




PARTS LIST

AR275 REV C

REF# PART# QTY DESCRIPTION * PART OF 6729 BOLT BAG

1	A1511	1	PUSHBEAM (28-7/8 OAL)	
2	6035	1	PUSHPLATE, PASSENGER'S SIDE	
3	6034	1	PUSHPLATE, DRIVER'S SIDE	
4	5020	2	HEADGEAR BRACE	
5	5005	2	* 5/8-11 X 1-1/2 (NC) DRILLED CAPSCREW	
6	90446	2	* 5/8 (NC) SLOTTED NUT	
7	90224	2	* 5/8-11 X 1-1/2 HX CS GR.5	
8	90343	8	* 5/8 (NC)NUT	
9	90366	8	* 5/8 LOCKWASHER	
10	90323	4	* 5/8 FLATWASHER	
11	6037	2	5/8 NUT W/ HANDLE	
12	90217	4	* 1/2-13 X 2 (NC) GR.5 CAPSCREW	
13	90210	4	* 1/2-13 X 1-1/2 (NC) GR.5 CAPSCREW	
14	90575	8	* 1/2-13 X 1-1/4 (NC) GR.5 CAPSCREW	
15	90337	20	* 1/2-13 (NC) NUT	
16	90364	20	* 1/2 LOCKWASHER	
17	90319	4	* 1/2 FLATWASHER	
18	90012	2	* 3/16 X 1-3/4 COTTER PIN	
19	4289	2	* 3/4 X 1-7/8 MACHINE PIN	
20	90658	2	* 5/32 X 1-1/4 COTTER PIN	
21	6920	2	CONNECTING PIN ASSEMBLY	
22	6815	2	CONNECTING PIN W/HANDLE	
23	821	2	* SPRING	
24	90601	2	* 1/4 X 1-1/2 COTTER PIN	
25	3	1	CONNECTING PIN RELEASE	
26	5528	1	CYLINDER PROTECTOR	
27	6071	1	PUSHRAIL, DRIVER'S SIDE	
28	6072	1	PUSHRAIL, PASSENGER'S SIDE	
29				
30				
31				
32				
33	90244	10	* 5/8 X 1-1/2 (NC) GR. 5 CAPSCREW	
34	90172	2	* 7/16 X 1 (NC) GR. 5 CAPSCREW	
35	90362	2	* 7/16 LOCKWASHER	
36	90335	2	* 7/16 (NC) NUT	
37	90210	4	* 1/2 X 1-1/2 (NC) GR. 5 CAPSCREW	
38	6070	2	HANGER	
39	5317	1	ANGLE BRACE	
	A6057	1	DASH BRACKET BAG	

FASTENER TORQUE (FT-LB)			
DIAMETER- THREADS PER INCH	GRADE DESIGNATION		
	 GRADE 2	 GRADE 5	 GRADE 8
1/4 - 20	6	9	13
5/16 - 18	11	18	28
3/8 - 16	19	31	46
7/16 - 14	30	50	75
1/2 - 13	45	75	115
9/16 - 12	66	110	165
5/8 - 11	93	150	225
3/4 - 10	150	250	370
7/8 - 9	150	378	591
1 - 8	220	583	893

IMPORTANT NOTICES

1. FISHER ENGINEERING MAKES THE FOLLOWING RESTRICTIONS FOR THIS KIT IN ACCORDANCE WITH FORD MOTOR COMPANY'S MINIMUM RECOMMENDED VEHICLE EQUIPMENT FOR A SNOWPLOW INSTALLATION. PECULIAR ATTACHMENT GROUP AR275 IS DESIGNED ONLY FOR USE ON THE FOLLOWING VEHICLES:

- A. **F150 PICKUPS WITH HEAVY DUTY FRONT SUSPENSION** - 3800 LB FRONT GAWR.
- B. **BRANCOS WITH HEAVY DUTY FRONT SUSPENSION** - 3800 LB FRONT GAWR.

2. **VEHICLE LOADING REQUIREMENTS:**

- A. THE TOTAL VEHICLE CURB WEIGHT MUST NOT EXCEED THE GROSS VEHICLE WEIGHT (GVW) OR CAUSE EITHER THE FRONT OR REAR GROSS AXLE WEIGHT RATING (GAWR) TO BE EXCEEDED. THE GVW AND GAWRS ARE SPECIFIED ON THE SAFETY COMPLIANCE CERTIFICATION LABEL AFFIXED TO THE VEHICLE. THE VEHICLE CURB WEIGHT INCLUDES ALL AFTER MARKET ACCESSORIES, THE SNOWPLOW SYSTEM INCLUDING THE BLADE, THE VEHICLE OCCUPANTS AND THE CARGO.
- B.
 - 1. NO MORE THAT 63 PERCENT OF THE TOTAL VEHICLE CURB WEIGHT SHOULD BE SUPPORTED BY THE FRONT AXLE.
 - 2. IF NECESSARY, WEIGHT SHOULD BE SECURELY ATTACHED TOWARD THE REAR OF THE VEHICLE TO OBTAIN THIS BALANCE FOR PURPOSES OF COMPLYING WITH FEDERAL MOTOR VEHICLE HYDRAULIC BRAKING STANDARDS.

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- A. IF VEHICLE IS SO EQUIPPED, REMOVE SWAY BAR, SWAY BAR BRACKET, RUBBER BUSHING AND U-SHAPED HANGERS FROM VEHICLE FRAME. DISCARD THE BRACKETS BUT SAVE ALL OTHER COMPONENTS AND CONNECTORS FOR LATER USE.
 - B. CUT SLOTS IN AIR DAM AS PER ILLUSTRATION AT END OF INSTRUCTIONS. REMOVE CLIPS HOLDING GROUND STRAPS ON EACH SIDE OF FRAME AND RELOCATE. NOTE: DURING THE FOLLOWING STEPS, LEAVE FASTENERS FINGER TIGHT UNTIL ALL COMPONENTS ARE INSTALLED AND THEN TIGHTEN AS DIRECTED.
 - C. **NOTE:** IF YOUR VEHICLE HAS A SWAY BAR YOU MUST LACE IT THROUGH THE PUSHPLATES (ONE SIDE AT A TIME) AS THEY ARE BEING INSTALLED IN THE FOLLOWING STEPS.

INSERT A 1/2 X 1-1/2 CAPSCREW (13) OUT THROUGH THE HEADGEAR BRACE TAB ON THE PASSENGER'S SIDE PUSHPLATE (2), THIS CAPSCREW CANNOT BE INSTALLED AFTER PLATE IS IN PLACE. PLACE PUSHPLATE UP AGAINST VEHICLE FRAME WITH REAR PLATE AGAINST OUTSIDE FACE OF FRAME. INSTALL TWO 1/2 X 2 (NC) CAPSCREWS (12) DOWN THROUGH FRAME AND PUSHPLATE. SECURE WITH TWO 1/2 FLATWASHERS (17), LOCKWASHERS (16) AND NUTS (15). INSTALL ONE 5/8 X 1-1/2 (NC) CAPSCREW (7) AND FLATWASHER (10) OUT THROUGH FRAME AND HOLE IN FORWARD TAB OF PUSHPLATE. SECURE WITH A 5/8 LOCKWASHER (9) & NUT (8).

D. REPEAT STEP "C" TO INSTALL THE DRIVERS SIDE PUSHPLATE(3).

NOTE: IF YOU ARE WORKING WITH A SWAY BAR REINSTALL THE MOUNTING HARDWARE AT THIS TIME. THE BUSHINGS NOW MOUNT DIRECTLY TO THE PUSHPLATE.

E. ASSEMBLE CONNECTING PIN (21) TO PUSHBEAM (1). FIRST INSERT SPRINGS (23) BETWEEN TWO INNER EARS ON EACH SIDE OF PUSHBEAM. THEN INSERT CONNECTING PIN (22) THROUGH ALL THREE EARS WITH HANDLE OF PIN TOWARDS THE CENTER OF THE BEAM. LEAVING THE HOLE IN THE PIN BETWEEN THE INNER TWO EARS, PULL BACK ON SPRING AND INSTALL COTTER PIN (24).

F. PLACE THE PUSHBEAM (1) BETWEEN THE TWO PUSHPLATES AND INSTALL TWO 5/8 X 1-1/2 DRILLED CAPSCREWS (5) OUT THROUGH THE PUSHBEAM AND PUSHPLATES. SECURE WITH 5/8" SLOTTED NUTS (6).

G. **NOTE:** ON 1991 MODELS ON INSIDE OF DR. SIDE FRAME REMOVE BRACKET HOLDING FUEL LINES AND REPOSITION BRACKET BY RELOCATING REAR HOLE OF BRACKET TO FRONT HOLE OF FRAME, USING REMAINING HOLE IN BRACKET AS A GUIDE, DRILL 9/32" HOLE IN FRAME TO ATTACH FUEL LINE BRACKET TO FRAME.

ON DRIVER'S SIDE, LOCATE SLOTTED HOLE IN FRAME EVEN WITH TRANSMISSION CROSS MEMBER. ALIGN REAR HOLE IN PUSHRAIL (27) WITH SLOT AND INSERT A 5/8 X 1-1/2 (NC) GR.5 CAPSCREW (33) WITH FLATWASHER (10) OUT THROUGH FRAME AND PUSHRAIL. FASTEN WITH A 5/8 LOCKWASHER (9) AND NUT (8). ALIGN HOLE IN ANGLE ON OTHER END OF PUSHRAIL WITH REAR HOLE IN PUSHPLATE. FASTEN WITH A 5/8 X 1-1/2 (NC) GR. 5 CAPSCREW (33), LOCKWASHER (9) AND NUT (8). ALIGN HOLE IN HANGER (38) WITH HOLE IN TAB ON PUSHRAIL. INSERT A 1/2 X 1-1/2 (NC) GR.5 CAPSCREW (37) IN THROUGH HANGER AND TAB. FASTEN WITH A 1/2 LOCKWASHER (16) AND NUT (15). ALIGN REMAINING HOLE IN HANGER WITH HOLE IN FRAME JUST BEHIND SHOCK MOUNT. USING THESE HOLES AS GUIDES, REAM FRAME TO 15/32". PLACE A 7/16 X 1 (NC) GR.5 CAPSCREW (34) OUT THROUGH FRAME AND HANGER. FASTEN WITH A 7/16 LOCKWASHER (35) AND NUT (36).

H. REPEAT STEP "G" FOR PASSENGER SIDE PUSHRAIL (28).

I. INSTALL ANGLE BRACE (39) ON TOP OF TABS ON PUSHRAILS. ALIGN HOLES AND FASTEN WITH TWO 1/2 X 1-1/2 (NC) GR. 5 CAPSCREWS (37), LOCKWASHERS (16) AND NUTS (15).

J. PLACE HEADGEAR (FROM COMMON ATTACHMENTS) ONTO MOUNTING PADS ON FRONT OF PUSHPLATES. INSTALL TWO 1/2 X 1-1/4 CAPSCREWS (14) DOWN THROUGH HEADGEAR AND PADS. SECURE WITH 1/2" LOCKWASHERS (16) AND NUTS (15).

K. INSTALL THE STRAIGHT ENDS OF THE HEADGEAR BRACES (4) TO THE PREVIOUSLY INSTALLED 1/2" CAPSCREWS IN THE BRACE TABS ON THE INSIDE OF THE PUSHPLATES. FASTEN WITH 1/2" LOCKWASHERS (16) AND NUTS (15). CONNECT THE UPPER ENDS OF THE BRACES TO THE HEADGEAR WITH 1/2 X 1-1/2 CAPSCREWS (13), LOCKWASHERS (16) AND NUTS (15)

- L. STARTING WITH THE PUSHBEAM AND PROCEEDING TO THE HEADGEAR AND HEADGEAR BRACES AND THEN WORKING FROM THE FRONT OF THE VEHICLE TO THE REAR, TIGHTEN ALL CAPSCREWS AND NUTS. INSTALL 3/16 X 1-3/4 COTTER PINS (18) TO BEAM BOLTS AFTER TIGHTENING SLOTTED NUTS.
- M. USING FORWARD HOLE OF REAR PLATE ON EACH PUSHRAIL AS A GUIDE, DRILL OR REAM TO 5/8". INSTALL A 5/8 X 1-1/2 (NC) GR. 5 CAPSCREW (33) OUT THROUGH FRAME AND PLATE. FASTEN WITH A 5/8 LOCKWASHER (9) AND NUT (8).
- N. LOCATE THE THREE REMAINING HOLES IN EACH OF THE REAR PLATES ON THE PUSHPLATES. USING THESE HOLES AS GUIDES DRILL OR REAM THE FORWARD FRAME HOLES TO 1/2" AND THE AFT HOLE TO 5/8". INSTALL TWO 1/2 X 1-1/4 (NC) CAPSCREWS (14) OUT THROUGH FRAME AND TWO FORWARD HOLES IN REAR PLATE. FASTEN WITH TWO 1/2 LOCKWASHERS (16) AND NUTS (15). SLIDE 5/8" NUT WITH HANDLE (11) INSIDE THE FRAME AND ALIGN WITH REARMOST HOLE. FASTEN WITH A 5/8 X 1-1/2 (NC) CAPSCREW (7). O. INSTALL CYLINDER PROTECTOR (26) (NOT SHOWN) ONTO BOTTOM OF HEADGEAR WITH FLANGE FORWARD AND POINTING DOWN USING TWO 1/2 X 1-1/4 CAPSCREWS (14), LOCKWASHERS (16) AND NUTS (15).

