

### Direct to frame APU mounting procedure

#### Overview

The Idle Free APU will be bolted directly to the truck’s frame rail.

The truck’s frame rail APU location will be determined based on available frame rail space.

Four each, 5/8” bolts, nuts, & washers will be used to secure the APU to the truck’s frame rail (bolt and nut ***MUST*** be Grade 8).

The “*Truck Mounting Location Hole Template, #67007*” will be used to properly locate the four, 5/8” holes that need to be drilled into the truck’s frame rail.

The APU will be bolted to the truck’s frame rail using IFS Kit #91706.

1. Determine the frame rail location for the IFS APU.
2. Use Idle Free template #67007 to mark the location of the four truck frame holes to be drilled. The frame holes will be drilled so as to be able to utilize 5/8” bolts. Use a center punch to mark the four frame holes.
3. Drill the truck’s frame using at least 2 different size drill bits. Make the first pass with a 3/8” (4 holes) drill bit. Drill the 4 holes with the second pass using a 5/8” or an 11/16” drill bit.
4. Locate IFS kit #91706 and utilize the (4 each) mounting bolts, washers, & lock nuts.
5. Push the APU into position next to the truck’s frame to confirm frame fit.
6. Confirm that clearance is available on all sides of the APU.
7. Raise the APU high enough against the truck’s frame to align the 4 frame mounting bolts.
8. Insert the four ***Grade 8*** 5/8" bolts and flat washers (included) through the APU and truck’s frame and add flat washers and ***Grade 8*** nuts to the opposite side of the bolt/nut assembly.
9. Tighten the four mounting bolts in a cross sequence and focus on keeping the APU in flush contact with the truck’s frame.
10. Tighten all 4 bolts to a very snug level only.
11. The APU should still be supported by the lifting cart or transmission jack, at this point in the installation process.
12. Remove the APU lifting cart when the frame is flushed and constant contact is made between the APU and the truck’s frame.
13. All bolts should then be torqued to 212 foot pounds.
14. The APU should have no gaps between the truck’s frame and the APU frame guides.

#### Witness Mark

15. Add a vertical witness mark to each bolt after the proper torque level (212 foot pounds) has been met.
  - a. Make sure that the paint mark extends to the frame.
  - b. The paint mark verifies proper torque.
  - c. Paint mark is used as a visual sign of bolt head movement.



#### Torque Check Service Required, Label

16. Affix Service Label on the top of the APU cover.
  - a. Use marker to write in the date, 6 months from installation.
  - b. Date entered is the next Torque Check Service Date.







