

REVISIONS				
ZONE	REV	DESCRIPTION	DATE	APPROVED

The U-bolt must be clean of any arc strikes, gouges, nicks and cracks. The U-bolt legs must be straight. All threads must be clean and free of galled or stripped threads.

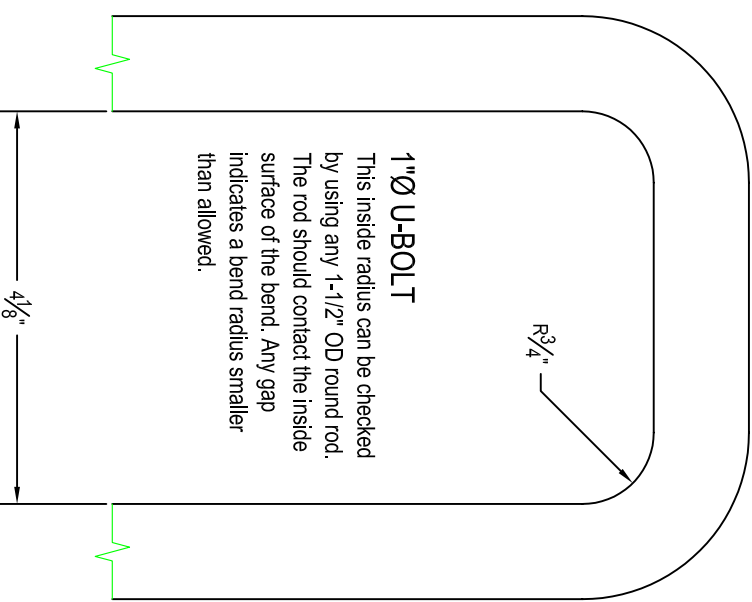
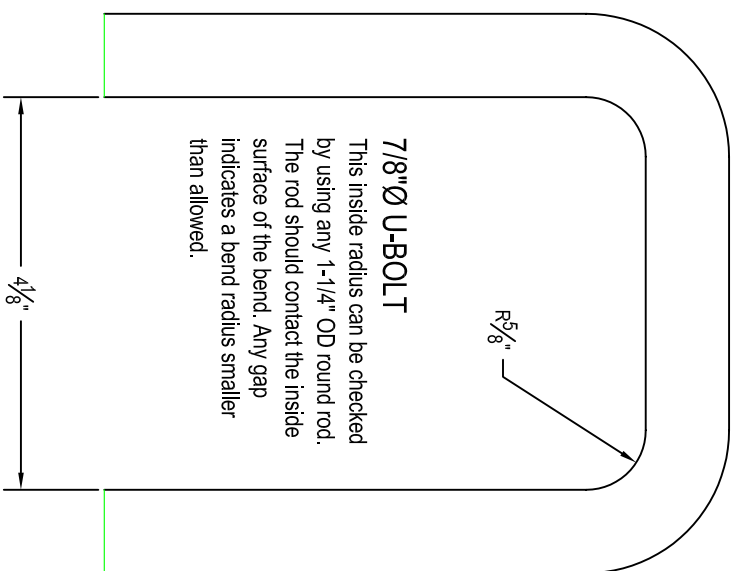
This U-bolt must be discarded and replaced with a conforming U-bolt.

U-bolt leg lengths range from 14" to 21" in length. Legs must be straight and parallel.

Threaded rods are acceptable. 7/8 - 14UNF minimum AISI 4140 annealed used with recommended "Arctic" tie-plates.

Care must be taken not to over torque U-Bolts/Rods. Frame flange and web buckling may occur.

Size	Mn. Torque
3/4" UNF	Clean-Oiled 200 ft/lb
7/8" UNF	225 ft/lb
1" UNF	240 ft/lb



**ARCTIC MANUFACTURING LTD.**  
 3323 HART HIGHWAY, PRINCE GEORGE, B.C. V2K 1M8  
**ARCTIC CAB-GUARD MOUNT**  
 U-Bolt Guide

BAS/00-02	SIZE A	FSCM NO.	DWG. NO. WCBCG-U-Bolt.DWG	REV 1
	SCALE N/A			SHEET