



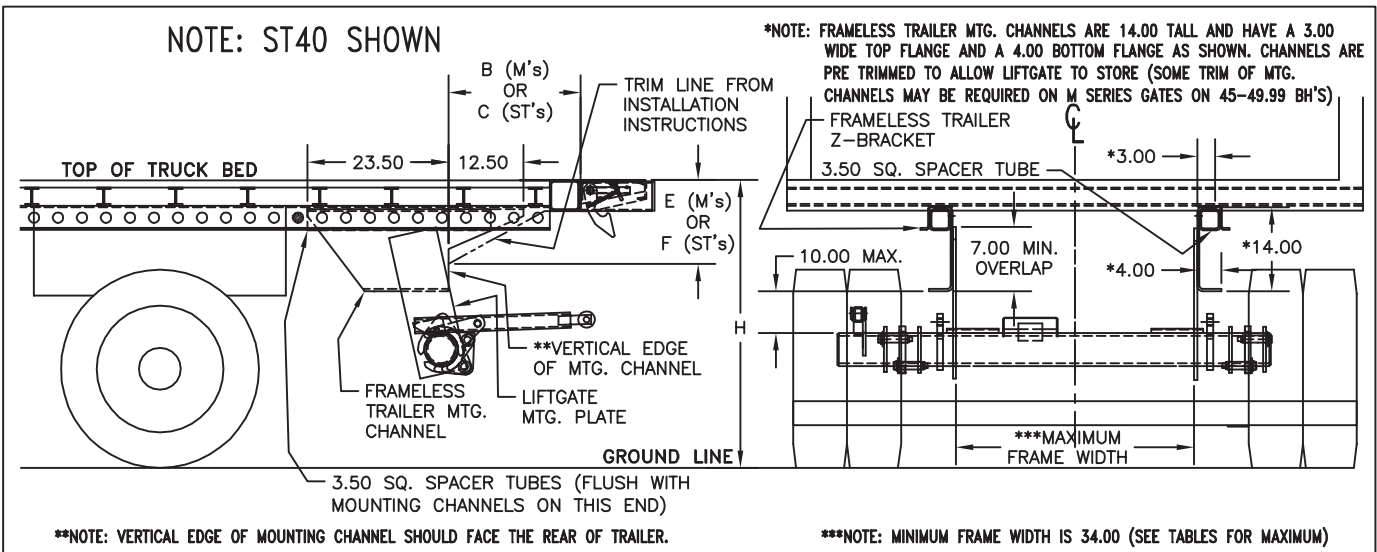
KIT 225

FRAMELESS TRAILER MOUNTING KIT

M AND ST 22, 31, 40
PART NO. 3728

FOR M16, 20, 25, 30 LIFTGATES 45.00 TO 54.00 INCH BED HEIGHTS.			
BED HEIGHT—H	B	E	MAX. FRAME WIDTH
45.00—49.99	16.00	10.00	40.00
50.00—54.00	15.00	11.00	40.00

FOR ST 22, 31, 40 LIFTGATES 48.00 TO 56.00 INCH BED HEIGHTS.			
BED HEIGHT—H	C	F	MAX. FRAME WIDTH
48.00—53.99	22.00	14.00	40.00
54.00—56.00	22.00	15.00	40.00



Step 1:

Read through and understand the standard liftgate "Installation Instructions" for either the M or ST series liftgate before proceeding. Notch the rear structure of the truck body according to pages 2 and 3 of the liftgate "Installation Instructions". Note that in the tables and drawings above the lettered dimensions [B (M's) or C (ST's), E (M's) or F (ST's), and H] all correspond to those in the liftgate "Installation Instructions" on pages 2 and 3.

Step 2.

Position the frameless trailer mounting channels and 3.50 sq. spacer tubes as shown in the drawings above. Note that the 3.00 wide flanges of the channels face up as shown. Also the side of the channels with the vertical edge face the rear of the truck as shown. Position this vertical edge of the mounting channels using the B (M's) or C (ST's) dimension as shown. The 3.50 square spacer tubes should be flush with the mounting channels on the forward edge. With the 3.00 flanges tight against the Z-brackets, the mounting channels should not interfere with the trim line (as shown) from the liftgate "Installation Instructions" (except on M series liftgates in the 45.00 to 49.99 bed height range where some trimming of the mounting channels may be required to fully stow the platform). Note that if the width between the inside of the liftgate mounting plates will be wider than the maximum frame width, this kit should not be used. Inside the liftgate mounting plates should be no less than 34.00 apart and no wider than the maximum frame width for the model of liftgate being mounted (see tables and drawings above).



Notes:

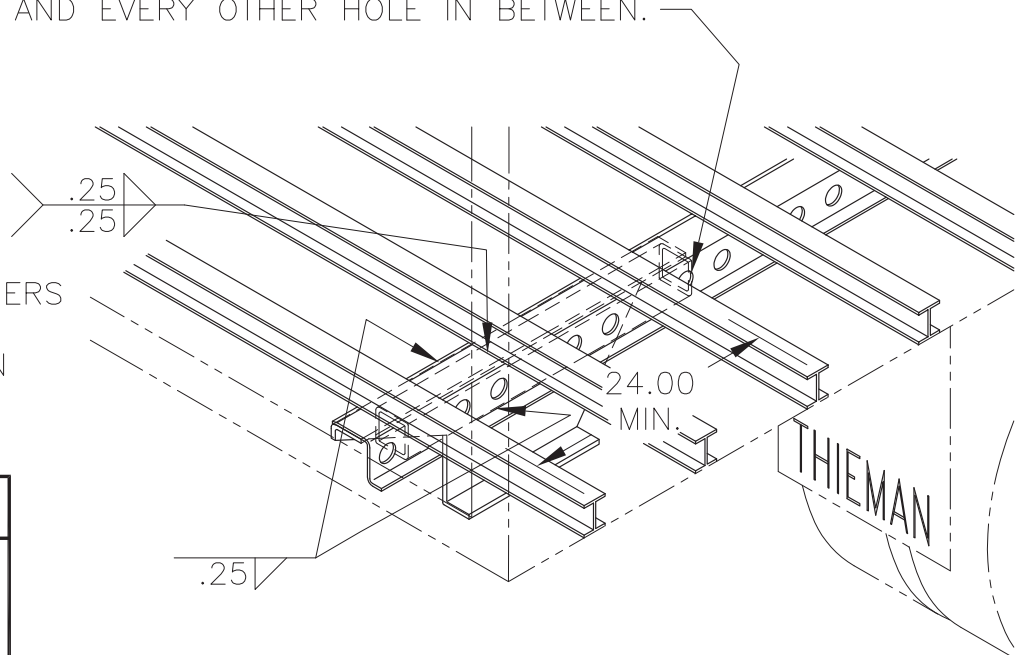
1. Initially tack weld the mounting channels and 3.50 sq. spacer tubes securely to the trailer until the entire liftgate has been mounted and is operating properly. Check for any interference before completing welds as shown below. Initial tack welds must be strong enough to support entire liftgate.
2. **DO NOT** weld across cross members at any point. Any welds to cross members should be in a direction parallel with the length of the cross members.

Step 3.

Check to make sure Z-brackets are welded securely to cross members. If not, weld Z-brackets to cross members using full .25 welds on both the front and back sides of cross members. Z-brackets must be welded securely to all cross members which pass over the mounting channels along with one cross member to the front and back of channels if possible. A minimum of three cross members must be welded to the Z-brackets. This is assuming cross members are centered every 12 inches. Closer cross member spacings will require that more than three cross members be welded to brackets. The cross member that overlaps the front of the mounting channel and the cross member that overlaps the rear of the mounting channel must be spaced a minimum of 24 inches apart on center. Weld the mounting channels and 3.50 sq. spacer tubes to the inside and outside edges of the Z-bar using two .25 welds the entire length of the mounting channels. Plug weld the 3.50 sq. spacer tubes to the Z-brackets at the holes in the Z-bracket which overlap the spacer tube closest to the ends of the spacer tube and plug weld the spacer tube to the Z-bracket at every other hole in between.

PLUG WELD 3.50 SQ. SPACER TUBE TO Z-BRACKET AT HOLES IN Z-BRACKET CLOSEST TO ENDS OF THE SPACER TUBE AND EVERY OTHER HOLE IN BETWEEN.

MAKE SURE Z-BRACKET IS WELDED SECURELY TO AT LEAST THREE CROSS MEMBERS (FARTHEST CROSS MEMBERS SPACED A MINIMUM OF 24.00 INCHES APART ON CENTER.)



CAUTION
DO NOT WELD ACROSS CROSS MEMBERS. THIS WILL WEAKEN THE TRAILER STRUCTURE. WELD ONLY PARALLEL TO CROSS MEMBER LENGTH AS SHOWN.