

## Crusader 4016 Handle Package Assembly Instructions

1. Remove the vacuum head from the tank and place the tank upside down.
2. Pry off the hub caps on the rear wheels and remove the two rear wheels. New hub caps are furnished with the handle package.
3. Pull the axle out of the tank.
4. Place the handle brackets (part # 2049) onto the rear of the tank so that the axle hole in the tank is aligned with the axle hole in the handle brackets.  
**Note:** Notice that the round tube on the handle bracket is welded off center onto the handle brackets. When assembling the handle brackets on a 5 or a 10 gallon tank, make certain that the offset welded tubes are toward the outside (toward each wheel). When assembling the handle brackets on a 15 gallon tank, the offset welded tubes should be toward the inside (away from each wheel).
5. Next reassemble the rear axle to the tank and handle brackets. Now the rear wheels can be assembled. Check to see if there is proper clearance between the wheel and the tank to be sure the wheels don't rub on the tank. If the wheels rub, put a washer on each side of the axle, which would have been on the tank originally. If the wheels still rub, additional washers may be needed. Next, with the wheels in place, assemble the hubcaps to the axle.
6. Next, slide the handle into the two tubes located on the handle brackets. The handle is held in place with the two 3/8" bolts and washers that are preassembled in the handle. Tip the tank back over, reinstall its filter(s), and powerhead. The vacuum is now ready for use!

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