

Replacing Mounting Brackets

The APU mounting back brackets ***will need to be replaced*** if the APU is using U-Channel Brackets or Aluminum Frame Clamps to secure it to the truck's frame. The replacement kit includes 3 inch L-brackets as well as grade 8 bolts, washers and a Torque Check Service Label.

The replacement L-brackets will require new bolts and washers to complete the replacement procedure.

Kit #91705

- (2) L-brackets
- (4) Grade 8 bolts
- (4) Washers
- (2) Gussets
- (1) Torque Check Service Label

- 1) Place table jack (for lifting APU) or a transmission jack under the IFS APU and lift just enough to relieve pressure from APU mounting bolts.
- 2) Remove the 4 APU mount bolts and original mounting hardware, discard all.
- 3) Locate the new mounting 3 inch L-brackets, replacement bolts, and replacement washers.
- 4) Push the APU back into position next to the truck's frame to confirm frame fit.
- 5) Confirm that clearance is available on all sides of the APU.
- 6) Confirm that the lift has raised the APU high enough against the truck's frame to allow the top 2 mounting bolts to clear the top of the truck's frame.
- 7) Insert two (new) Grade 8 5/8" bolts and flat washers (included) through the single holes at the top of the L-Brackets. The top bolts are routed over the top of truck's frame.
- 8) Leave about 1/2" clearance between the top of the frame and the 2 bolts. The 1/2" clearance is only used to decrease friction during the bolt tightening procedure. Make sure that the 2 top bolts are resting on top of the truck's frame ***after the installation procedure has been completed.***
- 9) Start the bolts and continue to turn them until they are through the APU's welded frame nut. The APU should still be supported by the lifting cart or transmission jack at this point in the installation process.
- 10) Lower the APU lifting device just until the top APU mounting bolts make contact with the top of the truck's frame.

It is important to make sure that the lowering of the APU, at this point, has exposed the two lower bolt holes needed for L-Bracket mounting.
- 11) Place two bolts with washers (provided) through the two lower mount holes on the L-Bracket.
- 12) Tighten the four mounting bolts in a cross sequence and focus on keeping the APU in flush contact with the truck's frame.

L-Bracket, 3 inch,
New



Grade 8 Bolt and Washer

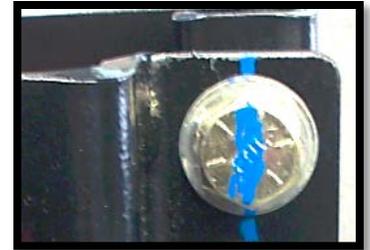
Replacing Mounting Brackets

- 13) Remove the APU lifting cart when flush frame, constant contact, is made between the APU and the truck's frame.
- 14) All bolts should then be torqued to 212 foot pounds.
- 15) All bolts should show the same exposed thread count from the weldnut end.
- 16) The APU should have no gaps between the truck's frame and the APU frame guides.
- 17) The top APU mounting bolts should be resting on the top of the truck's frame.

Witness Mark

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

Witness Mark



Torque Check Service Label

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

