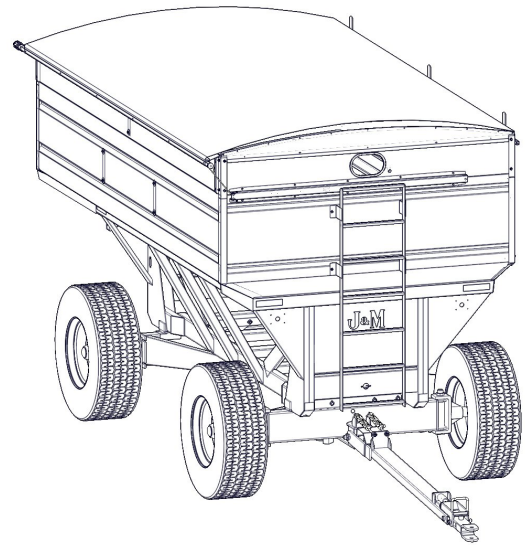


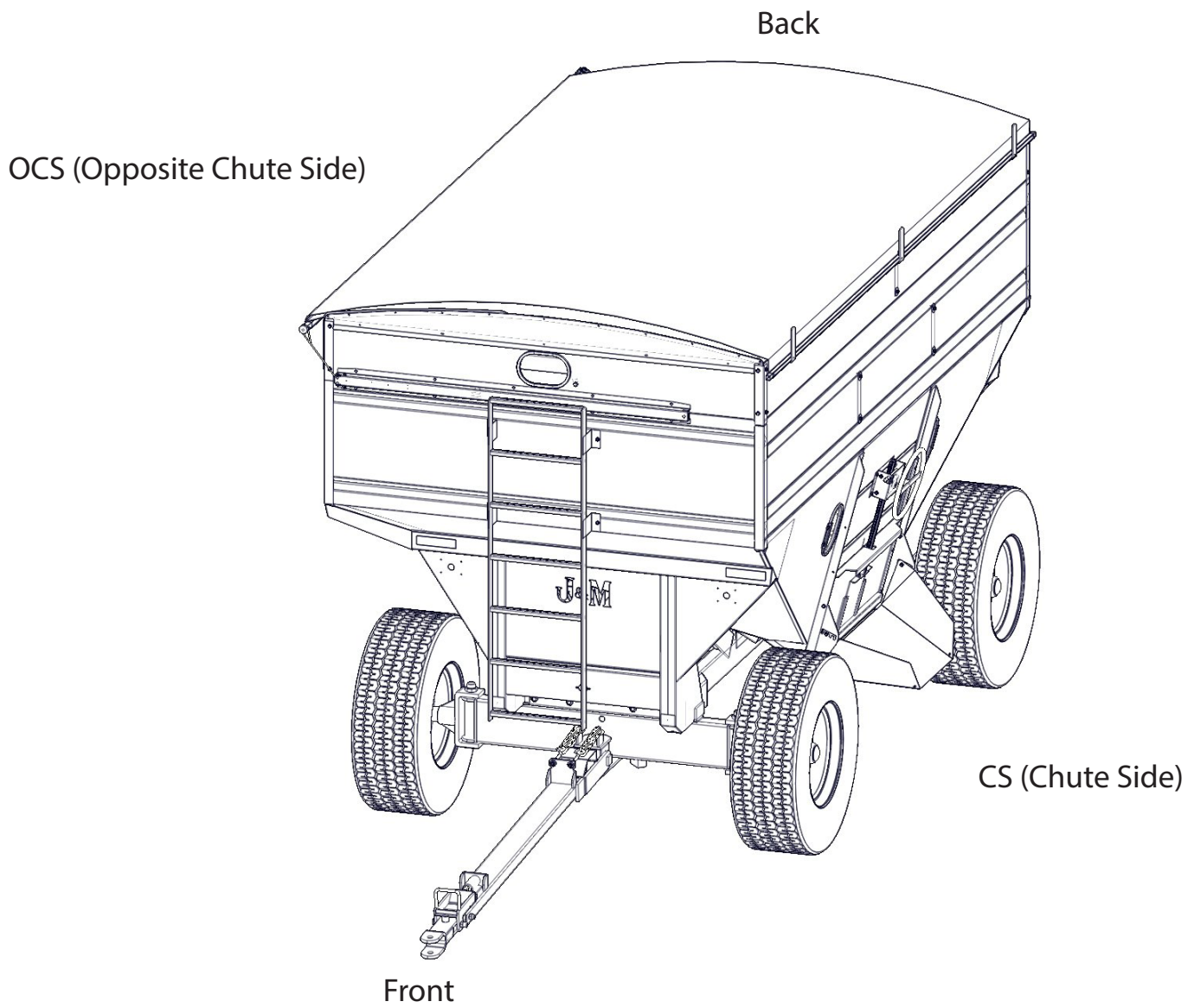
**455, 555, 655, 755 GRAVITY
BOX TARP INSTALLATION**

Installation Manual for Glide Right Roll Tarps



Rev. 9.9.2016

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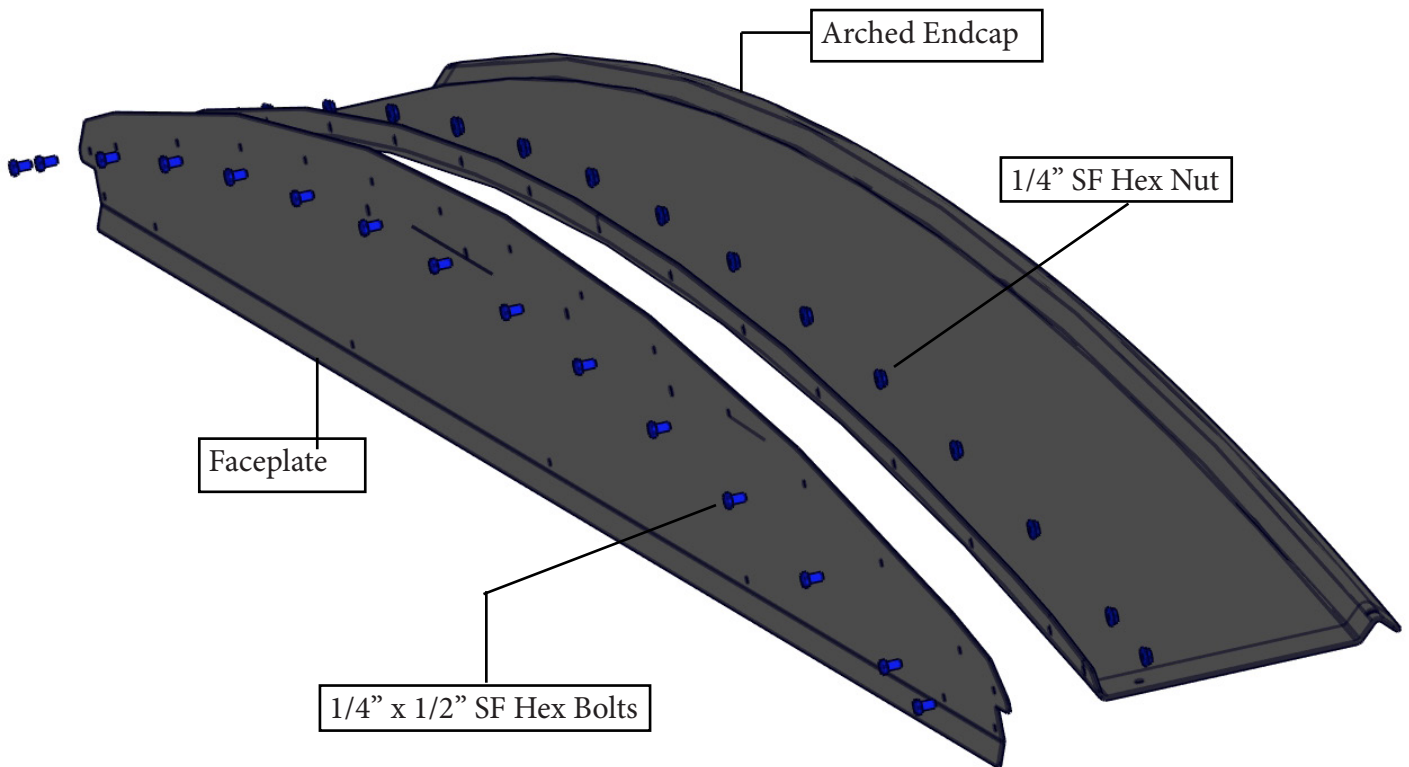


1.1 Mark four holes for each hanger bracket using the hanger bracket as a template and drill with a 7/16" drill bit. These holes should be on the back gravity box as low as possible and as shown in the image.

1.2 Fasten the hanger bracket to the gravity box using two 3/8" x 1" serrated flange bolts and two 3/8" serrated flange nuts.

1.3 Fasten the hanger hook to the hanger bracket as shown above with a 1/2" x 1 1/4" bolt and a 1/2" locknut. This should not be tightened all the way. The hanger hook needs to be able to swivel on the hanger bracket.

Step 2 - Endcaps Assembly

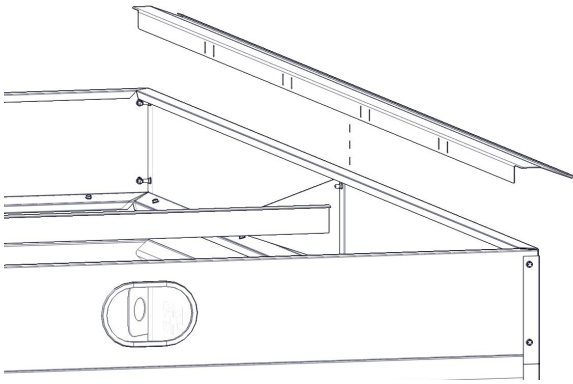


2.1 Aside from the gravity box, match up the holes on the Front Endcap Arch with the top Front Endcap Plate holes.

2.2 Insert 1/4" x 1/2" bolts in the remaining holes. Fasten with 1/4" serrated flange nuts.

2.3 Repeat Steps 2.1 - 2.2 for the back endcap arch and plate.

Step 3 - Place Lip Lock & Endcaps



3.1 Center the lip lock on top of the OCS.

3.2 Use a C-clamp to hold lip lock in place.

3.3 Rest the assembled front and back Endcaps in place.

* For the 655 & 755 there will be a front and back lip lock.

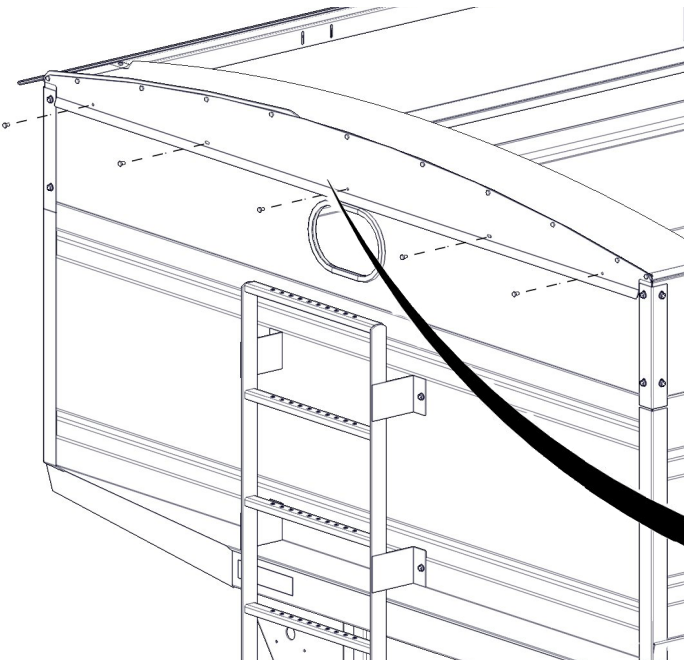
Step 4 - Endcaps

455/555 & 655/755 Models

4.1 Using the lower holes on the front Endcap Plate as a guide, drill holes through the front using a 5/16" drill bit.

4.2 Insert 1/4" x 1/2" bolts and fasten using 1/4" serrated flange nuts.

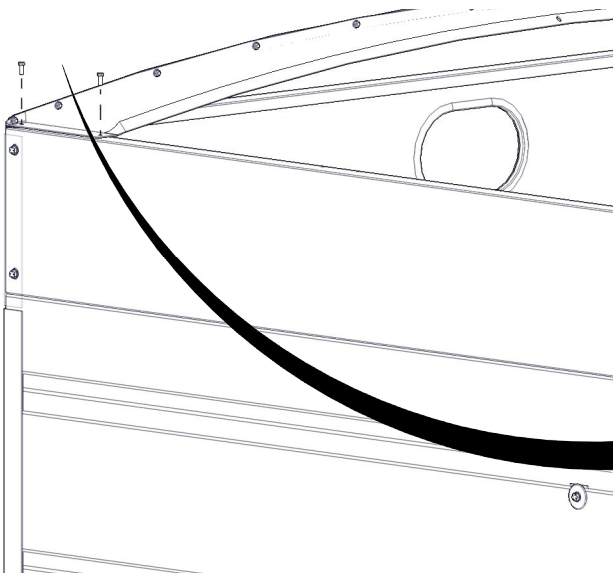
4.3 Repeat steps 4.1 & 4.2 for the back Endcap.



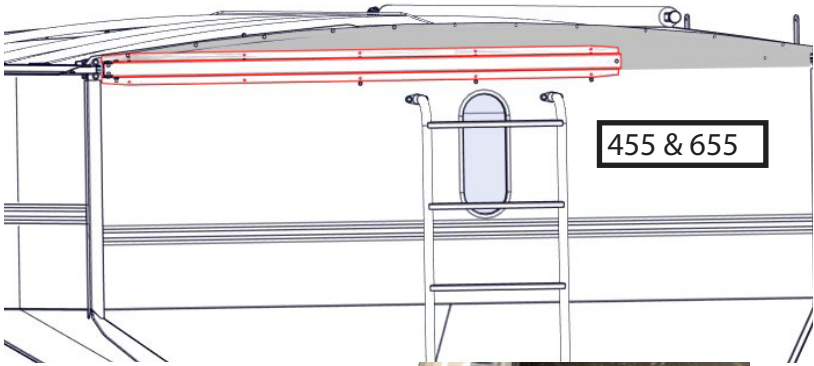
5.1 Use the four holes on the top of the front Endcap as a guide to drill four holes from the top using a 5/16" drill bit.

5.2 Insert 1/4" x 3/4" bolts and fasten with 1/4" serrated flange nuts.

5.3 Repeat Steps 5.1 & 5.2 for the back Endcap.



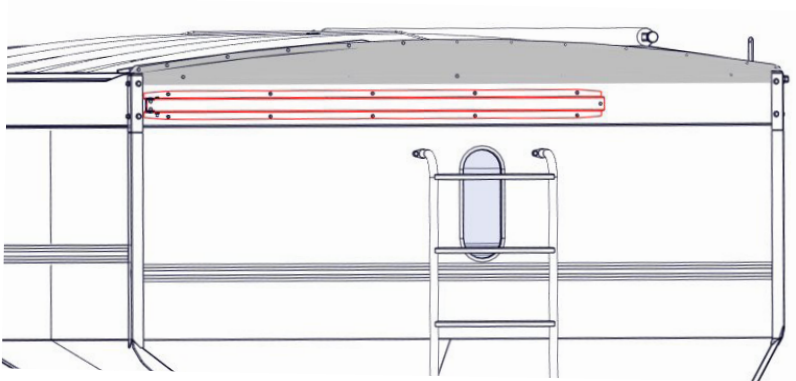
Step 6 - Spring Return



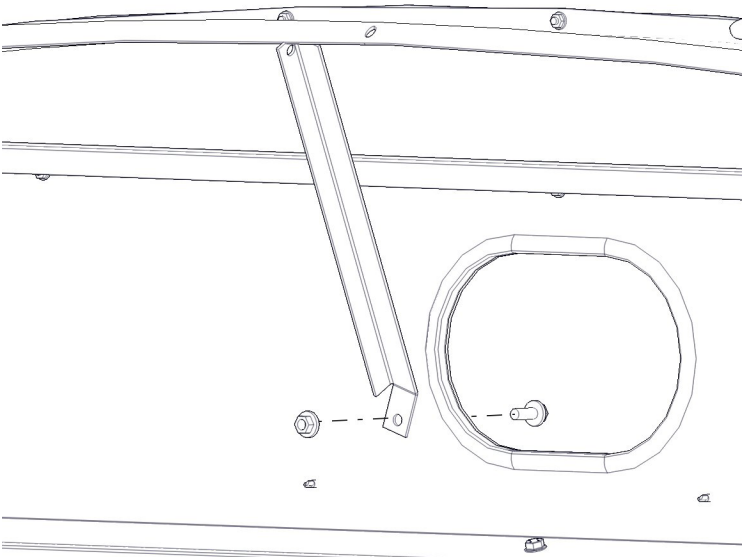
455 and 655 models will need spacers used (shown in red below) since it will be straddling the endcap. They will use 1/4" x 1-1/2" bolts to attach these spring returns.

The spring return on 555 & 755 use ten 1/4" x 3/4" self tapping bolts. Be sure the end with the cable loop is located on the OCS. It should be positioned up against the OCS corner brace. See the chart below for model specific Spring Return locations.

| Model | Spring Return Location |
|-----------|---|
| 455 & 655 | Straddling the End Cap and pushed up all the way possible |
| 555 & 755 | Right below the End Cap |



Step 7 - Knee Braces



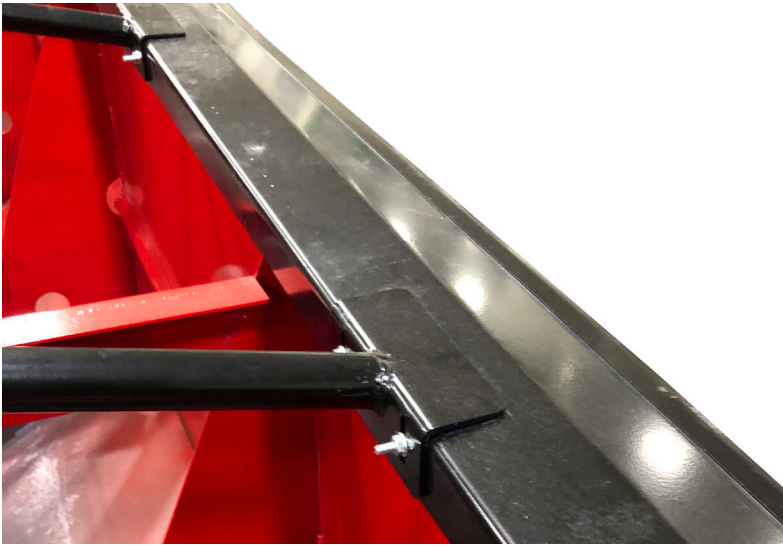
7.1 Mark the hole for the Knee Brace as centered as possible using the Knee Brace as a guide. When marking the hole push up on the Endcap to keep it from sagging.

7.2 Drill the hole using a 7/16" bit.

7.3 Use a 3/8" x 1" serrated flange bolt and a 3/8" serrated flange nut to fasten the knee brace. Be sure that the knee brace applies upward pressure to the Endcap. Making the the top endcap parrallel with the ground

7.4 Repeat Steps 7.1-7.3 for the remaining knee brace under the opposite Endcap.

Step 8 - Tarp Bows



8.1 Position the Tarp Bows on top of the Gravity Box. Be sure to spread the Bows out evenly from front to back.

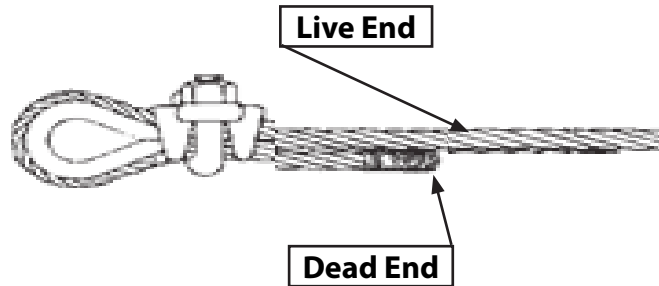
8.2 There should be existing holes in the Lip Lock and sideboards for the bows. If they happen to not line up, use the Tarp Bows as a guide, and drill holes with a 5/16 " drill bit.

8.3 Insert 1/4" x 3/4" bolts and fasten with 1/4" serrated flange nuts.

Step 9 - Cable

Using a cable clamp, feed one end of the cable through the cable clamp, make a small loop, then tighten the cable.

NOTE: Make sure that the base of the clip bears on the live end of the rope and the “U” of the bolt bears on the dead end.



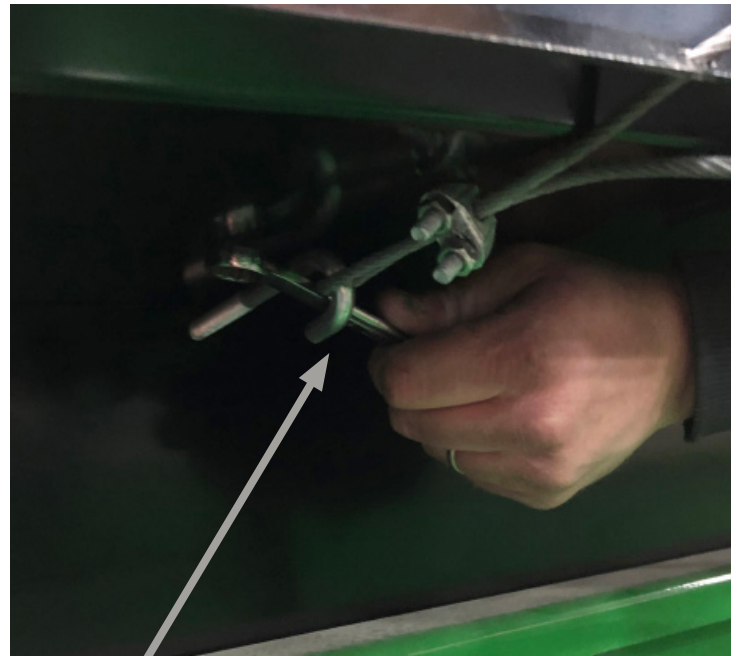
Now thread the cable through the front endcap pulling the end without the cable clamps through first.

NOTE: Make sure to pull from front to back.

Next guide the cable over the arched bows and thread them through the existing hole on the rear endcap. Now feed the cables through the cable clamps.

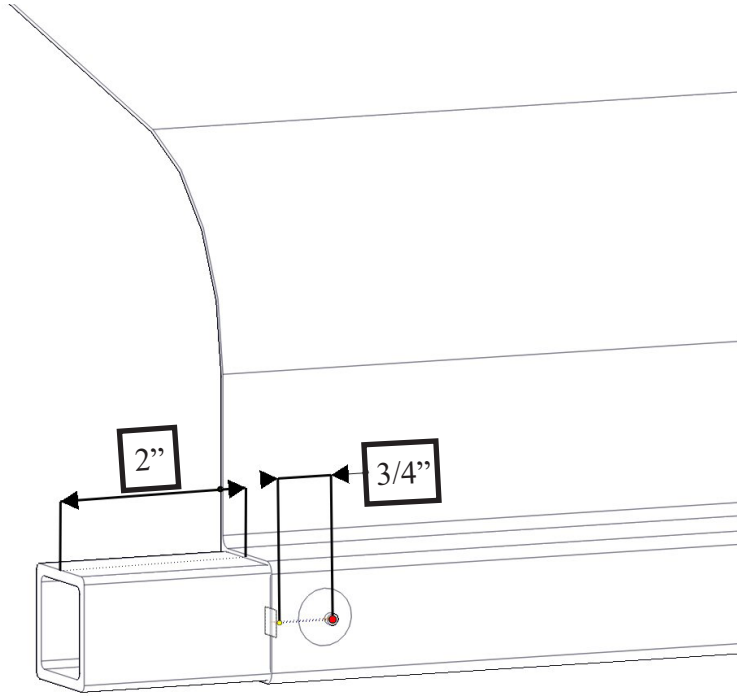
NOTE: Make sure that the base of the clip bears on the live end of the rope and the “U” of the bolt bears on the dead end.

Place the loop into the J-bolt. Use a vise grip to pull on the cable. Pull the cable tight. To remove all slack from the cable, aggressively tap the cable while applying tension with the vise grips. Then tighten the cable clamp. Once the clamps are tightened, tighten the J-bolts. Insert a wrench into the hook of the J-bolt and tighten the nut.



Use wrench or bolt to hold the J-bolt while tightening.

Step 11 - 1" Square Tube



11.1 Insert the 1" 14 ga Square Tube into the tarp sleeve on the opposite side of the stiffening patch (see pg. 11, Step 13 for a picture of the stiffening patch).

11.2 Center the 1" Square Tube inside the sleeve. This should leave around 2" of the tube sticking out of the sleeve on each side as shown above.

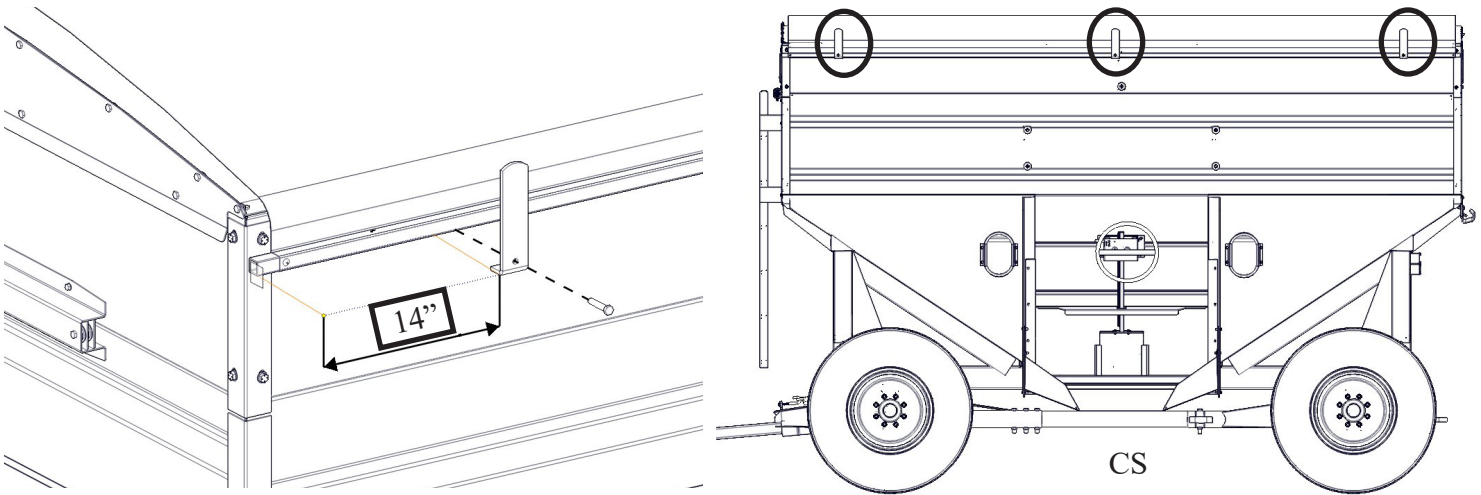
11.3 Use a 1/4" drill bit to drill a hole through the Canvas Tarp and one wall of the 1" Square Tube. The hole should be around 3/4" from the edge of the tarp.

11.4 Use a hammer to install a 1/4" Drive Rivet.

11.5 Repeat Steps 11.3 & 11.4 at the same location on the other end of the Square Tube.

-NOTE: Be sure the Tarp is pulled tight over the Square Tube between the Rivets.

Step 12 - Stop Brackets

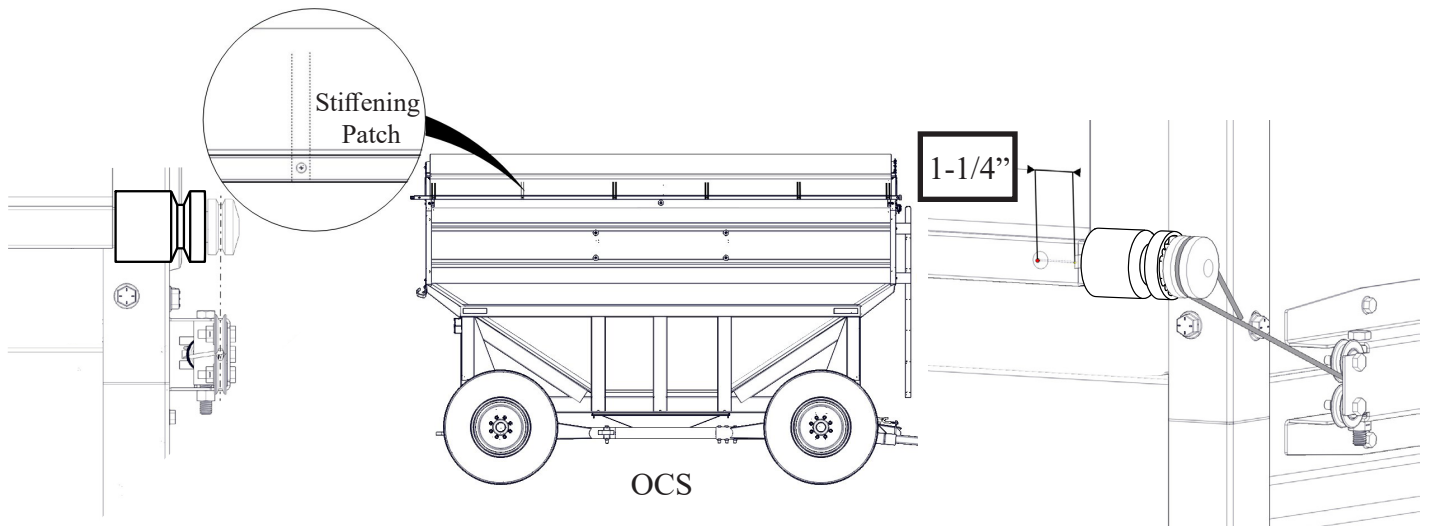


12.1 Center the 1" Square Tube that is riveted to the Canvas Tarp on the CS of the gravity box. Allow the Square Tube to hang below the top bolts on the corner brackets (around 2 1/2" below top of the Gravity Box).

12.2 Drill two 7/16" holes around 14" from the end of the Tube through the Tubing and sideboard wall. A third hole should be drilled as centered on the tube as possible. Avoid drilling through the center brace inside the gravity box.

12.3 Install each stop bracket with a 3/8" x 2" bolt and a 3/8" locknut. Tighten hardware.

Step 13 - 1 1/4" Square Tube



13.1 On the opposite side of the Canvas Tarp, slide roller guide onto the 1-1/4" Square Tube then slide the 1-1/4" square tube into the remaining sleeve until the spool lines up with the pulleys on the spring return, pictured above. The splined end of the 1-1/4" Square Tube should be towards the back of the Gravity Box.

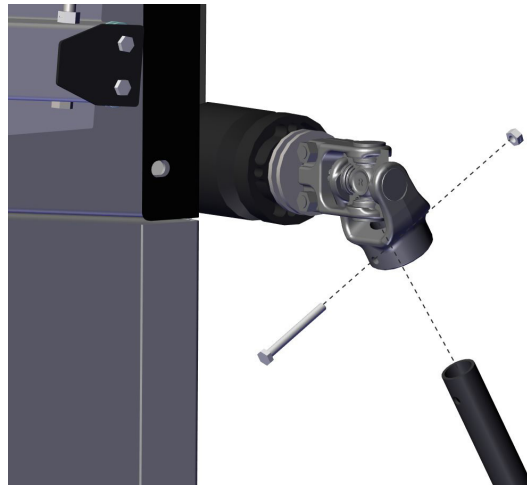
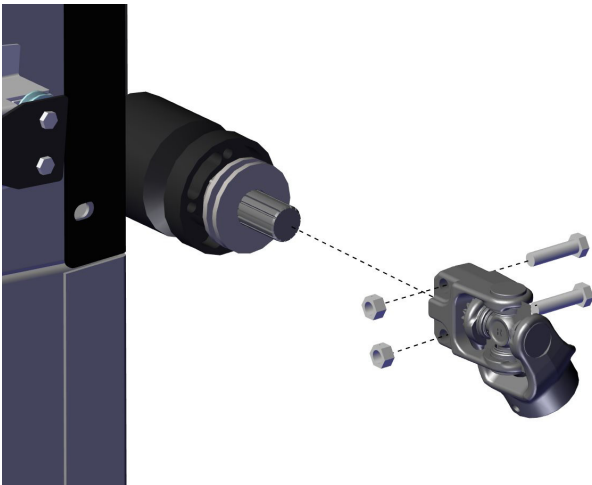
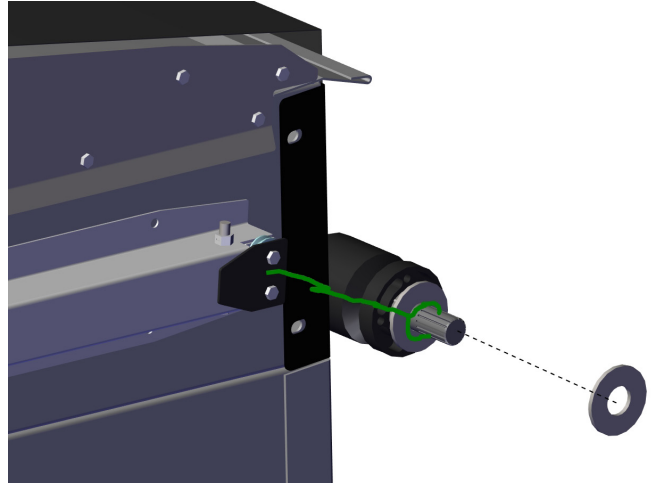
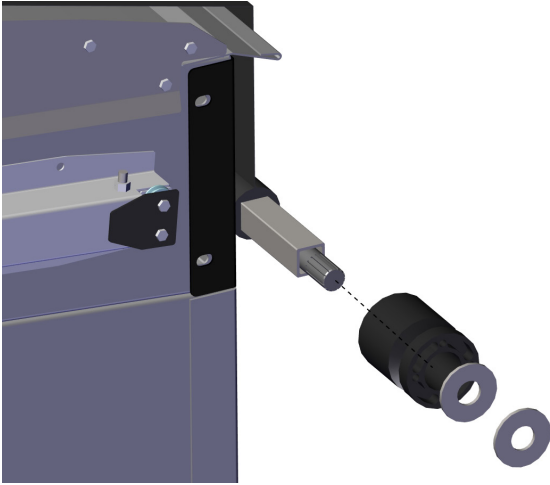
13.2 Push down on the 1-1/4" square roll tube on both ends and in the center to fully extend the canvas. Line the roll tube cable spool up with the spring return cable. Drill a 1/4" hole through the first stiffening patch. Fasten the canvas tarp using a pop rivet. Go to the rear of the cart, pull the canvas tarp tight, and repeat the process. Then install pop rivets at the remaining stiffening patches. Once finished slip the spring return cable loop over the cable spool.

13.3 Use a hammer to install 1/4" drive rivets into each of the drilled holes.

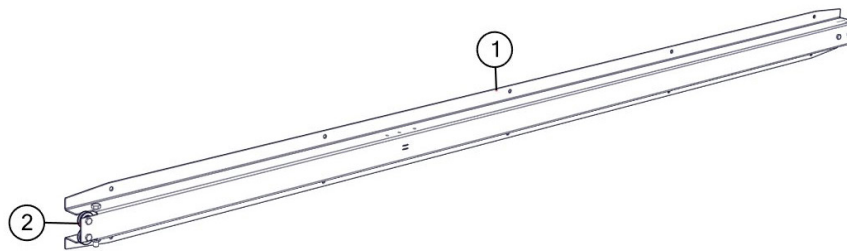
13.4 Slip the Spring Return cable loop over the spool.

Step 14 - U-Joint & Crank Handle

Slide tarp guide roller over rear end of 1-1/4" square roll tube. Then slide one washer over, then the spring return cable, then the next washer. Now attach the knuckle to the roll pipe. Use (2) 3/8" x 2" hex bolts along with (2) 3/8" lock nuts. Attach the crank handle to the universal joint. Install the crank handle using (1) 1/4" x 2-1/2" bolt and (1) 1/4" locknut. The universal joint may be pre-assembled to the crank handle.



Spring Return



| # | Description | Part. No. |
|---|------------------------|-----------|
| 1 | Spring Return Assembly | JM0002437 |
| 2 | Spring Return Cable | JM0010307 |

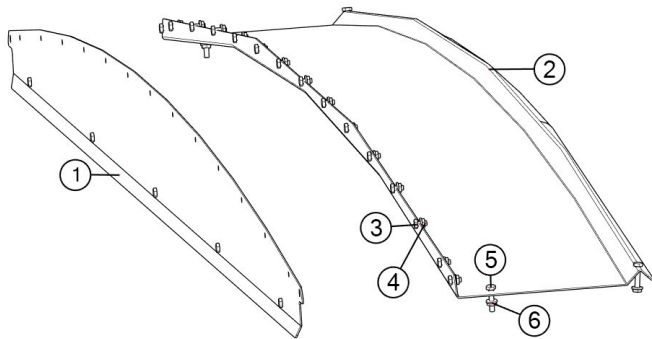
Roll Tarp Assembly

| # | Description: 455/555 | Part. No. |
|----|---|-----------|
| 1 | 455/555 Front Face Plate | JM0033224 |
| 2 | 455/555 Endcap Front (Top) | JM0033227 |
| 3 | 1/4"-20 x 1/2" Gr5 Z Hex Bolt | JM0001481 |
| 4 | 1/4"-20 Gr5 Z Serrated Flange Hex Nut | JM0001630 |
| 5 | 1/4"-20 x 5/8" Gr5 Z Hex Bolt | JM0001479 |
| 6 | 455/555 Endcap Rear (Top) | JM0033233 |
| 7 | 3/8"-16 Gr5 Z J-Bolt | JM0001519 |
| 8 | 3/8"-16 Gr5 Z Centerlock Hex Nut | JM0001512 |
| 9 | 455/555 Rear Faceplate | JM0033231 |
| 10 | Knee Brace | JM0000917 |
| 11 | 3/8"-16 Gr5 Z Serrated Flange Nut | JM0002152 |
| 12 | 3/8"-16 x 1" Gr5 Z Serrated Flange Hex Bolt | JM0002092 |
| 13 | Roll Tarp Guide Roller | JM0038446 |
| 14 | 1" USS Flat Washer | JM0003063 |
| 15 | Universal Joint | JM0001517 |
| 16 | 1/4"-20 Gr5 Z Centerlock Hex Nut | JM0001505 |
| 17 | Spring Return Cable | JM0010307 |
| 18 | 3/8"-16 x 1-1/2" Gr5 Z Hex Bolt | JM0001659 |
| 19 | 1/4"-20 x 2-1/2" Gr5 Z Hex Bolt | JM0001506 |
| 20 | Roll Tarp Hanger Bracket | JM0000815 |
| 21 | Handle Hanger Rubber Flap | JM0002551 |
| 22 | Pinless Crank Holder | JM0002967 |
| 23 | 1/2" Z Flat Washer | JM0003082 |
| 24 | 1/2"-13 x 1 1/4" Gr5 Z Hex Bolt | JM0001513 |
| 25 | Square Tie-Down Tube for 455/555 Roll Tarp | JM0033480 |
| 26 | 455/555 Canvas Tarp | JM0033471 |
| 27 | Square Roll Tube Weldment for 455/555 Roll Tarp | JM0033478 |
| 28 | 192" Cable | JM0022194 |
| 29 | 455/555 Roll Tarp Lip Lock | JM0033253 |
| 30 | 455/555 Tarp Bow Weldment | JM0033272 |
| 31 | Crank handle | JM0002907 |
| 32 | Yellow Cap | JM0018963 |
| 33 | Spring Return Assembly | JM0002437 |
| 34 | Spring Return Cable | JM0010307 |
| 35 | 3/8"-16 x 2" Gr5 Z Hex Bolt | JM0001510 |
| 36 | Tarp Stop | JM0000187 |
| 37 | 1/8" Cable Clamp | JM0001514 |

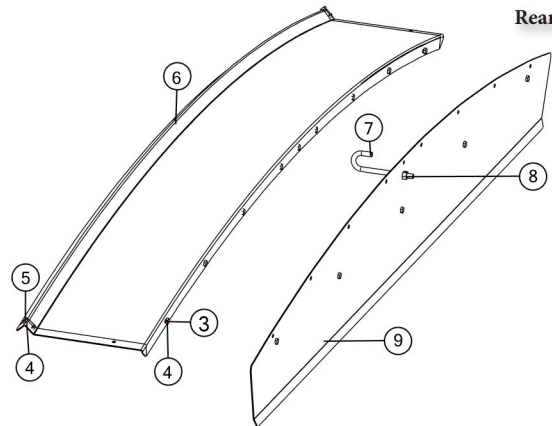
| # | Description: 655/755 | Part. No. |
|----|---|-----------|
| 1 | 655/755 Front Face Plate | JM0034329 |
| 2 | 655/755 Endcap Front (Top) | JM0034331 |
| 3 | 1/4"-20 x 1/2" Gr5 Z Hex Bolt | JM0001481 |
| 4 | 1/4"-20 Gr5 Z Serrated Flange Hex Nut | JM0001630 |
| 5 | 1/4"-20 x 5/8" Gr5 Z Hex Bolt | JM0001479 |
| 6 | 655/755 Endcap Rear (Top) | JM0034334 |
| 7 | 3/8"-16 Gr5 Z J-Bolt | JM0001519 |
| 8 | 3/8"-16 Gr5 Z Centerlock Hex Nut | JM0001512 |
| 9 | 655/755 Rear Faceplate | JM0034327 |
| 10 | Knee Brace | JM0000917 |
| 11 | 3/8"-16 Gr5 Z Serrated Flange Nut | JM0002152 |
| 12 | 3/8"-16 x 1" Gr5 Z Serrated Flange Hex Bolt | JM0002092 |
| 13 | Roll Tarp Guide Roller | JM0038446 |
| 14 | 1" USS Flat Washer | JM0003063 |
| 15 | Universal Joint | JM0001517 |
| 16 | 1/4"-20 Gr5 Z Centerlock Hex Nut | JM0001505 |
| 17 | Spring Return Cable | JM0010307 |
| 18 | 3/8"-16 x 1-1/2" Gr5 Z Hex Bolt | JM0001659 |
| 19 | 1/4"-20 x 2-1/2" Gr5 Z Hex Bolt | JM0001506 |
| 20 | Roll Tarp Hanger Bracket | JM0000815 |
| 21 | Handle Hanger Rubber Flap | JM0002551 |
| 22 | Pinless Crank Holder | JM0002967 |
| 23 | 1/2" Z Flat Washer | JM0003082 |
| 24 | 1/2"-13 x 1 1/4" Gr5 Z Hex Bolt | JM0001513 |
| 25 | Square Tie-Down Tube for 655/755 Roll Tarp | JM0034383 |
| 26 | 655/755 Canvas Tarp | JM0034386 |
| 27 | Square Roll Tube Weldment for 655/755 Roll Tarp | JM0034394 |
| 28 | 210" Cable | JM0036045 |
| 29 | 655/755 Roll Tarp Lip Lock (Front) | JM0034342 |
| 29 | 655/755 Roll Tarp Lip Lock (Rear) | JM0034542 |
| 30 | 655/755 Tarp Bow Weldment | JM0034349 |
| 31 | Crank handle | JM0002907 |
| 32 | Yellow Cap | JM0018963 |
| 33 | Spring Return Assembly | JM0002437 |
| 34 | Spring Return Cable | JM0010307 |
| 35 | 3/8"-16 x 2" Gr5 Z Hex Bolt | JM0001510 |
| 36 | Tarp Stop | JM0000187 |
| 37 | 1/8" Cable Clamp | JM0001514 |

Roll Tarp Assembly

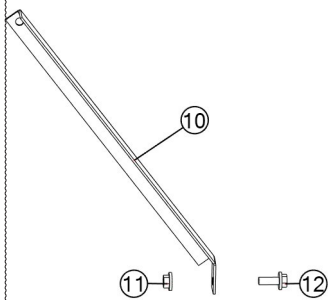
Front Endcap



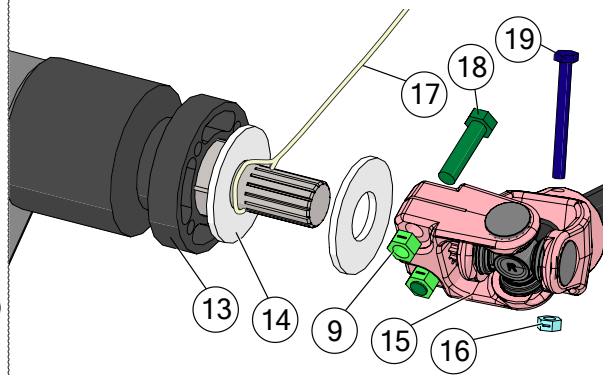
Rear Endcap



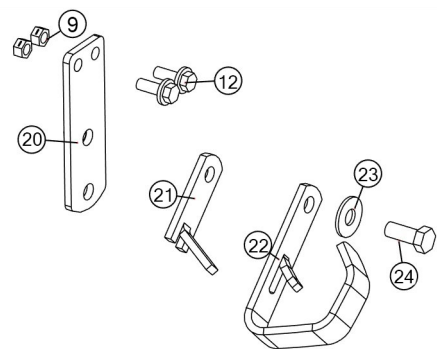
Endcap Support



Crank Handle U-Joint



Crank Handle Holder



Tarp Assembly

