

Assembly and Operation

of the

Fit Up Gear

(<http://www.fitupgear.com>)

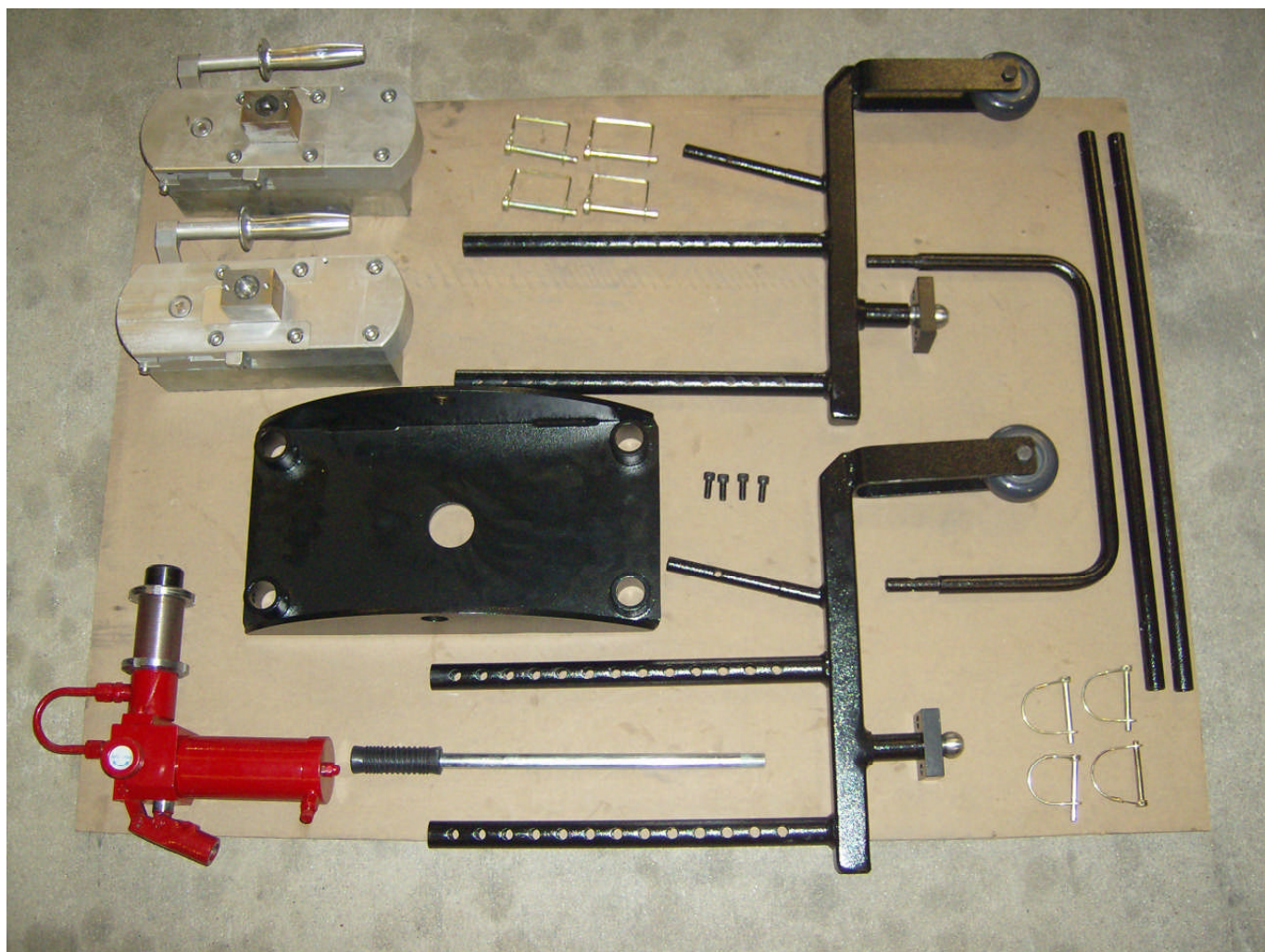
STIF-JAK



Assembly of the Stif-Jak is very easy. You will need only 3 tools and some grease: A hammer, a punch (or a large flat blade screwdriver that you don't mind using as a punch), and a ¼" Allen wrench.

First, check the contents to make sure all of the pieces are there. You should have:

- Center Body, 1
- Adjustable Caster/Magnet Frame, 2
- Hydraulic Jack, 1
- Hydraulic Jack Handle, 1
- Magnet, 2
- Straight Handle Section, 2
- U Handle Section, 1
- Allen Socket Cap Screw, 4
- Large Diameter Retaining Pin, 4
- Small Diameter Retaining Pin, 4



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Step 1

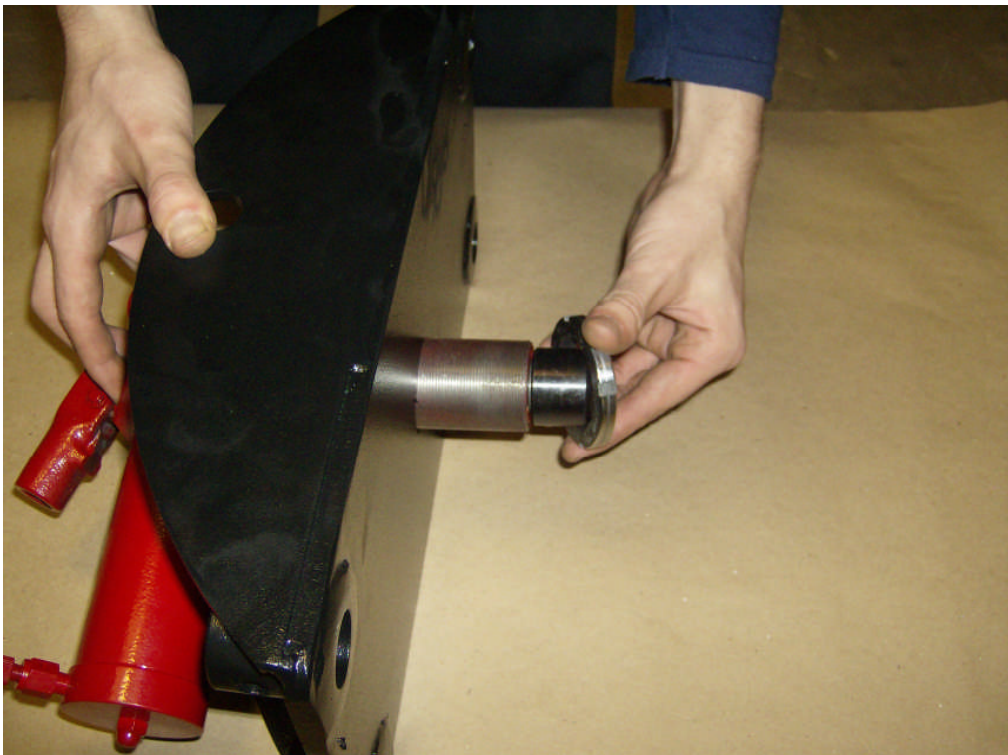
Install the Hydraulic Jack. Needed: Center body section and hydraulic jack. Tools: Hammer and punch or screwdriver.



Note that the hydraulic jack shank nuts have one side beveled, and one side flat. If needed, reinstall the first nut onto the hydraulic jack threaded shank **BEVELED SIDE FIRST** so that the flat side will be against the center body when installed. Run the nut all the way up to the top of the threads.



Stand the center body section on one side as shown. Insert the hydraulic jack threaded shank into center body section from the side with the gusset plates and adjustable leg retainers.



Screw the lower nut on, all the way up to the center body plate. Make sure to start this nut with the FLAT FACE toward the plate!

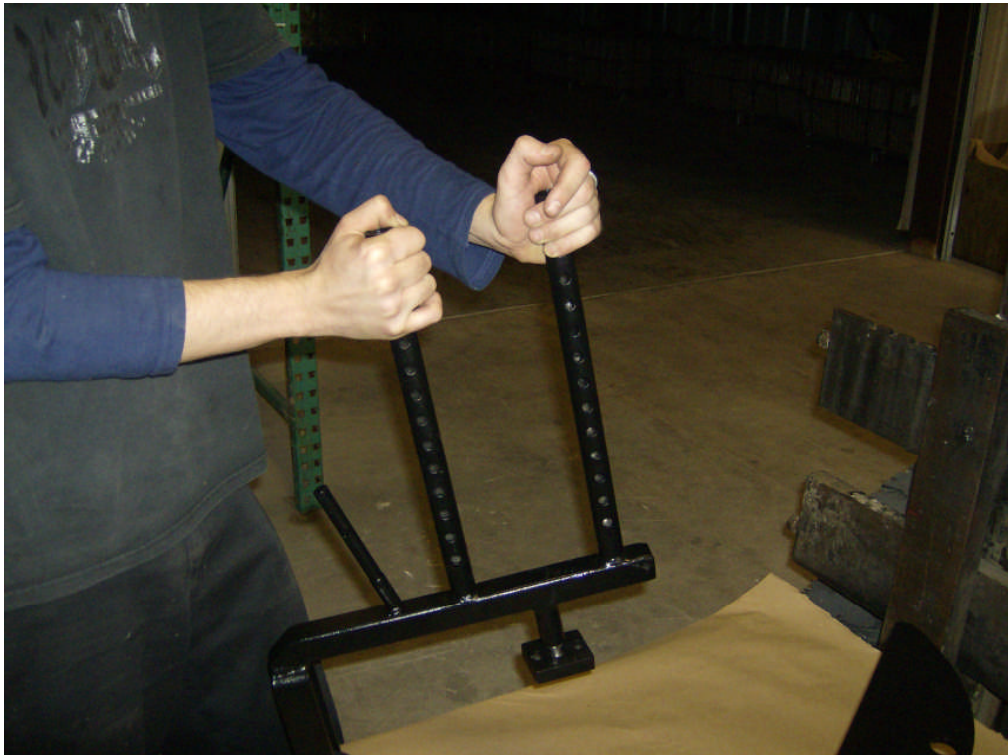
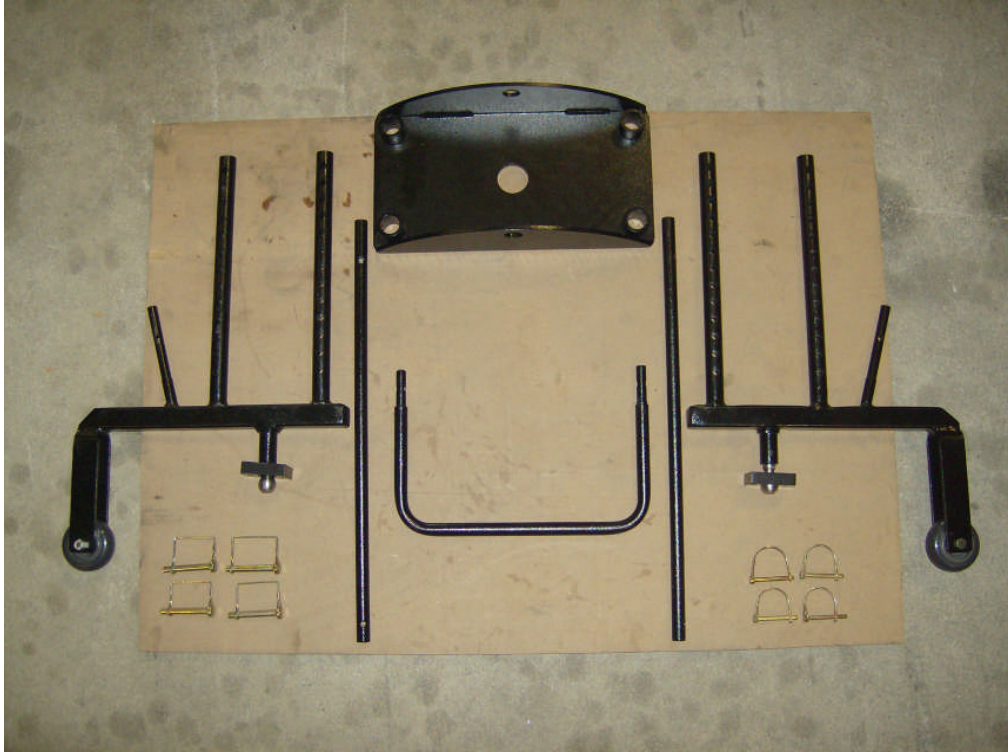


Use the hammer and punch (or screwdriver) to securely tighten the lower nut. Have someone hold the hydraulic jack body to keep it straight while you do this.

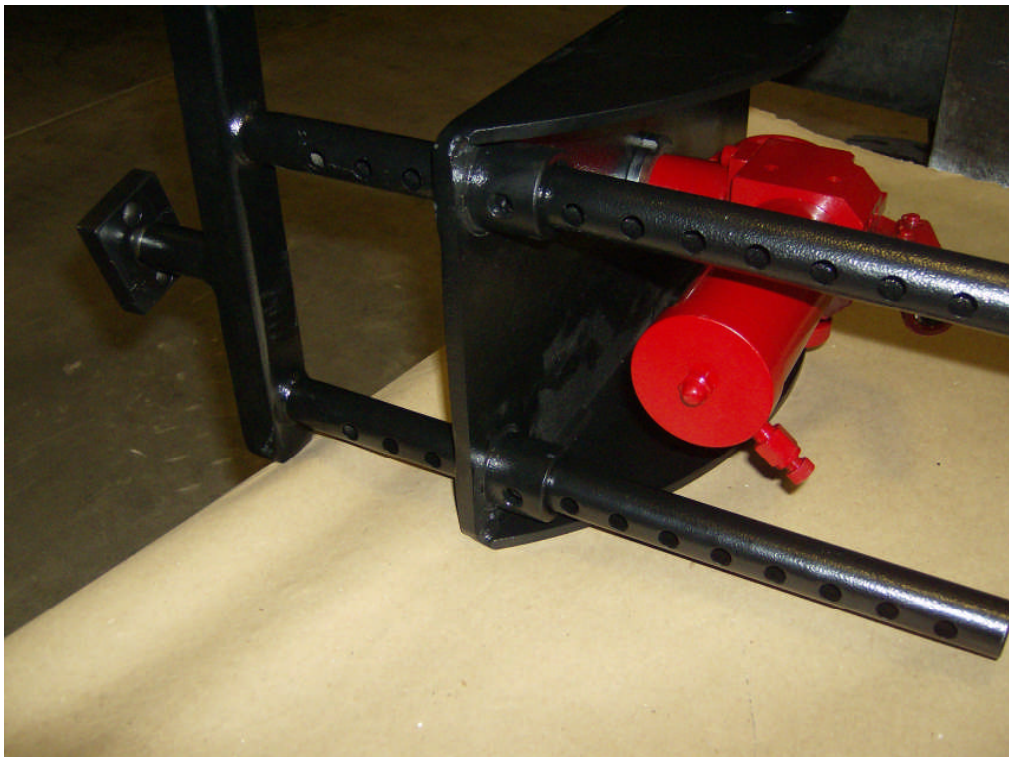
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Step 2

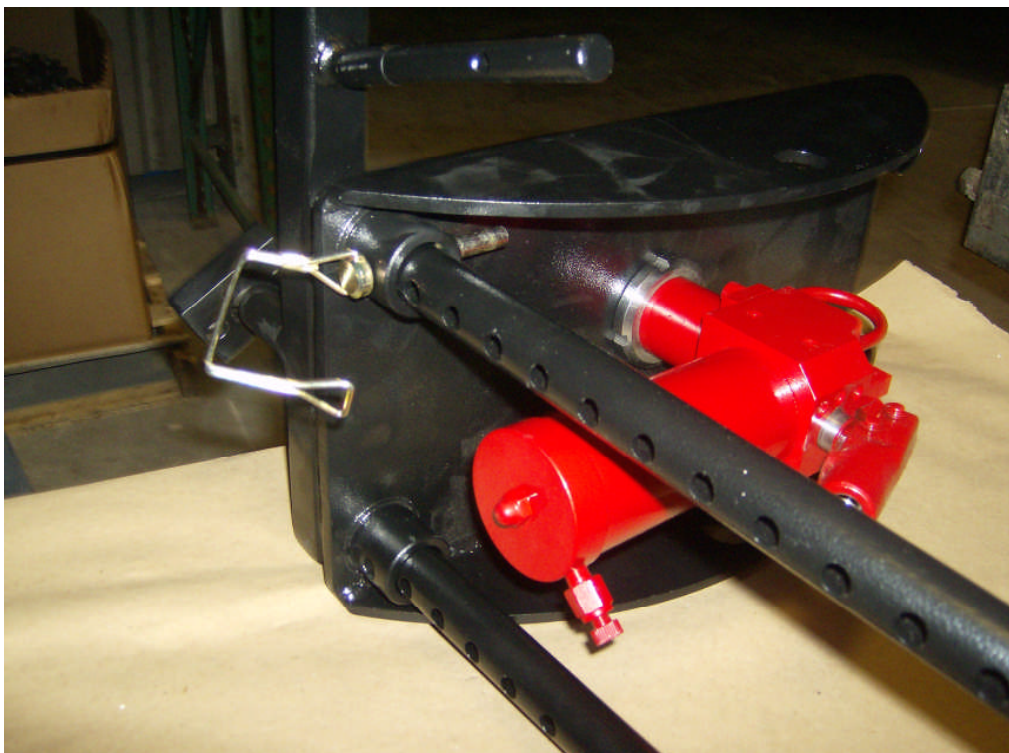
Assemble the lower frame components. Needed: center body section, the 2 caster/magnet frames and the 4 large retaining pins. Tools: None.



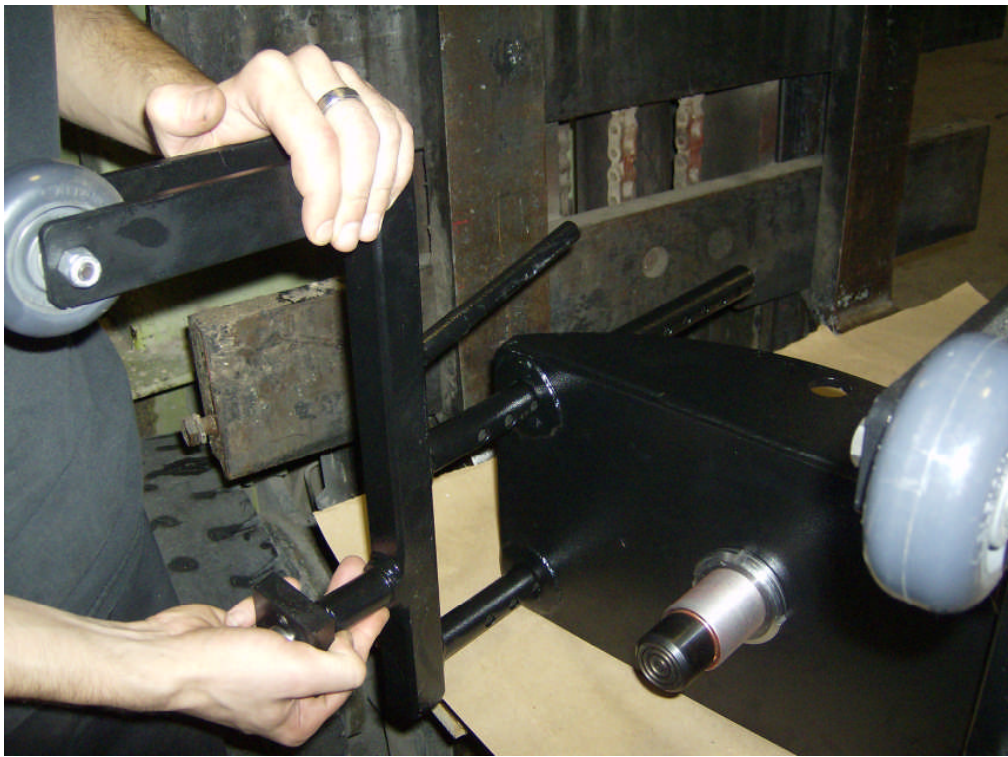
You might need to “spring” the legs just a tad!!



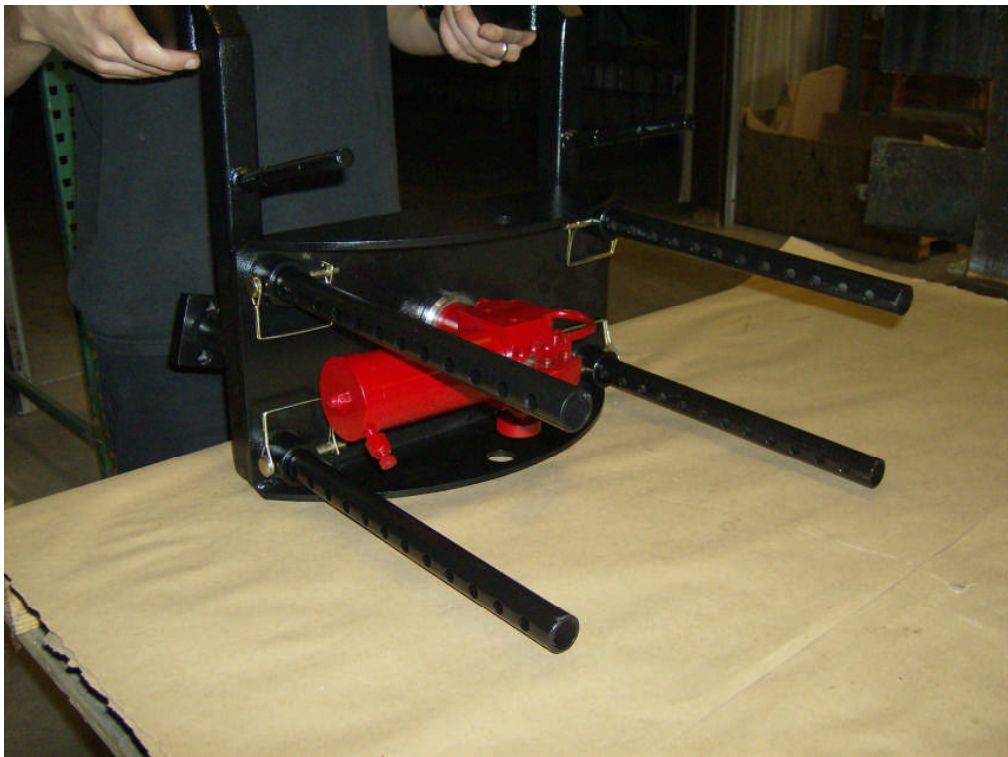
Insert the adjustable frame legs and align a pair of holes with the retainer holes.



Insert a large retaining pin in each hole.



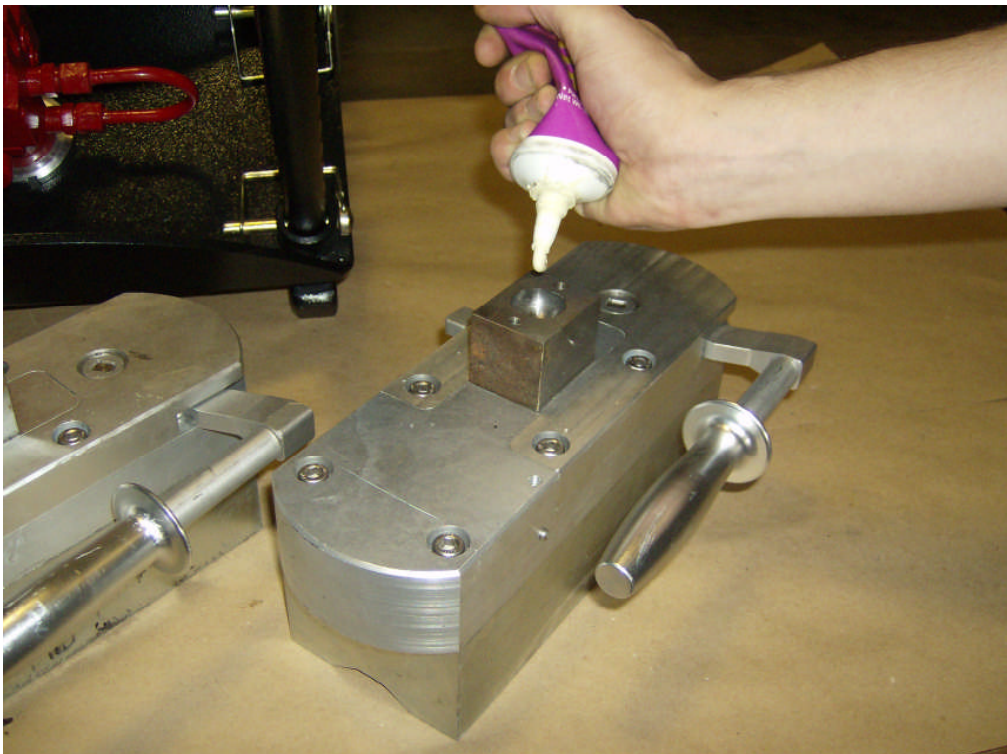
Repeat on the other side.



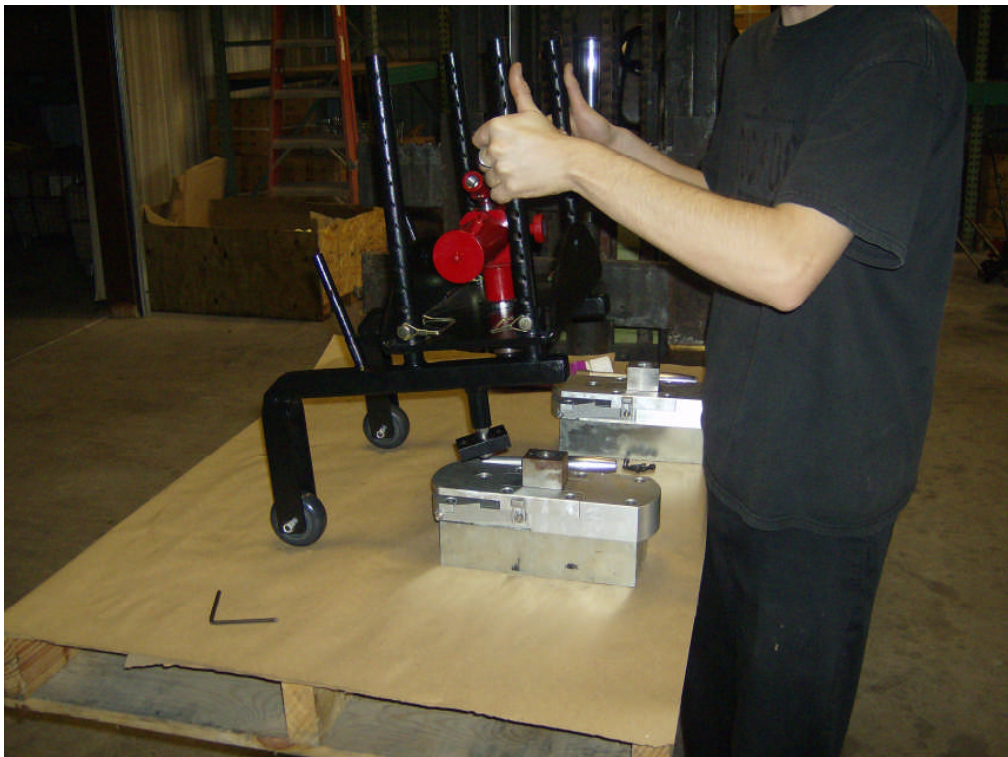
Install all 4 large retaining pins to finish this part.

Step 3

Attach the Magnets. Needed: The two magnets, 4 Allen socket cap screws. Tools: 1/4" Allen wrench, grease.

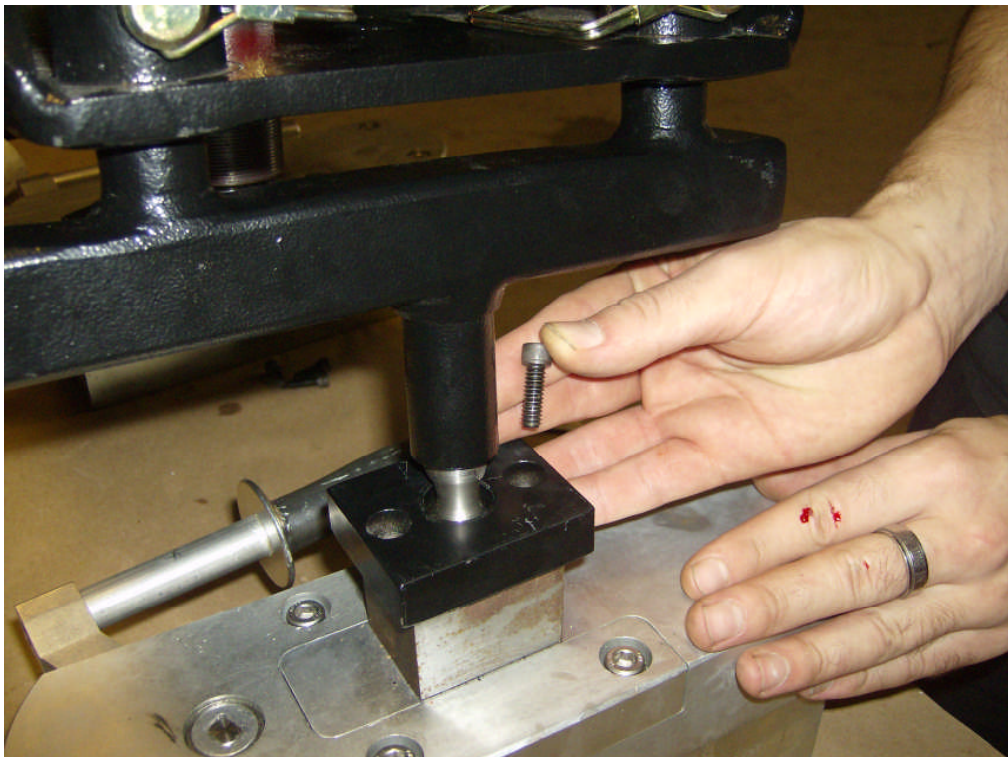


Apply a small amount of general purpose grease to the ball sockets (upper is not shown, it is part of the already assembled frame, grease it as well!)



Roll the frame forward to seat the ball into the socket on the first magnet.





Use the allen socket cap screws and the ¼" allen wrench to bolt the ball socket halves together. Also... don't drop the heavy magnet on your hand while handling it. As Patrick found out – that hurts!



Repeat for the second magnet, and this part is finished!

Step 4

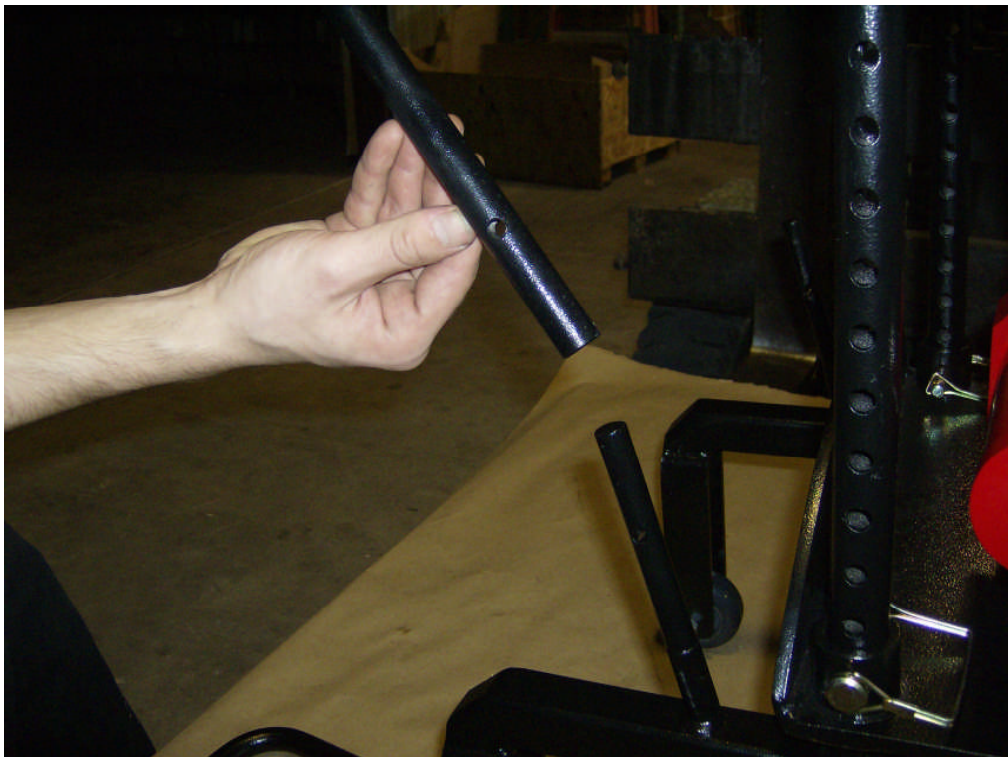
Attach the handles. Needed: The hydraulic jack handle, the 2 straight handle sections, the U handle section, and the 4 small diameter retaining pins. Tools: None.



Screw the hydraulic jack handle into the jack.



NOTE: The straight handle sections are different at each end. The hole is further in on one end.



Insert the straight handle sections onto the pins on the caster/magnet brackets.
NOTE: Use the end with the hole further in!



Use the small diameter retaining pins to secure the handle parts.

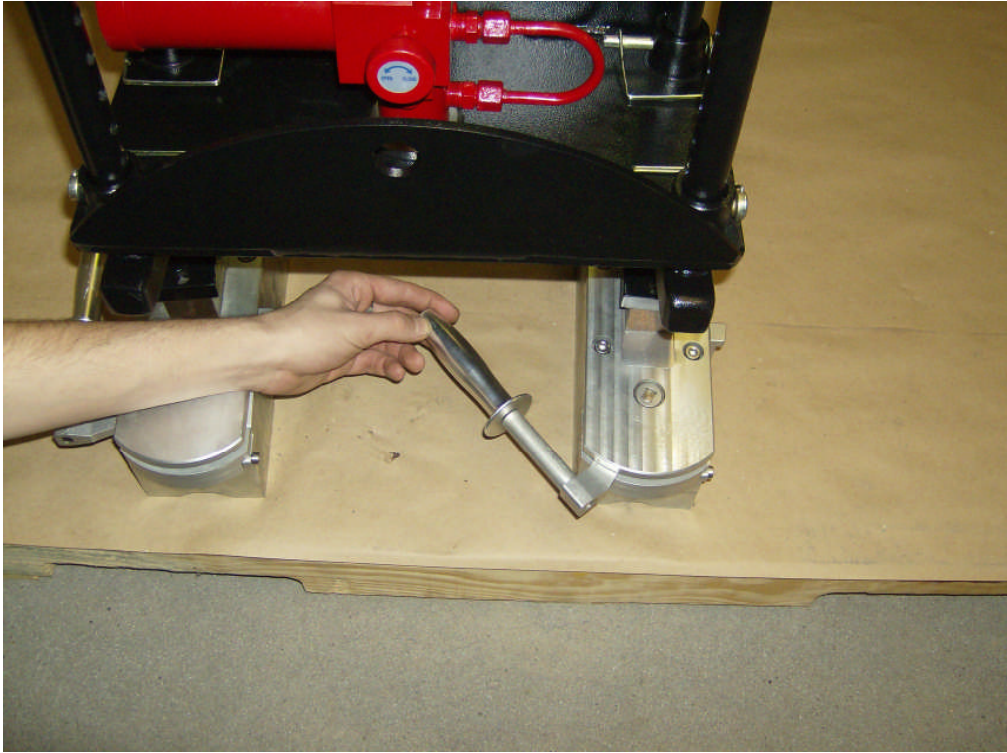


Insert the U handle section into the two straight handle sections and use the last two small diameter retaining pins to lock it in place. That finishes this part!

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Step 5

Orient the magnet operating levers properly.



Turn both magnets so the operating lever ends of the magnets are **AWAY** from the casters. Unscrew the magnet operating handle shown.



The handle consists of 3 parts.



Reinstall the handle facing OUT, as shown.

That's it! You have finished assembly of the STIF-JAK.

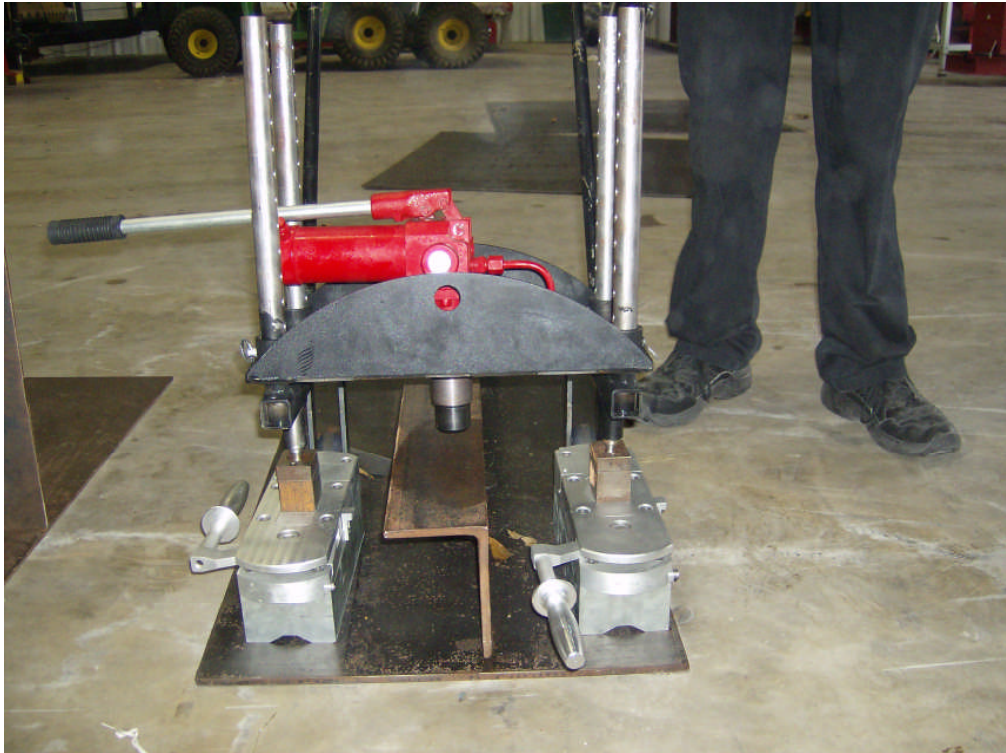


Operating the STIF-JAK

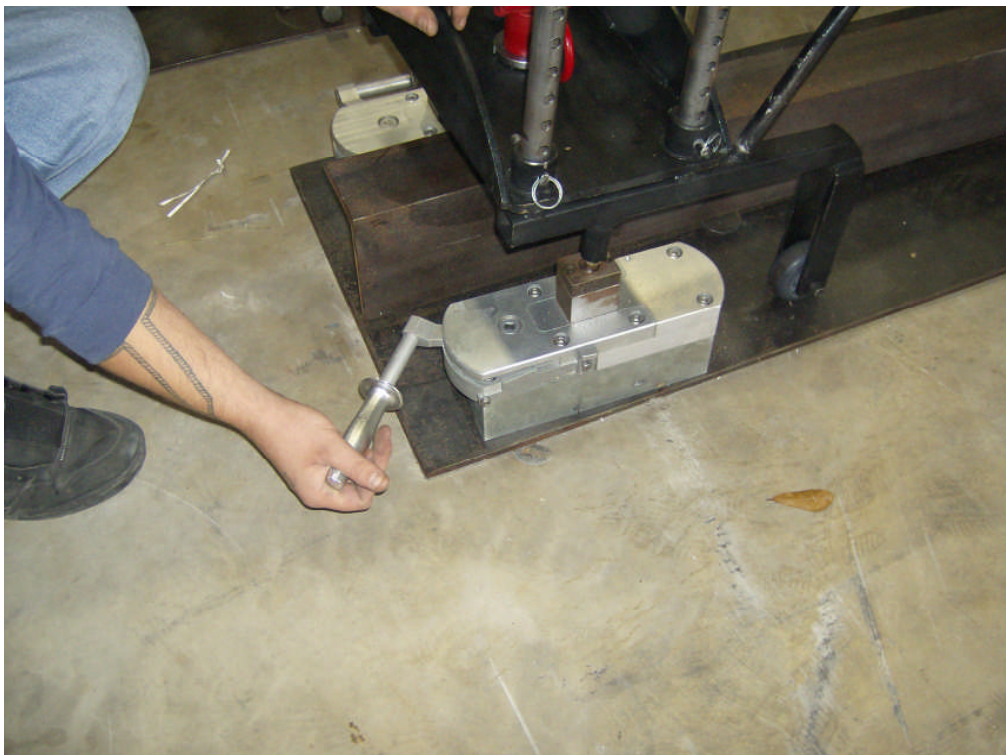
WARNING!!! WARNING!!! WARNING!!!

ALWAYS RELIEVE THE HYDRAULIC PRESSURE PRIOR TO TURNING THE MAGNETS OFF! SERIOUS INJURY COULD OCCUR FROM FAILURE TO DO SO!!!

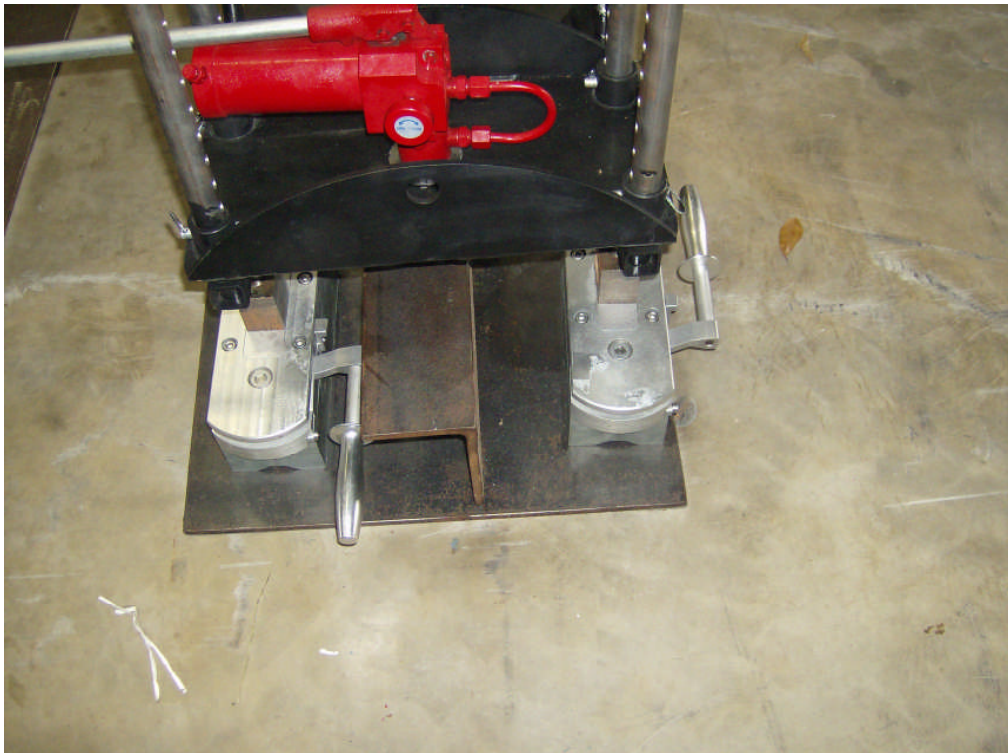
Do NOT heat the magnets. It will cause them to weaken.



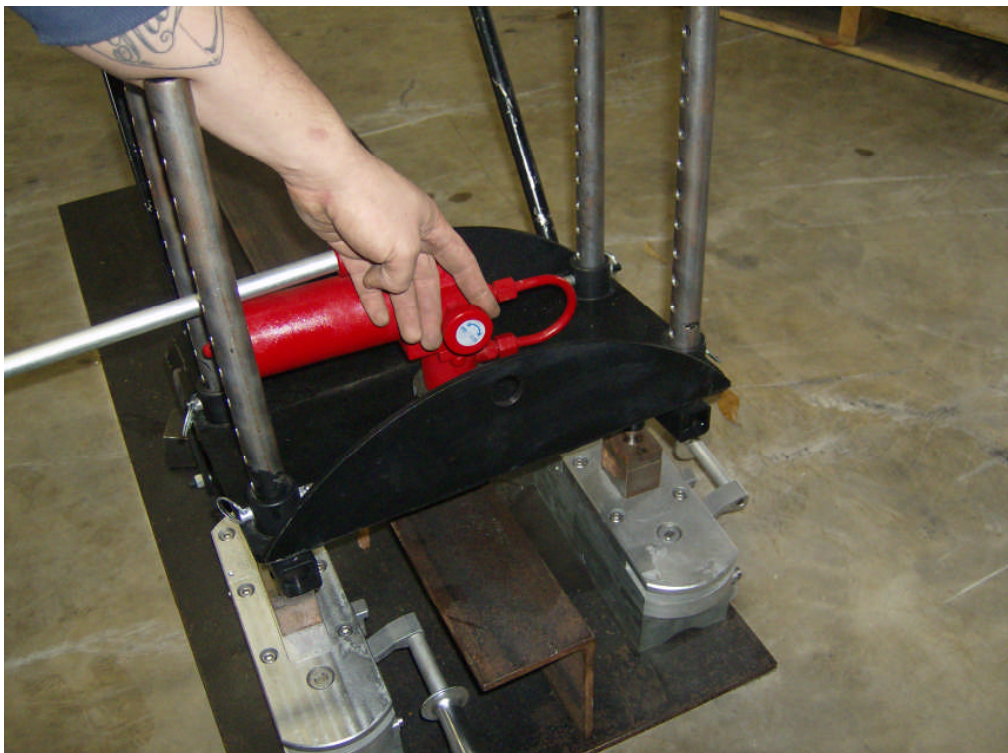
Roll the STIF-JAK into position.



Rotate the magnet levers 180 degrees to turn the magnets on. There will be a "click" and you'll feel it when the levers seat home in the full on position.



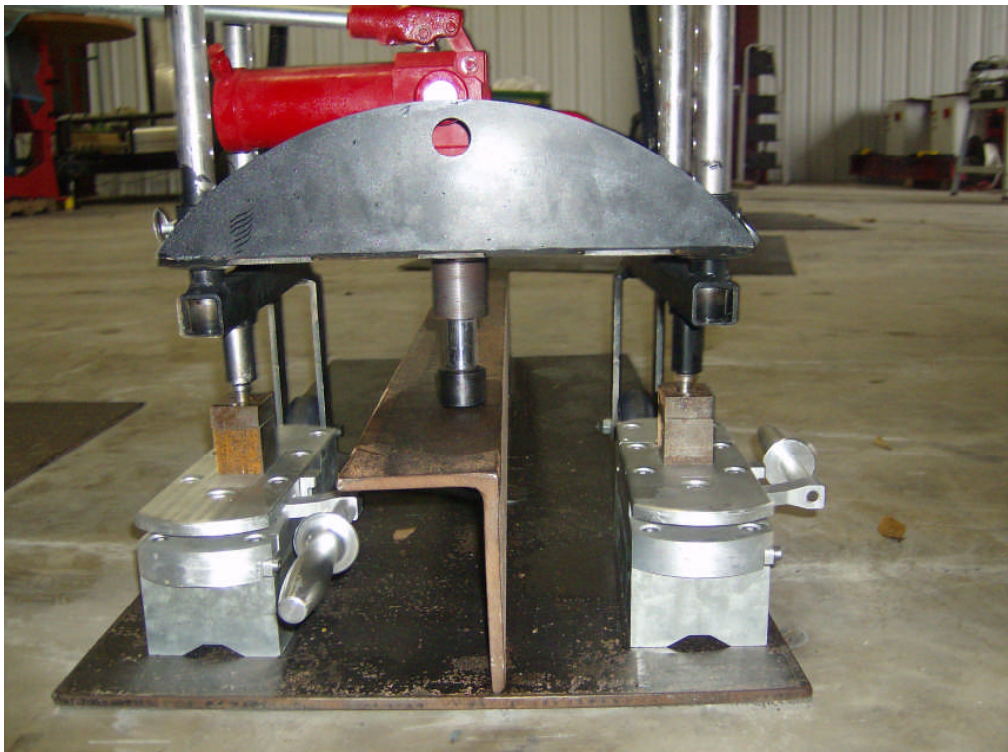
Both magnets are now on.



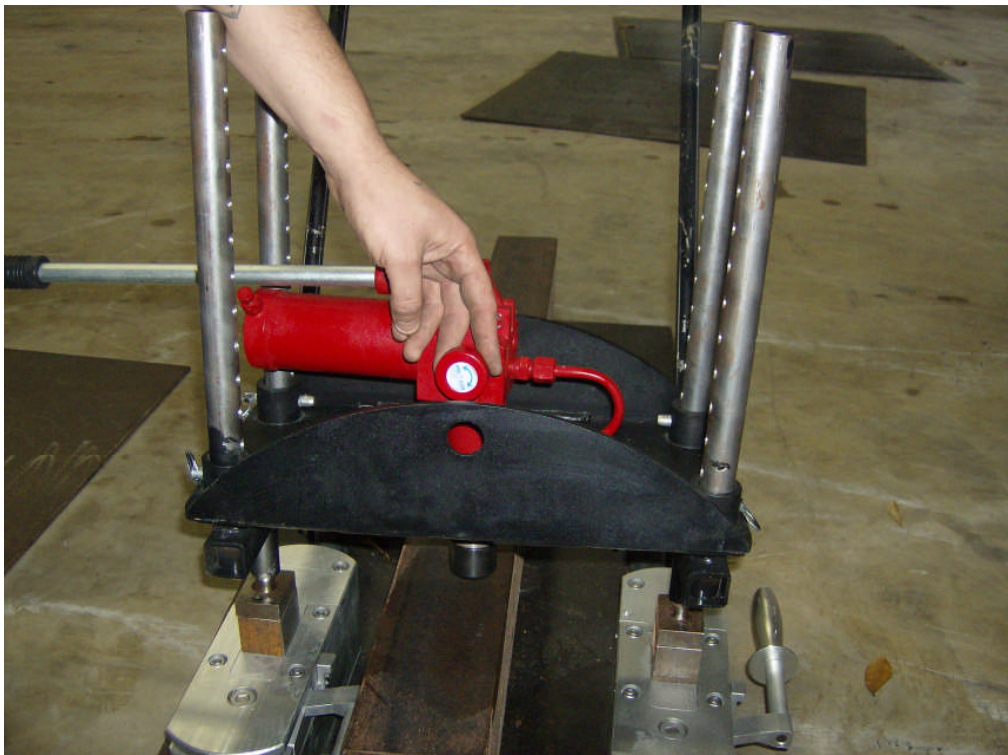
Close the hydraulic jack valve by turning the knob clockwise.



Pump the hydraulic jack handle until the bottom plate is pulled up against the stiffener.



The STIF-JAK is **VERY STRONG!** As you can see, we have pulled this plate up to the angle with enough force to not only bend it around the wedge that we have between the plate and angle behind the STIF-JAK, but we are also pulling it hard enough to cause the plate to begin curling up on each side of the stiffener. Be careful to not apply more force than is needed to do the job!

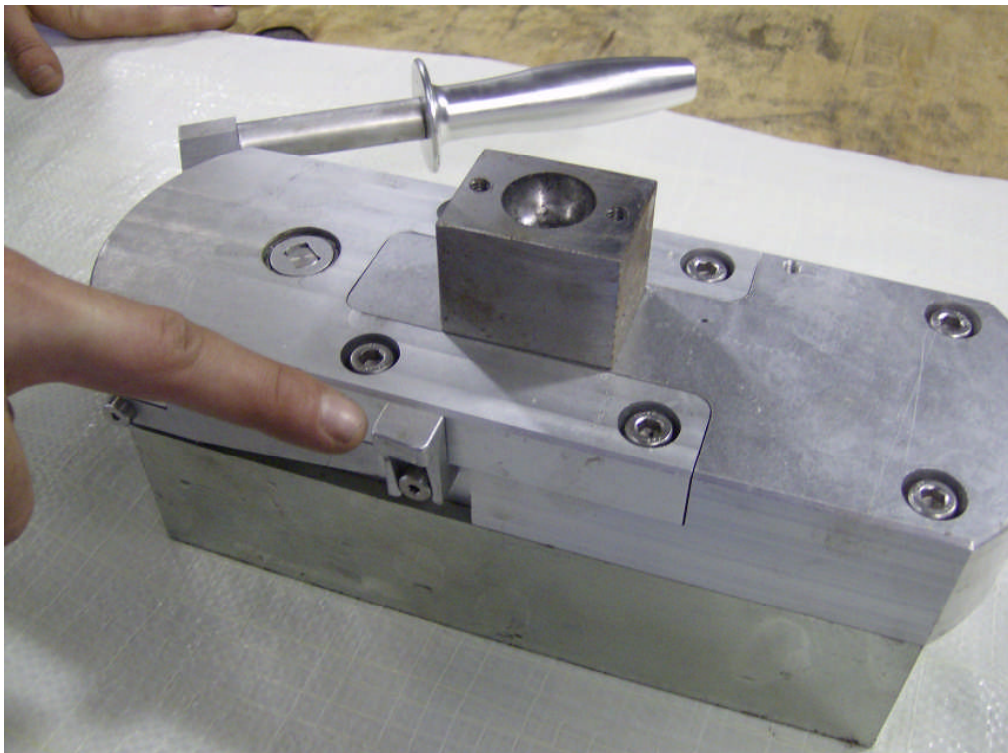


When you have done the tack welding, release the pressure by turning the valve knob counter-clockwise. Then turn the magnets off.

WARNING!!! WARNING!!! WARNING!!!

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Do NOT heat the magnets. It will cause them to weaken.



The magnets have a positive lock in the on position. To release the magnet operating lever so you can turn the magnet off, push down on the release lever.

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