TUFFY WEIGHT KIT OEM-290-265 Fit-Up for New BRONCO Frame

This Fit-Up is an interim solution for those few cases that may arise between now and when Engineering has developed a permanent solution.

This Fit-Up solution is a fix that <u>does not</u> require updating to any future Engineering solution.

Read through the "Introduction", "WARNING", "Kit Contents" and "Tools Required" sections of the Instructions that came with the OEM-290-265 Weight Kit, then follow the instructions below.

Additional Parts Supplied: (to be used in conjunction with select hardware that came with the OEM-290-265 Weight Kit.)

(Qty- 2) 710-1314A: 5/16"-18 x .75" Lg: GR8: Socket Head Cap Screw (SHCS)
(Qty- 2) 710-3103: 5/16"-18 x 2.00" Lg: GR5: Hex Head Cap Screw (HHCS)
(Qty- 4) 736-0264: .330" x .630" x .063": Washer:Flat
(Qty- 2) 736-0430: .350" x 1.59" x .063": Washer:Flat
(Qty- 2) 712-04063: 5/16"-18: GRF: Flange Lock Nut (Nylon)

Additional Tools Required: (In addition to the **Tools Required** listed on the OEM-290-265 Instruction sheet)

1/4", 3/8" and 1/2" High Speed drill bits
Drill press w/ chuck capacity for 1/2" drill bit
2 "C" clamps or drill press table clamps
T-45 Torx Drive Bit and appropriate Ratchet

Frame Weights Modification: (Rework both frame weights in the same manner)

1. Position frame weight onto the drill press table and align the 1/4" drill bit (in chuck) with the **<u>center</u>** of the counter bore shown in Figure 1. Clamp the weight securely to the drill press table.
2. Using a 1/4" drill bit, drill through the center of the web area of the counter bore.
3. Change the drill bit to the 3/8" and open the 1/4" diameter hole to 3/8" diameter.
4. Change the drill bit to the 1/2" and open the 3/8" diameter hole to 1/2" diameter.

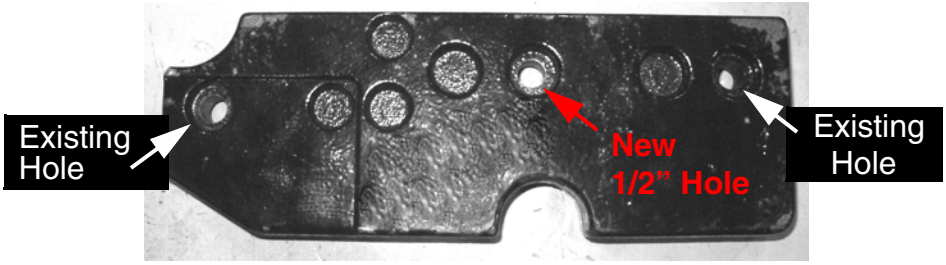

FIGURE 1

Installation: (Left hand side of frame is presented in photos)

5. Place a block beneath the transmission so that the left wheel is suspended off the ground.
6. Remove the Klik pin (or hairpin cotter and clevis pin) that secures the wheel to the axle. Remove the wheel.
7. Remove and retain the existing hardware (if later the weights are removed) as shown from the frame rail. See Figure 2.

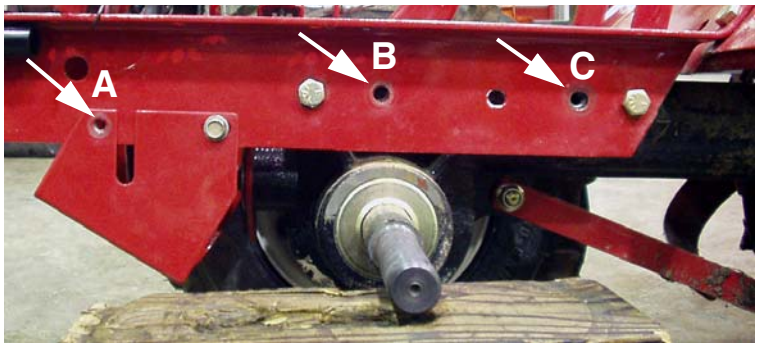

FIGURE 2

8. Place a 736-0264 flat washer onto a 710-1314A Socket Head Cap Screw and install in the hole marked “C” thereby securing the rear transmission mounting boss to the frame. Tighten securely. See Figure 3.

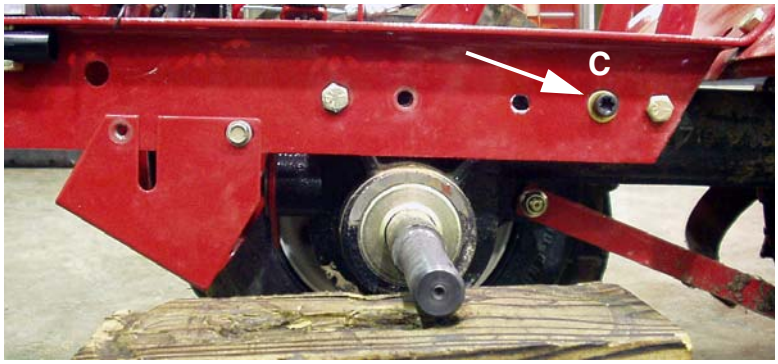

FIGURE 3

9. Place a 736-0264 (.330 x.630 x.063) Flat Washer onto a 710-3103 (5/16”-18 x 2.00” HHCS) Screw.
10. Insert the 710-3103 into the “B” hole in the weight.
11. Place a 736-0430 Large Flat Washer onto the 710-3103 so that the large washer will between the weight and the frame.
12. Refer to Figure 4. Align the weight, with bolt and washers, onto the frame so that the bolt goes through the “B” hole in frame and the lower handle.
13. Install a 712-04063 Lock Nut onto the bolt thereby attaching the handle and weight to the frame. DO NOT tighten, allow frame weight to be move.
14. From the original weight kit hardware pack, locate the 1100811 (1/4”20 x 1.5”, GR5) screws, the 736-0463 (.25 x.630 x.05) Flat washers, and 712-0287 1/4”-20 GR2 Hex Nuts.
15. Place a 736-0463 Flat Washer onto the 1100811 screw.
16. Insert the screw /washer assembly into the forward most frame weight hole “A”. Align the frame weight and screw with the hole in the frame and thread it into the hole. DO NOT tighten, allow frame weight to move. See Figure 4.

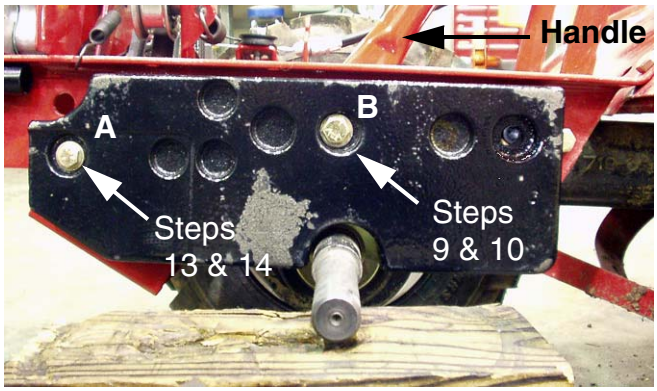

FIGURE 4

17. While pushing the frame weight up and to the rear on the frame, tighten the 5/16”-18 hardware (“B”) securely. See Figure 5.

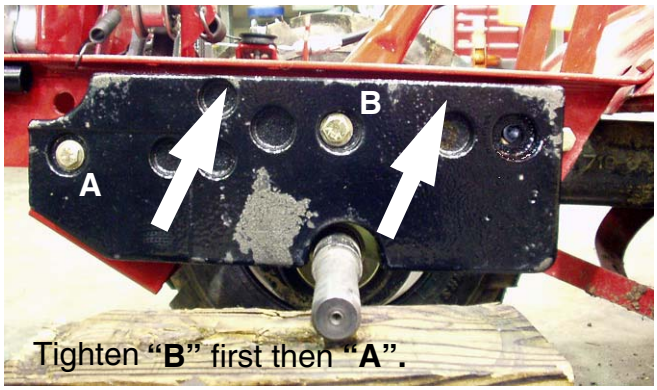

FIGURE 5

18. Tighten the 1/4”-20 screw at “A”. Install the 712-0287 1/4”-20 GR2 Hex Nut onto the 1/4”-20 screw from the inside of the frame and tighten securely.
19. Replace the wheel and Klik pin (or hairpin cotter and clevis pin).
20. Perform Steps 5 through 16 for the right side.

This completes the installation.