




Ref #	Part #	Quantity	Description
1	8533	1	Lower Gear
2	8580	1	Head Gear
3	8235	1	Lift Arm - Regular Duty
4	8628	1	A-Frame Assembly - HD Adapter
5	8514	2	Head Gear Brace (19-3/4 OAL)
6	7309	1	Chain 5/16 x 108"
7	8488	1	Jack Support - HD
8	8501	1	Jack Leg - HD
9	I90571	1	3/8-16 U-bolt RD Bend Gr. 2
10	I90361	2	3/8 Lock Washer
11	I90334	2	3/8-16 Nut
12	8551	1	Release Rod - HD & RD
13	8499	1	Jack Lever - HD & RD
14	A5108	2	Flexible Blade Guide
15	*6815	2	Connecting Pin (w/handle)
16	*6817	1	Pivot Pin - 1 x 6
17	*6814	2	Clevis Pin - 1 x 3-5/16
18	*4289	2	3/4 x 1-7/8" Machine Pin
19	*90658	3	5/32 x 1-1/4 Cotter Pin
20	*90601	4	1/4 x 1-1/2 Cotter Pin
21	*90013	1	1/4 x 2 Cotter Pin
22	*8173	1	Jack Handle
23	*7794	1	Spring - 1/2 OD x 2
24	I20182	1	Spring - Torsion 3-coil
25	*821	2	Spring - 1 ID x 3-1/2
26	*90453	2	3/8-16 U-bolt, RD bend
27	*90361	5	3/8 Lock Washer
28	*90334	6	3/8-16 Nut
29	*90210	5	1/2 - 13 x 1-1/2 Gr. 5 Cap Screw
30	*90572	5	1/2 Gr. 8 Flat Washer
31	I20183	1	Tab
32	20185	1	Torsion Spring Kit
33	*90575	7	1/2-13 x 1-1/4 Gr. 5 Cap Screw
34	*90364	7	1/2 Lock Washer
35	*90337	7	1/2 - 13 Nut
26,27,28	A6148K	2	U-Bolt Assembly
15,25,20	6920	2	Connecting Pin Assembly
36	8498	2	Bolting Bar
37	20244	1	Torsion Spring Stop Kit

DIAMETER - THREADS PER INCH	GRADE		
			
	CS	CS	CS
1/4 - 20	6	9	12
5/16 - 18	11	18	28
3/8 - 16	19	31	46
7/16 - 14	30	50	75
1/2 - 12	45	75	115
9/16 - 12	66	110	165
5/8 - 11	91	150	225
3/4 - 10	130	210	315
1 - 8	220	360	540

! Part of 20185 Torsion Spring Bag  
 \* Part of 8553 Bolt Bag

**NOTE: Installation of angle cylinders and A-Frame to blade are covered in the hydraulic instructions, Section 1.**

1. Attach the A-frame (4) to the blade with the 1 x 6 pivot pin (16). The pivot pin should be inserted down through the blade and A-frame and secured with a 1/4 x 2 cotter pin (21). After installing A-Frame to blade, place a 1-1/2" block in the center of the A-frame rear cross member. **A-frame cross-member should be parallel to the blade.**
2. Install a 3/8 U-bolt (26) through a link in the lift/carrying chain (6) 32" from the end (see lift/carrying chain illustration). Attach U-bolt & chain to the two front holes on driver's side of A-frame (4) with two 3/8 lock washers (27) and nuts (28). Do not fully tighten. **The other end of the lift chain will be attached to passenger's side of A-frame after lift arm is installed.**
3. To assemble connecting pins (15) to lower gear (1) insert springs (25) in pin holders (see connecting pin illustration). Then, insert connecting pin through all three holes with the pin handles toward the vehicle. Position cotter pin hole flush with inside plate, pull back on spring and install 1/4 x 1-1/2 cotter pins (20). **Bend both legs of cotter pins around connecting pins for proper clearance.**
4. Place bolting bar (36) inside head gear (narrow end in first, see assembly instructions). Place upper gear (2) on front end of lower gear (1). Insert four 1/2 x 1-1/4 cap screws (33) with Gr. 8 flat washers (30) through the holes in lower gear and head gear into the head gear bolting bar. Do not fully tighten.
5. Insert jack leg (8) up through jack stand (7) and engage jack lever when four slots are visible. Install one 3/8 nut (28) on jack handle (22) and insert into top round hole on jack leg. Fasten with one 3/8 lock washer (27) and nut (28).
6. Using jack lever (13), insert lever through the three holes on jack stand (7) to clean out paint before assembling. Place jack lever spring (23) between ear and guide on jack stand (7). (See jack stand illustration). Insert jack lever (13) through ear until cotter pin hole is flush with jack guide. Pull back on spring and install 5/32 x 1-1/4 cotter pin (19).
7. Install head gear braces (5) to each side of head gear (bent end on top) and to lower gear tab (bottom of braces to rear of tab) using four 1/2 x 1-1/2 cap screws (29), lock washers (34) and nuts (35). Tighten all fasteners on head gear - lower gear assembly.
8. Align holes in head gear/lower gear assembly with holes in the blocked up A-frame. Insert clevis pins (17) through ears and secure with two 1/4 x 1-1/2 cotter pins (20).
9. Install torsion spring per instructions located in torsion spring bag (32). **If upper pushear of A-frame used, install torsion spring stop per instructions located in torsion spring stop kit (37).**
10. Attach jack support (7) under the tabs on rear of head gear with two 1/2 x 1-1/4 cap screws (33), lock washers (34) and nuts (35). Attach the jack support stiffener to the lower gear beam with one 1/2 x 1-1/2 cap screw (29), Gr. 8 flat washer (30) and nut (35). Tighten all fasteners.
11. Check to be certain all fasteners are tight. Attach lift arm (3) to head gear (2) with two machine pins (18) and cotter pins (19). **After hydraulic lift package has been installed tip the head gear assembly forward until stops hit A-frame.** Insert long end of chain through pear shape link on lift arm and fasten end link to the two front holes in the passenger's side of the A-frame using a 3/8 U-bolt (26), lock washer (27) and nut (28). Tighten. When the plow is lifted with the cylinder, A-frame should hit upper gear just before lift cylinder is fully extended (10"). Adjust chain in driver's side if needed to accomplish the above and tighten the U-bolt. Hook 32" chain in chain plate on head gear.
12. Install the blade guides (14) on each end of the top bar on the blade.
13. See the release rod instructions (pn 6491) attached to the release rod regarding its use.
14. Attach to vehicle per installation decal located in the upper driver's side corner of blade.