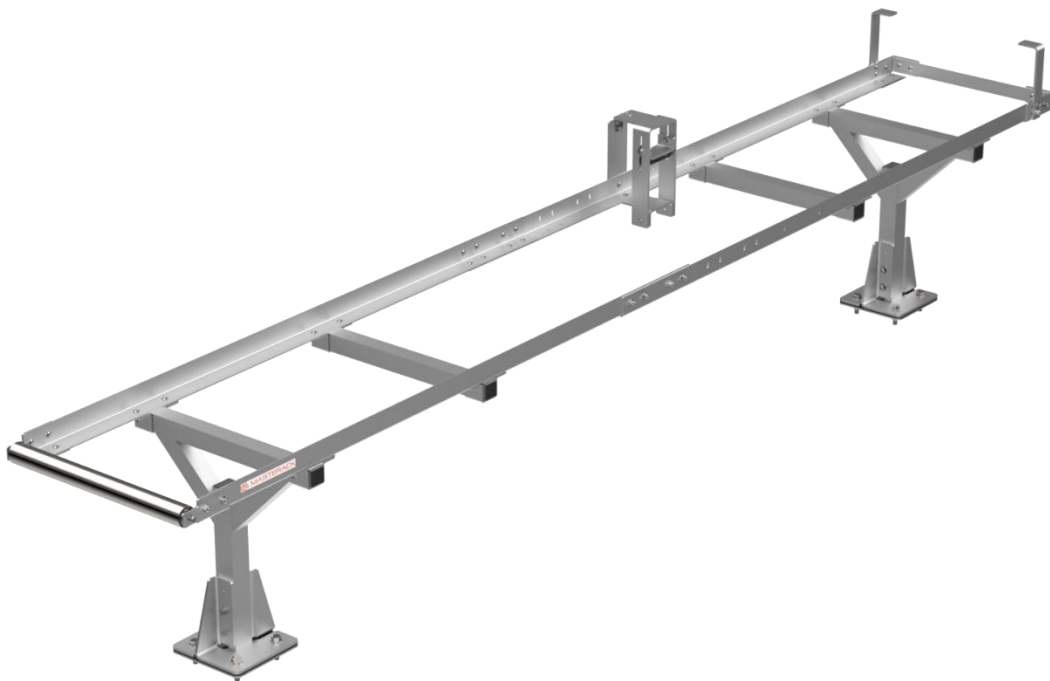




STANDARD WORK INSTRUCTIONS



SERVICE BODY LADDER RACK (STRAIGHT)

02S237KP AND 02S239KP

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STANDARD WARNING

- Read work instructions in entirety before starting.
- Check that you are properly clear of gas tank and wires before drilling.
- Contact Masterack engineering at 1-800-222-8785 if questions arise, or the document needs to be updated.
- Follow all listed OEM system functionality checks after installation.

PART IDENTIFICATION / BOM

Item Number	Description	Qty-UM
02S237KP	SB L/R 10FT & 11FT STRAIGHT	1
02S246	LOCK MECHANISM SA	1
02S247	GUSSET SUPPORT	4
02S253	SHT 0.13 L BEND CS FRT	1
02S254	SHT 0.13 L BEND RS FRT	1
02S255	BRKT STOPR FRT RH	1
02S256	BRKT STOPR FRT LH	1
02S257	BRKT TUBE SUPPORT	4
M8S01252	TUBE SQ 1.75X0.13X20.5	2
02S259	BRKT SIDE SUPPORT	2
02S260	SHT 20.25X1.5X0.13	1
02S261	SHT 0.13 L BEND CS	1
02S262	SHT 0.13 L BEND SS	1
02S263	BRKT ROLLER LH	1
02S264	BRKT ROLLER RH	1

02S269	MTG PLT 8.00X8.00X0.19	2
02S271	SPCR SHEET	2
02S313	WLDMT FRAME STRAIGHT	2
RM570711	RLR CONVEYOR 1.9 DIA	1
RM560703	CAP TUBE 1.56 POLYE	8
RM560704	GASKET RUBBER SQ 8 X 1/8 EPDM	2
RM560707	CAP TUBE 2.00 POLYE	2
02S307	SB L/R HARDWARE KIT	1
02S239KP	SB L/R 9FT STRAIGHT	1
02S310	SHT 0.13 L BEND CS 9FT	1
02S311	SHT 0.13 L BEND RS 9FT	1

RECOMMENDED TOOLS

- Impact Driver
- Torque Wrench



- 1/2 Socket



- 3/8 Socket
- 1/4 Socket

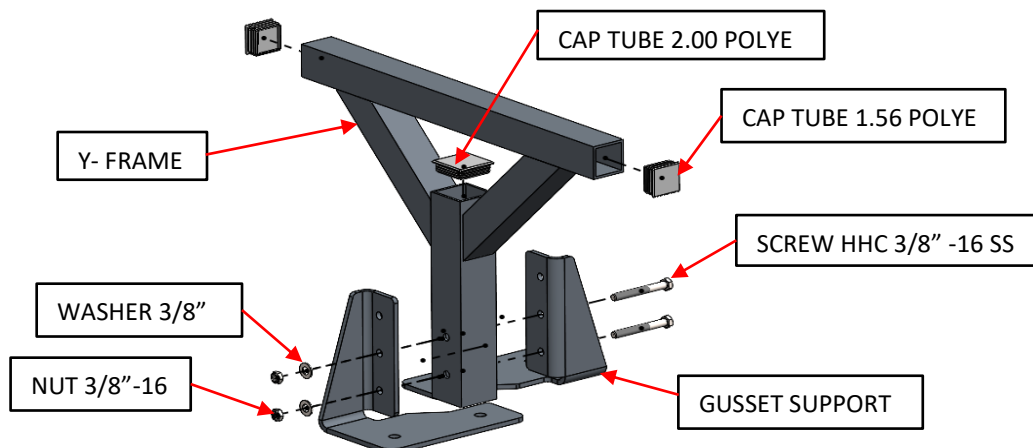
TORQUE TABLE

SIZE	TIGHTENING TORQUE
1/2-13 (0.500)	106 ft lbs.
3/8-16 (0.375)	44 ft lbs.
1/4-20 (0.250)	12 in lbs.

ASSEMBLY

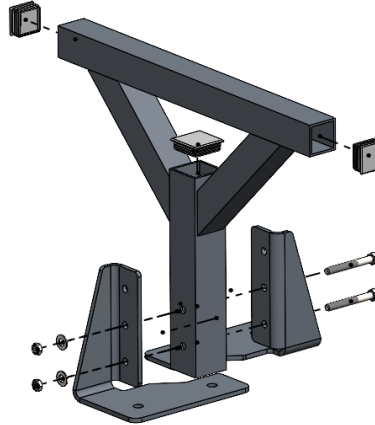
1.1 Y- FRAME SUB ASSEMBLY FRONT

- PLACE (1) Y-FRAME & (2) GUSSET SUPPORT on workbench, assemble using (2) SCREW HHC 3/8" -16 X 3" SS & (2) WASHER 3/8", (2) NUT 3/8"-16, As shown in the picture below.



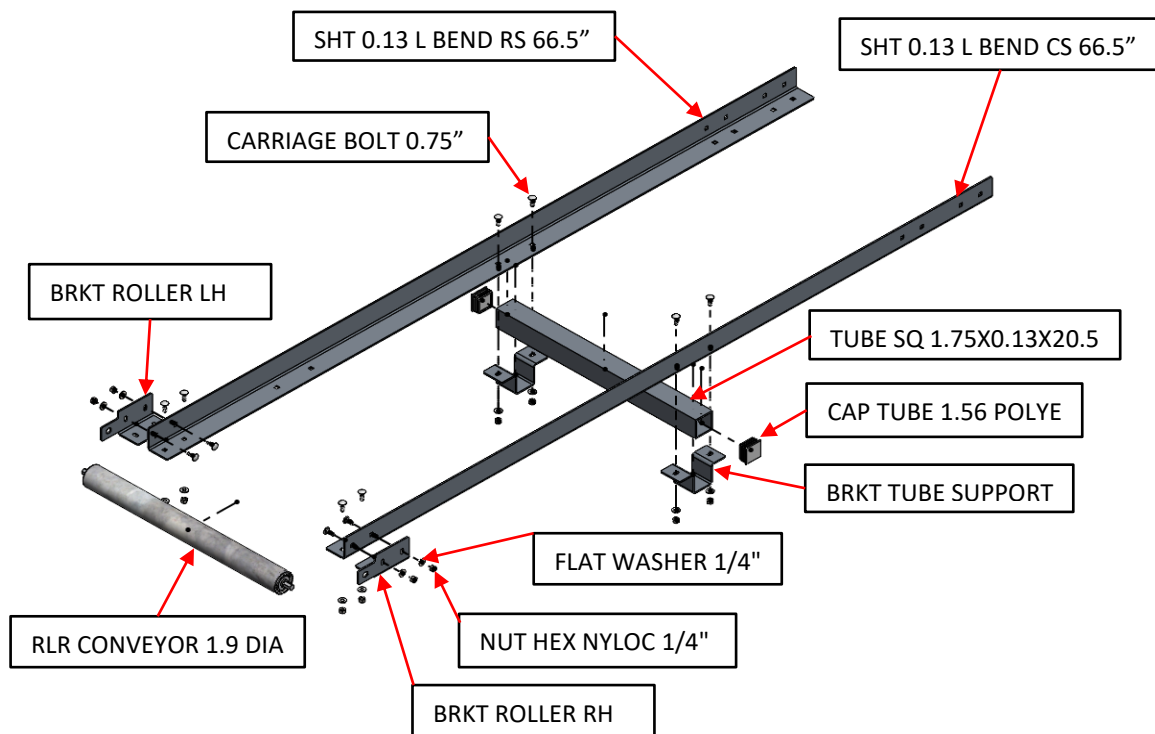
1.2 Y- FRAME SUB ASSEMBLY REAR

- PLACE (1) Y-FRAME & (2) GUSSET SUPPORT on workbench, assemble using (2) SCREW HHC 3/8 -16 X 3" SS & (2) WASHER 3/8, (2) NUT 3/8-16, As shown in the picture below.



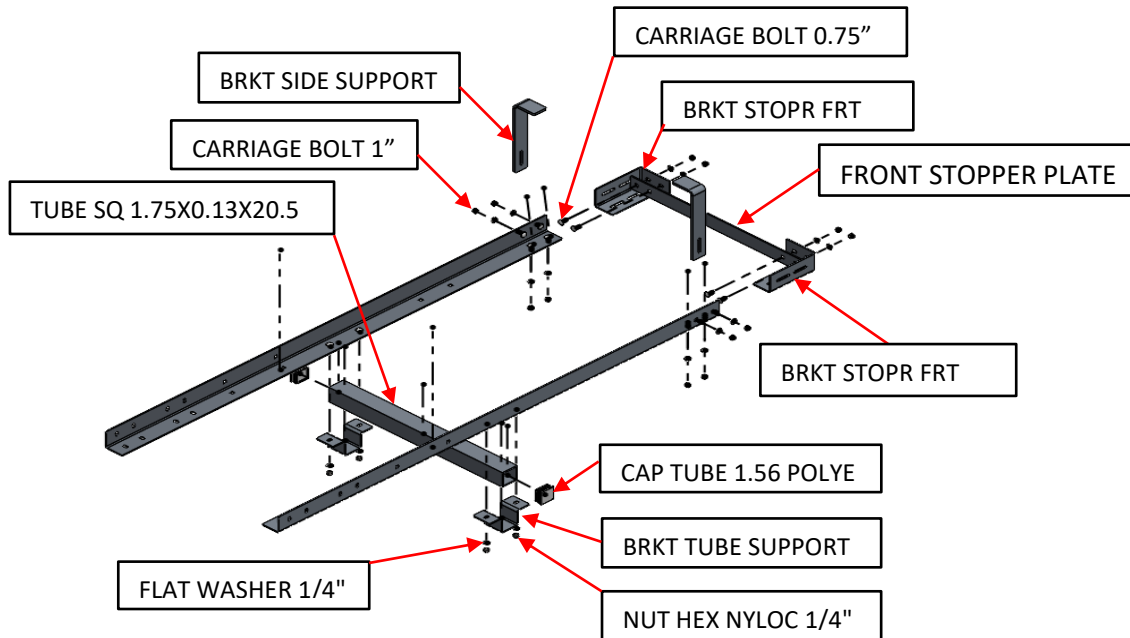
1.3 REAR SIDE RACK ASSEMBLY

- PLACE (2) L-ANGLE and (1) BRKT ROLLER LH & (1) BRK ROLLER RH, (1) CONVEYOR ROLLER on workbench assemble using (8) WASHER 1/4, (8) SCREW SQ NECK 1/4-20-0.75", (8) NUT 1/4-20.
- Assemble (1) SQ TUBE to the L – Angles using (2) BRACKETS TUBE SUPPORT, (4) SCREW SQ NECK 1/4 - 20, (4) NUT 1/4 - 20 & (4) WASHER 1/4 as shown in the picture below.
- INSERT (2) CAP TUBE 1.56 POLYE into the TUBE SQ.



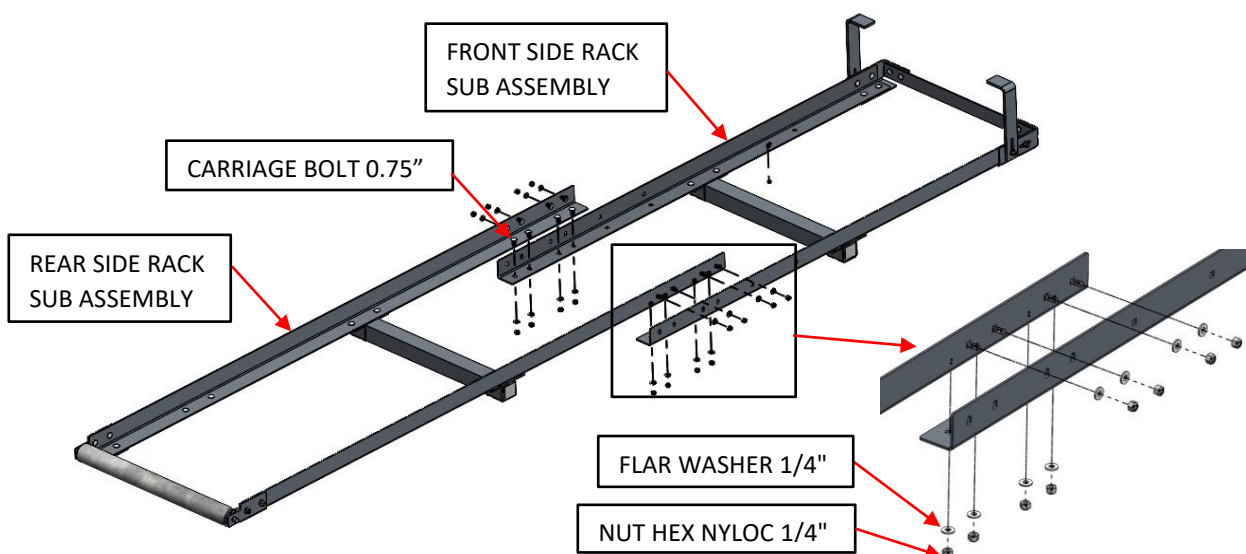
1.4 FRONT SIDE RACK ASSEMBLY

- PLACE (2) L-ANGLE and (1) BRKT ROLLER LH & (1) BRK ROLLER RH, (1) CONVEYOR ROLLER on workbench assemble using (8) WASHER 1/4, (8) SCREW SQ NECK 1/4-20-0.75", (8) NUT 1/4-20.
- Assemble (1) SQ TUBE to the L- Angles using (2) BRACKETS TUBE SUPPORT, (4) SCREW SQ NECK 1/4 - 20, (4) NUT 1/4 - 20 & (4) WASHER ¼ as shown in the picture below.
- Assemble (2) BRKT SIDE SUPPORT to the L- Angles using (4) SCREW SQ NECK 1/4 - 20, (4) NUT 1/4 - 20 & (4) WASHER ¼ as shown in the picture below.



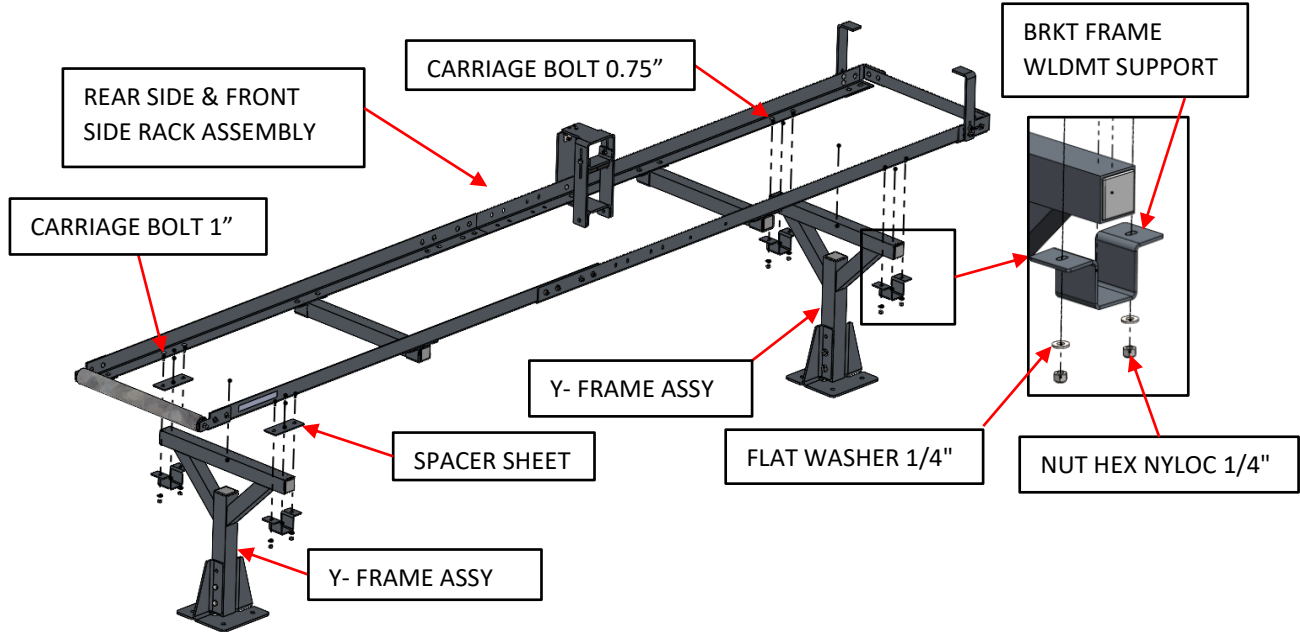
1.5 FRONT AND REAR SIDE RACK ASSEMBLY

- PLACE (1) FRONT SIDE RACK SUB ASSY and align with (1) REAR SIDE RACK SUB ASSY, assemble using (16) SCREW SQ NECK 1/4 - 20, (16) NUT 1/4 - 20 & (16) WASHER 1/4 as shown in the picture below.



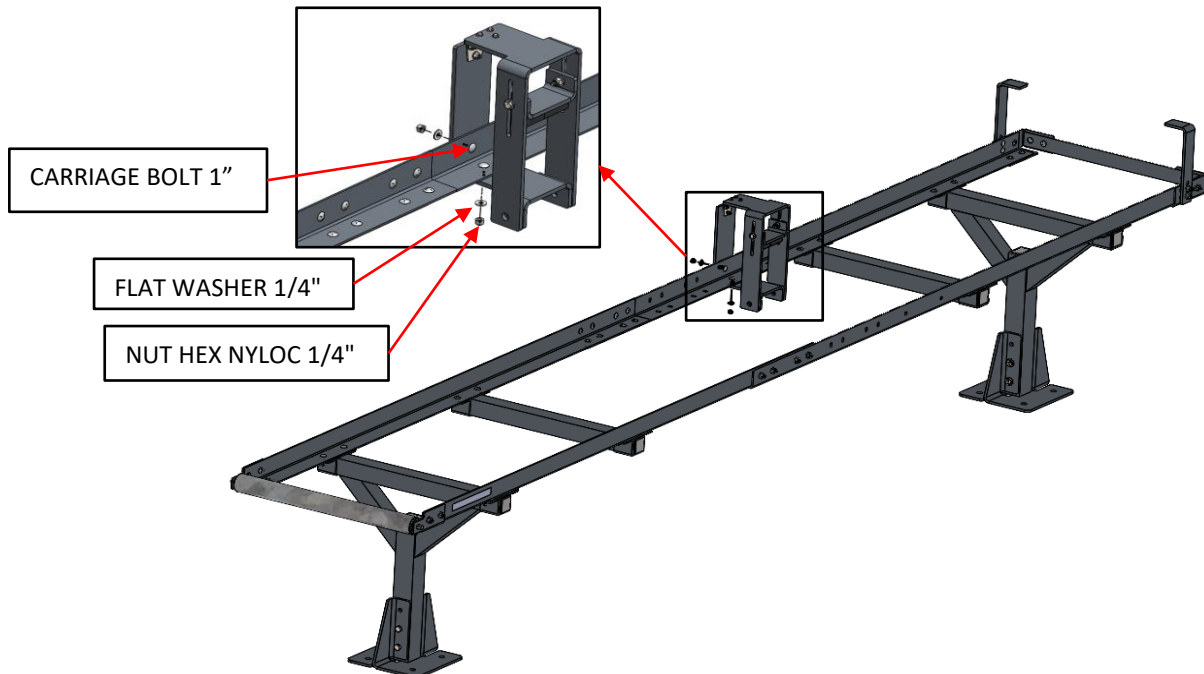
1.6 FRONT AND REAR SIDE RACK ASSEMBLY ON Y - FRAMES

- PLACE (1) Y- FRAME ASSY REAR and (1) Y- FRAME ASSY FRONT on workbench, assemble FRONT AND REAR SIDE RACK ASSY using (4) BRACKET FRAME, (8) SCREW SQ NECK 1/4 - 20, (8) NUT 1/4 - 20 & (8) WASHER 1/4 as shown in the picture below.



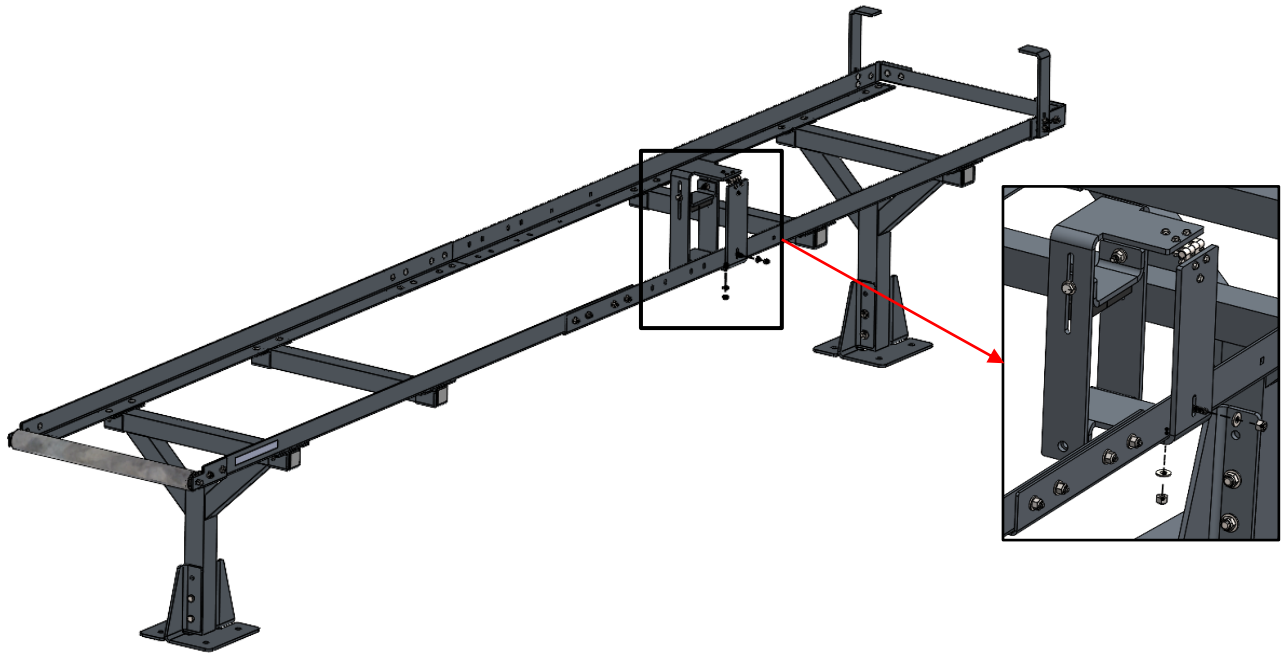
1.7 LOCK MECHANISM ASSEMBLY ROADSIDE

- Ladder rack mounts on the Roadside of the service body, assemble the lock mechanism on the front rack of the street side as shown in the picture below.



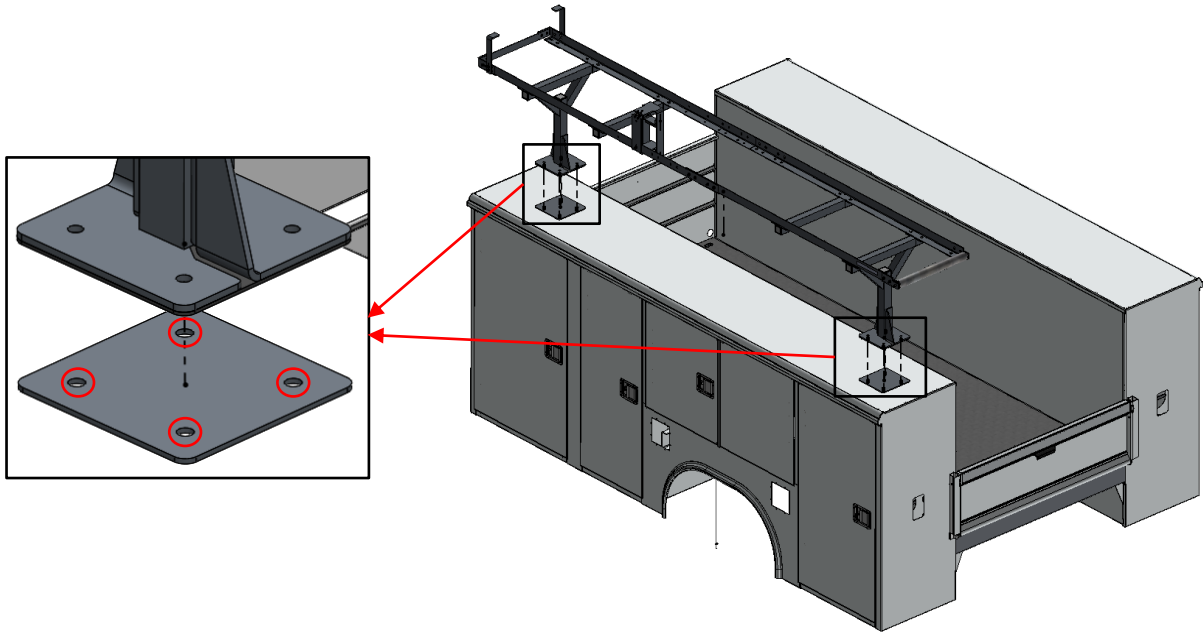
1.8 LOCK MECHANISM ASSEMBLY ON CURBSIDE

- Ladder rack mounts on the curb side of the service body, assemble the lock mechanism on the front rack of the curb side as shown in the picture below. (Same fasteners would be used here).

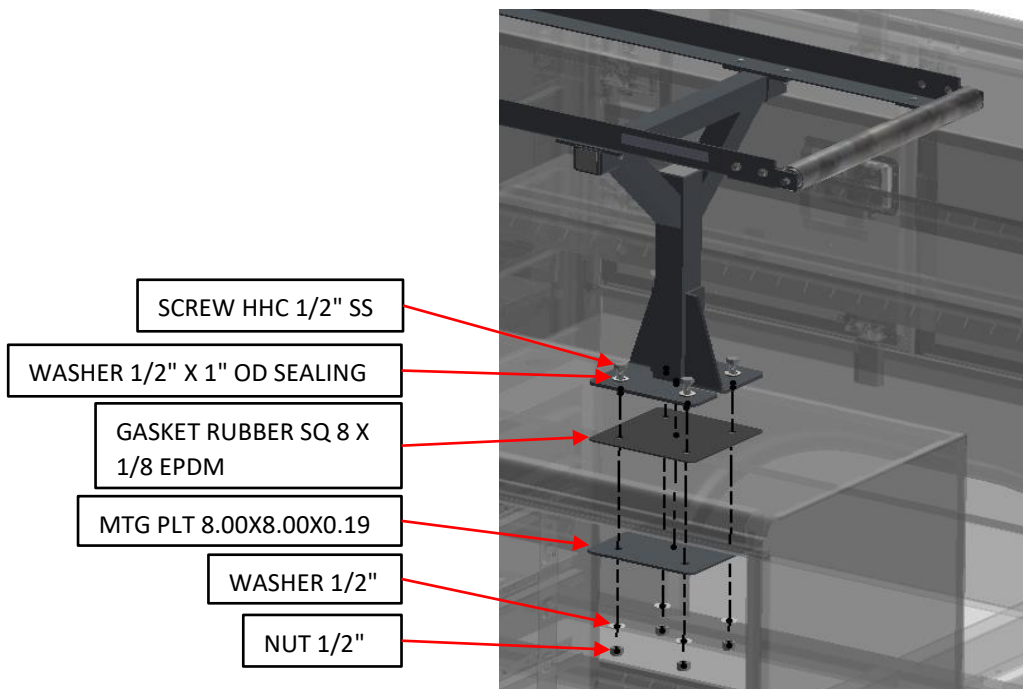


2. INSTALLATION INSTRUCTION

- Mark the holes on the service body by positioning the ladder rack assembly according to the desired location as shown in the picture below.



- Drill holes on the markings using 1/2" Drill bit by placing the Ladder rack assembly on Service Body.
- PLACE (1) GASKET RUBBER SQ 8 X 1/8 EPDM on Service body align with holes and place (1) Ladder rack assembly, align (2) MOUNTING PLATE and assemble using (8) SCREW HHC 1/2" - 13, (8) WASHER 1/2" X 1" OD SEALING, (8) WASHER 1/2" and (8) NUT 1/2" -13.



TITLE: SERVICE BODY LADDER RACK		
DOCUMENT #: WI-02S238KP	LABOR HOURS: 1.0	PRINT DATE: 8/2/24
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EFFECTIVE DATE: 7/15/2024	REVIEWED BY: SK	DATE REVIEWED: 7/15/24
FUNCTIONAL DEPARTMENT: ENGINEERING	APPROVED BY: SK	DATE APPROVED: 7/15/24

STANDARD WARNINGS:

- READ WORK INSTRUCTIONS IN ENTIRETY BEFORE STARTING
- CHECK THAT YOU ARE PROPERLY CLEAR OF GAS TANK AND WIRES BEFORE DRILLING
- CONTACT ENGINEERING IF QUESTIONS ARISE OR DOCUMENT NEEDS TO BE UPDATED
- FOLLOW ALL LISTED OEM SYSTEM FUNCTIONALITY CHECKS AFTER INSTALL.