

Installation Instructions

TC-300 / 310

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"WHERE WORKMENSHP IS EVERYTHING"

TC-300 / 310 Service Dumper ***Installation Instructions***

1. **Cut off the truck frame** if necessary. 109" (97" for TC-310) from the back of the cab to the end of the frame is max.
2. **Set the body** on the truck frame.
3. **Determine correct spacing above truck frame.** Refer to drawing **D1-01130** for dimension from bottom of subframe to bottom of wheelhousing. Refer to Chassis Manufacturer Incomplete Vehicle Manual to determine the height of the fuel filler housing above the chassis frame. The subframe spacers provided may be higher than required on some cab chassis.
4. **Locate the front and mid-ship mounting plates to best advantage based on the cab chassis frame.** The front mounting plates must be located as near the front as practical and the mid ship mounting plates should be located over the rear axle (see drawing **D1-01130**). After proper location, weld the mounting plates to the subframe and drill through the mounting plates and the truck frame for mounting to the truck frame. Guard all fuel lines, brake lines, electrical wires and fuel tanks when drilling.
5. **Position drivers side storage compartment** and complete the fuel filler installation per the Cab Chassis Incomplete Vehicle Document.
6. **Remove the side storage compartment** and hardware for painting.
7. **Paint the unit** being careful to always use the safety prop.

Dump Body:

- This dump body was fabricated using A60 Galvanneal steel.
- After welding, the body was washed with a high-pressure phosphating solution and dried.
- All welds and raw edges were coated with Sherwin-Williams DTM Epoxy Primer #E2A933 (see product data sheet attached).
- Apply a primer to the entire dump body that is compatible with the DTM primer and the topcoat that you intend to apply.
- Apply topcoat

Sid compartments: (Manufactured by Reading Body Works)

- Sand lightly with random action sander and 220 grit abrasive. Just remove the glossy surface, don't remove the primer to bare metal. The primer is applied to a thickness of 1.2 mils. If this primer is removed below a thickness of 1.0 mil, it will be necessary to apply a coating of rust-inhibiting primer to restore proper rust protection.
- If surface repairs are made which require sanding to bare metal, use an appropriate metal etching primer to ensure proper paint adhesion.
- It is necessary to use a primer/surfacer between the electrocoat primer and the base color coat when applying a base coat/clear coat finish.

8. **Run wiring** from dump switch to indicator light in cab. See wiring diagram (drawing **D1-01130**) for proper wiring.
9. **Reassemble** after painting. Install the lights and wiring harnesses provided.
10. Add the black vinyl stone guards to the front of each of the side storage compartments. Install the safety decals and TruckCraft logos as shown on drawing **D1-01130**.
11. **Connect hydraulic hose** to the power unit.
12. **Route the pump power cable** to the battery positive terminal in such a way as to **avoid sharp edges, and maintain a minimum distance of 8" from any portion of the exhaust system**. By routing the power cable along side the truck frame, you will give the cable maximum protection. Do not cross under or over the truck frame where the cable could get caught, rubbed, or pinched.
13. **Bleed air** from hydraulic cylinder. The hydraulic pump reservoir has been filled at the factory. More fluid must be added as the air is bleed out of the hydraulic cylinder (vent plug on top of cylinder). Use only Dexron Automatic Transmission Fluid.
14. **Tighten all fasteners** and lubricate the unit at the following locations:

Rear dump body pivots (2 places)

Lower tilt cylinder pivot (1 place)



DTM Primers
3.5 VOC Epoxy Primers
 Black **E2B931**
 Off-White **E2W932**
 Gray **E2A933**

PRODUCT DESCRIPTION:

3.5 VOC Epoxy Primers, E2B931/E2W932/E2A933, are low VOC, two-component primers offering excellent direct-to-metal adhesion and corrosion resistance over properly cleaned steel and aluminum substrates without the use of lead or chromates. 3.5 VOC Epoxy Primers E2B931/E2W932/E2A933 offer flexibility greater than standard epoxy primers. E2B931/E2W932/E2A933 require no induction time and are designed for truck manufacturers, fleets and automotive refinishers where extended service is important. These primers may be topcoated as soon as 30 minutes after priming.

TECHNICAL DATA:

	E2A933	E2W932	E2B931		
• Color	Gray	Off-White	Black	• Flash Point (@ 4:1:1)	38°F Seta
• Wt/gallon (mixed)	10.41 lbs/gal	10.43 lbs/gal	10.28 lbs/gal	• Viscosity (@ 4:1:1), #2 Zahn cup	14-16 sec.
• Mixing ratio by volume				• Performance after one week air dry (over Aluminum & Steel using GENESIS®)	
Primer : VS100 : V6V943	4 : 1 : 1	4 : 1 : 1	4 : 1 : 1	-Humidity Resistance - 100 hrs	Pass
• Volume Solids (@ 4:1:1)	40.88%	40.97%	40.90%	- Impact Resistance (direct @ 80 in-lbs)	Pass
• Coverage @ 1 mil (dry)	656 sq.ft./gal	657 sq. ft/gal	656 sq.ft/gal	- Flexibility (1/8" conical mandrel)	Pass
• Pot life @ 70-80°F	4 hrs	4 hrs	3 hrs	- Salt Spray Resistance - 250 hrs	Pass
• VOC less exempt @ 4:1:1	3.50 lbs/gal	3.50 lbs/gal	3.50 lbs/gal.	- Gloss Holdout (@ 15 - 30 mins re-coat)	Excellent
• HAPS Status	Compliant, Non-Photochemically Reactive			• Recommended dry film thickness (2 coats)1	.5-2.0 mil

SURFACE PREPARATION:

Substrates: Steel, Hot-dipped Galvaneal**, Aluminum, Stainless Steel (304 grade), SLI269 (SMC), E67AR1908 (IMC), ED5050 (E-Coated Steel), Body Filler****

**Note: With the inconsistencies of substrates, consult your local SHERWIN-WILLIAMS Representative for system recommendations and substrate testing.*

***Note: Recommended use of Hot-dipped Galvaneal only, using an Electro-deposited Galvaneal will result in substandard system performance.*

****Note: With several different types of Body Fillers available, consult your local SHERWIN-WILLIAMS Representative for system recommendations.*

1. Solvent clean with SHER-WILL-CLEAN® Solvent Cleaner R7K156 or AQUA-MATE™ Low VOC Surface Cleaner W4K157 and wipe dry with a clean, dry cloth.
2. Mechanically abrade all bare metal. For hot-rolled steel, a media blast is required to remove any surface impurities.
3. Solvent clean with SHER-WILL-CLEAN® Solvent Cleaner R7K156 or AQUA-MATE™ Low VOC Surface Cleaner W4K157 and wipe dry with a clean, dry cloth. For hot-rolled steel, proceed to primer application.
4. For IMC and SMC bare substrates clean with SC159 Plastic cleaner / Anti-static solvent based cleaner to remove all mold release or power wash agents. Follow with a deionized water rinse.

(For the above products refer to the appropriate product label or data page for complete information.)

Prepainted Substrates:

1. Wash surfaces with mild detergent in hot water. Rinse well and wipe dry with a clean, dry cloth.
2. Solvent clean surfaces with UltraClean® Surface Cleaner R7K158, SHER-WILL-CLEAN® Solvent Cleaner R7K156 or AQUA-MATE™ Low VOC Surface Cleaner W4K157. Wipe dry with a clean, dry cloth.
3. Grind repair area to remove paint and all rust as needed. Fill as needed using appropriate body filler. Allow body filler to tack up and shape as needed.

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- Sand repair area and featheredge using 80, 180, 280, and finish with 320 grit treated sandpaper on a random orbital sander. Solvent clean to remove sanding residue before recoating.

MIXING:

- Shake 3.5 VOC Epoxy Primer E2B931/E2W932/E2A933 thoroughly before mixing. Use care when opening after shaking, as slight solvent pressure may build. A 15 minute wait is recommended.
- Mix by volume 4 parts 3.5 Epoxy Primer E2B931/E2W932/E2A933 to 1 part VS100 Reducer to 1 part 3.5 Epoxy Activator V6V943. *Note: VS 100 maybe replaced with R7K7210 or ES20 for warm and hot conditions respectively where improved leveling and overspray acceptance are needed.*
- Stir thoroughly and strain.

APPLICATION:

- For proper results use the following equipment recommendations. Check equipment by applying E2B931/E2W932/E2A933Epoxy Primer to a test panel before using.
- Apply 2 wet coats of E2B931/E2W932/E2A933. Epoxy Primer to achieve the recommended dry film thickness of 1.5-2.0 mils.

DRYING SCHEDULE:

Dry times are based on the recommended dry film thickness of 1.5-2.0 mils.

- Air-dry times @ 75°F and 25% R.H.

Hand-slick	5 minutes
To Recoat Tack-Free	30 minutes (see below)
Nib Sandable	1 hour
Sandable	1 hour
Tape Free	1.5 hours (Slightly longer for Black) 1.5 hours (Slightly longer for Black)

- Force dry times (to tape free)

45 minutes at 160°F 30 minutes at 180°F

RECOMMENDED GUNS:

Spray Gun		Fluid Tip/		Atomizing	Fluid	Gun
Type & Model	Manufacturer	Needle	Air Cap	Air	Delivery	Distance
HVLP (M21)	Kremlin	#209 (.035)	LP3	10 psi at cap	10-12 oz/min	4-6 inches
HVLP (GTI)	DeVilbiss	1.4 mm	#100	10 psi at cap	10-12 oz/min	4-6 inches
HVLP (K-NR 95)	SATAjet	NR-95 (.0895)	NR-95 (.08)	10 psi at cap	10-12 oz/min	4-6 inches
Pressure Feed (JGA 502)	DeVilbiss	FF or FX	797/777	50-55 at gun	10-12 oz/min	10-12 inches
*Air-Assisted Airless (MX)	Kremlin	06-116 (.011)	BX-16	20 psi at gauge	600 psi at gauge	8-12 inches
*Air-Assisted Airless (MX)	Kremlin	09-1 36 (.013)	BX-16	20 psi at gauge	600 psi at gauge	8-12 inches

* See Spray Gun manufacturer for specific set up recommendations and constraints.

RECOATING:

- E2B931/E2W932/E2A933 3.5 VOC Epoxy Primers may be recoated up to 3 days after spraying without scuffing for all topcoats except Ultra 7000®, which may be recoated up to 2 days without scuffing. When 3 days have passed, scuff sand with 320 grit or finer sandpaper to insure proper adhesion.
- Recommended topcoats:

DIMENSION™ 3.5 Urethane	SUNFIRE® Acrylic Urethane
ULTRA ONE-STAGE TURBO®	SUNFIRE® Low VOC Acrylic Urethane
ULTRA 7000® Basecoat/Clearcoat	SUNFIRE® Basecoat/Clearcoat
ACRYLYD® 5.0*	GENESIS® 2.8/3.5 Acrylic Urethane
ACRYLYD® H.S.**	GENESIS® Basecoat/Clearcoat *

Topcoat within 8 hours when using ACRYLYD/V6V247 over E2A933 series primers. **

Topcoat within 24 hours when using ACRYLYD HS over E2A933 series primers

PRODUCT AT-A-GLANCE

PRODUCT

3.5 VOC Epoxy Primers

E2B931 Black
E2W932 Off-White E2A933

USE

- Direct to properly cleaned metal surfaces
- Ideal for harsh environments where corrosion protection is important
- Fast dry

SUITABLE SUBSTRATES*

- Steel/Stainless Steel
- Aluminum
- SLI269 (SMC)
- Body Filler
- *Hot-dipped Galvaneal*
- E67AR1908 (IMC)
- ED5050 (E-coated Steel)

* See previous section on surface preparation for details.

SURFACE PREPARATION

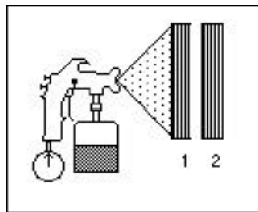
- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- Solvent clean with the appropriate solvent cleaner and wipe dry with a clean cloth.
- Grind repair area to remove paint and all rust as needed.
- Apply body filler to clean bare metal as needed.
- Sand all areas to be refinished and featheredge all broken film areas.

MIXING

1. Stir or shake 3.5 VOC Epoxy Primer E2B931/E2W932/E2A933 thoroughly before mixing. Use care when opening after shaking, as slight solvent pressure may build. A 15-minute wait is recommended.
2. Mix by volume 4 parts 3.5 Epoxy Primer E2B931/E2W932/E2A933 to 1 parts VS100 Reducer to 1 part 3.5 Epoxy Activator V6V943. *Note: VS100 maybe replaced with R7K7210 or ES20 for warm and hot conditions respect ively where improved leveling and overspray acceptance are needed.*
3. Stir thoroughly and strain.

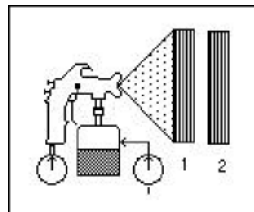
APPLICATION

Siphon Feed
Apply 2 coats.
Allow each coat to become hand slick.



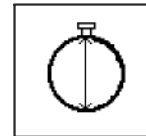
50 - 55 psi HVLP: 8-10 psi

Pressure Feed
Apply 2 coats.
Allow each coat to become hand slick.



50-55 psi pot pressure: 8-10 psi

Time to
Recoat
30 minutes



RECOAT

SUNFIRE® Acrylic Urethane
SUN FIRE® Low VOC Acrylic Urethane
SUNFIRE® Basecoat/Clearcoat
GENESIS® 2.8/3.5 Acrylic Urethane
GENESIS® Basecoat/Clearcoat

DIMENSION™ 3.5 Urethane ULTRA
7000® Basecoat/Clearcoat
ACRYLYD® HS
ACRYLYD® 5.0
ULTRA ONE-STAGE TURBO®

NOTES

- Scuff sand with 320 or finer sandpaper after 3 days of dry time before topcoating.
- For optimum corrosion resistance, 1.5-2.0 mils of primer (dry) is recommended.
- Topcoat within 8 hours when using ACRYLYD/V6V247 over E2A933 series primers.
- Topcoat within 24 hours when using ACRYLYD HS over E2A933 series primers

PERSONAL PROTECTION

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a NIOSH approved organic vapor respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, and rubber gloves when using product.

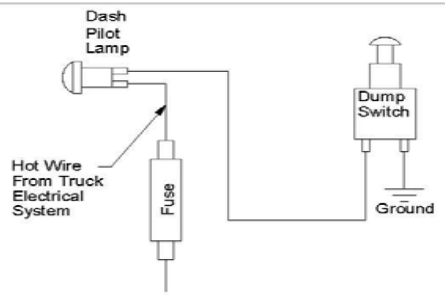
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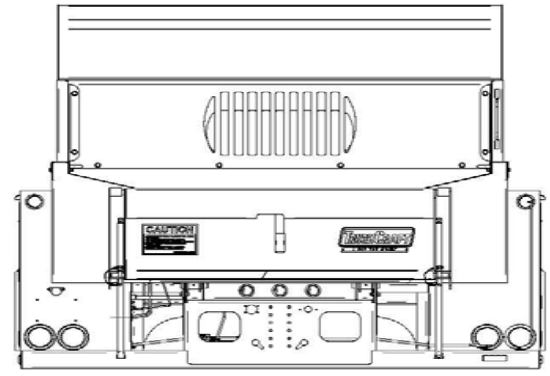
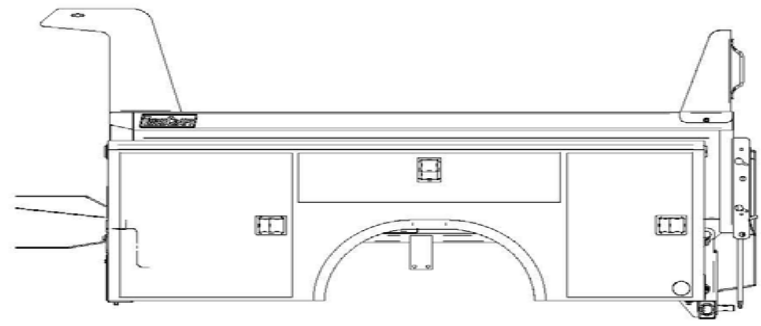
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TC-300/310 Service Dumper Tarp Kit INSTALLATION INSTRUCTIONS

1. Slide 1 nylon bearing on to tarp crank, bearing flange facing away from crank handle.
2. Insert tarp roller shaft end through the passenger side hole in the cabguard.
3. Slide crank through hole in cabguard on drivers side and into the tarp roller.
4. Slide 2nd bearing on to protruding shaft end with flange against cabguard.
5. Attach the bearings to the cabguard sides.
6. Drive roll pin through hole in crank shaft to secure shaft to roller.
7. Unfold tarp and stretch narrow width across roller, lining up grommets along roller.
8. Use hose clamps, opening them up and wrapping them around roller, and threading them through the tarp, one per grommet, to attach the tarp to the roller. Keep tarp taught from side to side.
9. Slide batten board through looped end of tarp until board is centered in tarp. In center of the board, in the narrow edge, drill a 3/16" hole through the fabric and into the board about 3/8" deep. Using the supplied screw eye, start it in the drilled hole and turn until tight.
10. Attach supplied rope to screw eye and wind tarp onto roller.

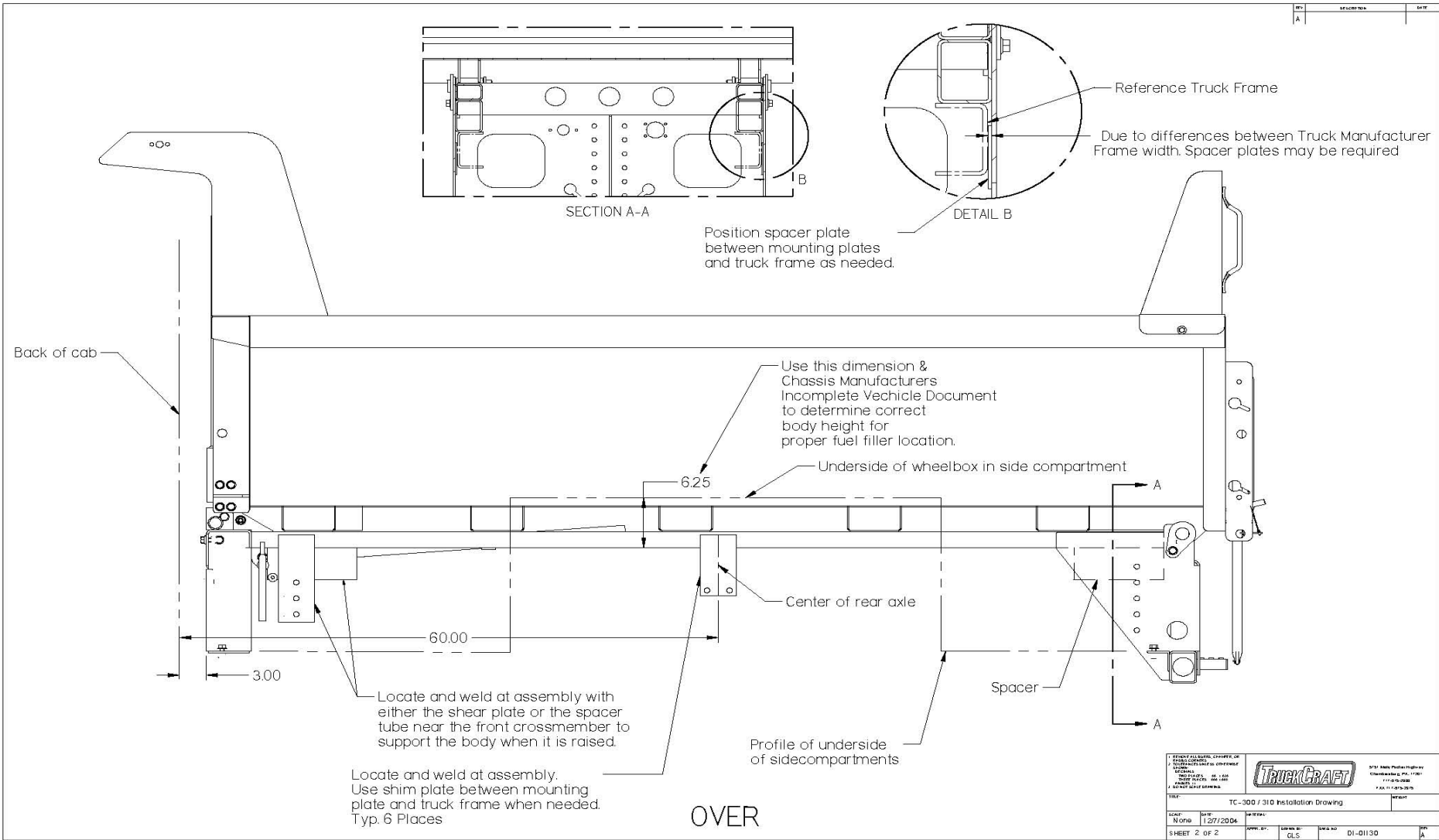


Dump Bed Raised Lamp
Wiring Diagram



OVER

<small> TRUCK CRAFT TRUCK PARTS 1000 W. 10th St. P.O. Box 1000 Tulsa, OK 74101 918-438-2222 FAX 918-438-2223 </small>				<small> 8700 W. Parkside Oklahoma City, OK 73126 405-751-1111 FAX 405-751-1112 </small>	
EC-300 / 310 Installation Drawing					
<small> DATE: 1/27/2004 SHEET 1 OF 2 </small>	<small> DRAWN BY: GLS </small>	<small> CHECKED BY: </small>	<small> DATE: 01-01-10 </small>	<small> 10 </small>	



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<small> SHEET 2 OF 2 </small>	<small> NONE </small>	<small> 1/27/2004 </small>	<small> CLS </small>	<small> DI-01130 </small>