



# **Assembly & Installation Instructions**

**FOR  
LEXAN® REPLACEMENT KIT  
FOR  
BOLT-IN STYLE LEXAN® BLADES  
(Includes Hardware)**

**TO FIT  
72", 80", 88", 90" & 96" PLOWS**



**1. THINK SAFETY, ALWAYS WEAR SAFETY GLASSES WHEN PERFORMING THE OPERATIONS PRESCRIBED IN THESE INSTRUCTIONS**

**2. READ ALL INSTRUCTIONS CAREFULLY BEFORE ATTEMPTING INSTALLATION**

### ASSEMBLY TOOLS NEEDED

Sockets	7/16" – 1-1/8"
Wrenches	7/16" – 1-1/8"
Torque Wrench	
Drill	
Drills	9/32", 11/32", 13/32"
6" C-Clamps (2)	
2" x 4" - 8' long	

### INSTALLATION NOTES

1. Unless specified, mount all components before tightening any bolts.
2. Plow should be mounted on vehicle.
3. Plow should be blocked up a couple of inches to provide clearance between Wearstrip and ground.

### WARNING

**Do not work on unit while suspended by the hydraulic system. Severe injury or death could result from accidental hydraulic system failure.**

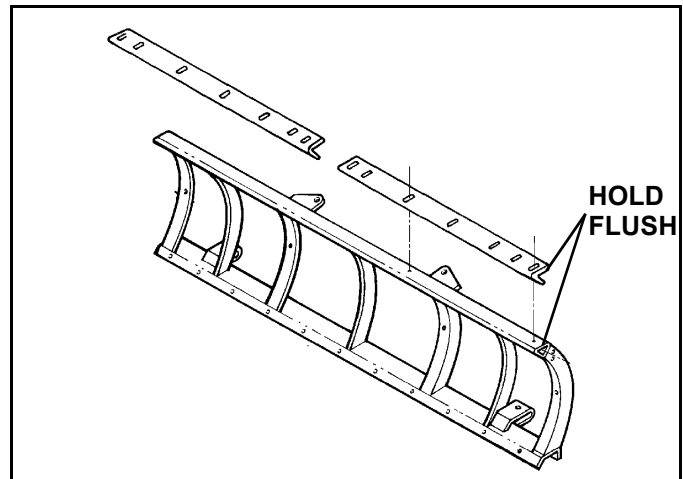
### REMOVAL

1. Loosen the Wearstrip by loosening, but not removing, the Wearstrip mounting hardware.
2. Remove the old Lexan sheet and all Lexan fastening hardware from the Blade Frame.
3. Clean off any accumulated dirt from Blade Rib Faces and from space between Wearstrip and Frame.
4. If there is a Deflector installed on the Blade Assembly remove it at this time.

### PREPARATION

*NOTE: If the unit was not equipped with a Deflector new mounting holes will have to be drilled to accommodate the new style mounting hardware. See steps below.*

1. Position the new Retainer Plates on the top rail of the Blade Assembly with the Retainer Plate Slots on the top surface of the top rail and flush with the outer ends of the top rail. (See Figure 1-1)



**Figure 1-1**

*NOTE: There will be a gap in the center of all but the 80" and 96" blade assemblies.*

2. Mark and centerpunch the top rail of the Blade Assembly using the slotted holes in the Retainer Plates as a template. Set Retainer Plates aside.

**IMPORTANT: Center punch at the center of the slotted holes.**

3. Drill a 9/32" hole at each marked location.
4. Enlarge two (2) end holes to 13/32".
5. Remove protective masking from one side of new LEXAN® Sheet. Loosen masking at top and bottom edge of opposite side.

## INSTALLATION

1. Align ends of LEXAN® Sheet with ends of Plow Frame and, with masked side away from Plow Frame, insert lower edge of LEXAN® Sheet in space between Wearstrip and Plow Frame.
2. Place 2x4 on face of LEXAN® Sheet and clamp to frame with a C-clamp at each end. (See Figure 1-2)

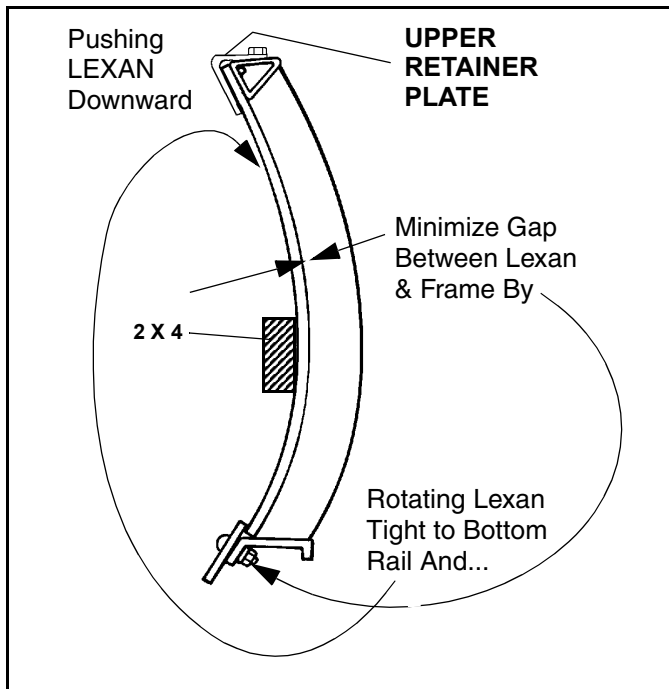


Figure 1-2

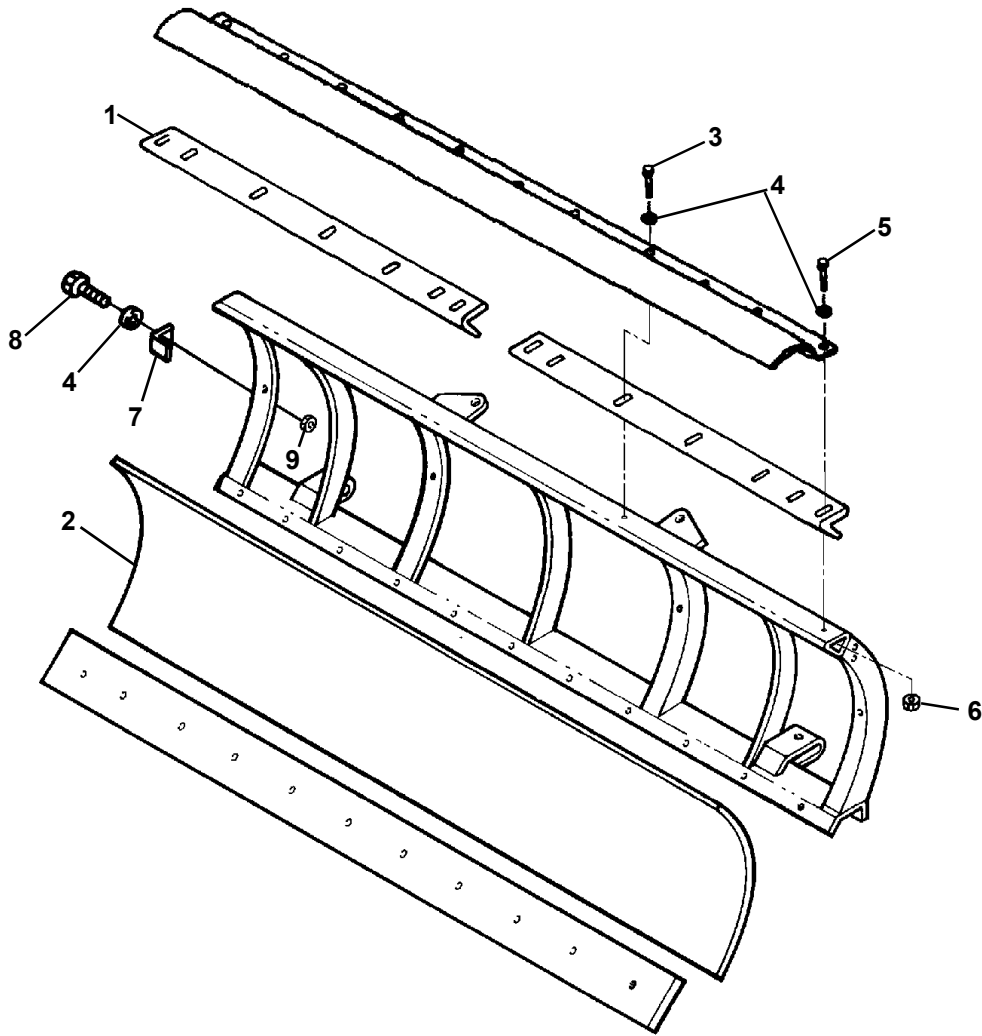
3. Slowly tighten clamps. At the same time force LEXAN® Sheet down into space between Wearstrip and Frame.
4. When LEXAN® Sheet is tight against frame, and securely seated against Wearstrip, Install the upper Retainer Plates over the upper edge of the LEXAN® Sheet and over the top rail of the Blade Frame. If a Deflector is to be installed put it in place over the Retainer Plates and secure both with 5/16" x 1" Self Tapping Screws, and Flat Washers provided. Tighten all hardware to 15 lb-ft.

*NOTE: Use 3/8" x 1-1/4" Capscrew, Flat Washers and Nylock nut on two outer holes. Torque to 30 lb-ft.*

5. Tighten all fasteners in Wearstrip to specifications in Torque Specification Chart below.
6. Position End Retainer Clips at approximately the center of the end rib, mark and drill to 11/32" and secure with 5/16" Capscrew, Flat Washer and Nylock nut provided. Tighten to specifications in Torque Specification Chart Below.
7. Remove C-clamps and 2x4.
8. Remove protective masking from front side of LEXAN® Sheet.
9. Remove Blocking.

TORQUE SPECIFICATIONS FOR STANDARD MACHINE HARDWARE					
Bolt Size	GR.2 Dry	GR.5 Dry	GR.8 Dry	Metric Size	GR.8.8 Dry
1/4"	66*	9	12	M8	17
5/16"	11	17	25	M10	35
3/8"	20	30	45	M12	60
7/16"	32	50	70	M14	95
1/2"	50	75	110	M16	155
9/16"	70	110	150		
5/8"	100	150	220		
3/4"	175	260	380		
7/8"	170	430	600		
1"	250	640	900		

Note: These torque values are to be used for all hardware. Unless otherwise specified, all torque values must meet this specification.  
 Note: All torque values are in Ft.-Lbs unless otherwise stated  
 Note: \*In-Lbs



ITEM	PART NO.	DESCRIPTION	QTY.
1	96101281	Plate, Retainer - (for 72" Blades) .....	2
	96101282	Plate, Retainer - (for 80" & 88" Blades) .....	2
	96101283	Plate, Retainer - (for 90" Blades) .....	2
	96101284	Plate, Retainer - (for 96" Blades) .....	2
	96101360	Sheet, LEXAN® (for 1572 Blade) .....	1
2	96101361	Sheet, LEXAN® (for 1580 Blade) .....	1
	96101362	Sheet, LEXAN® (for 2380 & 2480 Blade) .....	1
	96101363	Sheet, LEXAN® (for 2388 & 2488 Blade) .....	1
	96101364	Sheet, LEXAN® (for 2590 Blade) .....	1
	96101365	Sheet, LEXAN® (for 2596 Blade) .....	1
3	98019176	Screw, Self Tapping .....	12
4	98019230	Washer, Flat .....	16
5	98019034	Screw Hex, 3/8" x 1-1/4" .....	2
6	98019009	Nut, Nylock, 3/8" .....	2
7	96100213	Bracket, Retainer .....	2
8	98009149	Screw, Hex 5/16" x 1" .....	2
9	98009038	Nut, Nylock, 5/16" .....	2

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