

INSTRUCTION SHEET

STRAIGHT - ACTING CLAMPS

DRILLED AND TAPPED WELD ON STYLE

RAP93104, RAP93109, RAP93115, RAP93119

This kit contains weld on style clamps. This type of clamp is normally used with a mounting channel or plate. The kit has two sets of clamps. One set is for one of the top grooves in the jack barrel. The other set is for the center mounting area. **If a new cross tie clamp assembly is needed at the bottom of the jack, a cross tie clamp kit will have to be ordered separately.** The clamps are a different diameter and are not interchangeable with each other. The smaller diameter clamp can only be used in a groove. The clamp for the top groove is used to keep the jack at the proper mounting height and carries the entire vertical load for the jack.

IMPORTANT: Use the smaller diameter clamps in a groove at the top. If the larger diameter clamp is used in the top groove, the jack will not stay at the proper mounting height. This could cause damage to the mounting brackets, the jack cylinder and/or the vehicle.

There are two grooves at the top of the jack. This allows the mounting height of the jack to be changed by mounting the upper clamps in the upper or lower groove. Mounting the cylinder in the upper groove will move the jack closer to the ground. When replacing a cylinder or the clamps, the groove at the top of the jack that was used for the original mounting of the jack should be maintained. A gusset can be used with the top inner clamp. The gussets will help position the clamp and keep the clamp from "pulling" while welding the clamp. The gussets must be on the bottom of the clamp so they do not interfere with the spring bracket at the top of the jack. Gussets are NOT included with this kit. The jack should be used to position the clamps for tack welding. Make sure to maintain the original mounting height and position. **When welding the brackets in place, remove the jack cylinder after tacking the bracket and gussets so the cylinder is not overheated. Welding with the cylinder in place can damage the jack seals.**

The clamps are designed to allow slight clearance when fully tightened. This eliminates the possibility of any "squeeze" on the cylinder that could affect the operation of the jack. Check the jack grooves and the clamps for any debris that could cause a "squeeze" when the clamps are tightened. The jack can be slightly loose in the clamps with the clamps fully tightened.

