

**INSTRUCTIONS:**

- Step 1 Cut out materials.
  - 1 - 2" x .120 Sq. Tubing @ 4-1/2" (cut both ends square)
  - 1 - 5/8" Round Stock @ 5-1/2"
- Step 2 Mark and drill holes. Use center punch.
  - 1 1/16" hole in the tubing centered and 1" from end
  - 5/32" hole in round stock centered and 1/2" from end
- Step 3 Determine cover design & cut out
- Step 4 Weld cover back plate to tubing with 1/2" beads on the corners
- Step 5 Drill holes and weld in bolts for front plate (design)
- Step 6 Bend cover pin (45°) as indicated. Use an O/A unit to heat and bend.
- Step 7 Sandblast & paint or powder coat.
- Step 8 Assemble

