	Document Title				Document #	Revision
	Inframe Truck Box Installation Instructions				105250	A
	Author	Checked By		Effective Date	DCN #	Page 1
MJL	GRE	BAG	3/12/2020	264		

Inframe Truck Box Installation Instructions

- Review Figure 1 and specifications below to verify fit of the box to the truck.

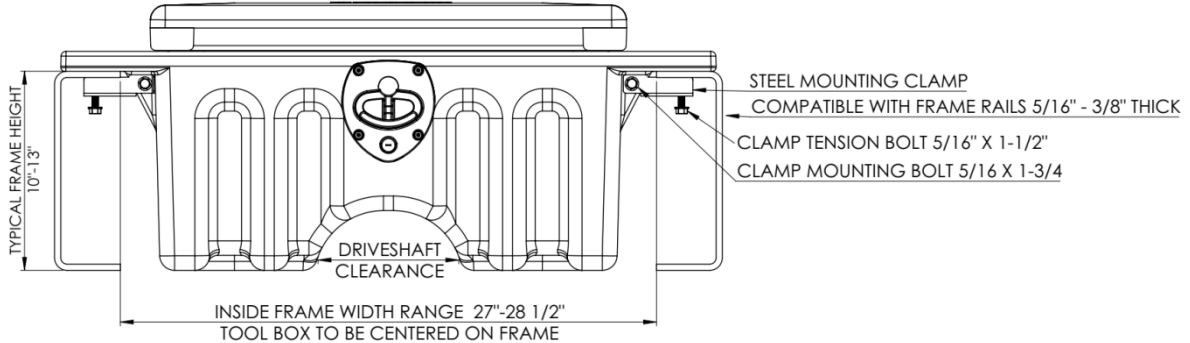


Figure 1. Inframe Truck Box Installation Drawing

- The Inframe truck box is designed for 27" to 28.5" wide frame openings.
 - The mounting clamps are compatible 5/16" or 3/8" thick frames.
 - Verify that there is clearance between the box and the driveshaft. Also confirm that there is no interference when the driveshaft is in motion.
 - Maximum weight capacity of truck box contents = 200 lbs.
 - Maximum weight of operator standing the cover = 350 lbs.
 - The Inframe truck box can also be used to hold batteries
 - See page 2 for further details
- Remove the clamps, nuts, bolts, Primer 94 and VHB tape strips shown in Figure 1 from the mounting kit bag.
 - Place the truck box on the frame rails and mark the desired position.
 - For best performance, Minimizer recommends that the truck box be centered in the opening between the frame rails if possible.
 - Remove the truck box from the frame and place it on its top to prep the bottom surface of the mounting flange.
 - Four strips of VHB tape are included to prevent the truck box from sliding on the frame.
 - Mark locations for tape strips at the (4) outer corners of the poly flange.
 - Verify that the strips are placed properly to make full contact with the truck frame
 - Apply Primer 94 to the bottom of the poly truck box flange to remove oil from the surface of the plastic
 - Allow the Primer 94 to dry for 5 minutes
 - Attach VHB Tape Strips to bottom flange of the truck box
 - Press on the tape strip for 30 seconds or roll it with a J-roller for optimal bond strength.
 - Remove the backing from the VHB tape strips and place the truck box at the desired location on the truck frame.

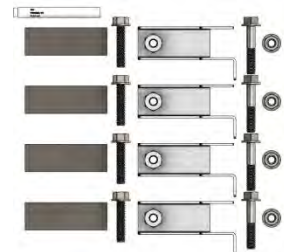



Figure 2. Mounting Kit



Figure 3. Apply Primer 94 to Mounting Flange



Figure 4. VHB Tape Locations

	Document Title				Document #	Revision
	Inframe Truck Box Installation Instructions				105250	A
	Author	Checked By		Effective Date	DCN #	Page 2
MJL	GRE	BAG	3/12/2020	264		

7. Use (4) 5/16 x 1.75" bolts provided to attach the mounting clamps to the existing holes in the outer gussets of the box.
 - a. Align the mounting clamps so they are flush against the frame rail prior to tightening.
 - b. **Tighten the mounting bolts to a torque of 13 Ft. Lbs.**
8. Turn the 5/16"x1.5" clamp tension bolt into the weld nut on the mounting clamp.
 - a. Turn until the bolt makes contact with the frame and creates downward force on the metal clamp.
 - b. The bolt will turn hard since the weld nuts have distorted (locking) threads. Use a 1/2" socket or ratcheting wrench to turn the bolt.

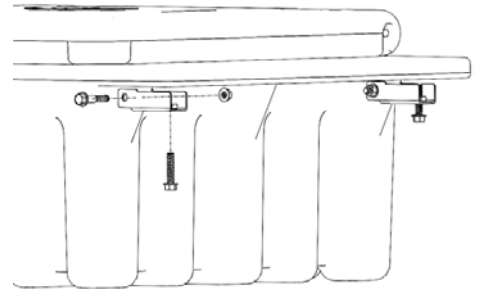


Figure 5. Mounting Clamp Install

Battery Box Application Recommendations

1. The Inframe truck box has ample space to hold (2) Group 30 or Group 31 truck batteries as shown in Figure 6.
2. Minimizer offers a battery hold down kit (Part # 105243) for this application (Figure 7) to be purchased separately.
3. Vent holes are required when storing batteries in the truck box (one near each battery). Drill 1/4" vent holes thru one layer of the center gusset on each end of the box.
4. Add holes in the rear wall of the box for battery cable entrance points. Use rubber grommets (not supplied) in the cable holes to protect the battery cables from wear.
 - a. Do not drill through the cover of the box.



Figure 6. Battery Box Application

Battery Hold Down Kit Installation

1. Battery hold down kit 105243 (shown in Figure 7) is designed for use with Group 30 or Group 31 batteries.
2. Place the batteries in the box and mark optimal locations.
3. Use the paper template provided to locate and drill (8) 1/4" clearance holes for the U-bolts in the box (see Figure 8).
4. Install the (4) U-bolts, (8) jamb nuts, and (4) washer plates on the inside at the bottom of the truck box.
5. Add (4) washer plates and (8) nylon locking nuts on the outside bottom surface of the box and tighten until snug.
6. Install j-hooks and poly battery clamp. Use the flat washers and (4) nylon locking nuts and tighten them until snug.

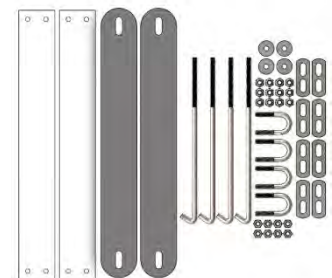


Figure 7. Battery Hold Down Kit

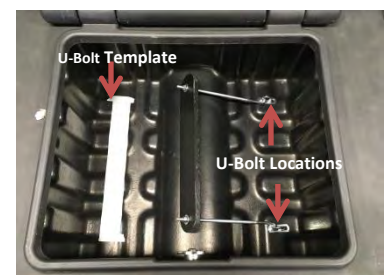


Figure 8. Battery Hold Down Install