

# **MOUNTING KIT**

## **52204-MKPB**

F150 4x4 1992-1996

F250 4x4 1992-1998

F350 SRW 4x4 1992-1998

F350 DRW 4x4 1992-1998

F450 DRW 4x2 1992-1998

(Note: For the snowplow lights this kit requires: 800067 or 800037AXV Light kit, 767052 Adapter Kit (vehicle's headlamp bulb H9007))



**Arctic Equipment Manufacturing Corporation**  
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52204-MKPB R09  
INST0010

Quik-link Mounting Kit 52204-MKPB								
Item	Part #	Description	MKPB	MKPB-QLII	QL-MKB	QLII-MKB	QLII-HI	QLII-HI-DLC
1a	53170-D-GA	Lift Frame QUIK*LINK® II Galvanized				1		
1b*	53171-D-GA	Lift Frame, QUIK*LINK® II-Hi boy Galvanized					1	
2a	52363-C	Spreader Bar QLII		1				
3	52207-01-B	Thrust Arm Driver Side		1				
4*	52207-02-B	Thrust Arm Curb Side		1				
5	52203-01-B	Mounting Bracket Driver Side		1				
6*	52203-02-B	Mounting Bracket Curb Side		1				
7	50069-C-GA	Lift Channel Galvanized				1		
7a*	52612-B	Lift Channel (2" cylinder) Galvanized						1
8a	52348-M	Mounting Pin Ass'y					2	
10	52208-B-GA	Light Brace Galvanized				2		
11	52209-B-GA	Light Antler Galvanized				1		
12	HH-00972-153	3/4"x3.1/2" UNF Cap screw		2				
13	HH-00972-149	3/4"x2.1/2" UNF Cap screw		1				
14	HH-00973-007	3/4" UNF Thin Collar Locknut		3				
15	52096-A	Thrust Arm Fastener		2				
16	HH-00972-090	½"x1.1/2" UNF Cap screw		6				
17	HH-00972-129	5/8"x1.3/4" UNF Cap screw		6				

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18	HH-00460-002	½" UNF Hex Nut		8				
19	HH-00457-001	½" Lock washer		8				
20	HH-00341-008	5/8" Flat washer		4				
21	HH-00972-132	5/8"x2.1/2" UNF Cap screw		8				
22	HH-00460-001	5/8" UNF Hex Nut		14				
23	HH-00457-003	5/8" Lock washer		14				
24*	HH-00293-006	1/4"x1" UNC Cap screw		4				
25*	HH-00294-001	1/4" Hex Nut		4				
26*	HH-00457-006	1/4" Lock washer		4				
27*	HH-00341-002	1/4" Flat washer		4				
28	52373-M	Jack Assembly					1	
29*	50999-B	Blade guides					2	
30*	HH-00972-155	3/4" x 4" UNF Cap screw						2

QUIK\*LINK is a trademark of Arctic Equipment Manufacturing Corporation

**Note:** \* These items are not shown on the drawing.

**GENERAL**

**Customer must be aware of following:**

Arctic Equipment Manufacturing Corporation (Arctic) does not assume liability for damage to your motor vehicle resulting from the attachment or use of an Arctic snowplow. The purchaser assumes all vehicle risk associated with the attachment and operation of this snowplow.

The Arctic snowplow you purchase must be used only on vehicles equipped with the manufacturer's snow plow preparation packages. Snow plowing without the original plow preparation package may damage your vehicle. The added weight may

impair the operation and control of your vehicle. Snow plowing with a vehicle not recommended for that purpose by the manufacturer may void your new vehicle warranty. If your vehicle is not equipped with an original snow plow preparation package, additional equipment may be necessary before snow plowing. Please consult your vehicle and snowplow dealers prior to the purchase and installation of the snowplow. The installation of such parts however is not a full substitute for the original equipment snowplow preparation package.

Before drilling any holes in the firewall or frame, move brake lines, fuel lines and/or electrical wiring from the path of the drill. Brake and fuel lines must also be clear of any fasteners.

All bolts should be installed from the inside of the truck frame so that the lock washers and nuts are accessible for re tightening.

If a slotted hole in the truck frame is utilized, a flat washer must be used under the bolt head. If a flat washer is used under a lock washer use LOCTITE #242. Also use this LOCTITE #242 if existing (vehicle) bolts and nuts are used.

Do not tighten any bolt assemblies until all fasteners and components are installed, unless otherwise specified.

**After first use, re tighten all mounting bolts**, thereafter check mounting bolt tightness periodically.



Before proceeding, read instructions carefully and familiarize yourself with the components and hardware.

### **INSTALLATION INSTRUCTIONS**

1. Remove the bumper and store it in a safe place, so that it does not get damaged.
2. Install thrust arms (3), (4). Insert thrust arm fasteners (15) into available slots on the truck frame. Fasten the thrust arm (3), (4) with ½" hex nut (18) and ½" lock washer (19). **DO NOT TIGHTEN.**
3. Install mounting brackets (5), (6). Insert ½"x1.1/2" bolts (16) through the bumper mounting angle and mounting bracket. Finger tighten only, as these are only to keep the bumper mount holes aligned and will be removed when reinstalling the bumper. Insert 5/8"x1.3/4" bolts (17) and flat washers (20) from inside frame through mounting bracket. Secure with 5/8" flat washer, lock washer and hex nut (20),(23),(22). Apply LOCTITE #242 on a 5/8" bolt.
4. Install spreader bar (2a), between the thrust arms (3), (4). Fasten using 5/8"x2.1/2" bolt (21), 5/8" hex nut (22) and 5/8" lock washer (23). The spreader pin hole should be located 14-1/2" (+/- ½"). **DO NOT TIGHTEN.**
5. While pushing up on the thrust arms (3), (4) so that they are tight against the bottom of the truck frame, tighten all the fasteners

except those noted in #3.

6. Locate and drill two 21/32" holes on each side of the frame using the thrust arms (3), (4) as guides.  
 NOTE: Some models may have a second set of slots in this location. Feed 5/8"x1.3/4" bolts (17) in through the frame using wire and fasten with 5/8" hex nut (23) and lock washer (19).
7. Torque all fasteners according to torque chart. Remove temporary 1/2"x1.1/2" bolts in mounting brackets and reinstall bumper.
8. Install lift frame (1A),(1B). Slide lift frame (1a)(1b) inside of spreader bar (2a). Insert spreader pin (8a) in top holes of spreader bar (2a).
9. Install light antler (11) and light brace (10) using 1/2"x1.1/2" bolts (16), 1/2" hex nut (18) and 1/2" lock washer (19). Fasten light antler (11) to top of the lift frame (1A),(1B) and light brace (10) to side of lift frame. Install plow lamps, not shown, so that stud of plow lamps is through light antler (11) and light brace (10).
10. Torque all fasteners according to torque chart.
11. Install lift channel (7) and lift cylinder (or power unit). Use 3/4"x3.1/2" bolts (12) and 3/4" thin collar locknut (14) at lift frame (1a)(1b) connection. Use 3/4"x2.1/2" bolt (13) and 3/4" thin collar locknut (14) at cylinder and lift channel (7) connection.

TORQUE CHART (FT. L.B.)		
SIZE	GRADE 5 BOLT 	GRADE 8 BOLT 
1/4 - 28	8	11
5/16 - 24	15	22
3/8 - 24	28	40
7/16 - 20	44	63
1/2 - 20	69	97
5/8 - 18	138	195
3/4 - 16	241	341
<small>Note: Torque values are for plated bolts only</small>		

**NOTE: Do not over tighten as this assembly must be able to pivot.**

12. Use 1/4"x1" bolt (24), 1/4" hex nut (25), 1/4" flat washer (27) and 1/4" lock washer (26) to fasten blade guides to plow.