



# Roll-Rite® Side-to-Side Systems Installation Instructions for Spring Bows

March 29, 2002

**Note:**

**For Corner Brackets:** If your body/trailer exceeds 92” inside width, you will have to fabricate mounts to bring the inside width down to at least 92”. Refer to figure 1 below. If your body/trailer does not exceed 92” inside, the spring bows are cut to the proper length based upon the required measurements given to Roll-Rite Corp. by the customer.

**For Flat Brackets:** If your body/trailer exceeds 90-1/2” inside width, you will have to fabricate mounts to bring the inside width down to at least 90-1/2”. Refer to figure 1 below. If your body/trailer does not exceed 90-1/2” inside, the spring bows are cut to the proper length based upon the required measurements given to Roll-Rite Corp. by the customer.

The following steps will explain how to find the locations of your spring bows. If you need to add mounts to get the desired inside width, do so at these locations.

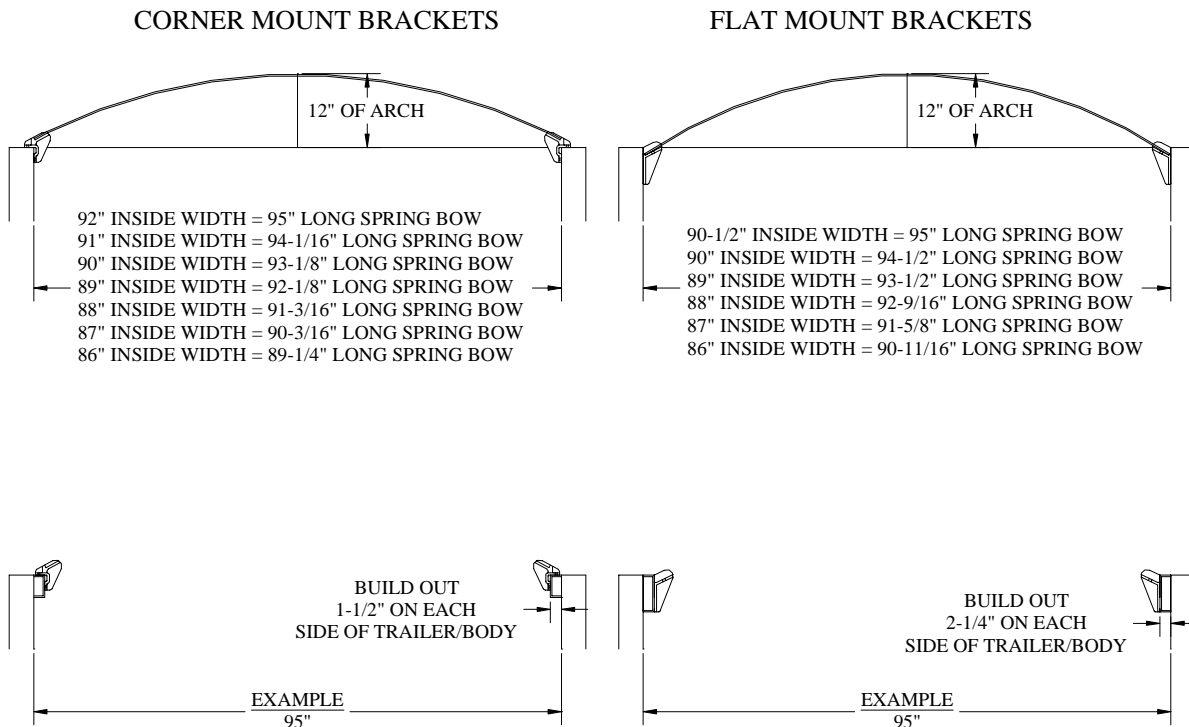


Figure 1.

## Spring Bow Installation

1. Measure from the outside edge of the front end cap 24 inches and put a mark on each top rail. Refer to figure 2 on page 2.

2. Measure from the outside edge of the rear end cap 24 inches and put a mark on each top rail. Refer to figure 2 below.

**Note:** The bows are placed 24" in from the end caps to prevent sag in the tarp at the front and rear of the trailer.

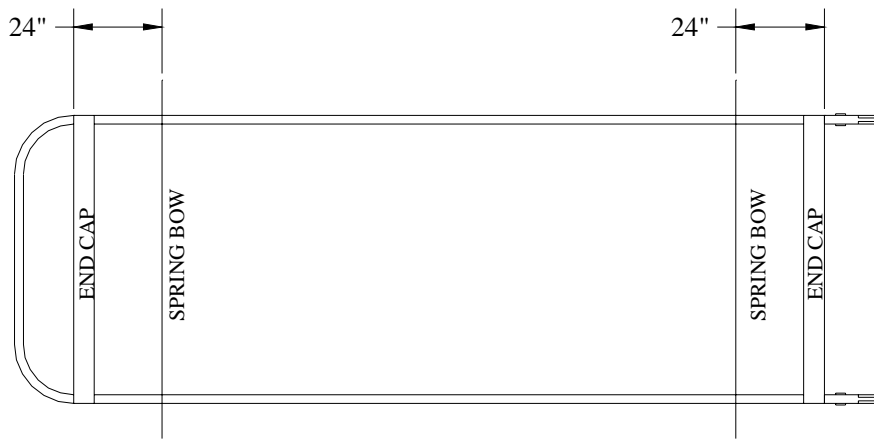


Figure 2.

3. Center a spring bow bracket on one of the marks made.

#### **Flat Mount Spring Bow Bracket:**

If you have the flat mount spring bow brackets, place the back edge flush with the top edge the box/trailer. Refer to the diagram on the left in figure 3 below.

Once in place, rivet or bolt the bracket to the box/trailer and do the same for the other three marks.

#### **Corner Mount Spring Bow Bracket:**

If you have the corner mount spring bow brackets, center one on a mark made on the top rail, as shown on the right in figure 3 below.

Once in place, rivet or bolt the bracket to the box/trailer and do the same for the other three marks.

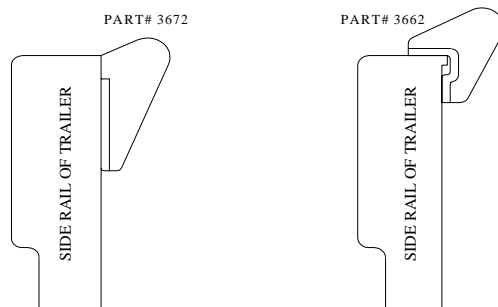


Figure 3.

4. Install the 2 spring bows by inserting one end at a time into the bow bracket and bolting it into place, using the 5/16 x 1-3/4" long bolts and lock nuts.

**To equally space the remaining spring bows, follow the steps below.**

5. Measure from the center of the front spring bow to the center of the back spring bow. Take that measurement, in inches, and divide it by the number of spring bows you have left + 1. For example, if you have 4 bows left, divide the length by 5. That will give you 5 equally spaced openings. Refer to Figure 4 below.

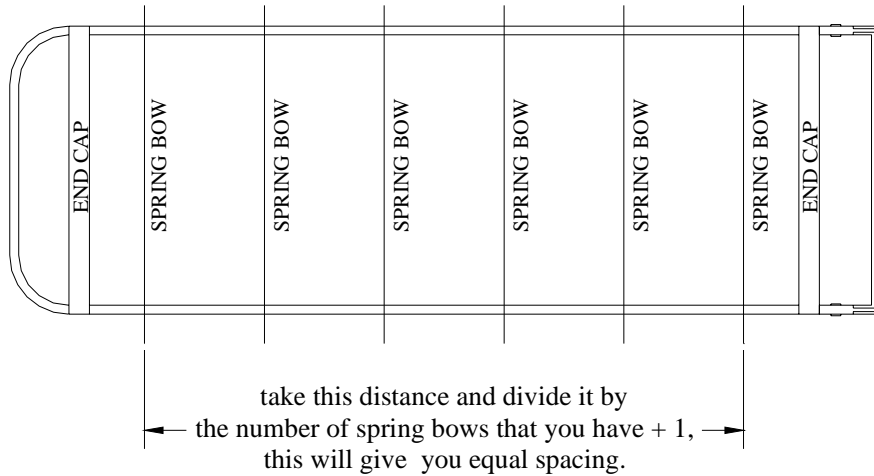


Figure 4.

6. Measure from the center of the front or back spring bow to the dimensions that were determined and mark the top rail.
7. Center the spring bow brackets on the marks made and install them the same as the front and back brackets that are already installed.
8. Install the remaining bows the same as the front and back bows that are already installed.

**If you have any questions, please call 1-800-297-9905.  
We will be glad to help.**

Thank you for choosing a Roll-Rite® products.