

INSTALLATION INSTRUCTIONS: TO CONVERT A VERTICAL TAILGATE INTO A TWO-WAY TAILGATE

1. Attach two clamps on each side of tailgate center ways.
2. Remove top tailgate pins from gate hinge.
3. Remove top tailgate hinge from right side of tailgate.
4. Remove both outer hinge bars that is welded on body.
5. Install **MOUNTING PLATE (ACS-02-5680)** on the right side at the top of tailgate.
6. Place **COMBO HINGE BAR (ACS-021-6391)** on right side of body. Tack **OUTER HINGE BAR (ACS-02-1174)** flush in place.
7. Take **TOP PIVOT PIN (ACS-02-4233)** and slide through **(1) SHORT HINGE BEARING (ACS-02-5684)**, then **LONG HINGE BEARING (ACS-02-5685)**, then the other **SHORT HINGE BEARING (ACS-02-5684)**.
8. Weld **WASHER (FF-50172)** on bottom and top of bearings.
9. Attach **SHORT HINGE BEARING (ACS-02-5684)** to **COMBO HINGE BAR (ACS-02-6391)**. (Make certain long hinge bearing is tacked to tailgate mtg. plate and short hinge bearings is tacked to combo hinge bar. Also, that the bearing assembly & combo hinge assy. is in line and pulled tight with outer hinge bar).
10. Attach **GUSSETS (ACS-02-5681)** to long hinge bearing.
11. Attach **FILLER BAR (ACS-02-5682)** to short hinge bearing.
12. Assemble **GATE HINGE ASSEMBLY (ACS-01-2801)** and **BODY HINGE ASSEMBLY (ACS-01-2800)** by placing **WASHER (FF-50172)** between gate hinge assembly and body hinge assembly. (Make certain both are held in line with **LOWER HINGE PIN ASSEMBLY (ACS-01-2721)**).
13. Weld lines # 5 through # 12 in place.
14. Weld **GUSSETS (ACS-02-5815)** to **SKID PLATES (ACS-02-5814)** then install both skid plates onto top of apron. (Make certain gussets fit snug to tailgate bottom).
15. Install **CHAIN BOX W/CHAIN (ACS-02-5803)** on left side of tailgate.
16. Open tailgate and swing tailgate around to the side and place **CHAIN ANCHOR PLATE (ACS-02-5802)** on side brace where chain and chain box will hook to and hold in place.
17. Close tailgate and install the **SCREW LOCK LATCH ASSEMBLY (FM-50122)** on left side.
18. Tack **OUTER HINGE BAR (ACS-02-1174)** on left side, open tailgate to make sure it clears.
19. Weld in place.

NOTE:

SEE ATTACHED DRAWINGS FOR ADDITIONAL REFERENCE.

ACS-02-1174 OUTER HINGE
NOTE: ALLOW SPACE TO SWING OPEN

ACS-02-1174 OUTER HINGE
NOTE: FIT TIGHT

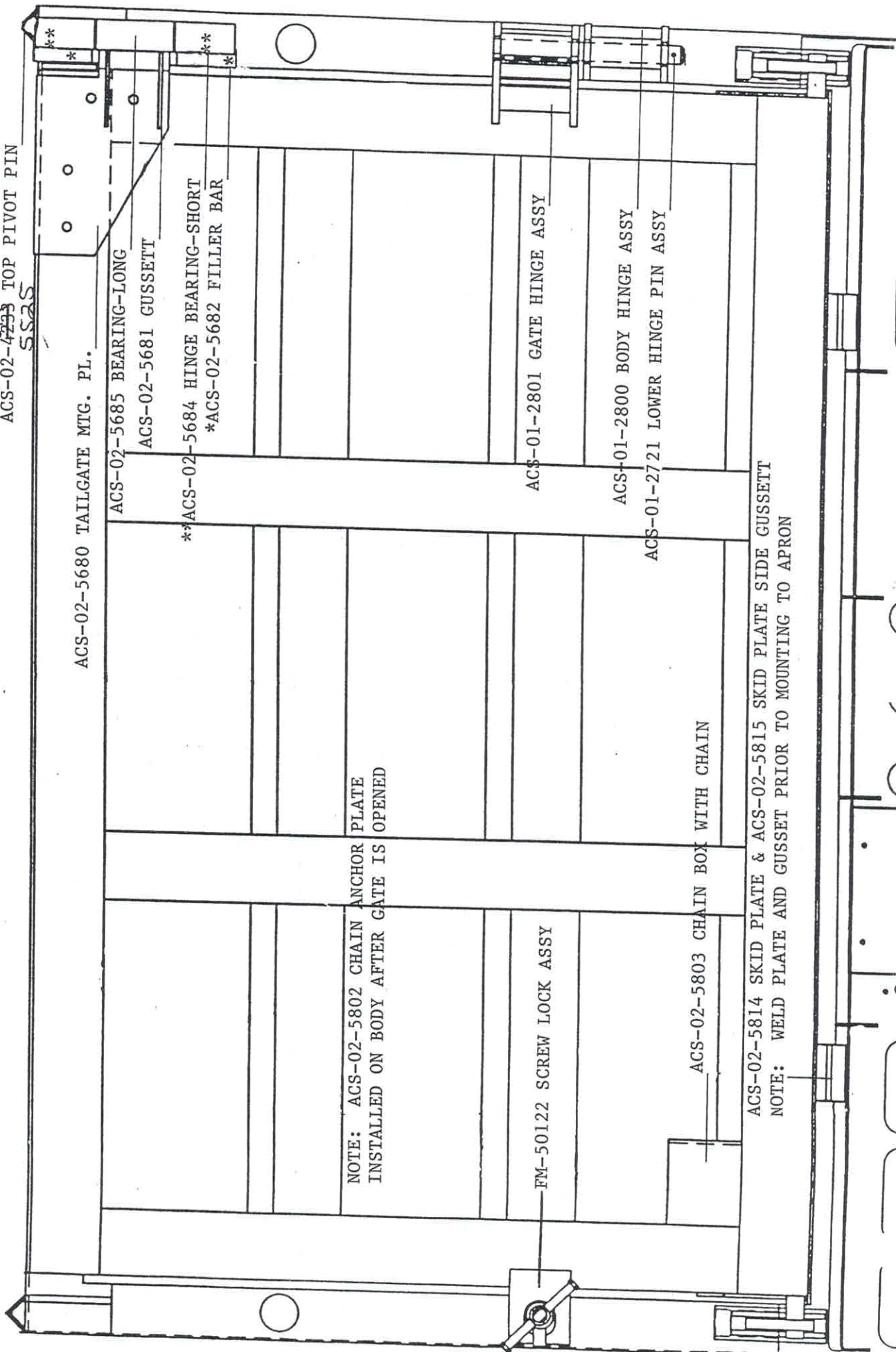
TOP VIEW OF ACS-01-2918 COMBO HINGE BAR ASSY
TOP VIEW OF ACS-01-2918 COMBO HINGE BAR (BEHIND BEARING ASSY)

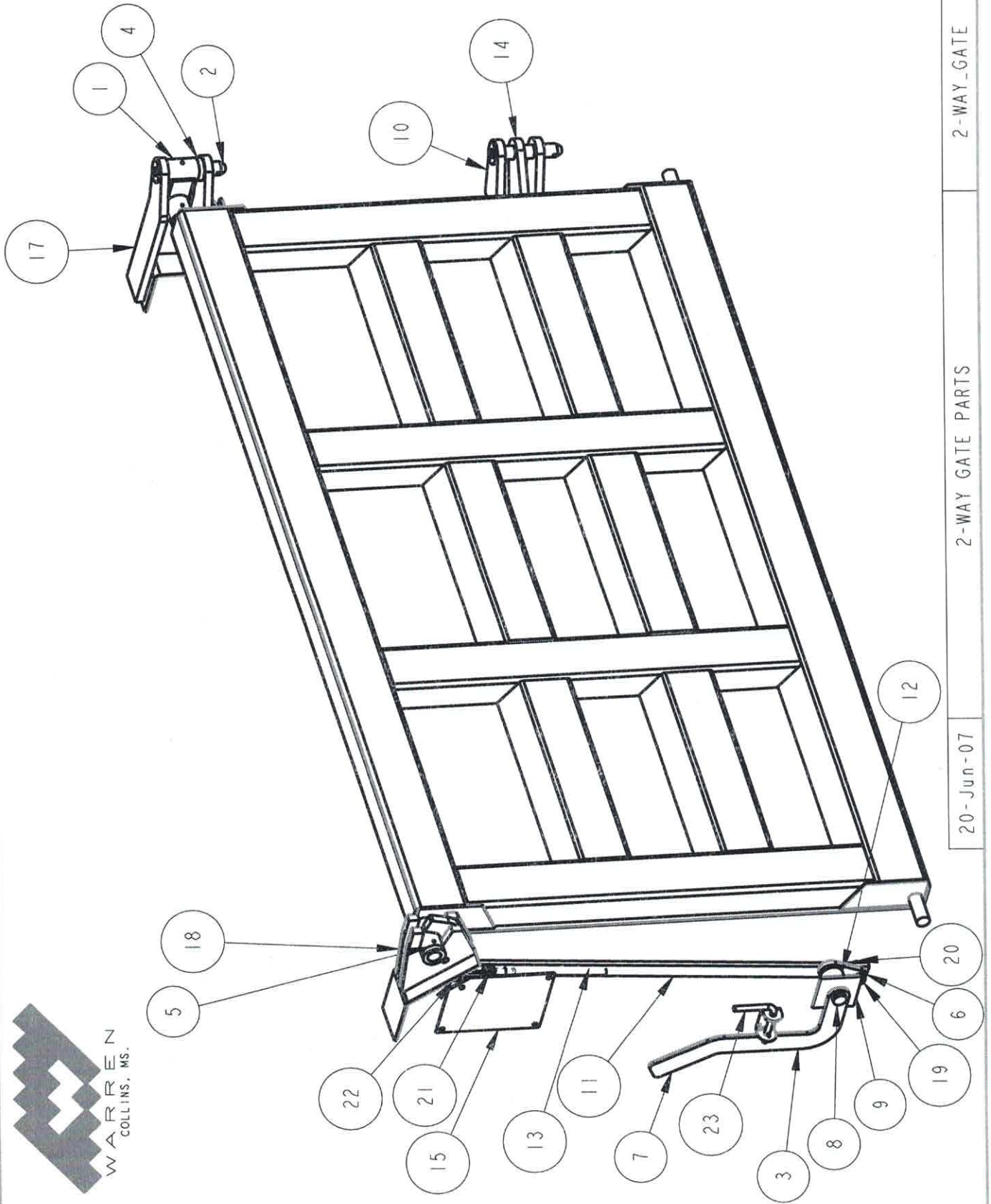
NOTE: NOT SHOWN ACS-02-6391 COMBO HINGE BAR (BEHIND BEARING ASSY)

Kit: 300-31109

KIT - 2-WAY GATE for STEEL DUMP BODY or TRAILER

ACS-02-~~4233~~ TOP PIVOT PIN
SSAS





2-WAY_GATE

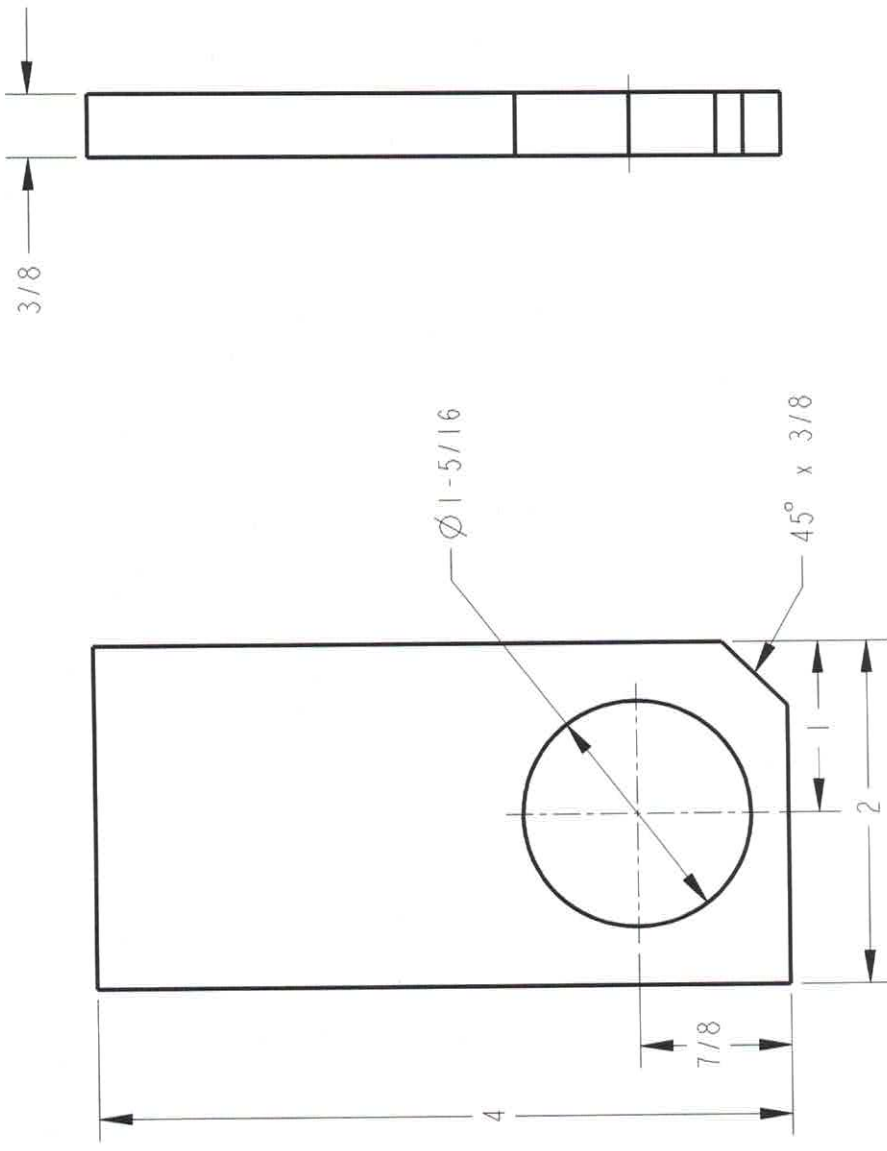
2-WAY GATE PARTS

20-Jun-07



ITEM	QTY.	PART NO.	WARREN PART NO.	DESCRIPTION	WEIGHT
1	1	A01-3472	300-30772	COMBO HINGE ASSEMBLY - 2005 - 2-WAY GATE	6.472
2	2	A01-3475	300-30773	PIN - TOP HINGE	2.272
3	1	A01-3476	300-30774	UPPER LATCH HANDLE ASSEMBLY	9.178
4	3	A02-8362	300-30810	BEARING - SPACER - BOTTOM PLATE	0.320
5	1	A02-8369	300-30811	BEARING - VERTICAL	2.235
6	1	A02-8370	300-30812	CAM	0.849
7	1	A02-8371	300-30813	HANDLE	4.731
8	1	A02-8372	300-30814	PIN - LATCH PIVOT - BOTTOM	1.324
9	1	A02-8373	300-30815	PLATE - BEARING ATTACHING	1.038
10	2	A02-8374	300-30816	BEARING PLATE - LOWER - POST	3.377
11	1	A02-8376	300-30817	PADDLE - LATCH	8.460
12	1	A02-8377	300-30818	BEARING - VERTICAL	1.234
13	1	A02-8378	300-30819	ROD - HOK CONNECTING	1.044
14	1	A02-8379	300-30820	PLATE - LOWER PIVOT - GATE	3.614
15	1	A02-8382	300-30821	COVER PLATE - 2-WAY GATE	2.787
16	2	ACS-02-0024-2	300-30823	PIN - LOWER TAILGATE - 2 WAY GATE	5.220
17	1	B01-3473	300-30837	HINGE - RIGHT HAND - 2-WAY GATE - 2005	26.231
18	1	B01-3474	300-30838	HINGE - LEFT HAND	19.027
19	1	FF-50204	900-80178	NUT - STOVER LOCK - 5/8 IN. NC	0.000
20	1	FF-50208	900-80180	5/8-11 X 1-3/4 HEX CAP SCREW GR 8 YEL ZN	0.221
21	1	FM-50001	800-80116	YOKE - END	0.856
22	1	FM-50002	800-30045	PIN - YOKE	0.160
23	1	SPRING-LATCH	300-30009	SPRING LATCH ASSEMBLY (FM-50199)	0.759

Inside
Plate
(2)



UNLESS OTHERWISE SPECIFIED, ALL WELDS TO BE CONTINUOUS. SIZE OF WELD TO BE AT LEAST THE THICKNESS OF THE THINNER OF THE ADJACENT METALS.

TOLERANCE - UNLESS OTHERWISE SPECIFIED.
 DECIMAL ± .0625 FRACTIONAL ± 1/16 ANGULAR ± 1°

OP. #	OPERATION	MACH. #	QTY. #	CLK. #	DATE	W/O#	SCALE	REQ'D.
							1/1	
							DRAWN	DATE
							PK	05-Aug-03
								WEIGHT
								0
							WARREN PART NO. 300-30093	
							NUMBER ACS-02-3812	
							NAME PLATE - PIN REINFORCEMENT - 1 1/4 IN. PIN	
							MATERIAL PL3/8 ASTM A36	
							WARRREN COLLINS, MS.	

01/28/2019

