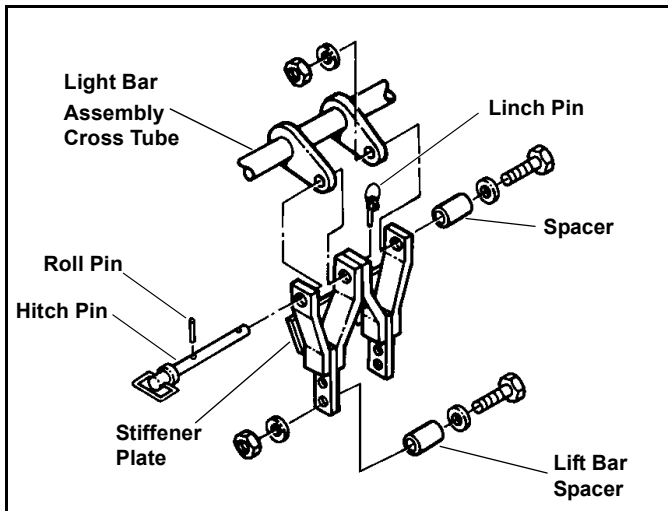
5. Remove 3/4" bar and Mounting Spacers.

Lift Bar Installation:

1. Locate the following items:
 - A. Lift Bar (#8) - 15 Series or 24 Series Plow.
 - B. Lift Bar (#9) - 25 Series Plow.
 - C. Hitch Pin (#13)
 - D. Roll Pin (#14).
 - E. Lift Bar Spacer (#12) - 15 Series or 24 Series Plow.
 - F. Lift Bar Spacer (#11) - 25 Series Plow.
 - G. Hitch Pins (#96100015).
2. Remove existing Lift Bar. Save Linch Pin, remove and discard old Lift Bar Spacers, Cap Screw, and Slotted Nuts and Cotter Pins. Remove lower Hitch Pins and Linch Pins. Save Linch Pins for reuse in step #6
3. For 15 Series or 24 Series Plow install new Lift Bar (#8) using (2) 3/8" x 2" Cap Screws (#10), Spacer (#12), Washers (#4), and Nylock Nuts (#3).
4. For 25 Series Plow install new Lift Bar (#9) using (2) 1/2" x 2" Cap Screws (#5), Lift Bar Spacer (#12), Washers (#7), and Nylock Nuts (#6).

NOTE: Cap Screws should be inserted from the inside of the Bell Crank out. *The 2" Cap Screws may appear long, but this length is necessary to provide proper support for the Lift Bar Spacer.*

5. Align 3/4" hole in mounting tab, on Lower Bar Assembly Cross Tube, with matching hole in lift arm. Insert Hitch Pin in aligned holes and install Roll Pin and Linch Pin.



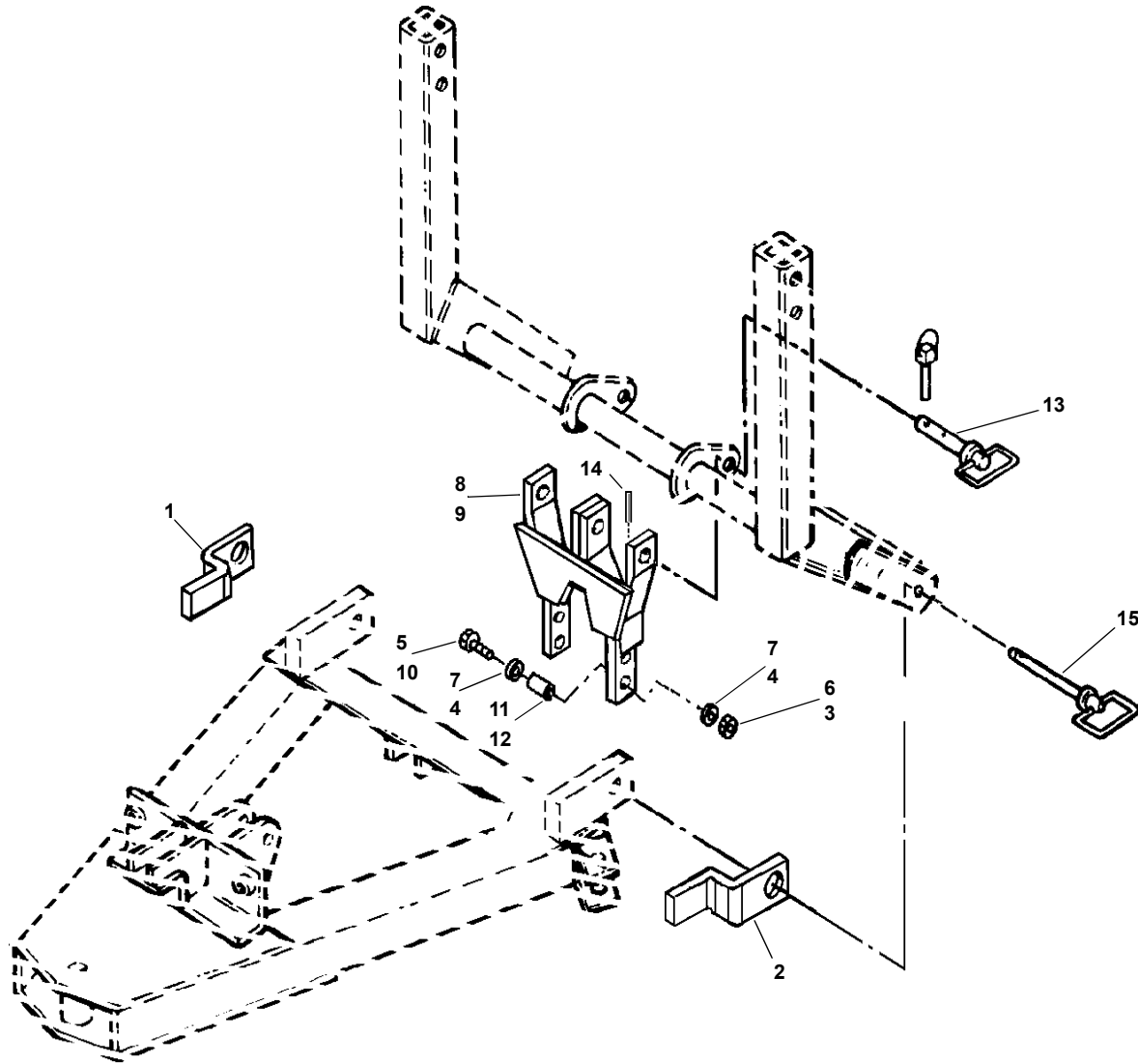
6. Install (2) new lower Hitch Pins (#13) with Linch Pins previously removed.
7. Using the Torque Specification Chart, torque all Cap Screws.

TORQUE SPECIFICATIONS FOR STANDARD MACHINE HARDWARE					
Bolt Size	GR.2 Dry	GR.5 Dry	GR.8 Dry	Metric Size	GR.8.8 Dry
1/4"	66*	9	12	M8	17
5/16"	11	17	25	M10	35
3/8"	20	30	45	M12	60
7/16"	32	50	70	M14	95
1/2"	50	75	110	M16	155
9/16"	70	110	150		
5/8"	100	150	220		
3/4"	175	260	380		
7/8"	170	430	600		
1"	250	640	900		

Note: These torque values are to be used for all hardware. Unless otherwise specified, all torque values must meet this specification.
 Note: All torque values are in Ft.-Lbs unless otherwise stated
 Note: *In-Lbs

REMEMBER After 5 to 10 hours of snowplow usage, re-torque all Cap Screws!

8. Use Installation and Parts Manual supplied with Auxiliary Light Package to complete Light Package installation.



ITEM	PART NO.	DESCRIPTION	QTY.
1	96100765	Plate, Weld-RH.....	1
2	96100766	Plate, Weld-LH	1
3	98009009	Nut, Hex., Nylock, 3/8"-16NC (For 15 & 24 Series Plows)	20
4	98009032	Washer, Flat, 3/8" (For 15 & 24 Series Plows)	16
5	98100010	Cap Screw, Hex., 1/2"-13 NC x 2" (For 25 Series Plows).....	3
6	98009013	Nut, Hex., Nylock, 1/2"-13NC (For 25 Series Plows).....	5
7	98009011	Washer, Flat, 1/2" (For 25 Series Plows).....	6
8	96100801	Bar, Lift (For 15 & 24 Series Plows)	1
9	96100799	Bar, Lift (For 25 Series Plows).....	1
10	98009058	Cap Screw, Hex., 3/8"-16NC x 2" (For 15 & 24 Series Plows) .	2
11	96100082	Spacer, Lift Bar (For 25 Series Plows)	2
12	96100803	Spacer, Lift Bar (For 15 & 24 Series Plows).....	2
13	96100101	Pin, Hitch	1
14	98100008	Pin, Spring, Roll.....	1
15	96100015	Pin, Hitch	2

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