

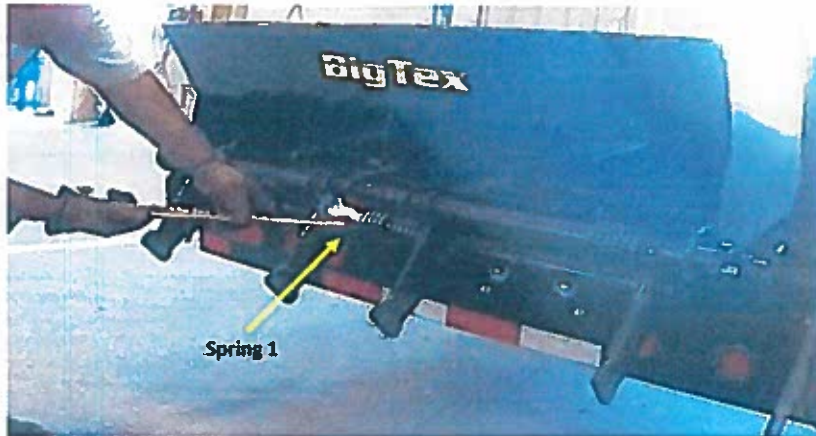
005 -1

25GN Mega Ramp Spring Repair



005-2

1. Cut bottom springs off on each mega ramp bar. (Two springs per mega ramp)



2. Remove keeper bolt on each mega ramp bar. (If bar does not come out, keeper will have to be cut off.)



005-3

3. Remove each mega ramp bar. (Ramps might have to be raised up in order to pull bar.)



4. Remove keeper bolt on each tailboard bar. (If bar does not come out, keeper will have to be cut off.)

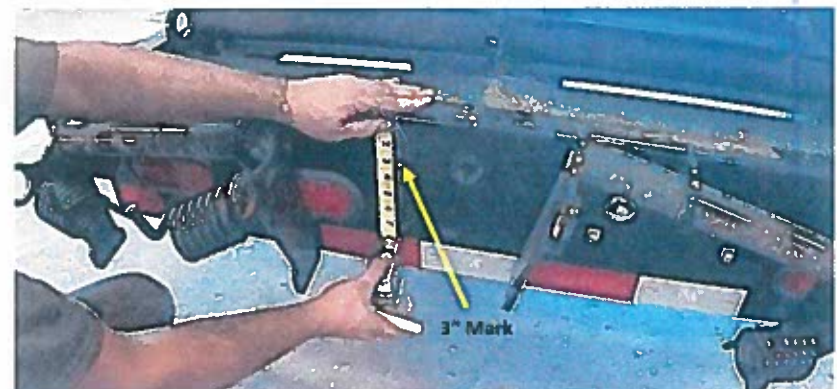
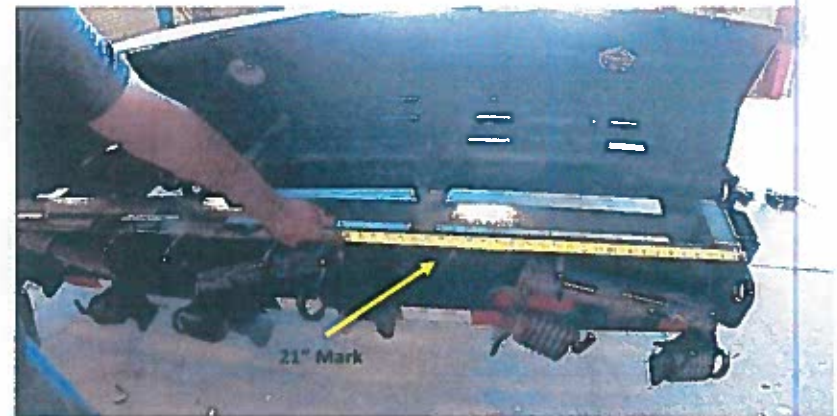


005-4

5. Remove each tailboard bar.



6. Measure and mark 21" from the outside of the tail board and 3" down from the top of the tailboard, on the front and back side on both the driver and passenger sides.



~~005-6~~
005-5

7. Use hole template to mark the holes on the front and back side of the tailboard. Remove stickers and lights in area where holes are marked. (These two new holes are for the additional spring attachment)



8. Cut holes in front and back side of tailboard and use 1" diameter pipe to verify correct holes size.



005-6

9. Place 1" diameter pipe 2 ¼" in length in each hole. Fully weld the pipe on the front side and the top half on the backside of the tailboard.



10. Cut the outer rotating link off on the driver and passenger side at the weld. Cut 1" off of the overall length.



005-7

11. Place each rotating link back on trailer.

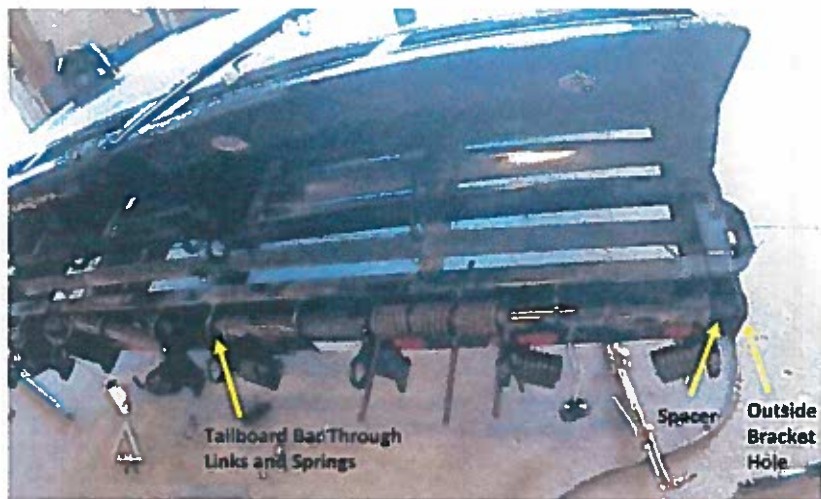


12. Place tailboard straight leg springs in the correct holes. (See diagram 1 for spring configuration)



005-8

13. Run each tailboard bar through the outside bracket hole, apply the 1 7/8" spacer and push bar to other side going through each rotating link and spring.



14. Weld the end of each rotating link.



005-9

15. Tighten keeper bolt. (If keeper was removed weld keeper back onto bar and tighten bolt.)



16. Run each mega ramp bar through the first rotating link with 2 springs. (See diagram 1 for spring configuration)



005-10

17. Place each of the legs on the bottom 3 springs of the tailboard in a holder and raise the ramp until the legs are behind the bar.



18. Place the remaining rotating link with 2 springs on the bar and push it through to the other side and lower mega ramp down. (See diagram 1 for spring configuration)



005-11

19. Tighten Bolt in keeper. (If keeper was removed add keeper back on to bar and tighten screw.)



20. Heat bottom springs legs and bend around bar. After springs are bent cut of remaining spring legs at an angle.



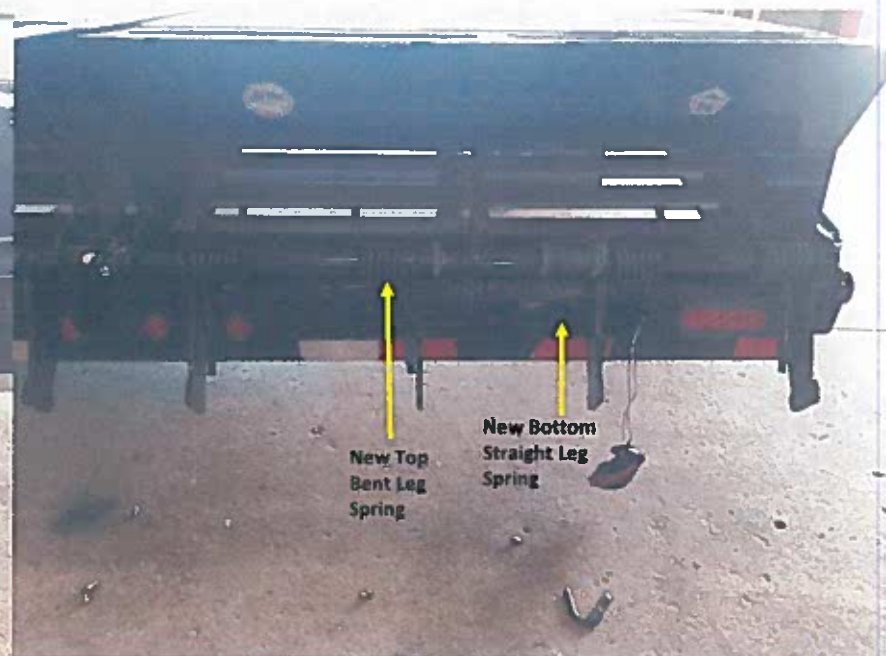
21. Weld tube on the rotating links to hold each new bent leg spring in place from the mega ramp bar. (See diagram 1 for configuration)



Driver Side



Passenger Side

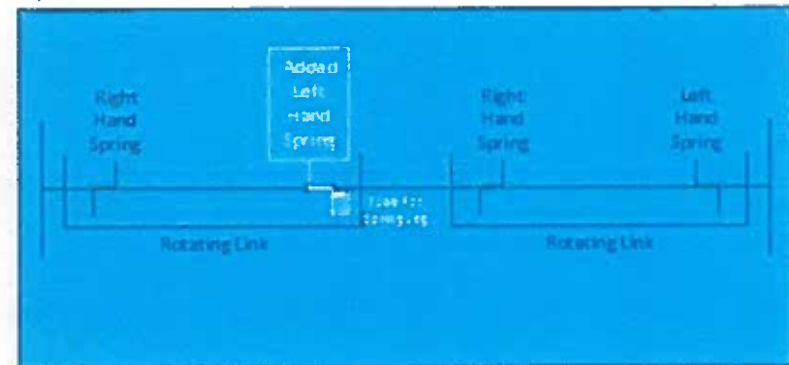
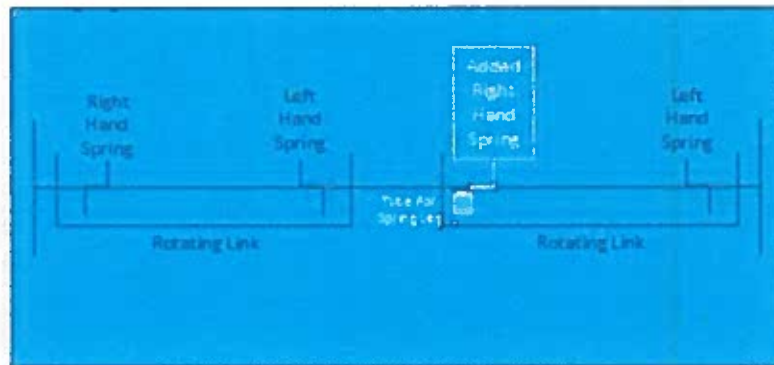


Spring Configuration (Diagram 1)

Driver Side

Mega Ramps

Passenger Side



Driver Side

Tailboard

Passenger Side

