

## ASSEMBLY GUIDE – ATHLETIC SERIES FORWARD FACING SAFETY SPOTTER ARMS

### PARTS:

- (2) AS-AS2-01008 – XTC Gear Plate High Tail
- (2) AS-AS2-01007-V2 – XTC Gear Plate Low Tail
- (2) XS-AS-01004-V2 – Upright Tube w/Pre-Installed Pin
- (2) XS-AS-01003-V2 – Horizontal Short Tube
- (2) XS-AS-01002-V2 – Horizontal Long Tube
- (6) 2x2" Plastic
- (4) 2.25" UHMW ROLLER
- (2) UHMW Liner

### HARDWARE:

- (10) 3/8" x3" BOLT
- (4) 3/8" x 1" BOLT
- (4) 3/8" WASHER
- (14) 3/8" NUT
- (14) 3/8" LOCK WASHER
- (4) 1/2" x 3" BOLT
- (8) 1/2" SAE FLAT WASHER
- (4) 1/2" JAM NUT
- (6) #10 X 3/4" FLAT SOCKET CAP – FINE THREAD
- (6) #10 NUT W/NYLOC – FINE THREAD

### TOOLS REQUIRED:

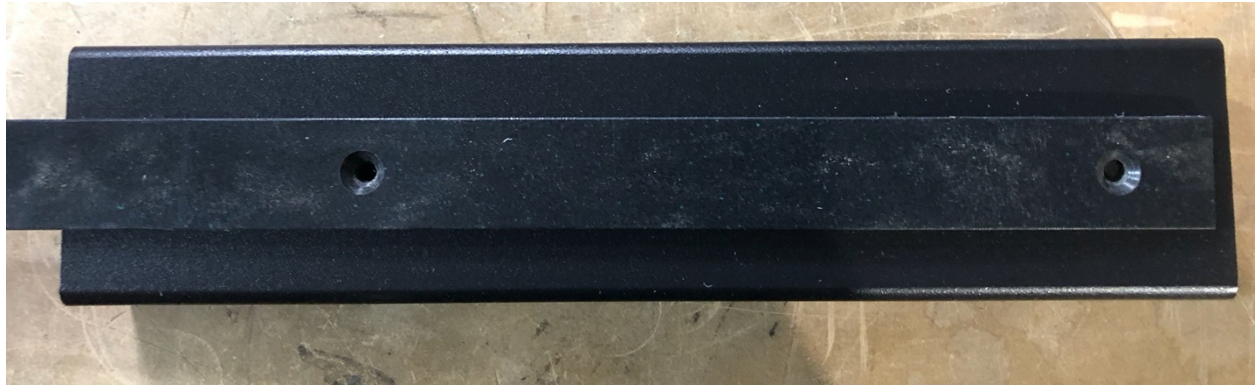
- (1) 9/16" WRENCH
- (1) 9/16" SOCKET
- (1) Rubber Mallet
- (1) #3 Allen Key
- (1) 3/8" Wrench
- (1) Electrical Tape

### INSTRUCTIONS:

#### STEP 1.

Lay *Horizontal Long Tube* on a flat working surface with the two smallest holes facing up. Line up the holes of one of the *UHMW Liner* with the two small holes, ensure that the counter sink on the *UHMW Liner* is facing up. See figure A. Install two *#10 Flat Socket Cap – Fine Thread Screws* and *#10 Nut w/Nyloc*. \*\*\*PRO-TIP use electrical tape and a BOX-HEAD 3/8" Wrench, tape one open side of the BOX-HEAD close then place *#10 Nut w/Nyloc* into the BOX-HEAD. Feed wrench with Nut inside the tube until the nut lines up with the hole, then finger tighten the *#10 Flat Socket Cap*. Repeat this process for both holes and then tighten hardware completely. AVOID OVERTIGHTENING HARDWARE.\*\*\*

FIGURE A.



\*\*\*PRO-TIP\*\*\*



STEP 2.

Place *Horizontal Short Tube* onto your work station such that the puzzle tab of the long tube lines up with the short tube (these parts are laser-cut on an angle so they will not sit together completely until final assembly). Line up the last hole on the *UHMW Liner* with the oval hole on the short tube and use *#10 Flat socket Cap Screw* and *#10 Fine Thread Nut*. *FINGER TIGHTEN*.

STEP 3.

Install *High and Low Tail XTC Gear Plates* on either side of the assembly built in step 1 & 2. The XTC Gear logo will read left to right on both sides when installed correctly. Use three 3/8" x 3" Bolts, Lock Washer and Nut and install from the nose of the XTC Gear Plate working Right to Left. Finger Tighten.

STEP 4.

Using two 3/8" x 1" Bolt, Washer, Lock Washer, and Nut install from the inside through the last hole. FINGER TIGHTEN.

STEP 5.

Tighten #10 Flat Socket Cap Screw on the *Short Horizontal Tube* completely.

STEP 6.

Install *Upright Tube* between assembly, ensure that the angled portion faces down. Use 3/8" x 3" Bolts, Lock Washer and Nut. Finger Tighten.

STEP 7.

TIGHTEN ALL HARDWARE COMPLETELY.

STEP 8.

REPEAT STEP 1-7 for the other arm.

STEP 9.

Install 2x2" Plastic with Rubber Mallet.