



## ADRIAN STEEL COMPANY

22200-1

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VAN/TRUCK VEHICLE INTERIOR AND FASTENER INSTALLATION PROCEDURE

### A. FASTENER APPLICATION STANDARD

The proper fastening method in all cases should be good metal to metal contact, using the fasteners supplied with Adrian's prepackaged arrangements.

1. Use nut and bolt through in all locations where possible.
2. Use a plusnut in all blind locations where nut and bolt is not possible.
3. The use of sheet metal screws is discouraged, except when nut & bolt or plusnuts can not be applied, and when this type of fastener can be applied in such a manner that places it in shear, or allows for several in close formation.

### B. GENERAL INTERIOR ASSEMBLY AND INSTALLATION PROCEDURE

Adrian Steel interior arrangements are usually illustrated on a product data sheet which shows the correct orientation of all components in your vehicle.

1. Use the assembly instructions sent with the components to pre-assemble any that may require it, ladder racks, cab/cargo partition, knock-down units, and modules.
2. All Adrian prepackaged interiors, except those for pickup bed boxes, include a cab/cargo partition. The partition should be installed first, using the instructions packed with it.
3. Next install the street side components. If the spare is being relocated to the panel behind the drivers seat, leave at least 10" between the partition and the first component on that side. Always set all the components in place before drilling to install. This allows you to check for obstructions on the vehicle that might require adjustments to the component positioning.
4. Next install the curb side components. Relocate the spare tire, if present, to the panel behind the driver or passenger seats.

### C. SPECIAL INSTRUCTIONS FOR ADRIAN STEEL PROVIDED FASTENERS

1. All holes drilled in the vehicle should have their raw metal edges sealed to resist corrosion. When and if, the drilled hole could allow the entry of exhaust gases into the cab area. It should be sealed at the time the fastener is installed with Butyl or silastic material which will remain flexible for an extended period of time.
2. The blind fastener of choice is the plusnut. Adrian supplies two thread sizes, 1/4-20 and 5/16-18. The 5/16-18 is only used for special applications (such as the mini-van polyguard partitions, floor only, or Sprinter Van Interiors).
3. After locating all positions that will need the plusnut, drill the proper size hole for the plusnut, see illustration below. 1/4-20 Plusnuts uses 3/8" dia. (all locations) 5/16-18 uses 1/2" dia. (floor only). The illustration below shows the sequence used to set a plusnut, and the proper way to use the floor spacers.

#### Plusnut Use and Installation

ASSEMBLE THE  
FOLLOWING

SETTING THE  
PLUSNUT

- 1) SETTING BOLT  
1/4-20 x 2" LONG  
OR  
5/16-18 x 2-1/4"
- 2) PLUSNUT TOOL
- 3) PLUSNUT

PLUSNUT  
TOOL

PLUSNUT  
1/4-20  
OR  
5/16-18

HAND TOOL, RATCHET  
OR AIR TOOL TURNS THE  
BOLT TO DRAW PLUSNUT

9/16 BOX OR OPEN  
END WRENCH HOLDS  
THE PLUSNUT TOOL

DRILL METAL  
3/8" DIA. FOR 1/4-20  
1/2" DIA. FOR 5/16-18

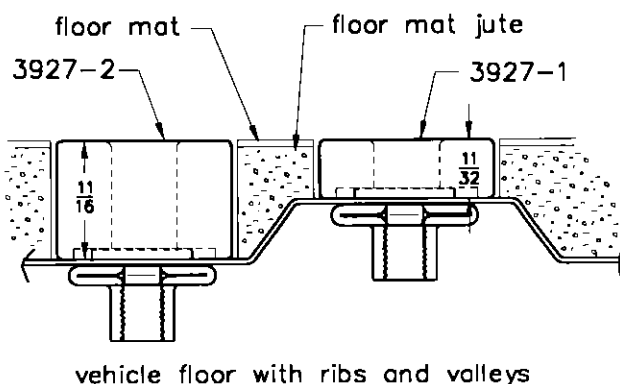
SHEET METAL  
INSTALLATION  
SURFACE

Set Plusnut till tight,  
DO NOT OVERTIGHTEN.

#### Spacer Use and Installation

3927-1  
(SHOWN)

ALWAYS PLACE RECESSED  
PART OF FLOOR SPACER  
ON TOP OF PLUSNUT.



Hand operated and pneumatic tools are available to set plusnuts.  
Refer to Mc Masters-Carr or similar industrial catalog under rivet nut insert tools.  
or call Adrian Steel Co. for more information.

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