

CTR	DESCRIPTION	DATE (YR-MO-DA)	APPROVED	DATE
A	REDRAWN WITH CHANGE, (AMG P8406)	94-08-24	<i>[Signature]</i>	7-15-94

NOTES:

1. APPLICABLE STANDARDS/SPECIFICATIONS:
A. DOD-STD-00100D(AR)

**INSTALLATION INSTRUCTIONS
CAB REINFORCEMENT KIT**

SECTION I. INTRODUCTION

- 1-1. PURPOSE. THE PURPOSE OF THESE INSTRUCTIONS IS TO PROVIDE A PROCEDURE FOR INSTALLATION OF THE CAB REINFORCEMENT KIT ON 2-1/2 TON M44A2, AND 5-TON M39A2, AND M809 SERIES VEHICLES. LESS THE FOLLOWING MODELS: 5-TON: M51A2, M291A2D, M328A2, M748A2, M815, M817, M820, M820A1, M820A2, AND M821. 2-1/2 TON: M342A2, M49A2C, AND M764.

REV STATUS OF SHEETS	REV	A	A	A	A	A											
	SHEET	1	2	3	4	5											

PMIC NA		CONTRACT NUMBER DAAE07-91-C-R053		U.S. ARMY TANK-AUTOMOTIVE COMMAND WARREN, MICHIGAN 48397-5000			
APPLICATION		CONTRACTOR AM GENERAL CORP. ENGINEERING & TECHNICAL SERVICES DIV. LIVONIA, MICHIGAN					
NEXT ASSY	USED ON	DRAWN BY DL	DATE (YR-MO-DA) 89-08-09	INSTRUCTIONS FOR INSTALLATION OF CAB REINFORCEMENT KIT 5705616			
	M39A2	CHECKER DMC	ENGINEER Steve Barcewicz				
	M44A2	DRAWING APPROVAL <i>[Signature]</i> 94-09-28		SIZE A	CAGE CODE 19207	12375530	
5705616	M809	DESIGN APPROVAL <i>[Signature]</i>		SCALE NONE	UNIT WT. —		
MATL ENGR AHF							

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SECTION II. INSTALLATION KIT

2-1. NEW MATERIAL. INSTALLATION KIT 5705616 CONTAINS THE FOLLOWING ITEMS:

<u>PART NO.</u>	<u>NOMENCLATURE</u>	<u>QTY.</u>
12315644-2	RIVET	95
12375497	INSTALLATION DRAWING	1
12375493	PLATE ASSEMBLY, REINFORCEMENT CAB	1
12375499	PLATE, REINFORCEMENT CAB CAP	1
12375520	NUT ASSEMBLY, PILLAR	1
12375530	INSTALLATION INSTRUCTIONS	1
MS27183-14	WASHER	4
MS35338-48	WASHER	1
MS51922-5	NUT	12
MS51922-21	NUT	4
MS90726-62	SCREW	4
MS90726-111	SCREW	1

2-2. EXISTING MATERIAL. ALL MATERIAL REMOVED AND NOT REUSED DURING INSTALLATION WILL BE RETURNED TO STOCK FOR DISPOSITION IN ACCORDANCE WITH AR 725-50.

SECTION III. INSTALLATION PROCEDURES

3-1. VEHICLE PREPARATION.

- A. PLACE VEHICLE IN A WELL LIGHTED AND VENTILATED AREA.
- B. APPLY HANDBRAKE. (REFER TO TM 9-2320-361-10 FOR 2-1/2 TON M44A2; TM 9-2320-211-10 FOR 5-TON, M39A2; AND TM 9-2320-260-10 FOR 5-TON, M809 SERIES VEHICLES.)
- C. REMOVE CAB TOP. (REFER TO TM 9-2320-361-10 FOR 2-1/2 TON, M44A2; TM 9-2320-211-10 FOR 5-TON, M39A2, AND TM 9-2320-260-10 FOR 5-TON, M809 SERIES VEHICLES.)
- D. REMOVE DRIVER'S AND COMPANION'S SEAT ASSEMBLIES. (REFER TO TM 9-2320-209-20 FOR 2-1/2 TON, M44A2; AND TM 9-2320-211-20 FOR 5-TON, M39A2; AND TM 9-2320-260-20 FOR 5-TON, M809 SERIES VEHICLES.)

TITLE INSTRUCTIONS FOR INSTALLATION OF CAB REINFORCEMENT KIT 5705616	SIZE A	CAGE CODE 19207	12375530
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WARNING

WEAR HEARING AND EYE PROTECTION WHEN TESTING CAB AREA.
FAILURE TO DO SO COULD RESULT IN INJURY TO PERSONNEL.

NOTE

- INSPECT CAB ASSEMBLY FOR DAMAGE THAT AFFECTS INSTALLATION OF THE CAB REINFORCEMENT KIT. TEST CAB AREAS, IDENTIFIED BY SHADING IN FIGURE 1, FOR METAL SOUNDNESS BY PROBING THE METAL SURFACES EVERY 3 IN. (7.6 CM) WITH A 3/8 IN. FLAT POINT PUNCH AND 16 OZ. MACHINIST'S BALL PEEN HAMMER (FRONT AND REAR OF CAB.)
- GOOD METAL WILL REMAIN INTACT OR DENT SLIGHTLY WHEN TAPPED WITH HAMMER AND PUNCH. RUSTED, CORRODED, OR DAMAGED METAL WILL PUNCH THROUGH OR CRUMBLE WHEN STRUCK. IF METAL SURFACES ARE SOUND, PROCEED WITH INSTALLATION INSTRUCTIONS AS DESCRIBED IN KIT. IF RUST OR DAMAGE IS FOUND, THE EXTENT OF DAMAGE MUST BE DETERMINED IN ORDER TO DECIDE WHAT REPAIR PROCEDURE TO USE OR WHETHER CAB ASSEMBLY SHOULD BE REPLACED. RUST OR OTHER METAL DAMAGE MUST BE REPAIRED BEFORE INSTALLING CAB REINFORCEMENT KIT.
- DURING INSTALLATION OF CAB REINFORCEMENT KIT, TWO MIDDLE SEATBELTS MUST BE REMOVED IN ORDER TO INSTALL REINFORCEMENT PLATE.
- IF THERMAL BARRIER KIT IS INSTALLED, PERFORM STEP "E". IF THERMAL BARRIER KIT IS NOT INSTALLED, PROCEED TO STEP "F".

E. REMOVE THERMAL BARRIER FROM CAB REINFORCEMENT PILLARS AS SHOWN IN FIGURE 1.

NOTE

REMOVE AND REPLACE SCREWS AND CAGE NUTS INDIVIDUALLY.

- F. REMOVE FOUR CAB SUPPORT SCREWS AND CAGE NUTS AND REPLACE WITH FOUR MS90726-62 SCREWS, MS27183-14 WASHERS AND MS51922-21 NUTS AS SHOWN IN FIGURE 1.**
- G. LOCATE, MARK, AND SCRIBE CENTER LINES ON FIVE CAB REINFORCEMENT PILLARS AS SHOWN IN FIGURE 2.**

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3-2. INSTALLATION OF CAB REINFORCEMENT KIT.

- A. POSITION TOP OF 12375498 CAB REINFORCEMENT PLATE PARALLEL AND CENTERED SEVEN INCHES BELOW TOP OF CAB FLANGE AS SHOWN IN FIGURE 3. SECURE WITH CLAMPS.
- B. SCRIBE CENTER LINES FROM CAB REINFORCEMENT PILLARS ONTO CAB REINFORCEMENT PLATE AS SHOWN IN FIGURES 2 AND 3.
- C. SCRIBE FLANGE CENTER LINES ON CAB REINFORCEMENT PLATE AS SHOWN IN FIGURE 3.
- D. REMOVE CLAMPS AND CAB REINFORCEMENT PLATE FROM CAB OF VEHICLE.
- E. LOCATE, MARK, AND DRILL THREE 0.257-INCH DIAMETER HOLES MARKED "A" AS SHOWN IN FIGURE 4. RIVETS AS SHOWN IN FIGURE 5.

CAUTION

DO NOT DRILL HOLES WITHIN 0.50-INCH OF SEATBELT CUTOUT.

- F. LOCATE, MARK, AND DRILL SEVENTY-FOUR 0.257-INCH DIAMETER HOLES IN CAB REINFORCEMENT PLATE AS SHOWN IN FIGURE 4.

NOTE

REMOVE ALL BURRS AND SHARP EDGES AROUND HOLES.

- G. CLEAN, PRIME, AND PAINT CAB REINFORCEMENT PLATE IN ACCORDANCE WITH TM 43-1039.
- H. ALINE AND CLAMP REINFORCEMENT PLATE TO CAB REINFORCEMENT PILLARS AS SHOWN IN FIGURE 5.
- I. DRILLING AND RIVETING ONE HOLE AT A TIME, START AT TOP OF CENTER PILLAR AND DRILL THROUGH SEVENTY-SEVEN HOLES IN REINFORCING PLATE INTO CAB REINFORCEMENT PILLARS WITH 0.257-INCH BIT AND INSTALL SEVENTY-SEVEN 12315644-2 RIVETS AS SHOWN IN FIGURE 5.

NOTE

- IF CORNER REINFORCEMENT GUSSET HAS TWO HOLES AT ONE END, PERFORM STEPS "J" AND "K".
- IF CORNER REINFORCEMENT GUSSET DOES NOT HAVE TWO HOLES AT ONE END, PERFORM STEPS "L" AND "M".

- J. LOCATE, MARK, AND DRILL FOURTEEN 0.257-INCH DIAMETER HOLES IN DOOR PILLAR CORNER GUSSETS AS SHOWN IN FIGURE 5A.
- K. INSTALL FOURTEEN 12315644-2 RIVETS THROUGH DOOR PILLAR CORNER GUSSETS AS SHOWN IN FIGURE 5A.
- L. LOCATE, MARK, AND DRILL SIXTEEN 0.257-INCH DIAMETER HOLES IN DOOR PILLAR CORNER GUSSETS AS SHOWN IN FIGURE 5B.

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TITLE INSTRUCTIONS FOR INSTALLATION OF CAB REINFORCEMENT KIT 5705616	SIZE A	CAGE CODE 19207	12375530	
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- M. INSTALL SIXTEEN 12315644-2 RIVETS THROUGH DOOR PILLAR CORNER GUSSETS AS SHOWN IN FIGURE 5B.
- N. REMOVE SCREW, WASHER, AND CAGE NUT FROM TOP BOLT HOLE OF RIGHT DOOR FRONT PILLAR AS SHOWN IN FIGURE 6.
- O. DRILL TOP BOLT HOLE OF RIGHT DOOR FRONT PILLAR TO 0.531-INCH AS SHOWN IN FIGURE 6.
- P. INSTALL 12375520 PILLAR NUT ASSEMBLY WITH MS90726-111 SCREW AND MS35338-48 WASHER AS SHOWN IN FIGURE 6.

NOTE

PERFORM STEP "Q" ONLY IF SEAT CATCH IS INSTALLED ON REAR CAB WALL.

- Q. REMOVE THIRTEEN SCREWS AND NUTS AND SEAT CATCH FROM REAR CAB WALL AS SHOWN IN FIGURE 4. DISCARD NUTS.
- R. REMOVE TWELVE SCREWS AND NUTS (IF NOT DONE IN STEP "Q"), AND PANEL FROM REAR OF CAB AND CUT 9.00-INCHES FROM PANEL AS SHOWN IN FIGURE 4. DISCARD NUTS.
- S. INSTALL PANEL WITH TEN SCREWS AND MS51922-5 NUTS AS SHOWN IN FIGURE 4.
- T. CLEAN RIGHT REAR CAB CORNER IN ACCORDANCE WITH TM 9-247 AND WELD 12375499 PLATE ON TOP OF RIGHT REAR CAB CORNER AS SHOWN IN FIGURE 5.

NOTE

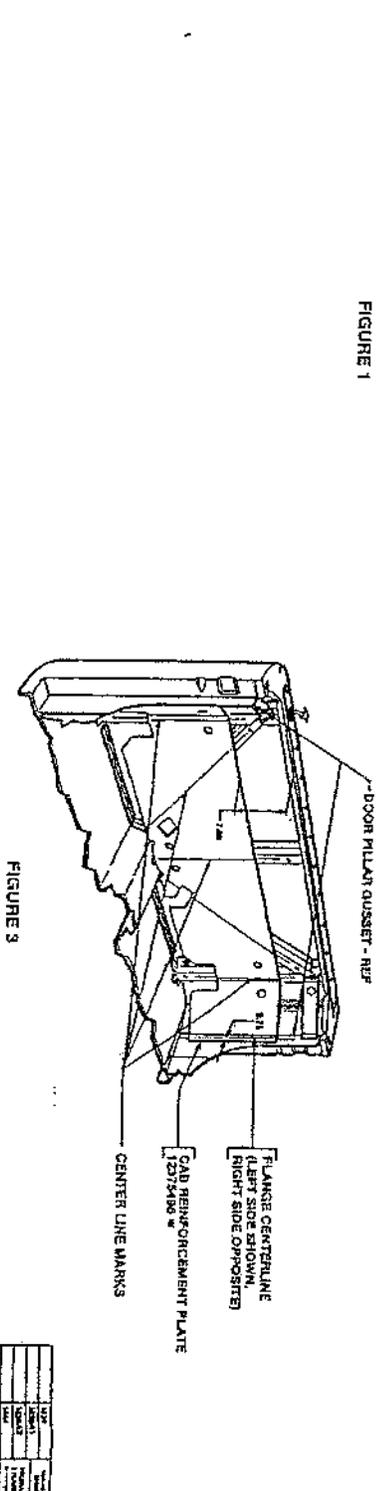
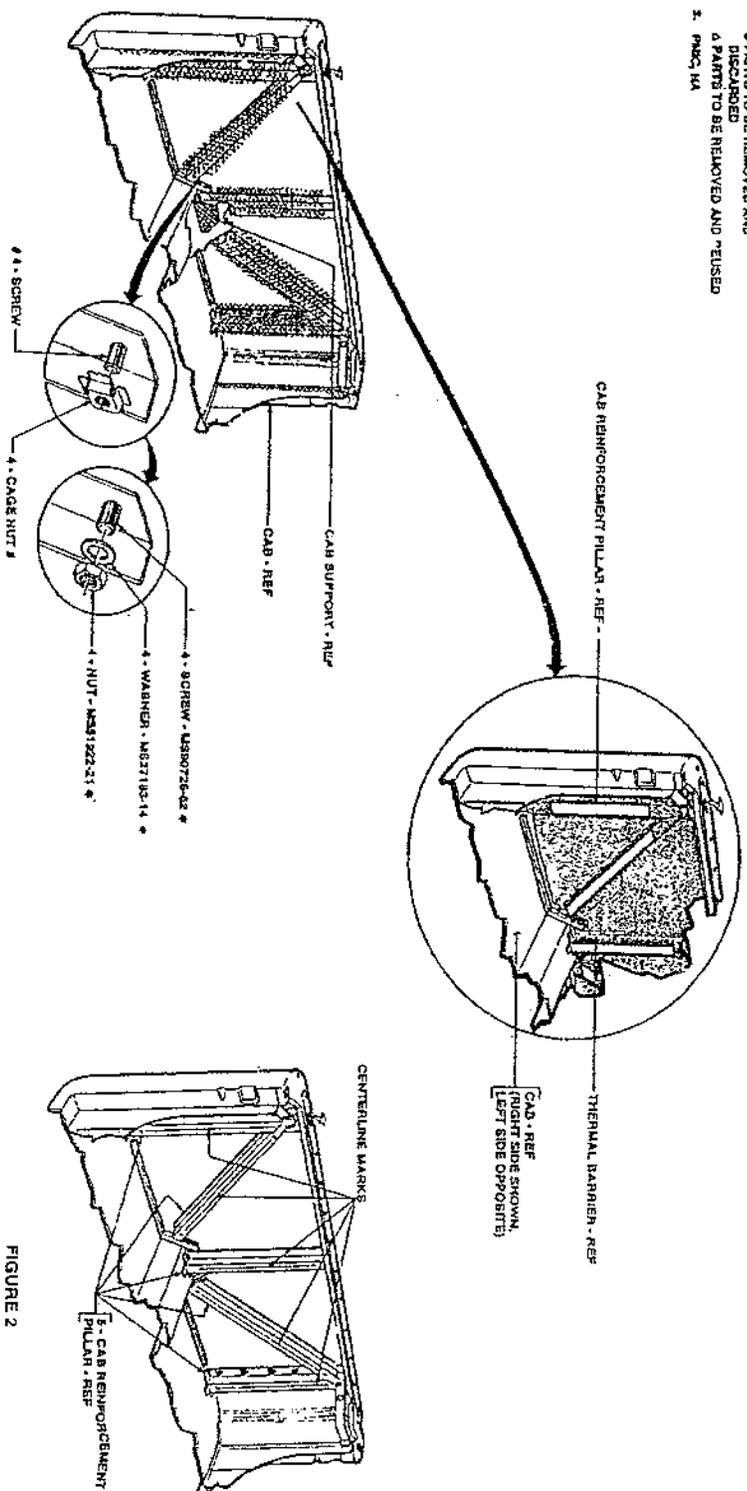
PERFORM STEPS "U" AND "V" ONLY IF SEAT CATCH WAS REMOVED.

- U. USING CATCH AS A TEMPLATE, LOCATE, MARK, AND DRILL TWO 0.280-INCH HOLES IN PANEL AS SHOWN IN FIGURE 5.
- V. INSTALL SEAT CATCH WITH TWO MS51922-5 NUTS AND EXISTING SCREWS AS SHOWN IN FIGURE 5.
- W. CLEAN, PRIME, AND PAINT CAB CAP REINFORCEMENT PLATE AND INSTALLED HARDWARE AFTER WELDING IN ACCORDANCE WITH TM 43-1039.
- X. INSTALL TWO MIDDLE SEATBELTS. TIGHTEN 25 LB-FT (34 N-M).
- Y. INSTALL DRIVER'S AND COMPANION'S SEATS. (REFER TO TM 9-2320-209-20 FOR 2-1/2 TON, M44 M44A1, AND M44A2; TM 9-2320-211-20 FOR 5-TON, M39, M39A1, M39A2; AND TM 9-2320-260-20 FOR 5-TON, M809 SERIES VEHICLES.)
- Z. INSTALL CAB TOP. (REFER TO TM 9-2320-209-10 FOR 2-1/2 TON, M44 AND M44A1; TM 9-2320-361-10 FOR 2-1/2 TON, M44A2; TM 9-2320-211-10 FOR 5-TON, M39, M39A1, M39A2; AND TM 9-2320-260-10 FOR 5-TON, M809 SERIES VEHICLES.)

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- NOTES:
 1. APPLICABLE STANDARDS/SPECIFICATIONS:
 A. 5008-STD-901000(A)
 2. CALLOUTS IDENTIFIED AS FOLLOWS:
 * NEW PARTS
 # PARTS TO BE REMOVED AND DISCARDED
 Δ PARTS TO BE REMOVED AND REUSED
 PMSQ, NA



REV	DESCRIPTION	DATE	BY	CHKD
1	PRODUCT BASELINE			
2	ADD MODS			
3	(1) ADDED REV STATUS BLK (2) ADDED NOTE 3 (3-7) SEE CH2 (ADD PENDING)			

REVISION STATUS OF SHEETS	SHEET 1	SHEET 2	SHEET 3

PART NO.		12375497	
U.S. ARMY TANK AIRCRAFTING COMMAND			
INSTALLATION DRAWING FOR CAB REINFORCEMENT KIT			
5765815			
E 19207 12375497			

