

## ATTENTION

The steel frame gripper mounting kit (#91712) cannot be used on trucks with 10 1/8" frames (flange to flange measurement). The steel frame gripper mounting kit can only be used with truck frames larger than 10 1/2". If the truck's frame is 10 1/8", you must use the L-bracket kit (#91707) or the direct-mount kit (#91706).

If you have questions call Idle Free Customer Service at (920) 206-9333

### Overview

#### 91712 Steel Frame Clip Kit

Steel Frame Clips are used on mounting applications where obstacles prevent the use of Standard Frame L Brackets. Four steel frame clips will be needed to secure the APU to the truck's frame.

The Idle Free APU uses weld nuts (on the APU's frame) to receive the four, 6", GR8 mounting bolts.



1. Determine the frame rail location for the IFS APU.
2. Place the APU into position next to the truck's frame to confirm frame fit.
3. Confirm that clearance is available on all sides of the APU.
4. Raise the APU high enough against the truck's frame to align the 4 Steel Frame Clips. Insert the four **Grade 8** 5/8" bolts and flat washers (included) through the frame clips, over the truck's frame and into the APU's weld nuts.
5. Tighten the four mounting bolts in a cross sequence pattern and focus on keeping the APU in flush contact with the truck's frame.
6. Tighten all 4 bolts to a very snug level only.
7. The APU should still be supported by the lifting cart or transmission jack, at this point in the installation process.
8. Remove the APU lifting cart when the APU is flush and in constant contact with the truck's frame.
9. The APU should have no gaps between the truck's frame and the APU frame guides.
10. All bolts should then be torqued to 212 foot pounds. These torque values are a **DRY TORQUE** value. **DO NOT USE LUBRICANTS OR ANTI-SEIZE** as it significantly lowers the torque value required to achieve the same bolt tensioning.



### Witness Mark

11. Add a vertical witness mark to each bolt after the APU has been secured to the truck's frame. Make sure that the paint mark extends to the frame. This mark is used as a visual sign of bolt head movement.

### Torque Check Service Required, Label

12. Affix the Service Label on the top of the APU cover.
  - a. Use marker to write in the date, 6 months from installation.

