



**INSTALLATION INSTRUCTIONS
EATON 4 BOLT CAM FLANGE, 20K AXLE
Kit # B6684SBA**

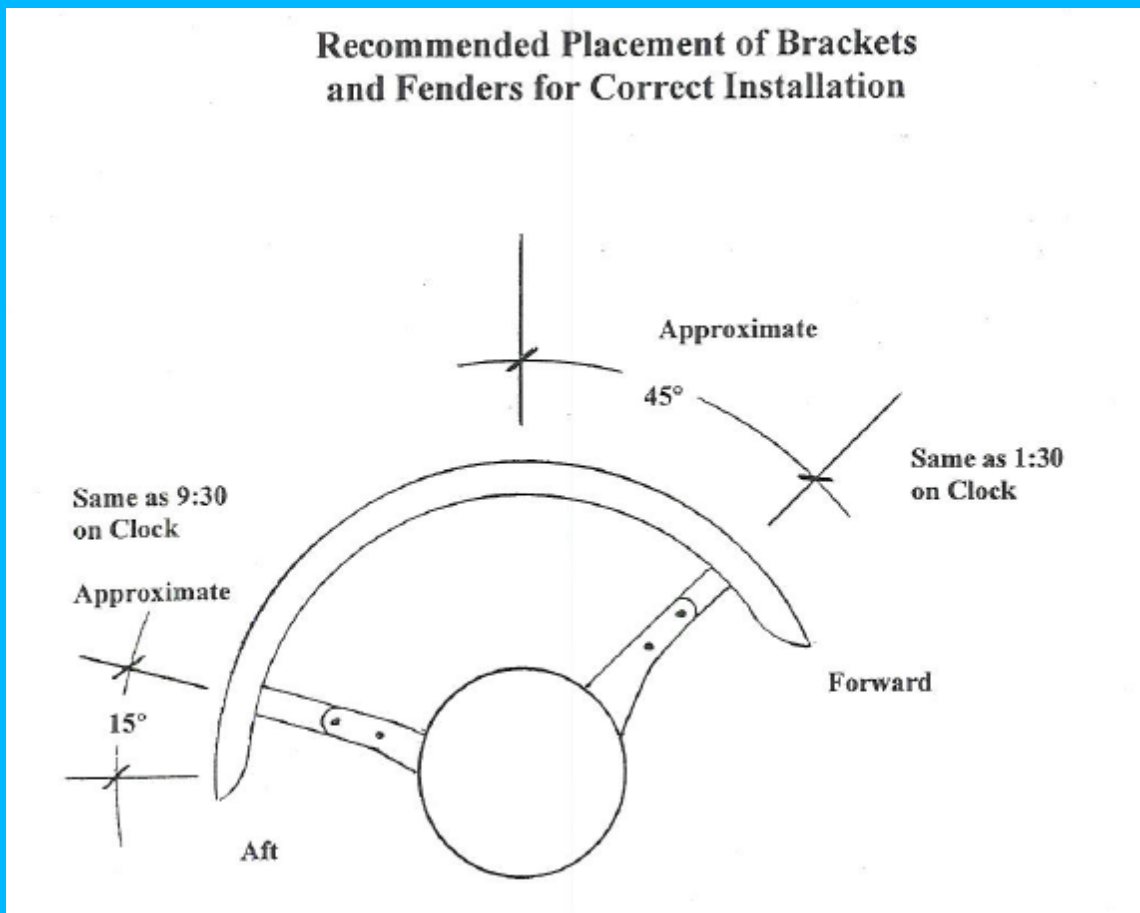


*****BOLTS ARE ONLY PROVIDED FOR STEPS 8 & 9. BOLT SIZES VARY IN STEPS 1-7 DEPENDING ON THE APPLICATION AND ARE NOT PROVIDED.***

1. Remove the hub & drum assembly (with outboard hubs, you may only have to remove the drum).
2. Remove the lower three backing plate to spindle bolts on the rear side of the spindle.
3. Install the PB7842L/R offset mounting plate with longer grade 8 bolts and 2 to 4 SAE flat washers between the spindle and the offset mounting plate. (This is to get the plate away from the irregular surface.
4. Install the PB6642L/R bracket on the top 2 holes & the lower front hole of the S- cam tube mounting flange using $\frac{1}{2}$ " longer bolts.
5. Re-install hub and drum assembly.

6. Install tire and wheel.
7. Hold arms in place parallel to top edge of steel mounting brackets, 1-1/2" away from tire tread to inside of arm.
8. Clamp in place with vice grip. Mark and drill 1/2" holes in aluminum arms. Bolt aluminum arms to steel mounting brackets on outside of offset bracket (side toward truck frame) using 1/2" bolts with self-locking nuts (provided in kit). For 315/80R 22.5 tires, install aluminum arms on inside (tire side) of steel brackets.
9. Install the all aluminum fender on top of the aluminum arms. It should be roughly the same distance from the end of the fender to the aluminum arm on both ends of the fender. Make sure the edge of the fender is parallel to the side of the tire. Drill two each 5/16" diameter holes to bolt the fender to the arm. Use 5/16" bolts with self-locking nuts (provided in kit).

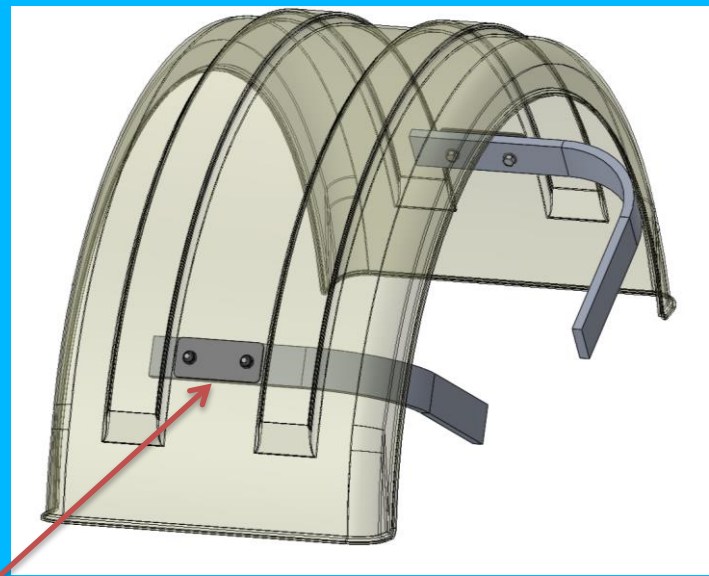
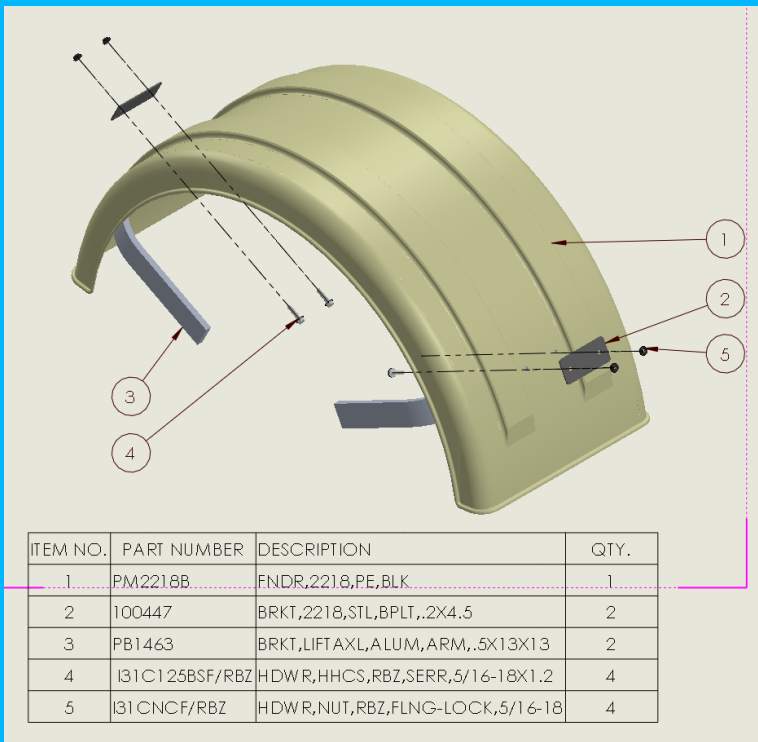
NOTE: PB6642L (left hand) mounts to passenger side
 PB6645R (right hand) mounts to driver side



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Instructions for use of MIN221800 fenders with Minimizer steerable lift axle brackets:

- Inside the Minimizer bracket kit locate four steel plates (Minimizer part number 100447)
- The steel plates are to be installed on the exterior surface of the fender.
 - Align the steel plate so it is even (top to bottom) with the aluminum arm. Use one plate for each aluminum arm.
 - Drill two 21/64" holes through the fender using the steel plate as a template
 - Drill two 21/64" holes in the aluminum arm using the fender and steel plate as a template.
 - Use the 5/16-18"x 1-1/4" hardware provided by Minimizer to fasten the fender in between the aluminum arm and the steel plate.
 - **Tighten the 5/16-18X1-1/4 bolts to a recommended torque of 5-7 ft-lbs. Do not exceed the recommended torque.**
- Failure to install the exterior steel plates at the time of installation will void the manufacturer's warranty on the MIN221800 fender component.
- If installing fender model MIN161200 or any model other than MIN221800, the steel plates are not necessary and may be discarded.



ALIGN STEEL PLATE WITH ALUM. ARM