



SD 60 Double Ended Ram Mount Installation Instructions

Thank you for purchasing this product!

Installation Notes:

- This kit is designed to be used with our Pro-Series 2005-up Super Duty Dana 60 Axle Truss. These instructions assume that the truss has already been installed with the face of the truss rotated back 10° from the differential cover mounting surface.
- This kit is designed to be used with a PSC Motorsports 2.5"x8" double ended cylinder (SCX2212 or SC2212). Other manufactures cylinders may be compatible but have not been tested.
- This kit requires high steer arms to be installed on the axle.

Tools required:

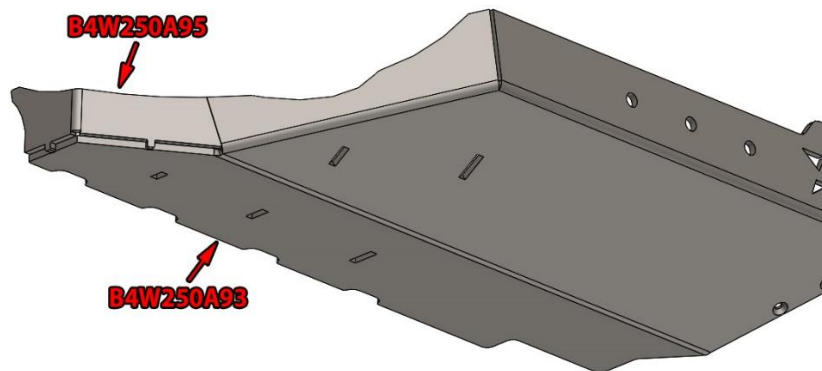
- Welding machine with the capability to weld at least 3/8" thick steel
- Square
- 3/4" Socket and ratchet
- 3/4" Open end wrench
- 7/16" Open end wrench
- 5/32" Hex wrench

Contents of kit

Bill Of Materials For B4WK12359			
QTY	Part Number	Etch Number	Description
1	B4W250516	516B	SD 60 Ram Mount Top Gusset
1	B4W250517	517	SD 60 Ram Mount Gusset Tab
1	B4W250518	518	SD 60 Ram Mount Brace 1
1	B4W250519	519	SD 60 Ram Mount Brace 2
1	B4W250520	520	SD 60 Ram Mount Brace 3
1	B4W250521	521	SD 60 Ram Mount Brace 4
1	B4W250A20	A20B	SD 60 Ram Mount Top Bridge Left Side Brace
1	B4W250A21	A21	SD 60 Ram Mount Top Bridge Center Brace
1	B4W250A22	A22B	SD 60 Ram Mount Top Bridge Right Side Brace
1	B4W500018	018	SD 60 Ram Mount Winch Point REV B
6	50C150HCS8Y	NA	1/2"-13 X 1-1/2" Hex Head Bolt Yellow
12	50NWSAFY	NA	1/2" SAE Flat Washer Yellow Zinc
6	50CNNE0Y/GC	NA	1/2"-13 Nylon Lock Nut
10	25C100KFCS	NA	1/4"-20X1" Stainless Countersunk Hex
10	25CNNE0Z	NA	1/4"-20 Nylock Nut
1	B4W250A92	A92CB	05-Up SD Dana 60 DE Mount Center Skid
1	B4W250A93	A93CB	05-Up SD Dana 60 DE Ram Mount Main Body
1	B4W250A90	A90B	05-Up SD Dana 60 DE Ram Mount Bolt Flange 1
1	B4W250A89	A89	05-Up SD Dana 60 DE Ram Mount Bolt Flange 2
1	B4W250A91	A91	05-Up SD Dana 60 DE Ram Mount Bolt Flange 3
1	B4W250A84	A84	05-Up Dana 60 Double Ended Ram Mount Short Gusset
1	B4W250A83	A83	05-Up Dana 60 Double Ended Ram Mount Long Gusset
1	B4W250A94	A94CB	05-Up SD Dana 60 DE Ram Mount Main Body Left
1	B4W250A95	A95B	05-Up SD Dana 60 DE Ram Mount Main Body Right

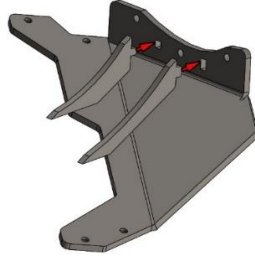
Step 1:

Align the tabs on the ram mount main body right (B4W250A95) with the slots on ram mount main body (B4W250A93) and weld the seam between the 2 components.



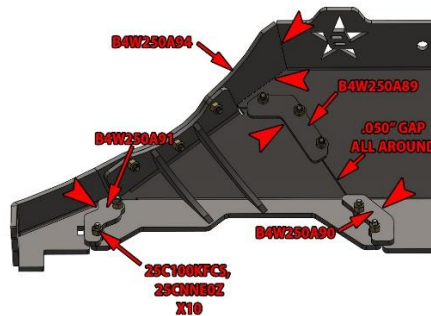
Step 2:

Insert the tab on the long gusset (B4W250A83) and short gusset (B4W250A84) into the slots on the center skid (B4W250A92), the gussets will be positioned 90° from the front face of the skid. Weld both gussets in place when properly positioned.



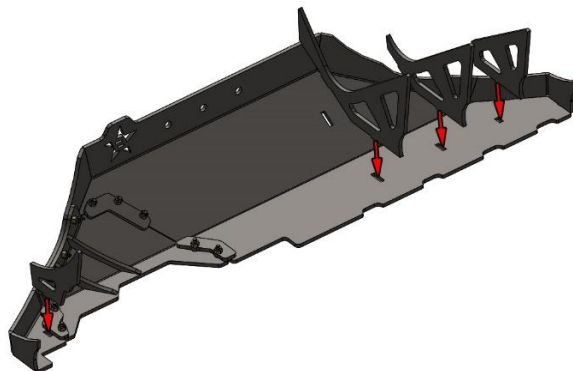
Step 3:

Assemble the components in the image below with the provided ¼" hardware. After all components have been assembled, check that the skid has a .050" gap (4 standard business cards stacked together) between the main skid and the removable skid. Weld the components together in the areas noted below with arrowheads. Do not weld the side of B4W250A91 in the area where the rectangular slot is located, a gusset will be installed here in later steps.



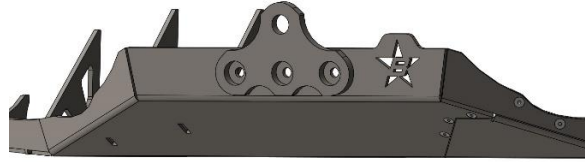
Step 4:

Install the 4 ram mount braces across the skid assembly as shown in the image below. Use the tabs and slots to locate each brace in its correct location, verify that each brace is at a 90° angle to the base of the skid and weld in place.



Step 5:

Install the winch point to the front of the skid assembly, center the bolt holes in the front of the skid with the holes in the winch point and weld in place.



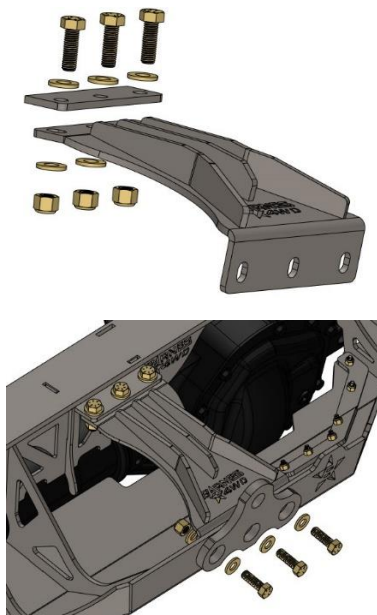
Step 6:

Using the etch marks on the top tie in bracket, weld the top braces on to the top tie in bracket. We recommend using a stitching method to weld these pieces together, alternating sides. The top braces will sit on the inside of the etch marks with the center brace going down the middle of the bracket.



Step 7:

Using the 3/4" socket and 3/4" wrench, attach the provided tab to the top of the top tie in bracket, and bolt the assembly to the steering cylinder mount. Weld the tab to the underside of the of the truss top.



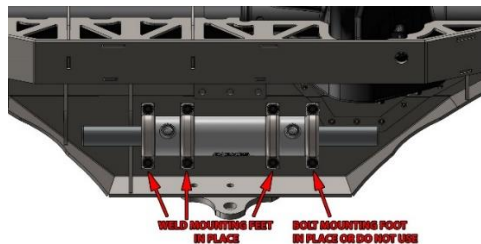
Step 8:

It is now time to mount the steering cylinder. Remove the 6 bolts and the bridge plate installed in the last step. Place the steering cylinder on the skid and center left to right. In most cases the cylinder center line will need to be located 4-7/8" from the front face of the skid. However this can vary depending on the cylinder and high steer arms that are used.



Step 9:

This step is dependent on how many clamps your hydraulic cylinder will use. If using only two clamps place both clamps towards the inside of the cylinder and weld the mounting feet into place. If your cylinder uses 4 clamps only three mounting feet will need to be welded into place. The clamp closest to the differential cover will either not be used, or we recommend drilling two holes in the skid and thru bolting the mounting base and clamp to the skid, with a nut on top of the clamp. This is to allow access, if the carrier or ring gear needs to be removed after installation of the cylinder mount.



Step 10:

Install the top tie in brace with the provided hardware and tighten. Complete welding of any seams not welded in previous steps.

Congratulations installation is complete!

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