



Installing IFS Frame Caps



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Remove APU

1) Place Table Jack (for lifting APU) or transmission Jack under the APU and lift to relieve pressure from APU mounting bolts.

2) Loosen APU mount bolts to reduce strain on bracket.

3) Use a wire wheel to clean off the paint on the upper inner corner of the APU upright for a clean weld, should just take a brush or two with a course knot wheel.

Weld Frame Cap

4) Hold the gusset as shown and tack into place. The gusset has little legs to stand on to help allow for good penetration. Push the gusset so that the 4 legs are in contact with the APU.

5) Weld the gusset along the 3 edges of contact with the APU. Make sure to get good penetration and a quality bead.

6) Use a can of Black spray paint to cover the weld and gusset.

7) Apply Blue Loctite to all mounting bolts.

Install APU

8) Torque APU mounting bolts to 125 ft-lbs.

a. Tighten top bolts till the APU lightly touches the frame.

b. Tighten bottom bolts till APU lightly touches the frame.

c. Tighten bottom bolts to 125 ft-lbs.

d. Tighten top bolts to 125 ft-lbs.