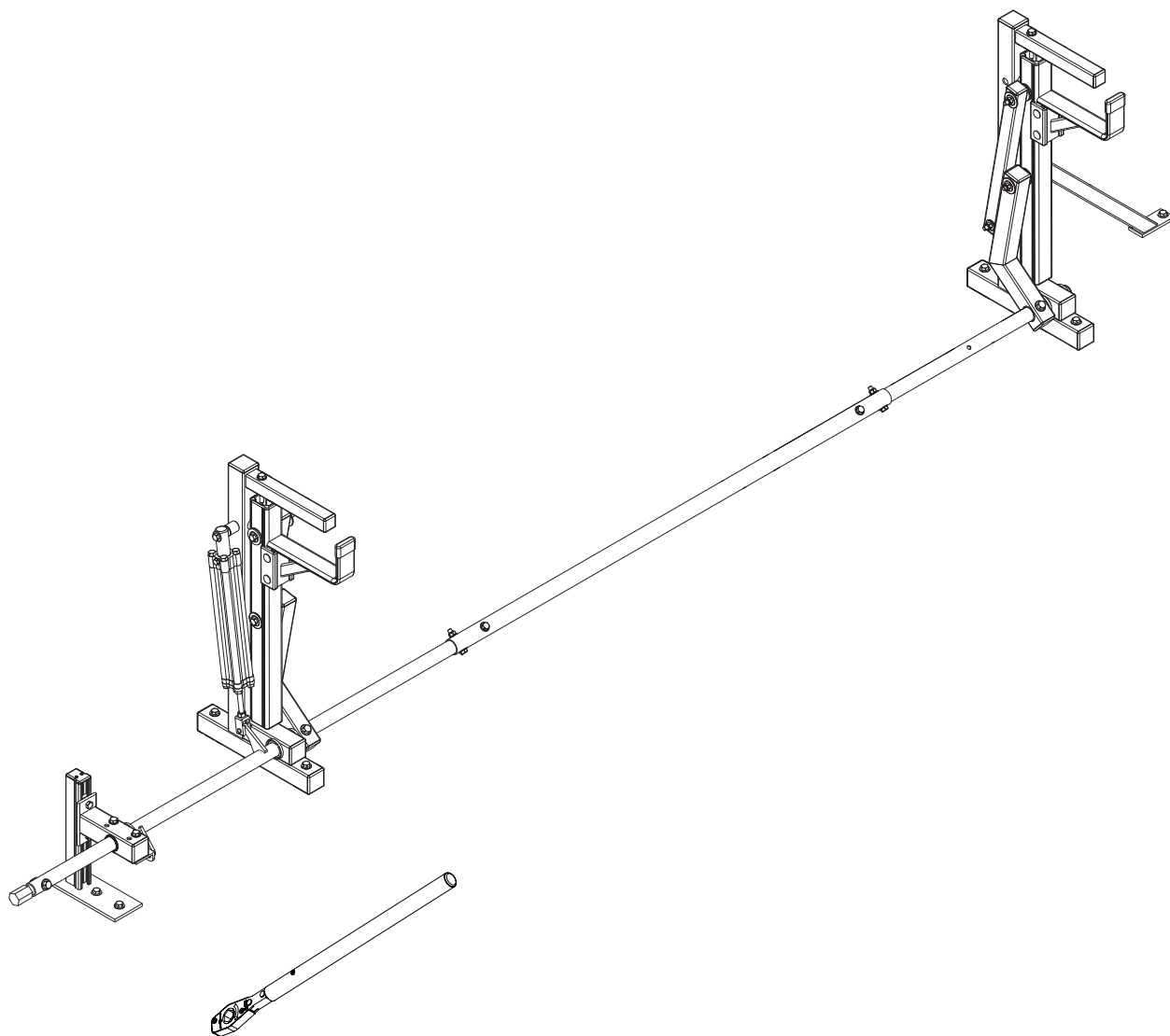


# PRIME DESIGN™

A Safe Fleet Brand

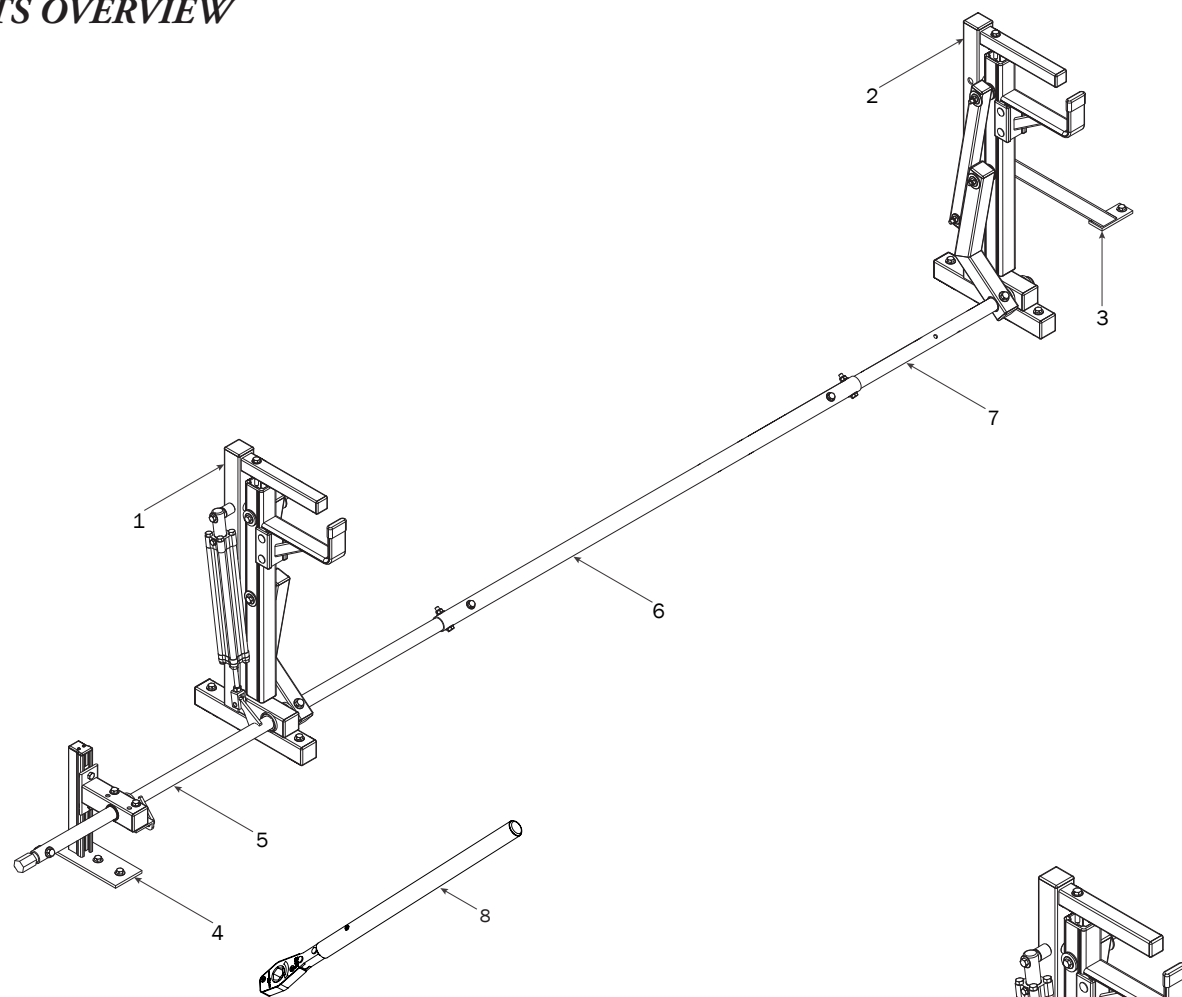


20' AXN

PRIME DESIGN, A SAFE FLEET BRAND

Address: 580 Opperman Drive, Eagan, MN 55123 • Toll Free: 1.8.PRIME.RACK

Fax: 651-552-1799 • Email: [info@primedesign.net](mailto:info@primedesign.net) • Website: [www.primedesign.net](http://www.primedesign.net)

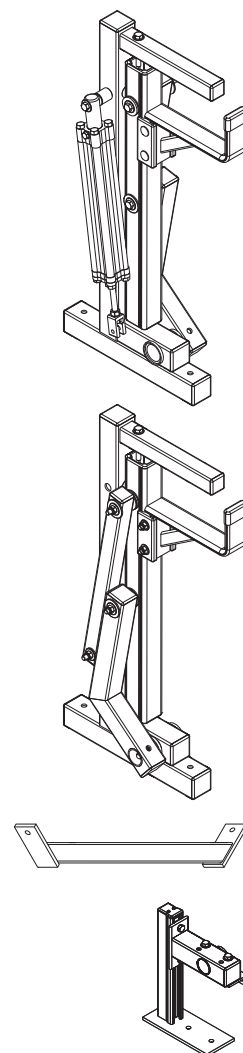


1—Rear Rotation Assembly..... (Qty 1)

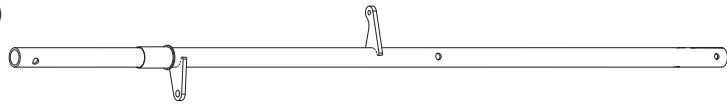
2—Front Rotation Assembly..... (Qty 1)

3—Mount Brace..... (Qty 1)  
20.00"

4—Vertical Drive Shaft Support..... (Qty 1)  
Utility, Right Hand



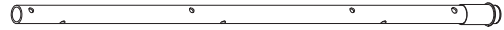
5—Rear Drive Shaft..... (Qty 1)  
Hex Head, Right Hand, 50.00"



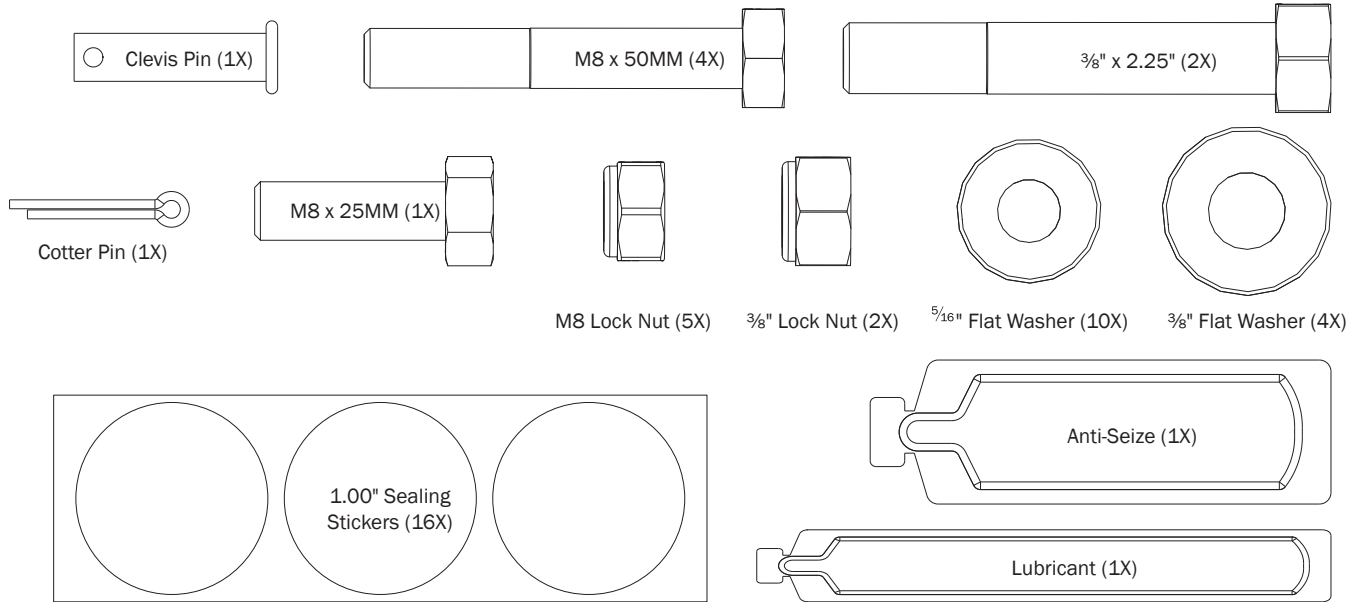
6—Connecting Bar..... (Qty 1)  
48.00"



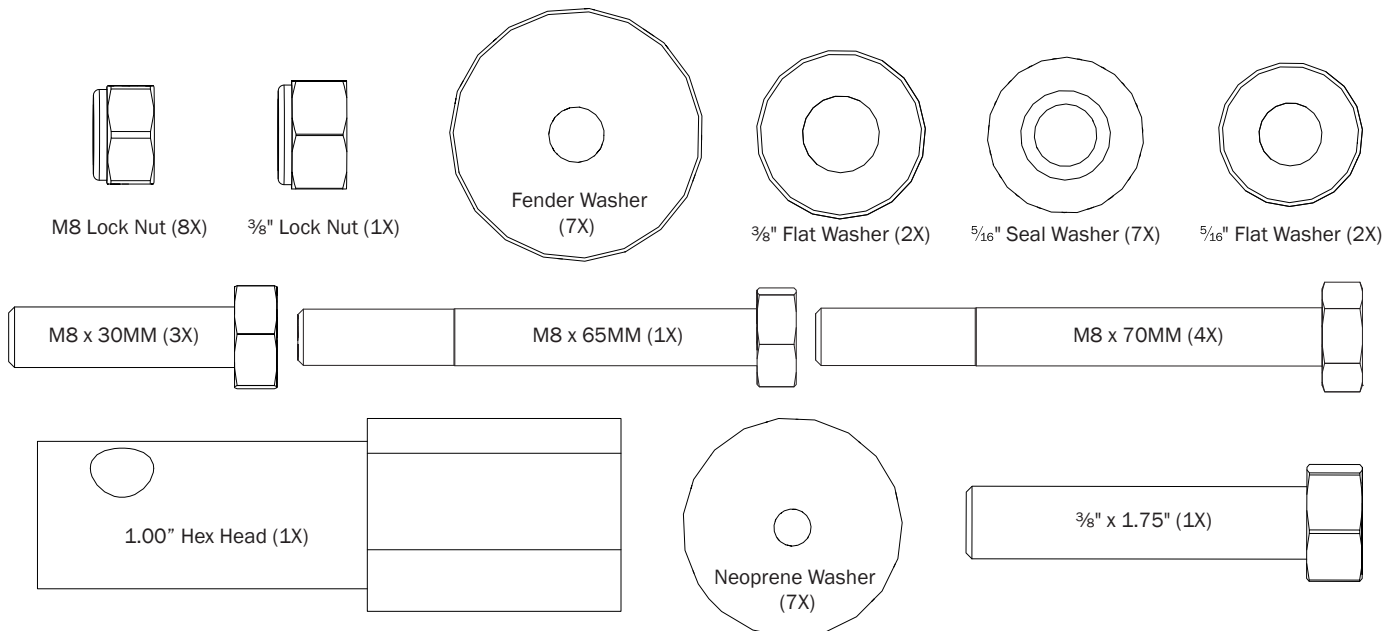
7—Front Drive Shaft..... (Qty 1)  
B Version, 35.75"



#### HKT-8163-Rotation Hardware Kit



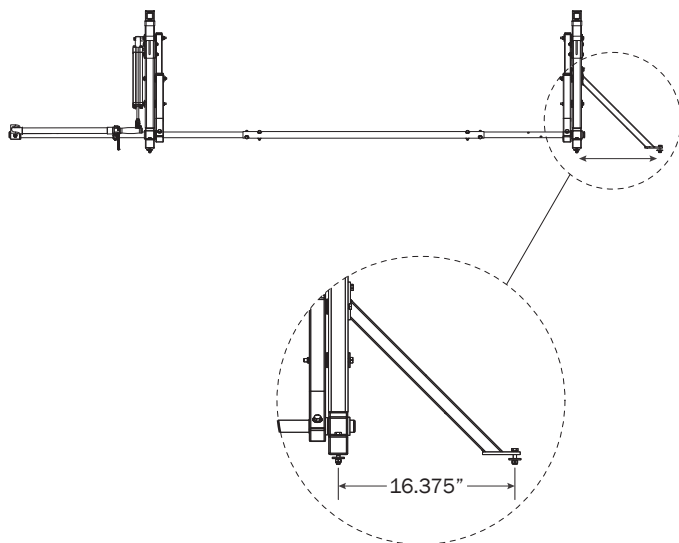
#### HKT-0255-Hardware Kit



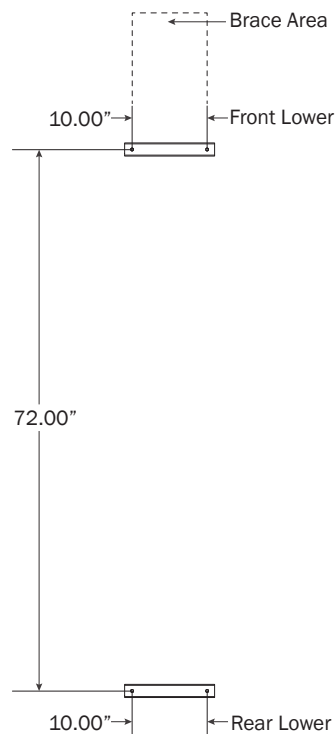
**MOUNTING DIMENSIONS**

Mounting to Service Body: dimensions are dependent upon Crossbar distances of 6'-8' plus allowance for the Mount Brace from the front of the Utility Rack.

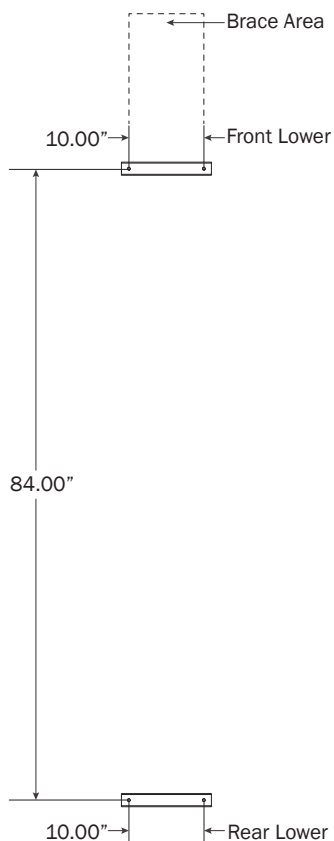
Allow spacing for the Mount Brace, but do not drill or install until Step 10.



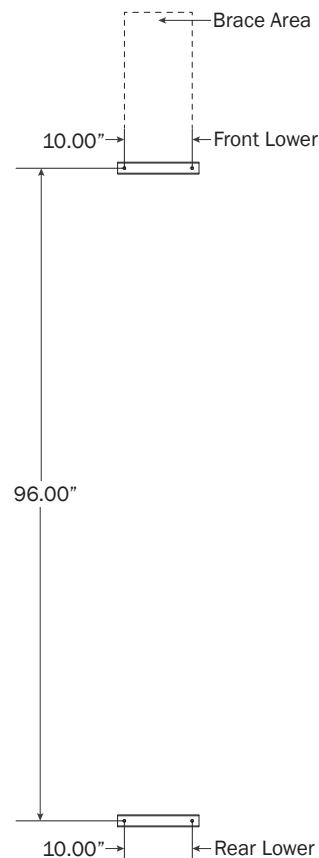
- 0.1** 6.00 Ft: Drill holes into the Service Body mounting location according to dimensions shown.



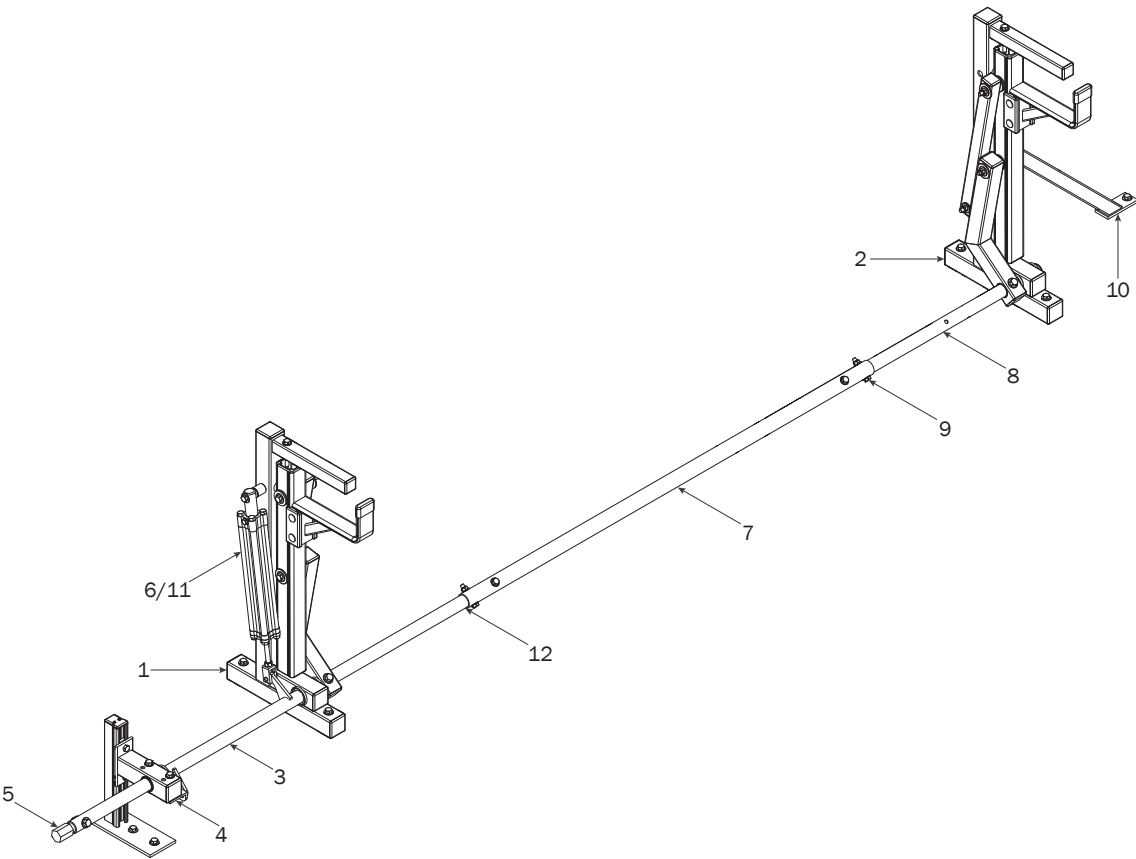
- 0.2** 7.00 Ft: Drill holes into the Service Body mounting location according to dimensions shown.



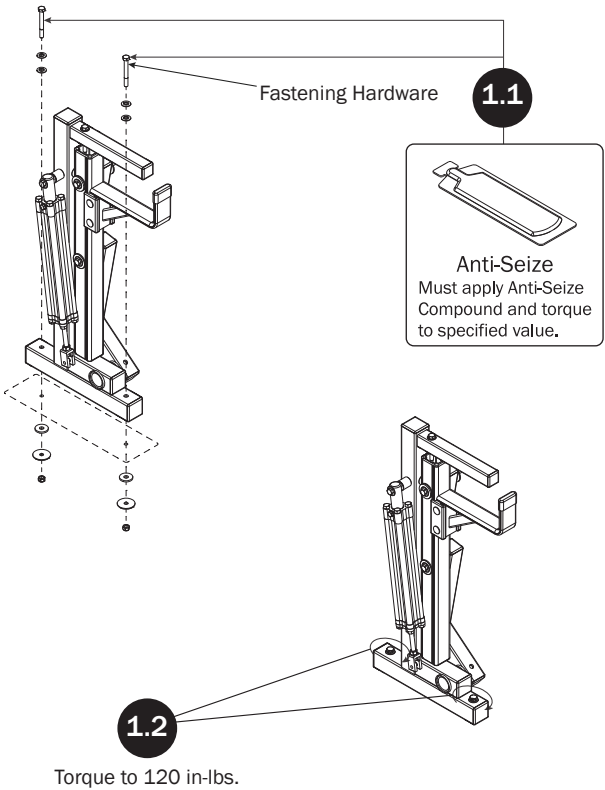
- 0.3** 8.00 Ft: Drill holes into the Service Body mounting location according to dimensions shown.



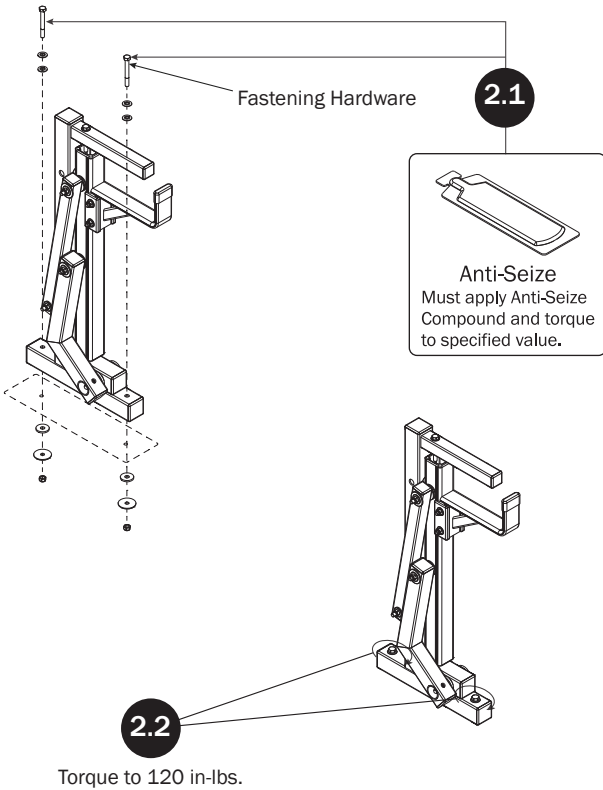
RIGHT ROTATION ASSEMBLY SEQUENCE

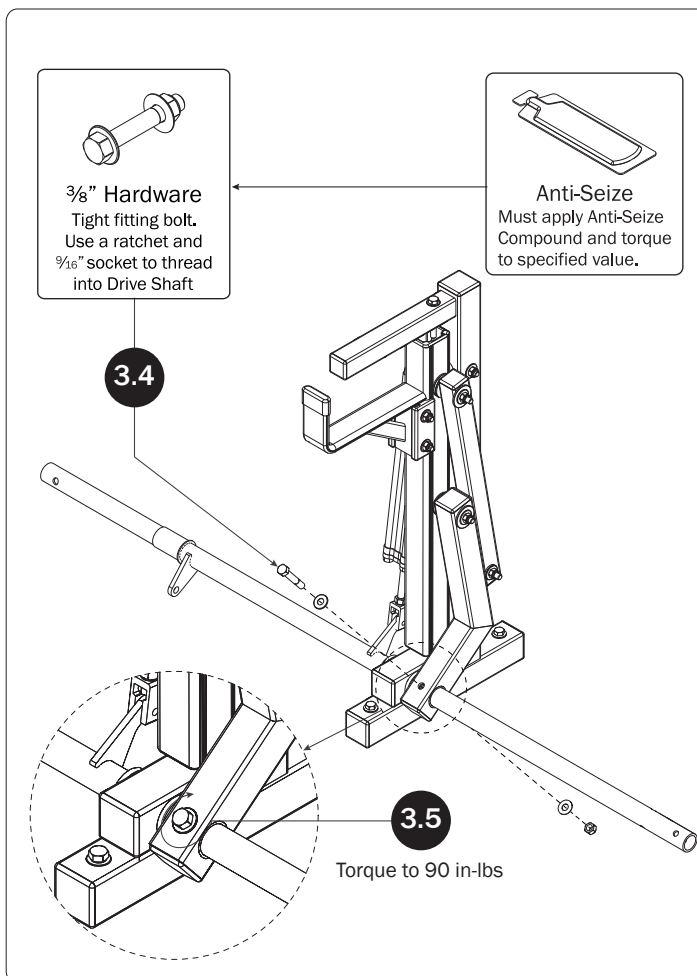
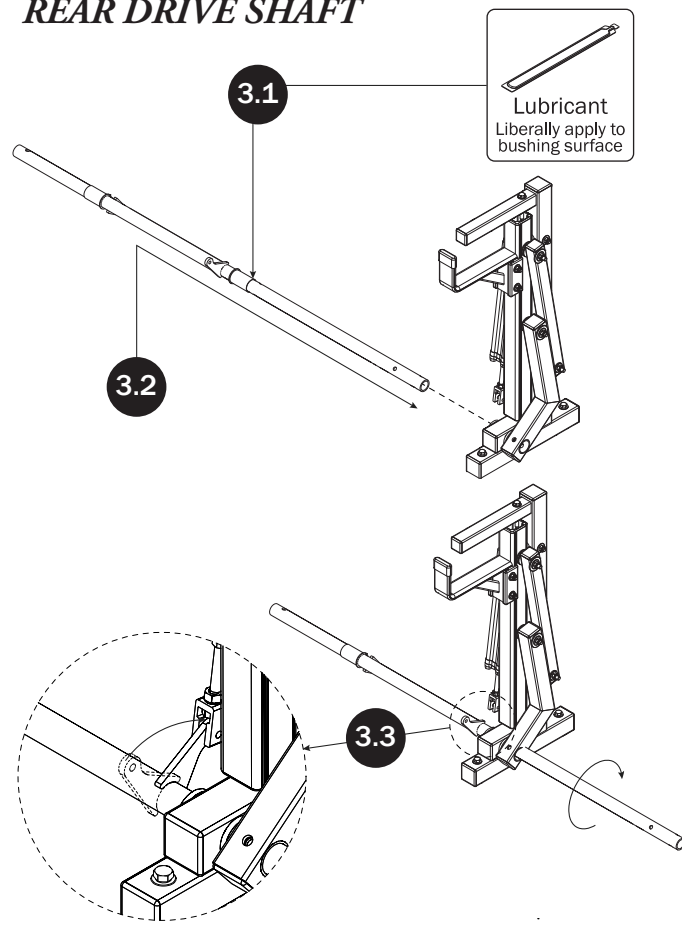
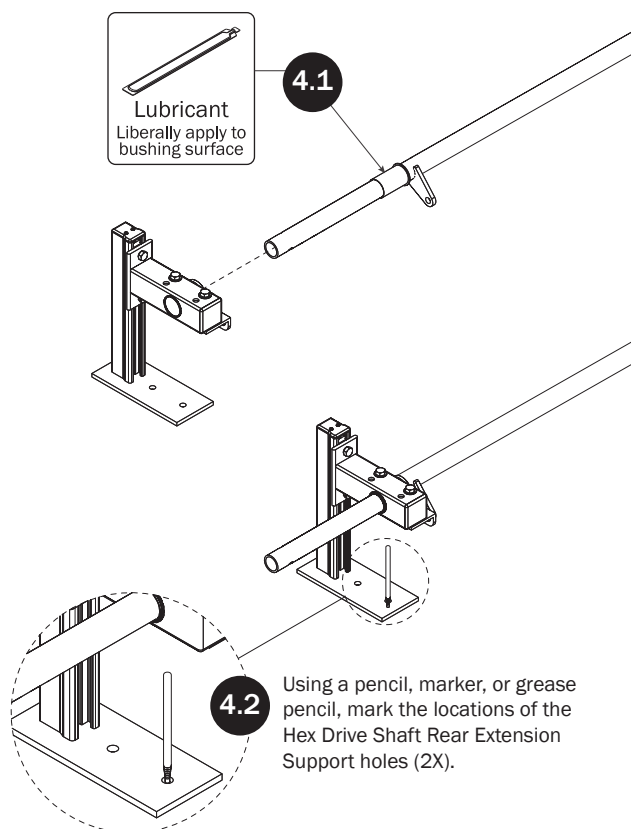


REAR ROTATION ASSEMBLY

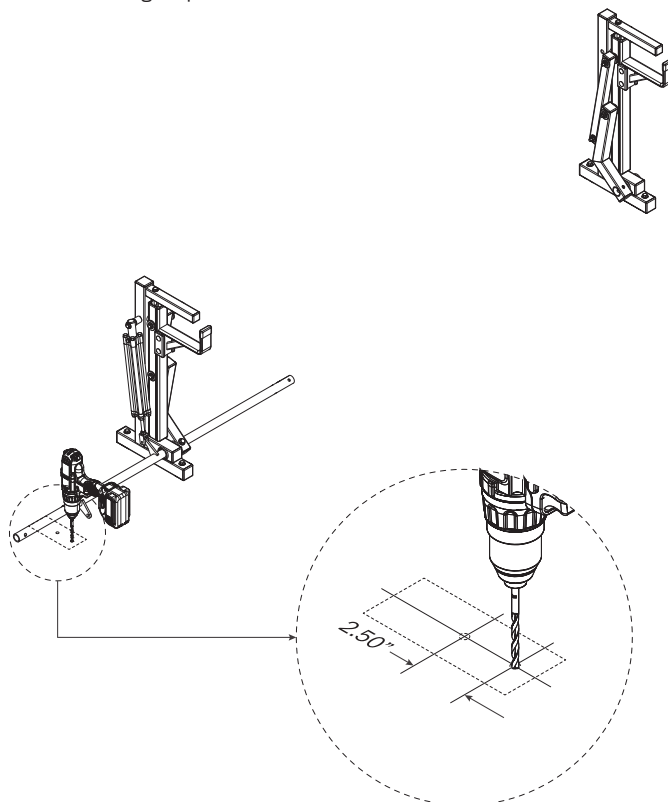


FRONT ROTATION ASSEMBLY



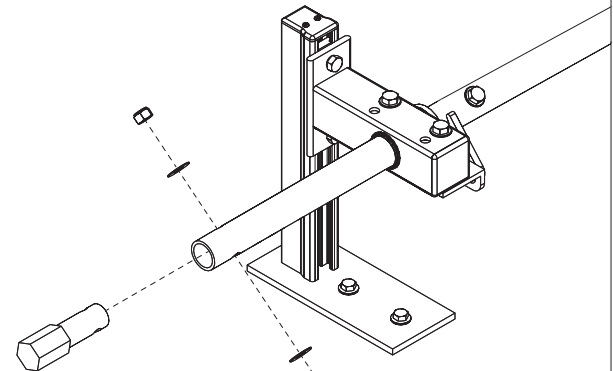
**REAR DRIVE SHAFT****DRIVE SHAFT SUPPORT**

- 4.3** Remove the Drive Shaft Support to expose the bolt hole markings. Using a 9MM, 23/64", or T size bit, drill holes into the Utility Body at the marked mounting bolt hole locations created during Step 4.2.

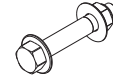


**DRIVE SHAFT HEX STUD****5.1**

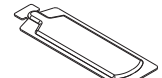
Insert the Drive Shaft Hex Stud into the open end of the Drive Shaft Extension. Align the bolt holes, then install the 3/8" x 1.75" Hex Stud Bolt (1X), 3/8" Washer (2X), and 3/8" Lock Nut (1X) in the order shown.

**5.2**

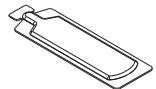
Torque to 90 in-lbs



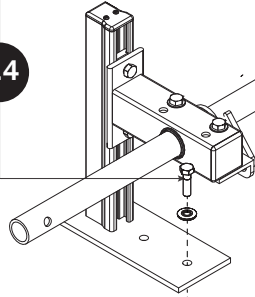
3/8" Hardware  
Tight fitting bolt.  
Use a ratchet and  
5/16" socket to thread  
into Drive Shaft



Anti-Seize  
Must apply Anti-Seize  
Compound and torque  
to specified value.



Anti-Seize  
Must apply Anti-Seize  
Compound and torque  
to specified value.

**4.4****4.5**

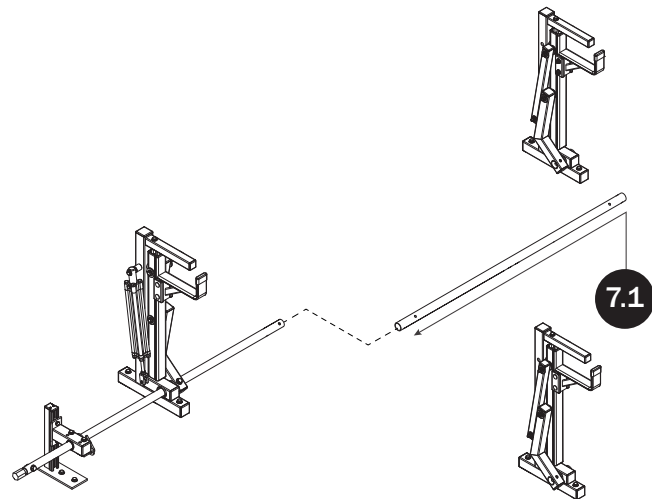
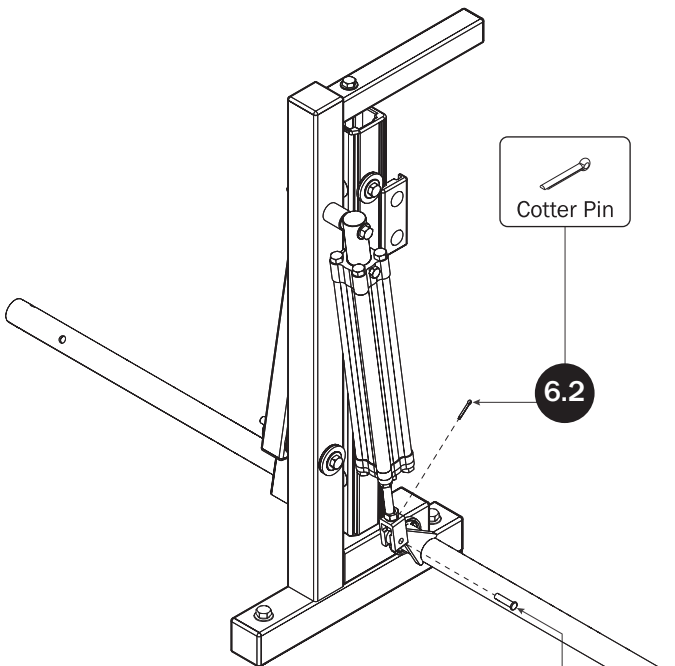
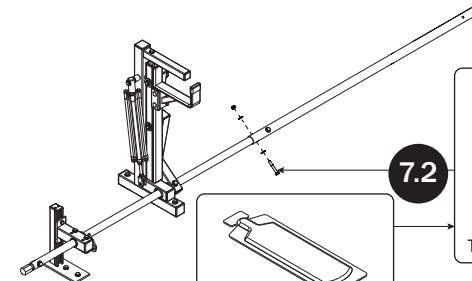
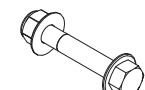
Torque to 90 in-lbs



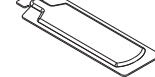
Cotter Pin

**6.2****6.1**

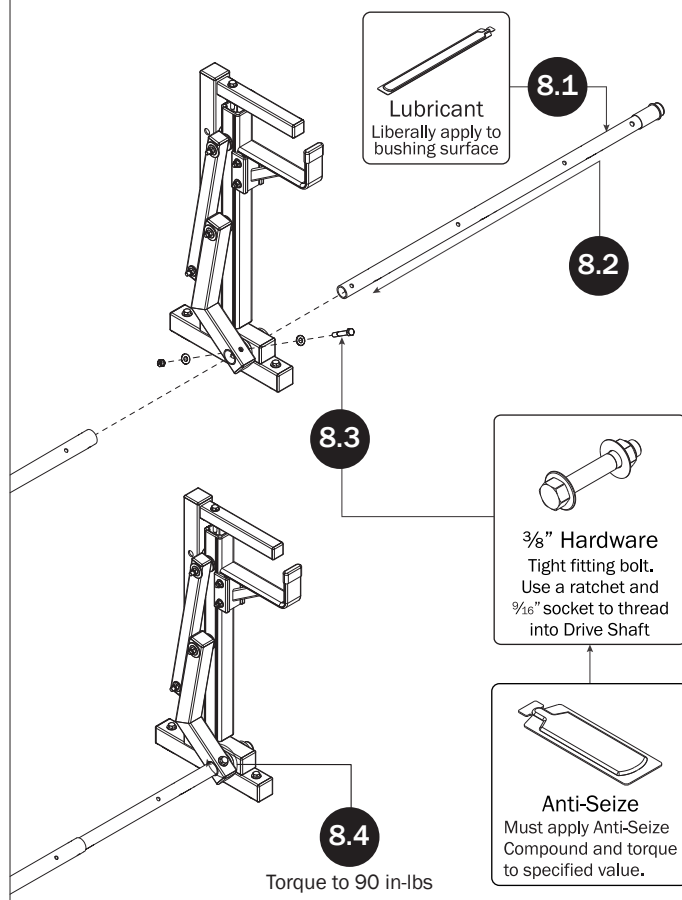
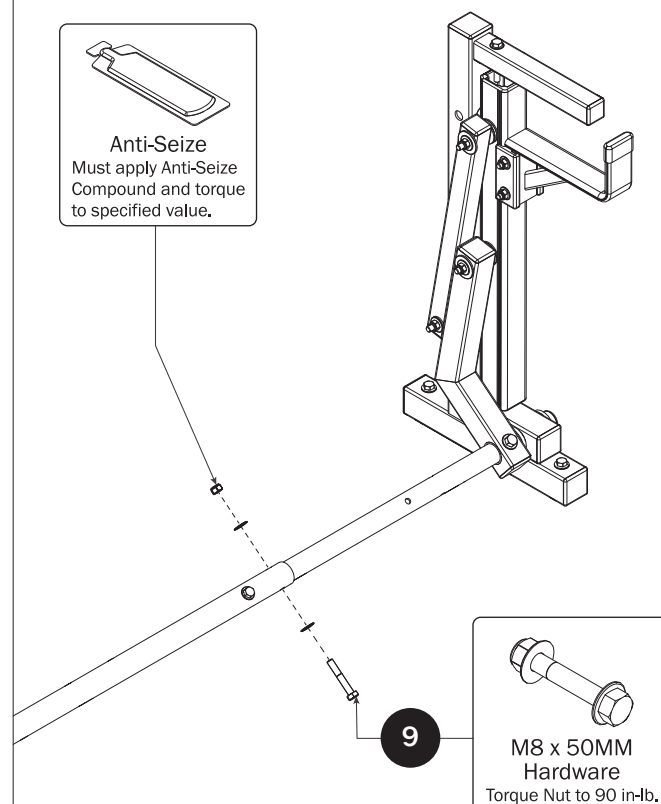
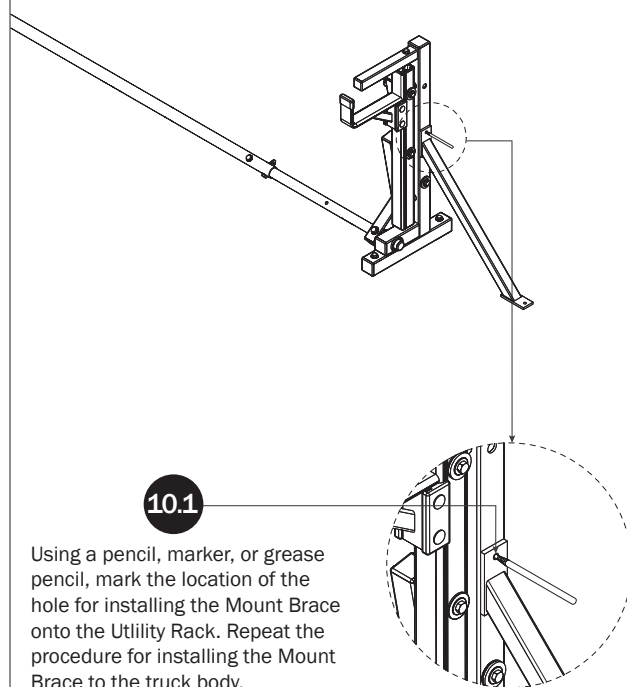
Clevis Pin

**7.1****7.2**

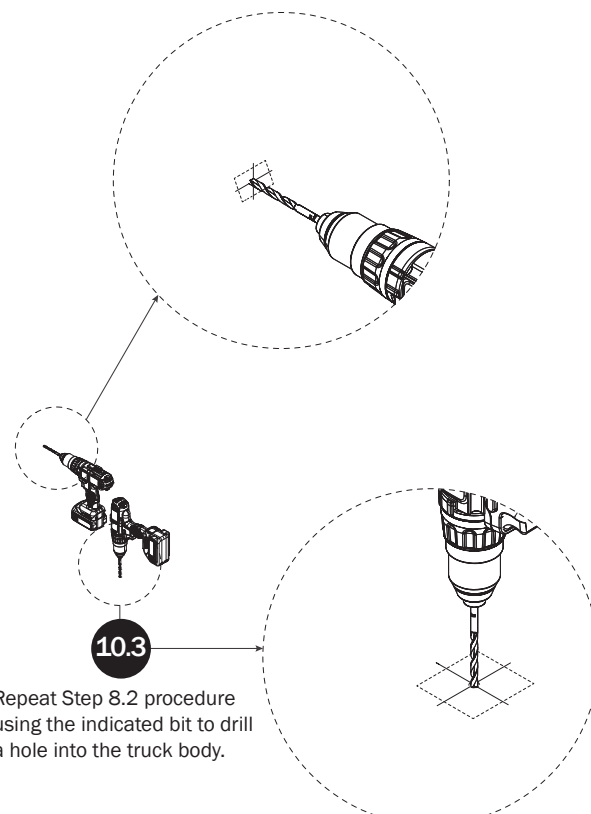
M8 x 50MM  
Hardware  
Torque Nut to 90 in-lb.



Anti-Seize  
Must apply Anti-Seize  
Compound and torque  
to specified value.

**FRONT DRIVE SHAFT****CONNECTING BAR FASTENERS****MOUNT BRACE INSTALLATION**

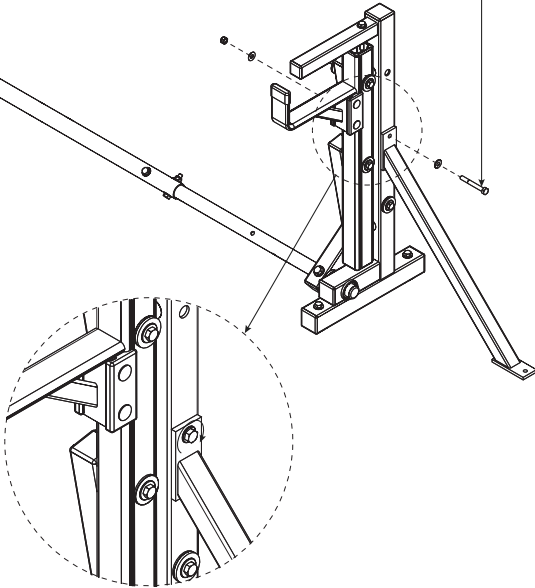
- 10.2** Remove the Mount Brace to expose the bolt hole markings. Using a 9MM, 23/64", or T size bit, drill a hole into the Utility Rack at the marked bolt hole location created during Step 10.1.



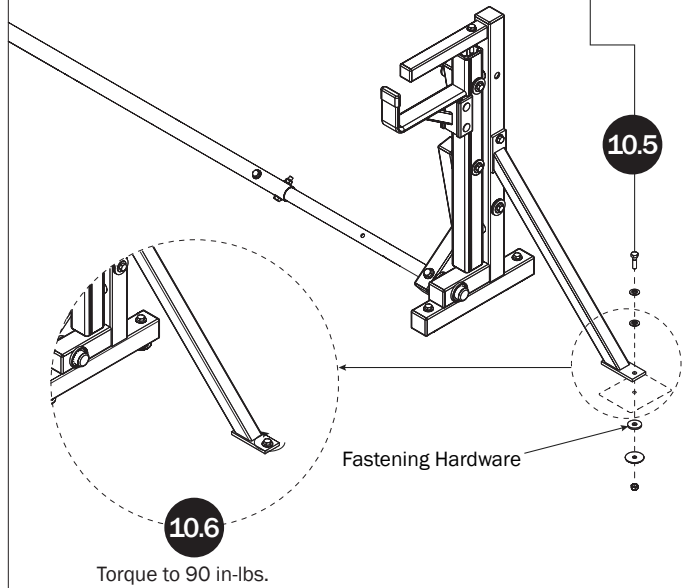




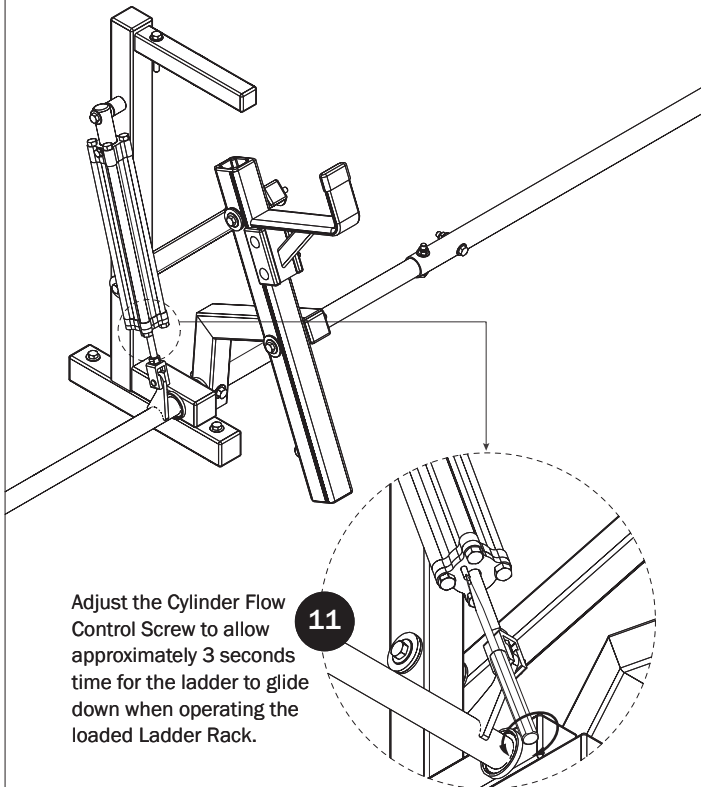
10.4



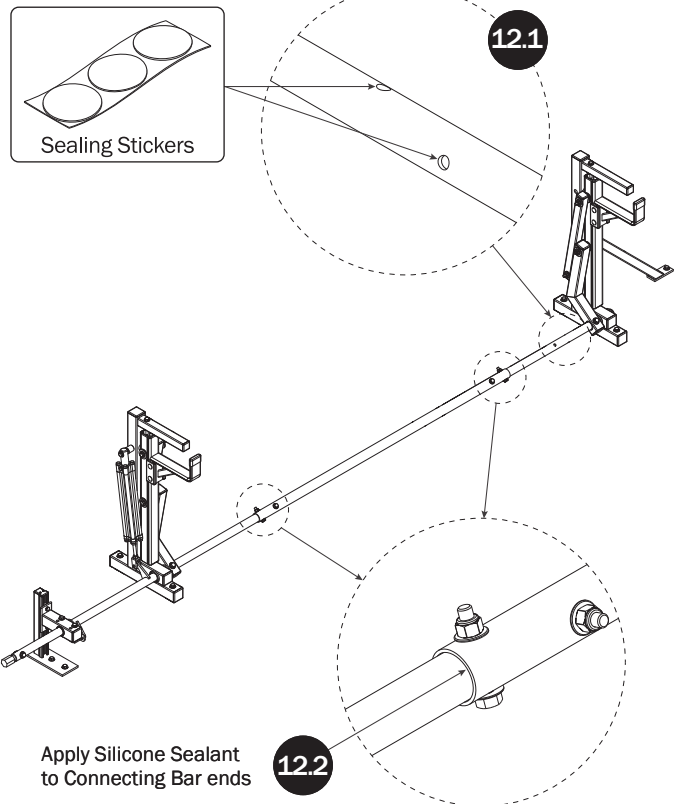
10.5



## CYLINDER ADJUSTMENT



## DRIVE SHAFT SEALING



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