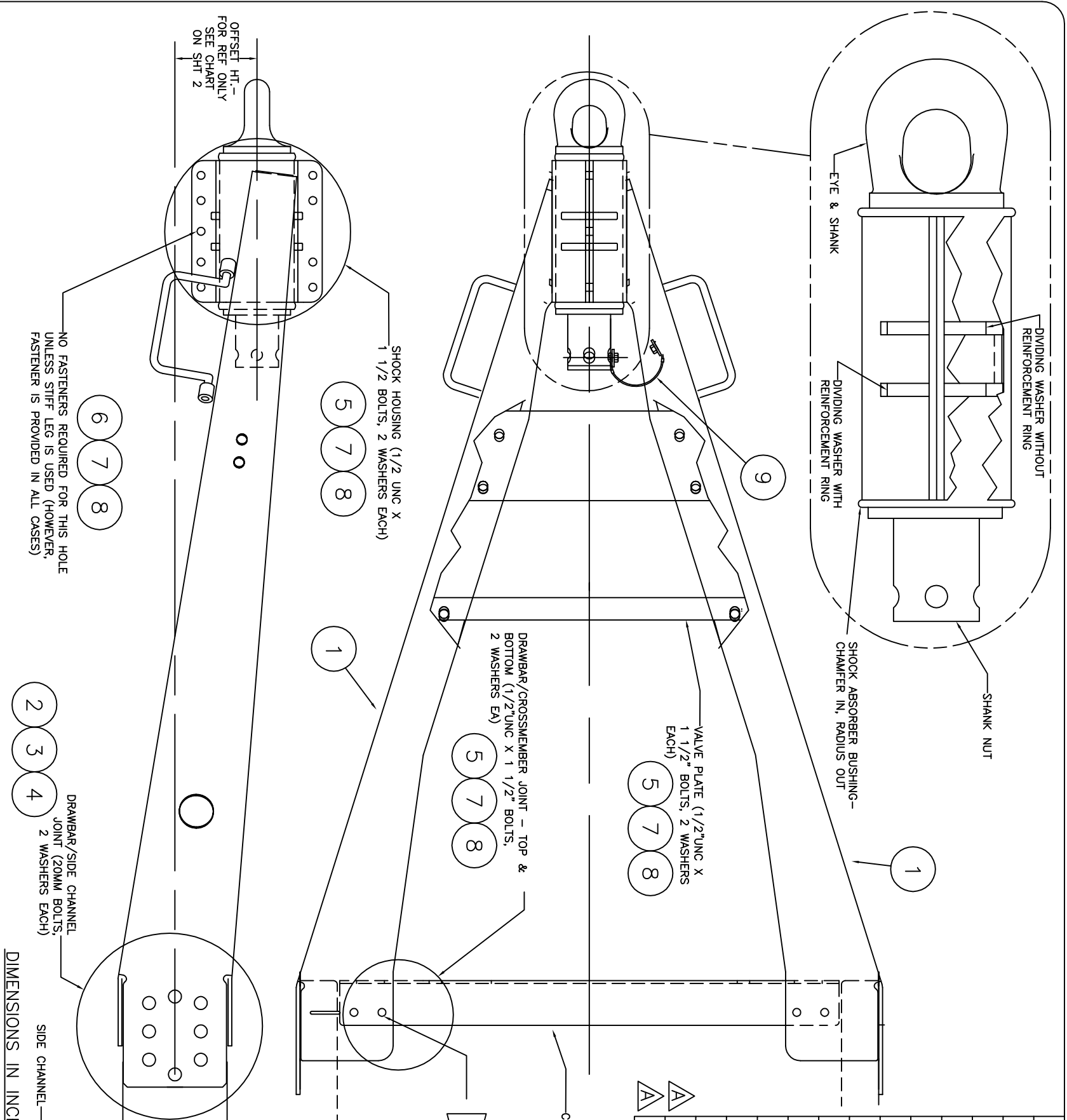


| ITEM | QTY | PART No. | DWG No. | DESCRIPTION |
|------|-----|-----------|-----------|--|
| - | - | SEE CHART | 98-337 | DWB KIT, VA |
| 1 | 1 | SEE CHART | SEE CHART | WELDMENT, DRAWBAR |
| 2 | 8 | 10253 | - | CAPSCREW, 20MMX2.5P X 45MM, HEX, GRD10.9, PLTD |
| 3 | 8 | 10256 | - | NUT, 20MMX2.5P, HEX, MET-LOCK, CLASS10, PLTD |
| 4 | 16 | 3367 | - | WASHER, 3/4, FLAT, F436, HRDN, PLTD |
| 5 | 17 | 9706 | - | CAPSCREW, 1/2-13 UNC X 1 1/2, HX, GR8, PLTD |
| 6 | 1 | 1473 | - | CAPSCREW, 1/2-13 UNC X 2-1/4, HX, GR5, PLTD |
| 7 | 18 | 1942 | - | NUT, 1/2-13 UNC, MET-LOCK, HX, GRC, PLTD |
| 8 | 36 | 3438 | - | WASHER, 1/2, FLAT, A325, HRDN, PLTD |
| 9 | 1 | 10970 | 98-327 | INSTALLATION, SAFETY WIRE |
| 10 | 1 | 98-337 | 98-337 | SPECIFICATIONS, DRAWBAR KIT, VA |
| 11 | 1 | 11207 | 98-455 | TAG, NOTICE, DRAWBAR KIT, VA |
| 12 | 1 | 1936 | - | TIE WRAP, BLACK, 8" |



NOTE: ILLUSTRATION IS FOR FIELD INSTALLATION INSTRUCTION ONLY. PARTS ARE PACKAGED UNASSEMBLED FOR SHIPPING

SHEET 1 OF 2

Silver Eagle Manufacturing Company claims Proprietary rights in the information disclosed hereon. It is agreed that any and all Specifications, Data, and Design Concepts shown shall remain CONFIDENTIAL with the specific understanding that neither this Drawing nor any Reproduction thereof will be disclosed to others or used for the purpose of manufacture or procurement of the article or part shown hereon without written consent of Silver Eagle Manufacturing Company.

TOLERANCES
 Fraction X/X ± 1/16
 Decimal XX ± 0.1
 Decimal XXX ± 0.06
 Decimal XXXX ± 0.030
 Angular X° ± 1
 Unless Specified



| REV | DATE | BY | CHK'D | REVISION |
|-----|----------|-----|-------|--|
| J | 1/11/07 | JDW | GCW | 330 FT-LBS WAS 450 FT-LBS, ADDED LOCTITE A/S |
| H | 6/5/03 | GCW | GCW | 450 FT-LBS WAS 385-400 FT-LBS |
| G | 4/30/03 | WAY | WAY | 385-400 FT-LBS WAS 450 FT-LBS |
| F | 11/01/01 | JMF | JMF | REVISED INSTRUCTIONS FOR CLARIFICATION |
| E | 01/15/01 | STB | STB | ADDED P/N 13671 |
| D | 12/10/00 | STB | JY | ADDED P/N 13450; 12520 WAS 11460 |
| C | 8/22/00 | STB | JY | CONVERTED ALL KITS TO 1-PC DWBS; REMOVED P/N'S 11069, 11080, 11081, 11082, & 11083; ADDED NOTE 7 |
| B | 8/25/99 | STB | JY | ADDED P/N 11577 & 11578 |
| A | 2-5-99 | DH | JY | ADDED P/N 11207 & 1936 |

Scale 1/8
 Date 9/29/98
 REL NO. 80469
 Drawn by: STB
 CHECKED: JCY
 Used On: DWG SIZE: B Drawing # 98-337 Rev. J
 TITLE: DRAWBAR KIT, VA
 SILVER EAGLE MANUFACTURING CO., INC.
 5825 NE SKYPORT WAY Portland, Oregon 97218



























DRAWBAR REPLACEMENT PROCEDURE:

1. SUPPORT THE TAILPLATE AND FRONT END OF DOLLY SUCH THAT THE SIDE CHANNELS ARE LEVEL AS INDICATED BY USING A BUBBLE LEVEL. BE SURE THAT WHEN THE DRAWBARS ARE REMOVED THE DOLLY WILL NOT FALL BACKWARDS BY REMOVAL OF THE FRONT END WEIGHT.
2. REMOVE THE VALVE PLATE FASTENERS ON THE SIDE/S WITH THE DAMAGED DRAWBAR/S (ALL VALVE PLATE FASTENERS IF BOTH DRAWBARS ARE TO BE REPLACED).
3. DETACH THE AIRLINES, AND ELECTRICAL HARNESS FROM THE DAMAGED DRAWBAR/S. THE ELECTRICAL AND AIR SYSTEM COMPONENTS MAY HAVE TO BE DETACHED FROM THE CROSSMEMBER AS WELL IF BOTH DRAWBARS REQUIRE REPLACEMENT.
4. REMOVE THE EYE AND SHANK COMPONENTS INCLUDING THE EYE & SHANK, SAFETY WIRE ASSY, SHANK NUT, AND THE SHOCK ABSORBER BUSHINGS.
5. REMOVE THE DRAWBAR/CROSSMEMBER FASTENERS ON THE SIDE OF THE DAMAGED DRAWBAR/S.
6. REMOVE DAMAGED DRAWBAR OR DRAWBARS BY USE OF STANDARD IMPACT TOOLS. THE MAXIMUM TORQUE REQUIRED TO REMOVE THE 12MM HUCKS FOR THE SHOCK HOUSING & CROSSMEMBER AND THE 20MM DRAWBAR HUCKS IS 200 FT-LBS & 300 FT-LBS RESPECTIVELY. IF THIS CAN'T BE ACCOMPLISHED, THEN REMOVAL CAN BE DONE BY CUTTING THRU THE HUCK BOLT COLLARS EDGEWISE, INTO THE SIDE OF THE COLLAR (AN ABRASIVE WHEEL OR CUTTING DISC MAY BE USED. DO NOT USE A TORCH OR THE E-COAT FINISH WILL BE DAMAGED AND THE NEW JOINT INTEGRITY MAY BE DIMINISHED). CUT SUCH THAT THE ENTIRE ROUND SECTION WILL BE REMOVED WITH THE HEX SECTION REMAINING. THIS WILL FREE THE HUCK COLLAR FROM THE HUCK PIN. CUT THE DRAWBAR TO SIDE CHANNEL & CROSSMEMBER HUCKS FROM THE DAMAGED SIDE FIRST. THEN CUT THE SHOCK HOUSING HUCKS.

7 THE REPLACEMENT DRAWBAR MAY BE A SLIGHTLY DIFFERENT DESIGN FROM THE ORIGINAL EQUIPMENT

- DRAWBAR. ALIGNMENT WITH THE CROSSMEMBER HOLES MAY BE AFFECTED. IF THIS IS THE CASE THEN MATCH DRILL THE OLD CROSSMEMBER TO THE NEW DRAWBAR AFTER STEP 14 WHEN ALL FASTENERS HAVE BEEN TORQUED. ALSO, IF A JACK MOUNT EXISTS ON THE OLD DRAWBAR, CUT IT OFF WITH A TORCH AND WELD IT ON THE NEW DRAWBAR. THIS WILL OF COURSE REQUIRE TOUCH UP PAINTING (AN ALTERNATIVE IS TO PURCHASE THE NEWER IMPROVED CENTER-MOUNT JACK SYSTEM WHICH WILL REQUIRE A NEW VALVE PLATE AS WELL).
8. *USE (12) 1/2 UNC X 1-1/2 GRD 8 BOLTS WITH LOCK NUTS AND HARDENED WASHERS PROVIDED IN THE DRAWBAR KIT FOR (8) SHOCK HOUSING HOLES & (4) CROSSMEMBER HOLES FOR EACH DAMAGED SIDE. THE LOWER MIDDLE HOLE IS SPECIFICALLY FOR THE SUPPORT LEG.
 9. POSITION THE NEW DRAWBAR/S IN PLACE WITH THE DIVIDING WASHERS INSTALLED AS ILLUSTRATED.
 10. *LOOSELY INSTALL ALL SHOCK HOUSING & CROSSMEMBER BOLTS. USE ONE (1) WASHER ON EACH END OF EACH BOLT (2 PER BOLT). FOR ANY SHOCK HOUSING HOLES THAT DON'T ALLOW BOLTS TO PASS THROUGH, DRILL WITH 17/32 DRILL BIT. *****DO NOT>>>DRILL HOLE SIZE TO GREATER THAN 9/16.
 11. *USE THE 20MM GRADE 10.9 BOLTS AND LOCK NUTS PROVIDED WITH HARDENED WASHERS FOR THE (8) SIDE CHANNEL HOLES PER DRAWBAR. USE ONE (1) HARDENED WASHER ON EACH END OF EACH SIDE CHANNEL BOLT (2 PER BOLT). INSTALL ALL THE DRAWBAR FASTENERS PRIOR TO TIGHTENING.
 12. *INSTALL THE VALVE PLATE WITH THE NEW FASTENERS PROVIDED - (3) 1/2 UNC X 1-1/2 BOLTS PER DAMAGED DRAWBAR SIDE. USE THE GRD 8 LOCK NUTS & HARDENED WASHERS PROVIDED. APPLY ONE (1) WASHER ON EACH END OF EACH BOLT (2 PER BOLT).
 13. BE SURE SHOCK HOUSING IS LEVEL. THEN SNUG ALL DRAWBAR FASTENERS IN THE FOLLOWING ORDER PRIOR TO TORQUING THEM:
(1) SIDE CHANNEL, (2) SHOCK HOUSING, (3) VALVE PLATE, AND (4) CROSSMEMBER. TORQUE ALL FASTENERS IN THE SAME ORDER.
 14. ADD LOCTITE ANTI-SIEZE #34026 AND TORQUE 20 MM DRAWBAR BOLTS TO *****330 FT-LBS*****.  
 15. *TORQUE SHOCK HOUSING, VALVE PLATE, AND CROSSMEMBER BOLTS TO *****90 FT-LBS*****.
 16. REINSTALL THE EYE AND SHANK COMPONENTS. TIGHTEN THE SHANK NUT SUCH THAT THERE ARE ONLY 3 THREADS EXPOSED BEYOND THE SHANK INSIDE THE NUT. WORN BUSHINGS MAY REQUIRE FEWER THREADS EXPOSED. FINALLY, REATTACH THE SAFETY WIRE.
- * ONLY THE FASTENERS INCLUDED IN THIS KIT HAVE BEEN TESTED AND APPROVED FOR THE DRAWBAR KIT INSTALLATION. MAKE NO SUBSTITUTIONS. TORQUING OF NUTS AS SPECIFIED ABOVE IS VERY CRITICAL.

| ITEM | QTY | PART No. | DWG No. | DESCRIPTION |
|------|-----|----------|---------|-------------|
|------|-----|----------|---------|-------------|

| KIT P/N DESCRIPTION | DWB P/N | OFFSET HT (in) |
|---|------------|----------------|
|  11063 (18") | 11432 (CS) | -10.5 |
|  11064 (18") | 11431 (RS) | -10.5 |
|  12113 (18") UPS | 12520 (CS) | -10.5 |
|  13450 (18") UPS | 12521 (RS) | -10.5 |
|  11065 (21") | 11435 (CS) | -7.5 |
|  11066 (21") | 11434 (RS) | -7.5 |
|  11067 (23") | 11438 (CS) | -5.5 |
|  11068 (23") | 11437 (RS) | -5.5 |
|  11070 (25") | 11441 (CS) | -3.5 |
|  11071 (25") | 11440 (RS) | -3.5 |
|  11072 (27") | 11444 (CS) | -1.5 |
|  11073 (27") | 11443 (RS) | -1.5 |
|  11074 (28 1/2") | 11447 (CS) | 0 |
|  11075 (28 1/2") | 11446 (RS) | 0 |
|  11076 (30") | 11450 (CS) | +1.5 |
|  11077 (30") | 11449 (RS) | +1.5 |
|  11078 (32") | 11453 (CS) | +3.5 |
|  11079 (32") | 11452 (RS) | +3.5 |
|  11577 (32") | 11391 (CS) | +3.5 |
|  11578 (32") | 11452 (RS) | +3.5 |
|  10848 (34") | 11456 (CS) | +5.5 |
|  10849 (34") | 11455 (RS) | +5.5 |
|  13671 (34") | 13192 (CS) | +5.5 |
|  11084 (36") | 11459 (CS) | +7.5 |
|  12114 (36") | 11488 (CS) | +7.5 |
|  11085 (36") | 11458 (RS) | +7.5 |

SHEET 2 OF 2

| | | | |
|---|---|---|----------|
| Silver Eagle Manufacturing Company claims Proprietary rights in the information disclosed hereon. It is agreed that any and all Specifications, Data, and Design Concepts shown shall remain CONFIDENTIAL with the specific understanding that neither this Drawing nor any Reproduction thereof will be disclosed to others or used for the purpose of manufacture or procurement of the article or part shown hereon without written consent of Silver Eagle Manufacturing Company. | | TOLERANCES Fraction X/X ± 1/16 Decimal XX ± 0.1 Decimal XXX ± 0.06 Decimal XXXX ± 0.030 Angular X° ± 1 Unless Specified | |
| DIMENSIONS IN INCHES | Scale 1/8 Date 9/29/98 REL NO. 80469 Drawn by: STB CHECKED: JCY | BY CHK'D | REVISION |
| SILVER EAGLE MANUFACTURING CO., INC. 5825 NE SKYPORT WAY Portland, Oregon 97218 | | TITLE DRAWBAR KIT, VA | |
| Used On: | DWG SIZE: B | Drawing # 98-337 | Rev. J |