

Installation Instructions

Side Frame Repair Kit Part No.

For Ferris IS4500Z Models

⚠ WARNING

Before beginning any service work turn off the PTO, set the parking brake, turn off the ignition, and disconnect the spark plug wire(s).

1. Park machine on a flat, level surface. Engage the parking brake, disengage the PTO switch, turn off the ignition switch and remove the ignition key.
2. Remove the floor pan and the brake plate (A, Figure 2).
3. Remove the 3/4" hardware (A, Figure 3) securing the rear suspension arm to the broken part of the frame cross member. Set the hardware aside for reinstallation.
4. Refer to Figure 3. Cut the frame perpendicular on the inside of the break. Prepare the surface for weld to the repair section.
5. Slide the new support tube (A, Figure 4) inside of the frame cross member until the support tube bottoms out against the other end of the frame cross member.
6. Refer to Figure 4. Trim the frame repair section (B, Figure 1) so that the end of the repair section measures 9-13/16 from the outside of the frame rail allowing for a 1/4" gap between cut end of the frame cross member and the end of the repair section for weld.
7. Clamp the repair section in place. Weld in the 1/4" gap completely and weld the surface that was prepared in step 4 to the rear of the repair section. Remove the clamp.
8. Clamp the support bracket (C, Figure 1) in place. The weld shown in Figure 5 may have to be ground flush to allow for the support bracket to set correctly. Weld the bracket to the repair section and to the frame as shown in Figure 6. Remove the clamp.
9. Paint the repaired section of the frame and allow the paint to dry.
10. Install the body clip (A, Figure 4) into slot in the repair section. Reinstall the 3/4" hardware securing the rear suspension arm to the repaired frame.
11. Reinstall the floor pan and the brake plate.

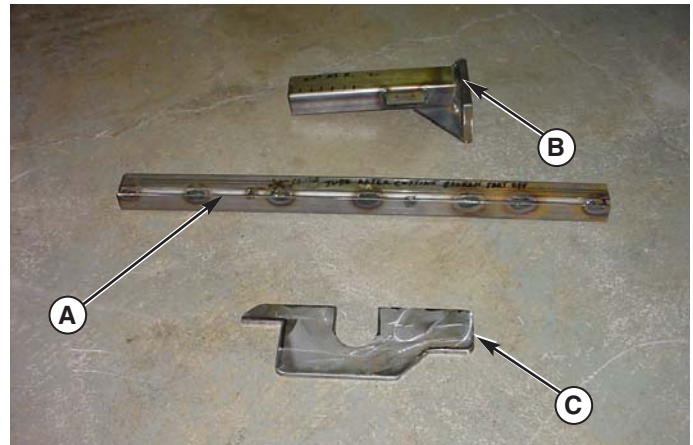


Figure 1. Support Tube, Support Bracket, and Repair Section

- A. Support Tube
- B. Repair Section
- C. Support Bracket

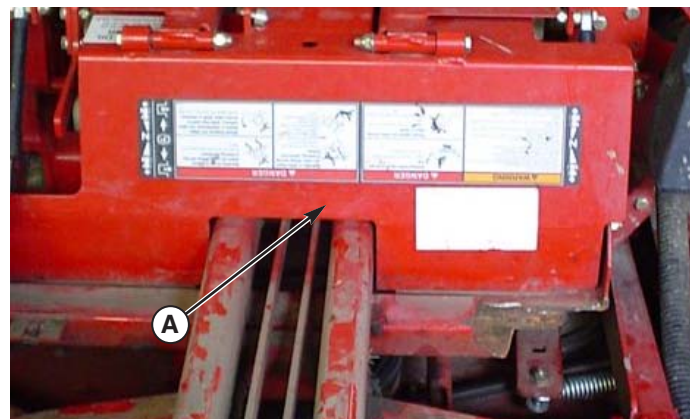


Figure 2. Remove Brake Plate

- A. Brake Plate

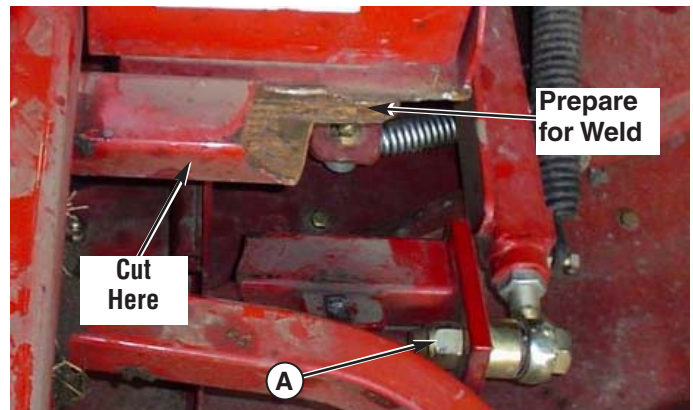


Figure 3. Remove 3/4" Hardware and Cut Cross Member

- A. 3/4" Hardware

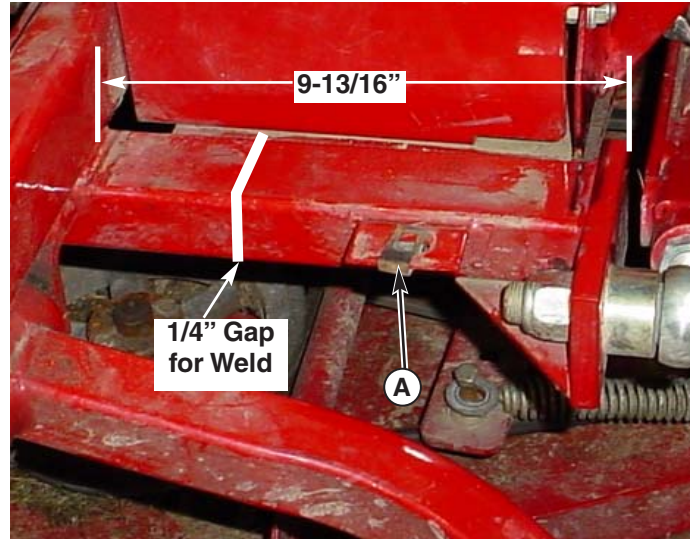


Figure 4. Measure and Trim Repair Section
A. Body Clip

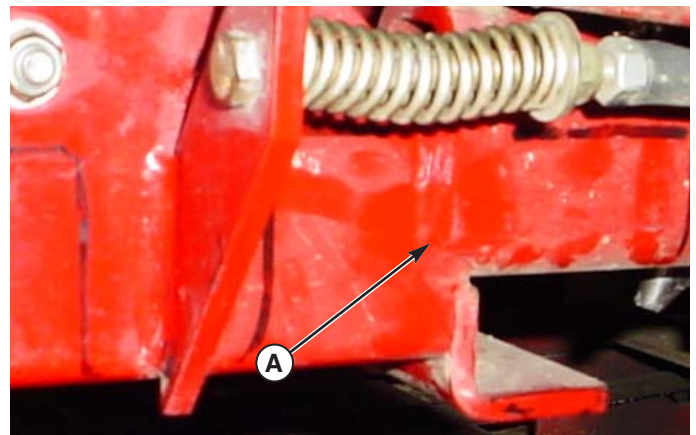


Figure 5. Grind Weld Flush
A. Weld

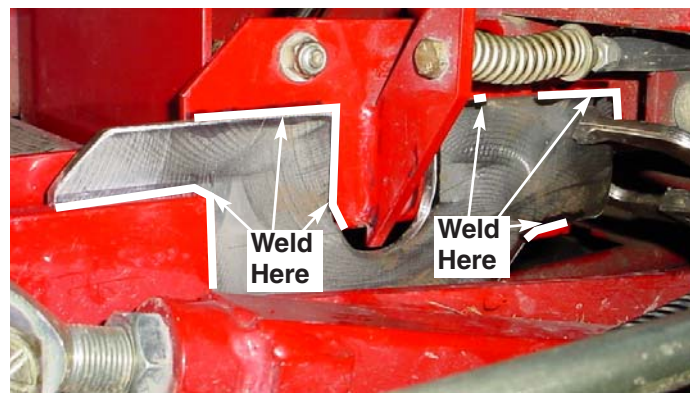


Figure 6. Weld Support Bracket