

# CAB FRAME KIT

P/N 2880203

Application

GEM eM 1400



Before you begin, read these instructions and check to be sure all parts and tools are accounted for. Please retain these installation instructions for future reference and part ordering information.

## CAB FRAME ASSEMBLY

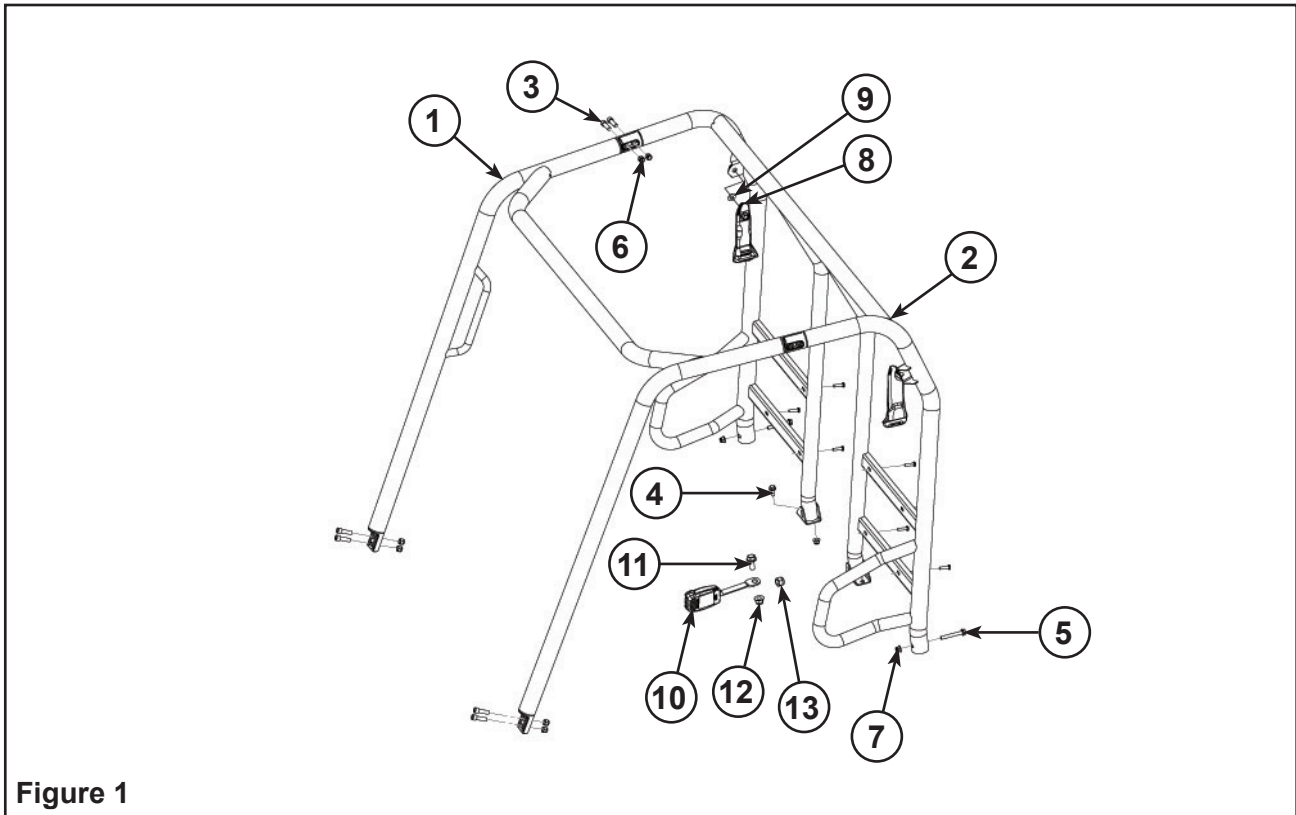


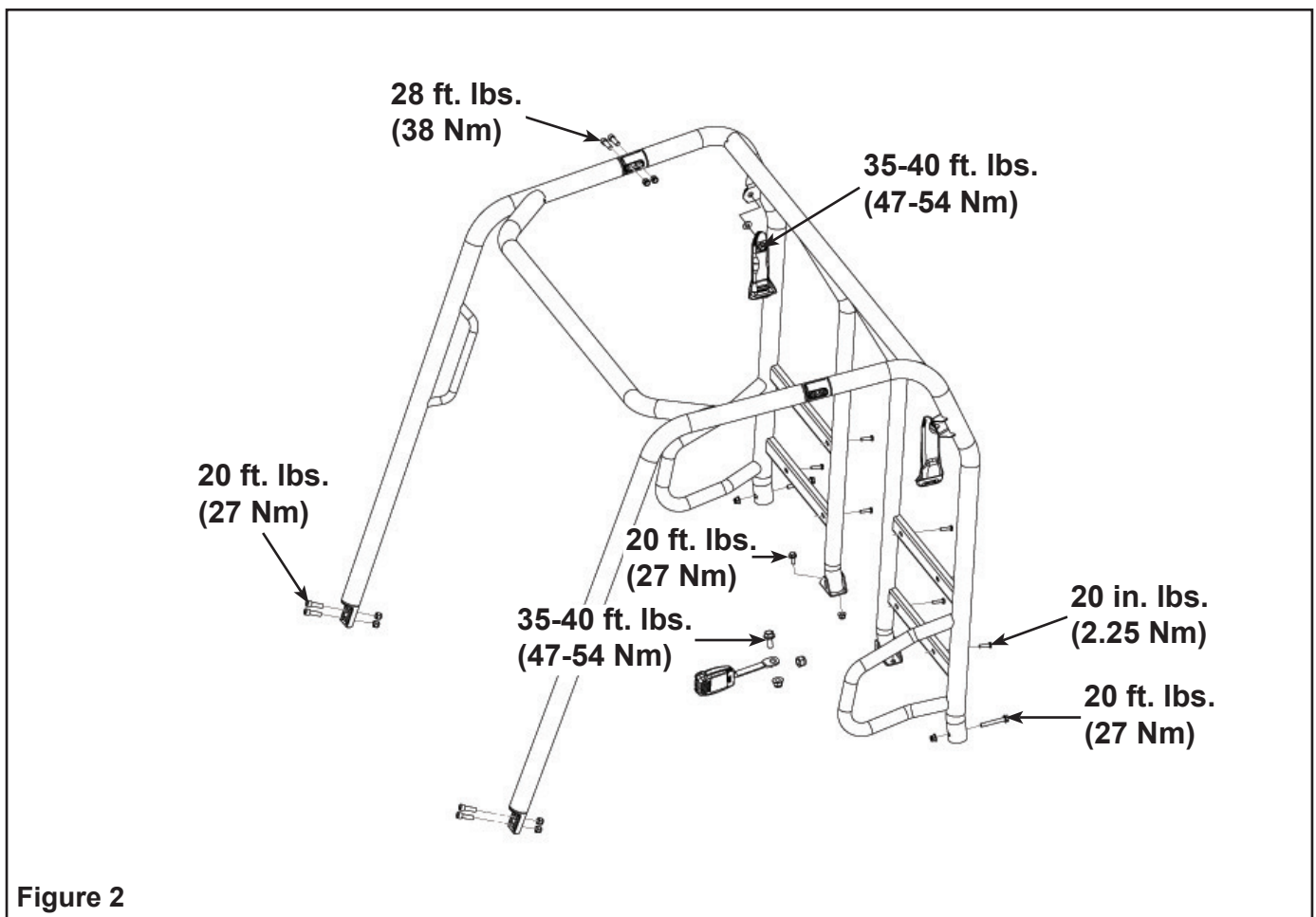
Figure 1

### This Kit Includes:

<u>Ref</u>	<u>Qty</u>	<u>Part Description</u>	<u>Part Number</u>
1	1	Cab Frame, Front	1016686-458
2	1	Cab Frame, Rear	1016688-458
3	8	Screw, 3/8-16 x 1 1/4	7517935
4	2	Bolt, M8 x 1.25 x 20	7518702
5	2	Screw, M8 x 1.25 x 60	7516733
6	8	Nut, 3/8-16	7542451
7	4	Nut, M8 x 1.25	7547317
8	2	Seat Belt, 3 PT	2635049
9	2	Washer-Seatbelt, Rubber	5813829
10	2	Buckle	2635104
11	2	Screw	7519072
12	2	Nut	7540000
13	4	Hexflange Nut	7547441
	1	Instructions	9925185

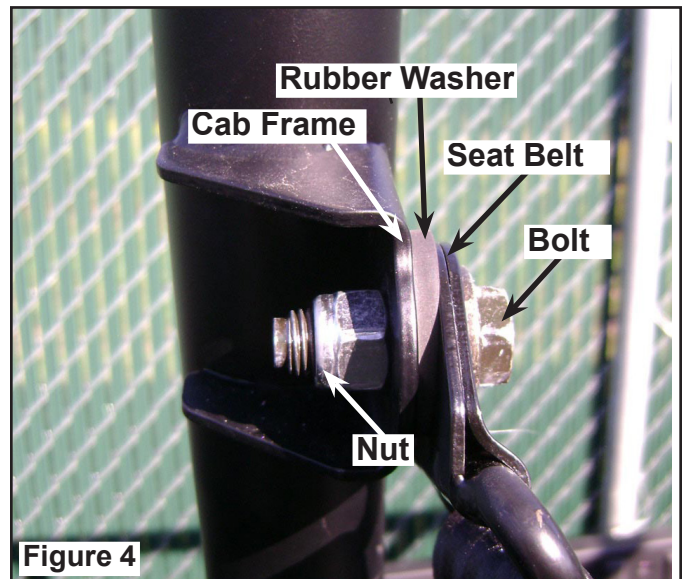
## ROPS CAB FRAME ASSEMBLY:

1. Place the rear cab frame on the vehicle and align the rear mounting locations. Secure the rear cab frame with M8 hardware provided. Bolts should be finger-tight at this time.
2. Carefully assemble the front cab frame to the vehicle and align all mounting points. Secure the front cab frame to the vehicle with 3/8" hardware. Bolts should be finger-tight at this time.
3. Use the 3/8" hardware to fasten the front cab frame to the rear cab frame at the coupler joint and tighten to 28 ft. lbs. (38 Nm).
4. Tighten all M8 cab frame hardware to 20 ft. lbs. (27 Nm).
5. Tighten remaining 3/8" cab frame screws to 20 ft. lbs. (27 Nm).
6. Check all nuts and bolts for proper installation and torque.
7. Place the seat back in the seat back cover and fasten the assembly to the rear cab frame reusing the eight screws from the previous seatback weldment. Tighten all seatback fasteners to 20 in. lbs. (2.25 Nm). See Figure 2 for component placement. Lower seat base can also be installed at this time.



## SAFETY BELT INSTALLATION INSTRUCTIONS:

Use the hardware provided with the seat belt assembly to attach the shoulder strap and the net bracket to the cab frame as indicated in Figure 3 and Figure 4. The order of installation from inside of vehicle should be as follows; bolt, seat belt, rubber washer (PN 5813829), cab frame and nut. Torque the seat belt hardware to 35-40 ft. lbs. (47-54 Nm). Be sure the seat belt strap is routed on the inside of the hip bolster as shown in Figure 5. Be sure the white seat belt MFG tag faces inward. Check seat belt for proper operation after installation and make sure the strap is not twisted. This procedure should be repeated on the passenger side of the vehicle.



Attach the buckle to the seat base using the M12 hardware as shown in Figure 6.

**NOTE:** Torque the buckle hardware to 35-40 ft. lbs. (47-54 Nm).



Figure 6