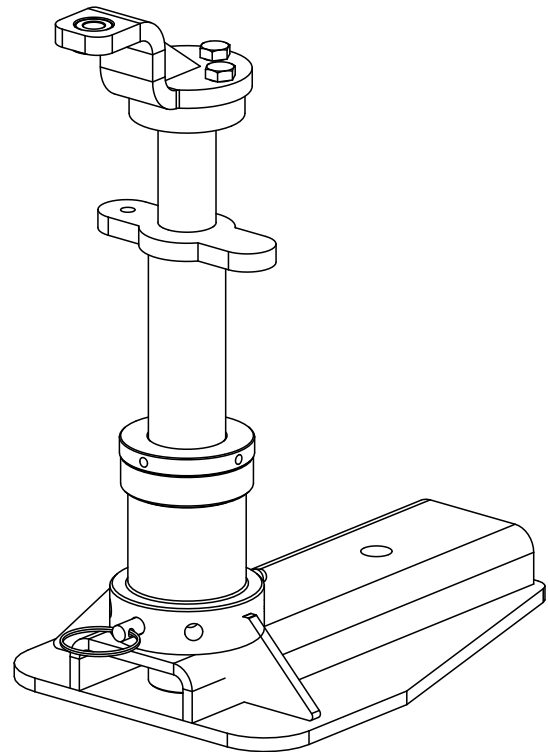
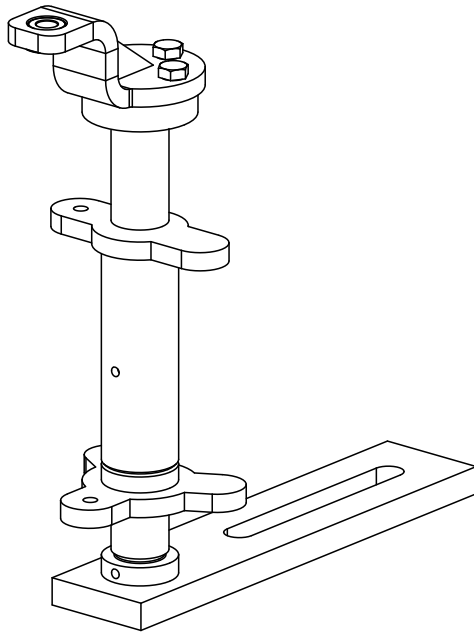




Structural Holding System

Users Manual



CHIEF'S LIMITED ONE-YEAR WARRANTY & LIABILITY

Chief Automotive Technologies warrants for one year from the date of installation and/or purchase any of its products which do not perform satisfactorily due to defect caused by faulty material or workmanship. Chief's obligation under this warranty is limited to the repair or replacement of products which are defective and which have not been misused, carelessly handled, or defaced by repairs made or attempted by others.

CHIEF AUTOMOTIVE TECHNOLOGIES DOES NOT ASSUME RESPONSIBILITY FOR ANY DEATH, INJURY OR PROPERTY DAMAGE RESULTING FROM THE OPERATOR'S NEGLIGENCE OR MISUSE OF THIS PRODUCT OR ITS ATTACHMENTS. CHIEF MAKES NO WRITTEN, EXPRESS OR IMPLIED WARRANTY WHATSOEVER OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR OTHERWISE REGARDING THE EQUIPMENT OR ANY PART OF THE PRODUCT OTHER THAN THE LIMITED ONE-YEAR WARRANTY STATED ABOVE.

This users manual is designed to assist operators with the safe and efficient use of the Chief Structural Holding System. When used with Chief Electronic Measuring, the parts holding system provides operators with the ability to accurately and securely hold replacement parts during vehicle repair.

IMPORTANT:

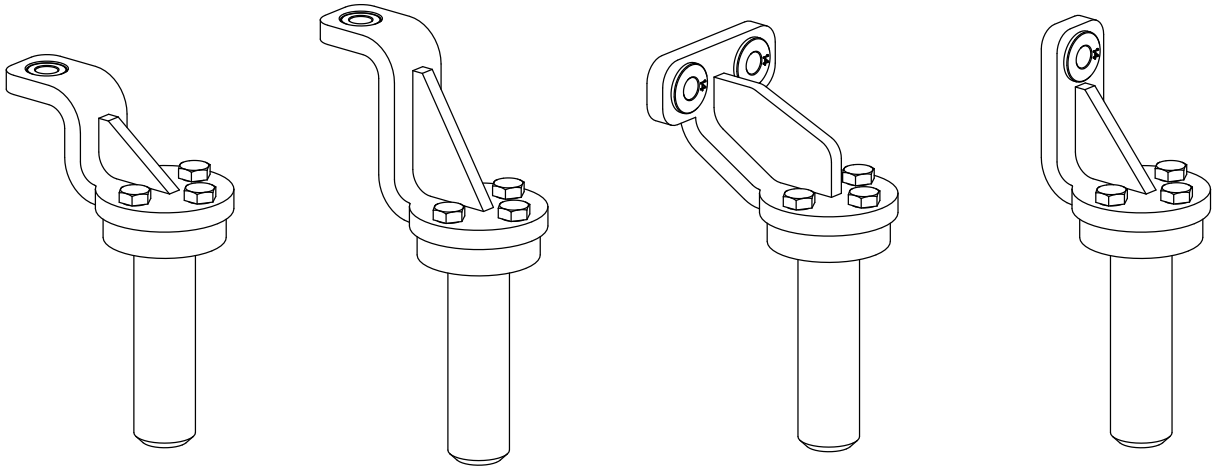
This manual only identifies basic usage procedures for the Structural Holding System. The usage of the system is limited only by the imagination of the technician doing the work.

The Chief Structural Holding System is designed for the holding and positioning replacement parts. It is not designed as a replacement for Chief Anchoring. The Structural Holding System must not be subjected to heavy pulling forces. The Chief Universal Anchoring Stands provided with the rack will still serve as the primary vehicle anchoring.

Because Chief Structural Holding System works with Chief electronic measuring, special attention should be given to the replacement of the Structural Holding stands during setup. Best results will be achieved with the stands located on the perimeter of the vehicle being repaired to prevent shading of measuring targets.

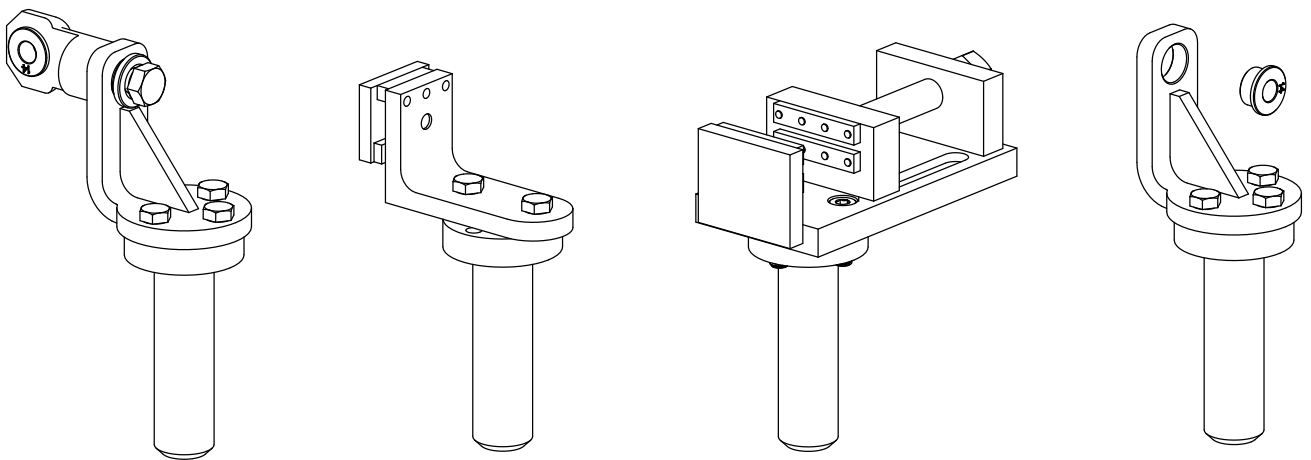
PLANNING AND SETUP

The Structural Holding System is a universal system that will adapt to any Chief style systems with rectangular holes in the deck. The Fixtures are designed to be bolted to any existing threaded bolt or any location there is a threaded nut, flange or boxed rail on a vehicle. This could be used with suspension (components) that are installed or removed and are designed with an offset to also be used with Chiefs computerized measuring system. The system includes two short vertical fixtures and two tall vertical fixtures that will accommodate most bolts or threaded holes from 10mm to 25mm with the use of bushings. The large and tall horizontal fixtures are designed for any bolts or bolt hole ranging from 10mm to 25mm with the use of bushings that is facing forward, inward, outward or rearward.

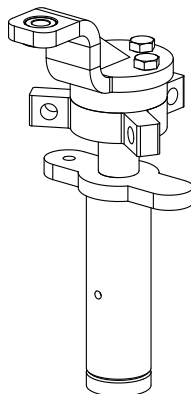


Additional attachments will allow for connection of the fixture to the structure in several different methods. The angle adapter allows for the location of the fixture to be used if the location is at an angle. The jaw clamp assembly allows for the clamping of any vertical or horizontal flange in any angle to be held securely during the repair process. The Structural vise assembly is designed for a box rail on a unitized or full frame structure.

Note: All bushings are designed to allow for the correct sizing of the hole for the bolt to be used to allowing for centering of the Fixture and should be placed on the opposite side of the fixture away from the structure.



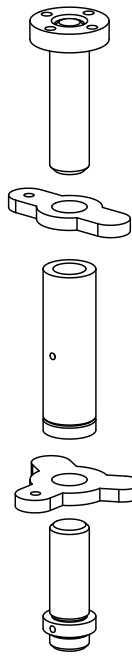
A heavy three-ear rigging nut can be placed directly below the foundation adapter. This will serve as a cable tie off when additional pulling is required for added stability when needed.



Directly below the foundation adapter is the turnbuckle adjustment mechanism. The foundation adapter threaded stud screws into the top of the turnbuckle center section while the Structural Holding lower adapter screws into the bottom. A two-ear wing nut is threaded on to the foundation adapter to lock the top half of the turnbuckle once correct vertical position is achieved. A three-ear wing nut is threaded on the lower adapter to lock that half of the turnbuckle.

Note: The long threaded portion of the Structural Holding lower adapter utilizes a left hand thread, which is compatible with the bottom of the turnbuckle center section (marked with a v-groove around the outside of the part) and the three-ear wing nut.

Turnbuckle Assembly

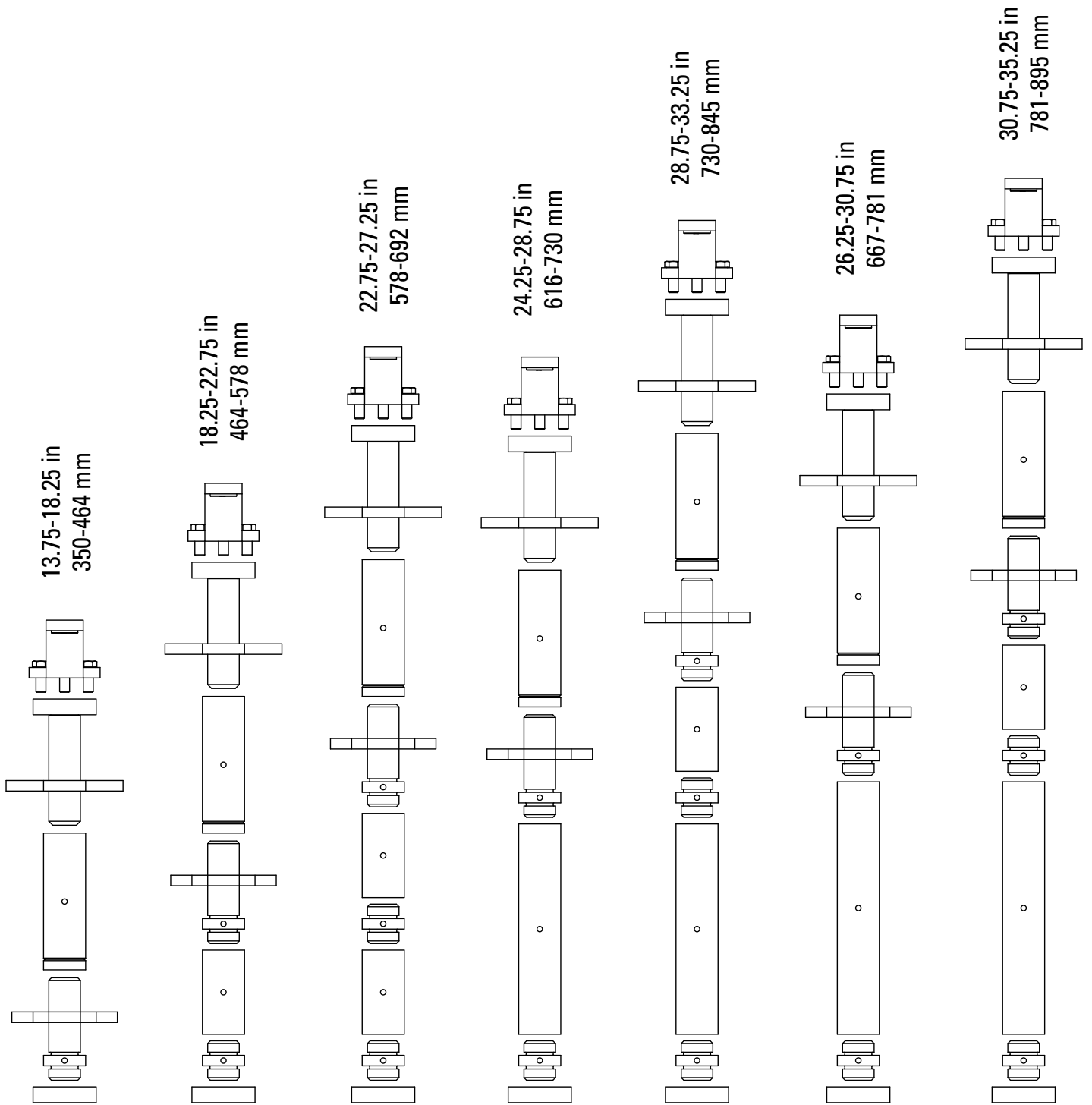
	<ol style="list-style-type: none">1. Completely thread two-ear wing nut onto foundation adapter threaded stud.2. Thread non-grooved end of turnbuckle center section completely onto foundation adapter threaded stud.3. Completely thread three-ear wing nut onto Parts Holding lower adapter.4. Completely thread Structural Holding lower adapter three-ear wing nut assembly into grooved end of the turnbuckle center section.
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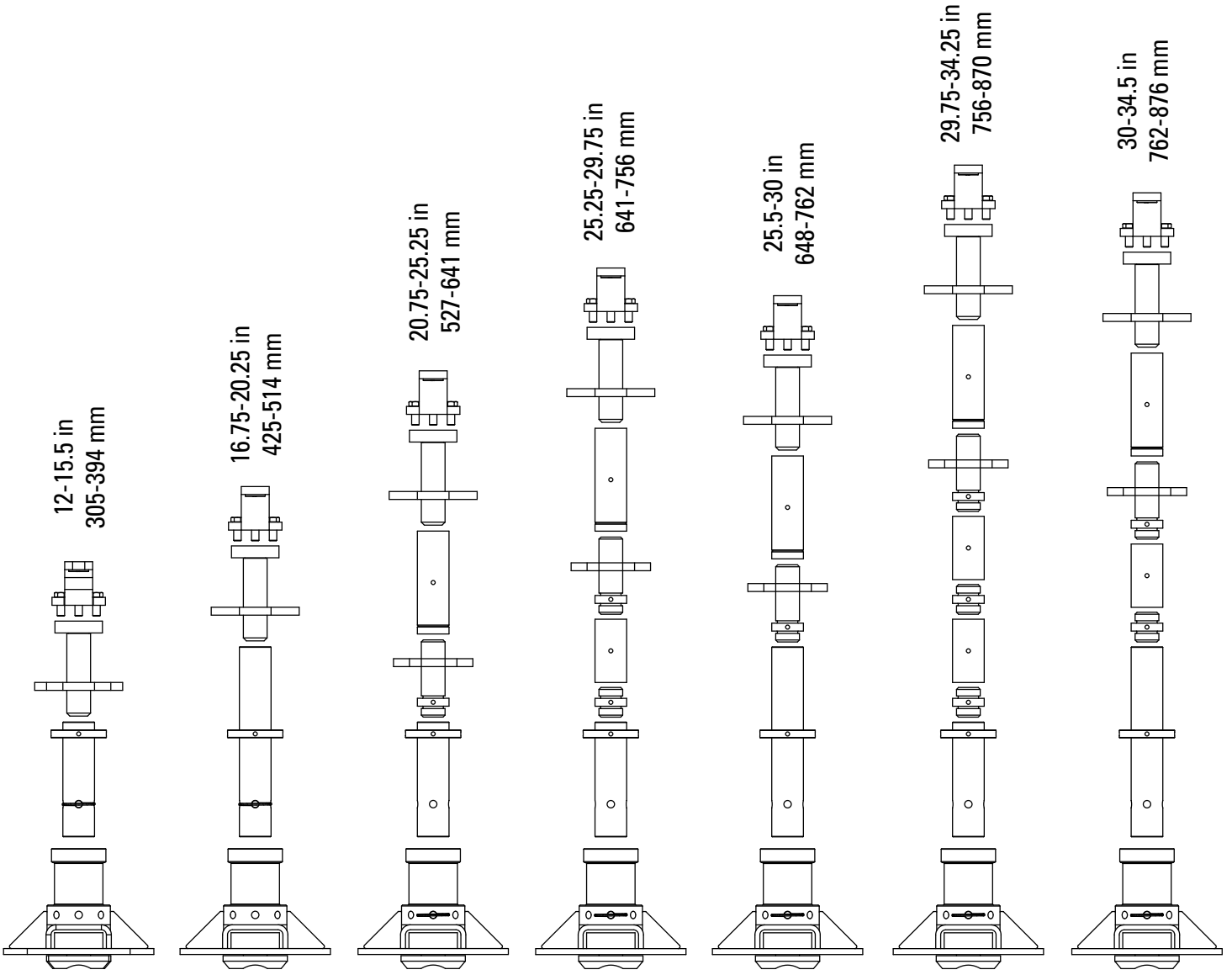
The short threaded side of the Structural Holding lower adapter is a standard right hand thread that is compatible with the Structural Holding stand base and extension tubes.

Note: It is not necessary to completely disassemble the turnbuckle section when changing setups or reconfiguring the stand. The fully assembled turnbuckle section can be unscrewed from the rest of the stand system using the included spanner wrenches.

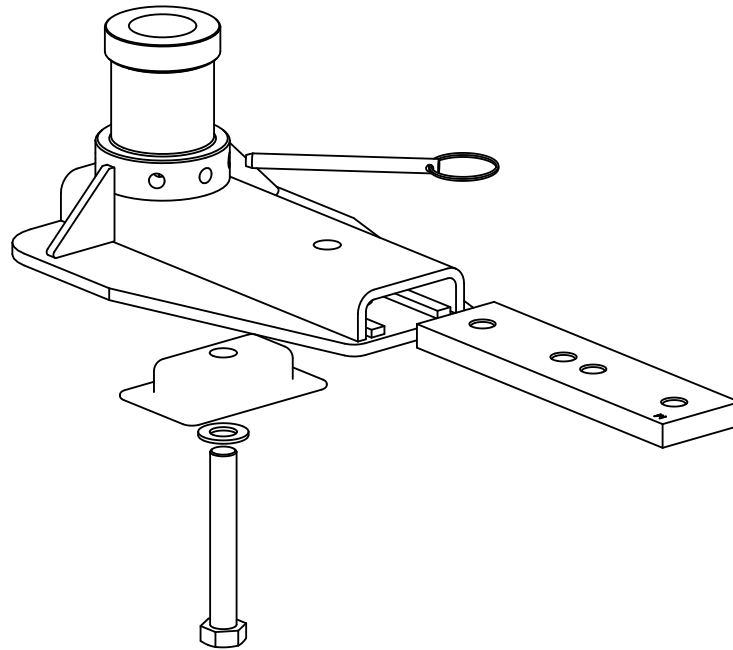
Note: For best results, always have foundation adapter and the lower Structural Holding adapter threaded into the turnbuckle center section equal amounts before starting up.

Vertical positioning of the Structural Holding System uses a turnbuckle style adjustment over a 4.5" (115mm) range. Additional height can be achieved by using the extension tubes and extension adapters included with the system. Compare the approximate height required to the table below to determine how to configure the extension tubes and adapters.





Once the proper configuration has been determined, assemble the required Structural Holding components on the base stand. The base stand should be loosely secured to the frame machine deck using M20x2.5 hardware and a UAS fastener plate. The M20x2.5 hardware will be fully tightened after the Structural Holding stand is located properly. Once the Structural Holding components are assembled, they can be fully tightened using the included spanner wrenches.



Securing New Part

Secure the replacement part to the Structural Holding stand using the foundation adapter and fixtures. Horizontal adjustment of the part can be made by lightly tapping on the stand base. Once the part is located correctly in both horizontal directions, torque down the stand base using a 30 mm wrench or socket. Vertical adjustment of the parts is achieved by turning the clockwise rotation will raise the stand. The turnbuckle section should turn easily by hand, but there is a provision to use a spanner wrench if necessary. Once the part is at the proper vertical position, tighten the top and bottom wing nuts to lock the turnbuckle center section in place and insert the release pin into one of the three hole positions.

Note: For best results, the two-ear and three-ear wing nuts should be threaded away from the turnbuckle center section when making vertical position adjustments.

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Chief reserves the right to alter product specifications and/or package components without notice.