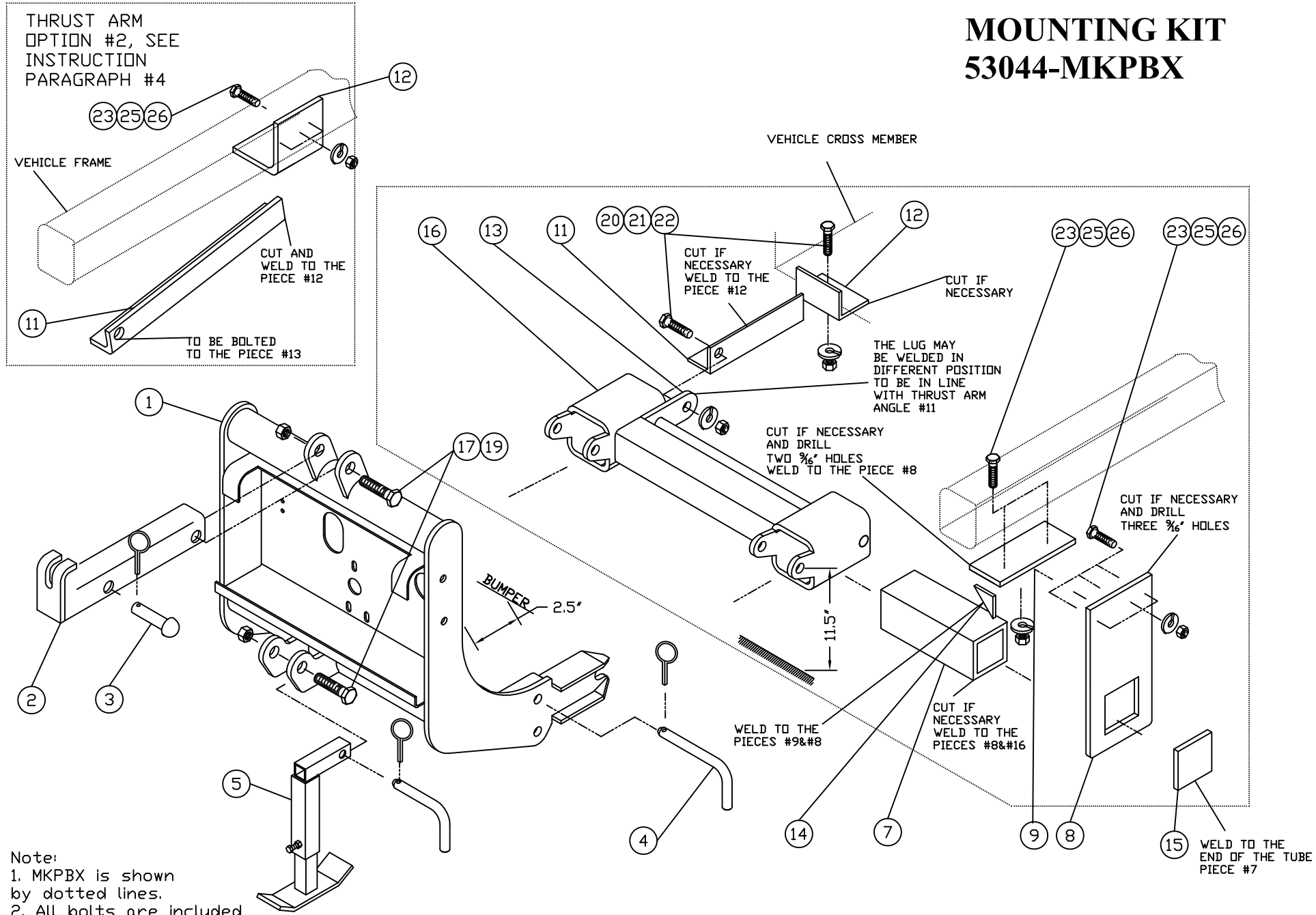


MOUNTING KIT
53044-MKPBX

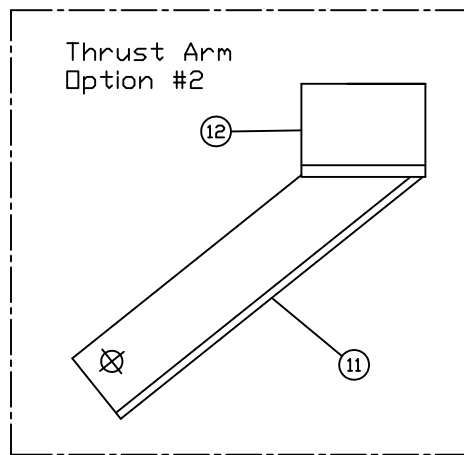
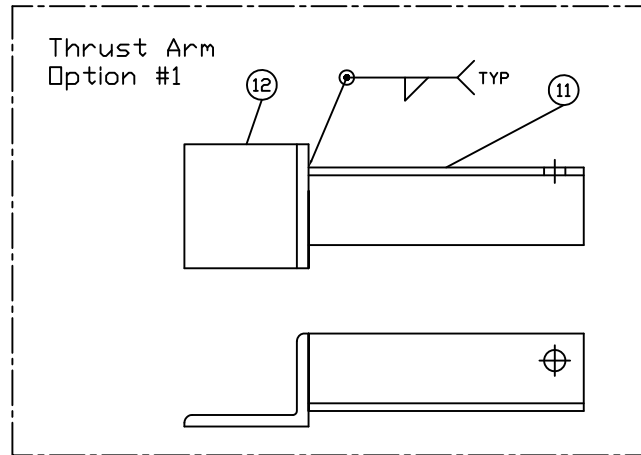
Universal LD Plows

MOUNTING KIT 53044-MKPBX



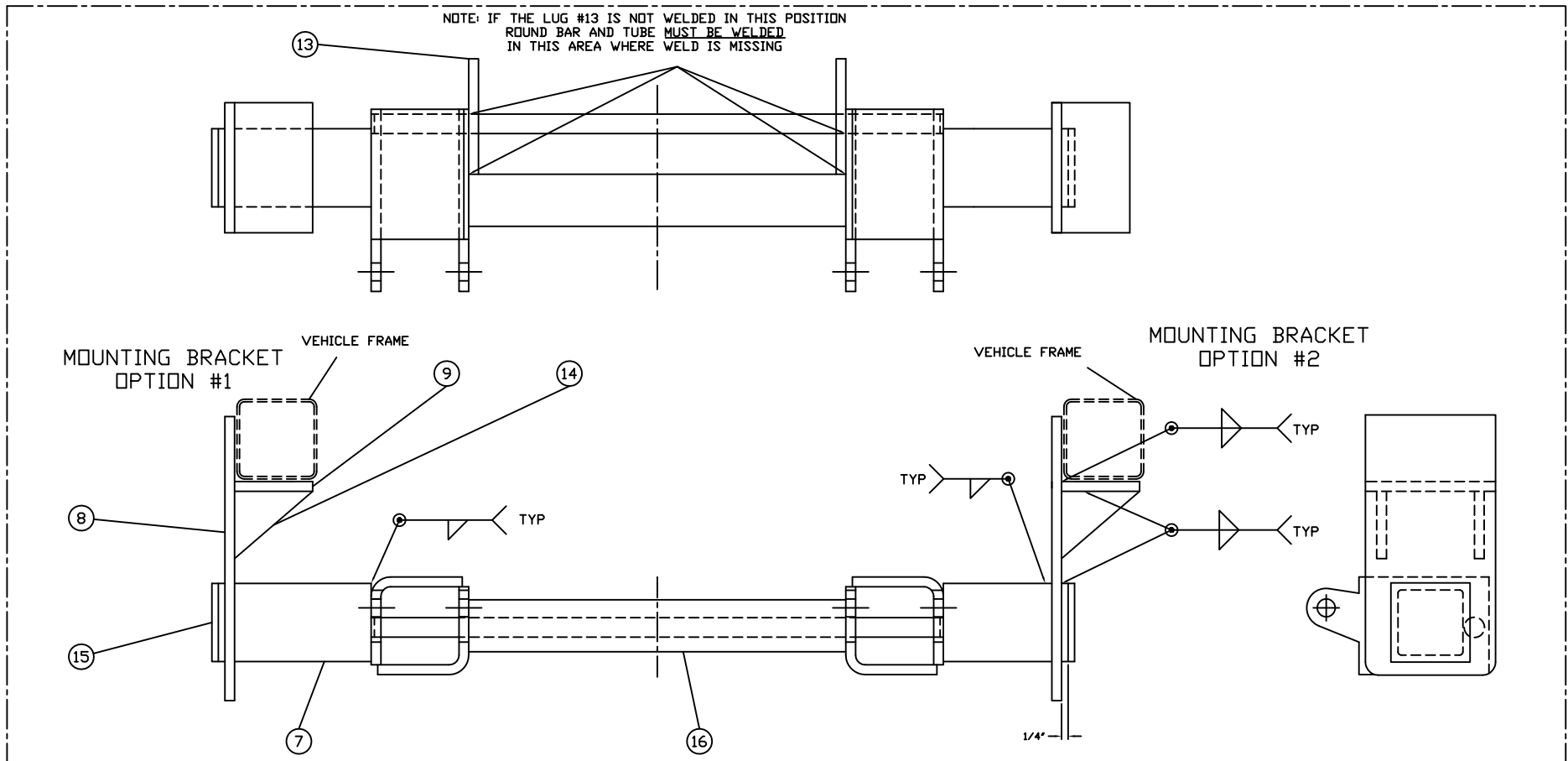
Note:
 1. MKPBX is shown by dotted lines.
 2. All bolts are included in MKPBX.
 3. Please use LOCTITE®, or similar locking product on ALL mounting hardware (bolts, nuts, etc.).

MOUNTING KIT 53044-MKPB



Note:

1. Your mounting kit and thrust arm may look like as shown on the drawing after welding.
2. Material provided is low carbon steel 44W. All welds to be minimum ¼" fillets (all the way around) if welding wire has same properties as material.



Arctic Equipment Manufacturing Corporation

Mounting kit 53044-MKPBX

53044-MKPBX R04

INST0072

Mounting Kit 53044-MKPBX				
Item	Part #	Description	MKPBX	X-MKB
1	52638-D-GA	Lift Frame Galvanized		1
2	50069-C-GA	Lift Channel Galvanized		1
3	52757-M	Rivet Ass'y (rivet & lynch pin)		1
4	1302045	Pin assembly		2
5	52671-M	Jack Assembly (with lynch pin)		1
6*	50999-B	Blade Guides		2
7	53053-N	Square Tube 1/4"x3"x3" length 8"	2	
8	53054-B	Side Plate	2	
9	53055-N	Frame Plate 3/8" x 3" x 5"	2	
10*	53056-01-B	Thrust Arm Angle Driver Side	1	
11	53056-02-B	Thrust Arm Angle Curb Side	1	
12	53057-N	Thrust Arm Frame Plate 3/8" x 3"x 4" x length 4"	2	
13	52673-A	Lug	2	
14	52215-03-C	Gusset 3/8" x 3" x 3"	6	
15	53058-N	Cover Plate 1/4" x 3" x 3"	2	
16	53052-C	Spreader Bar	1	
17	HH-00972-153	3/4-16x3.1/2 Hex Head Cap Screw	2	
19	HH-00973-007	3/4-16 Nylon Insert Lock nut	2	

Mounting Kit 53044-MKPBX				
Item	Part #	Description	MKPBX	X-MKB
20	HH-00972-129	5/8-18x1.3/4 Hex Head Cap Screw	4	
21	HH-00457-003	5/8 Lock washer	4	
22	HH-00460-001	5/8-18 Hex Nut	4	
23	HH-00972-091	1/2-20x1.3/4 Hex Head Cap Screw	16	
25	HH-00457-001	1/2 Lock washer	16	
26	HH-00460-002	1/2-20 Hex Nut	16	
27*	HH-00293-006	1/4-20x1 Hex Head Cap Screw	4	
28*	HH-00457-006	1/4 Lock washer	4	
29*	HH-00341-002	1/4 Flat washer	4	
30*	HH-00294-001	1/4-20 Hex Nut	4	

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

GENERAL

Customer must be aware of following:

Warranty for installation errors and omissions shall be the responsibility of the selling dealer and Arctic Equipment

Manufacturing Corporation will not be responsible for any damage caused by improper installation by others. 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 package. 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 (where it is possible).

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

General order of installation:

- install all components (mounting bracket, thrust arms) and all fasteners finger tight (snug) through existing holes,
- drill necessary holes and
- tighten all hardware.



After first use, re-tighten all mounting bolts, thereafter check mounting bolt tightness periodically and at the start of the season.

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

INSTALLATION INSTRUCTIONS

1. Install the spreader bar (16) to the lift frame (1) and move that assembly toward the truck. The spreader pin hole needs to be approximately 11.5" from the ground and the lift frame must be 2.5" from the bumper.
2. Place the side plate (8) on the side of the vehicle frame (see the option #1 and option #2 for mounting bracket). The cut out in the side plate (8) needs to be in the same line as the spreader bar (16) (if necessary the length of the side plate (8) could be adjusted). Place the square tube (7) from the spreader bar (16) to the side plate (8). The square tube (7) needs to protrude 1/4" through the side plate (8). Tack the square tube (7) to the spreader bar (16) and to the side plate (8). Drill 3 holes 9/16" in the top of the side plate (8) and the vehicle frame. Note: use existing holes in the truck chassis if possible.
3. Place the frame plate (9) against the vehicle frame. Drill 2 holes 9/16" in the frame plate (9) and through the bottom of the vehicle frame. Note: use existing holes in the truck chassis if possible. Tack the frame plate (9) to the side plate (8). Add gussets (14) as necessary.
4. To install the thrust arm place the frame plate (12) against the truck cross member and adjust length of the thrust arm angle (11) that would be in the same line as the lug (13) (the lug (13) needs to be welded to the spreader bar (16)). One 11/16" hole needs to be drilled in the frame plate (12) and the truck cross member. Note: If there is no place for the frame plate to be installed on the vehicle cross member, the frame plate (12) may be installed against the vehicle frame. The thrust arm angle (11) should be again be in same line as lug (13) (to be bolted to the lug) and welded to the frame plate (12). Drill 3 holes 9/16" in the top of the frame plate (12) and the vehicle frame. Note: use existing holes in the truck chassis if possible.
5. Note some of the pieces above need to be trimmed for the best fit.
6. Finish welding and paint all parts.
7. Install welded mounting bracket and thrust arms. Install all bolts and torque all fasteners according to torque chart.

8. Install lift frame (1). Slide lift frame (1) inside of spreader bar (16). Insert mounting pin (4) in top holes of the spreader bar (16).
9. Fasten lift channel (2) and lift cylinder to the lift frame (1) using 3/4"x3 1/2" bolts (17) and 3/4" lock nut (19). Use 3/4" rivet and lynch pin to attach lift cylinder (lift cylinder needs to be installed after power unit is installed). NOTE: *Do not over tighten as this assembly must be able to pivot.*
10. Torque all fasteners according to torque chart.
11. Use 1/4"x1" bolt (27), 1/4" lock washer (28) and 1/4" hex nut (30) to fasten blade guides (6) to plow.
12. See separate installation instructions for the hydraulic pump, wiring and controls.

TORQUE CHART (FT. LB.)		
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
<i>Note:</i> Torque values are for plated bolts only		