

Winsky Jig

THE BETTER BODY HANDLER

FRAME OFF RESTORATION MADE EASY

Over the years there has not been an easy way to do a frame off restoration. Handling of the body once off the frame is always a problem. If panel replacement is required in structural areas such as rockers, quarters, or floors there is always the possibility of body distortion. Many frame off restorations have resulted in cars that have doors, trunk lids, and sometimes even glass that no longer fits properly.

Our competitors' adjustable holding fixtures designed to hold the body to a rotisserie will do only that. The fixture can in no way assure structural integrity of the body, and in many cases causes distortion.

The only holding fixture designed for a specific body is the frame that the body came on. By spacing the body 4" to 6" off the frame and using the frame to hold the body to the rotisserie, you can now restore the frame and body on one jig at the same time and use only one space.

For information call or write:

Winsky Jig

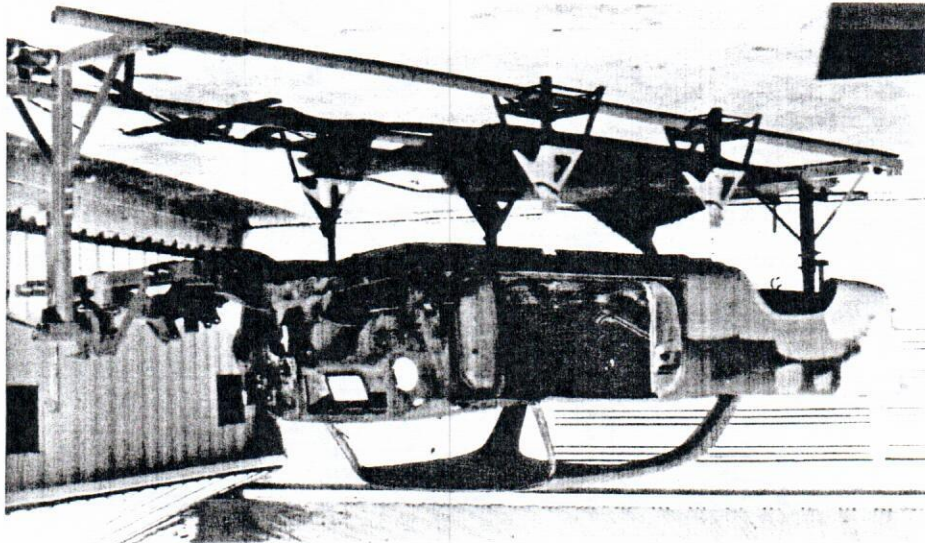
Warren Emerson

Eric Emerson

Paris, TN 38242

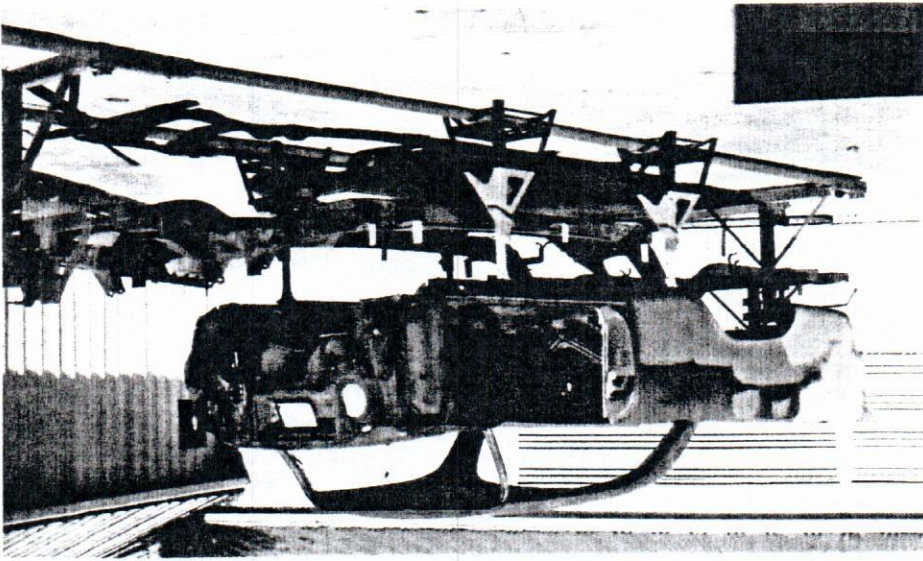
4700 Hwy 641S.

Phone 731 642 0660

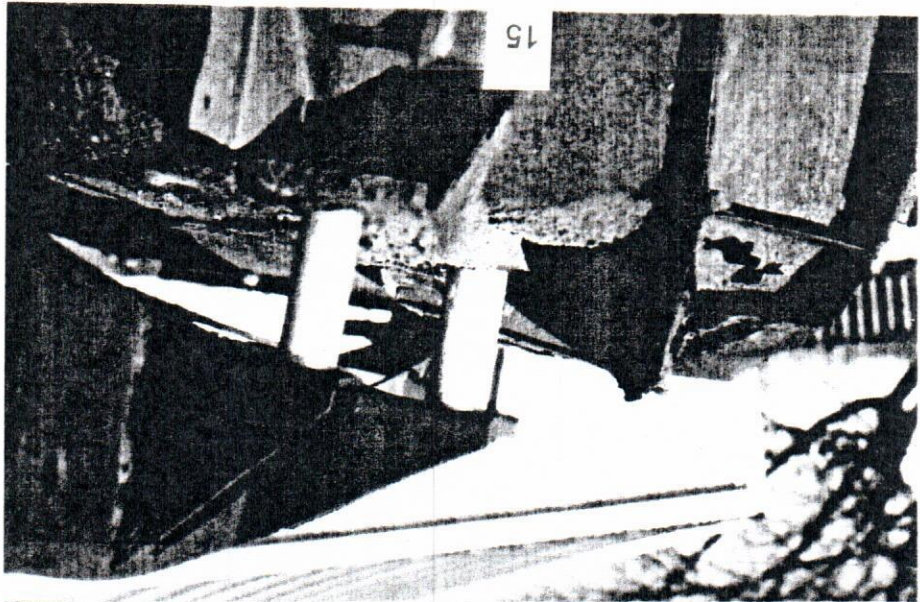


3. Using our 12" jack stand bases or a similar method support the body along the rockers by bridging the jack stands with 2" x 4" wood or, as in our case, 2" x 2" angle iron.

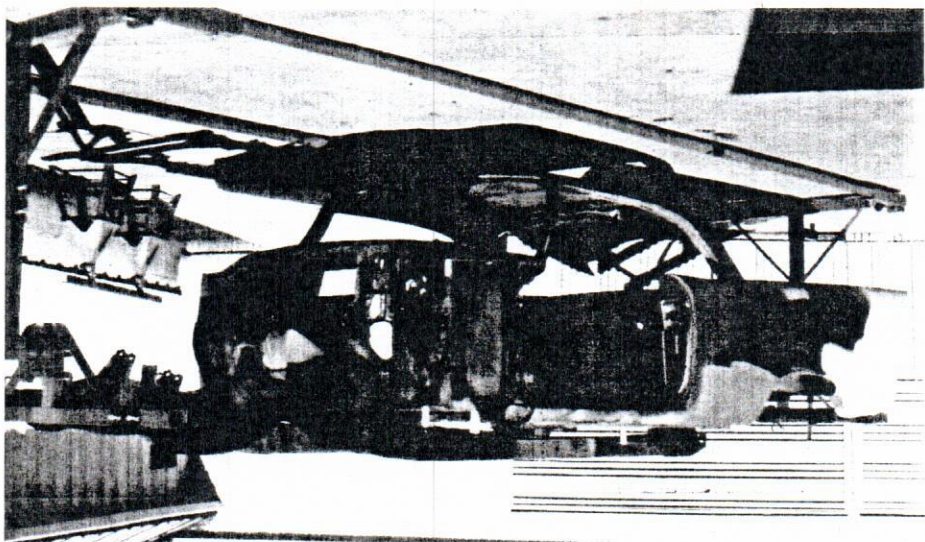
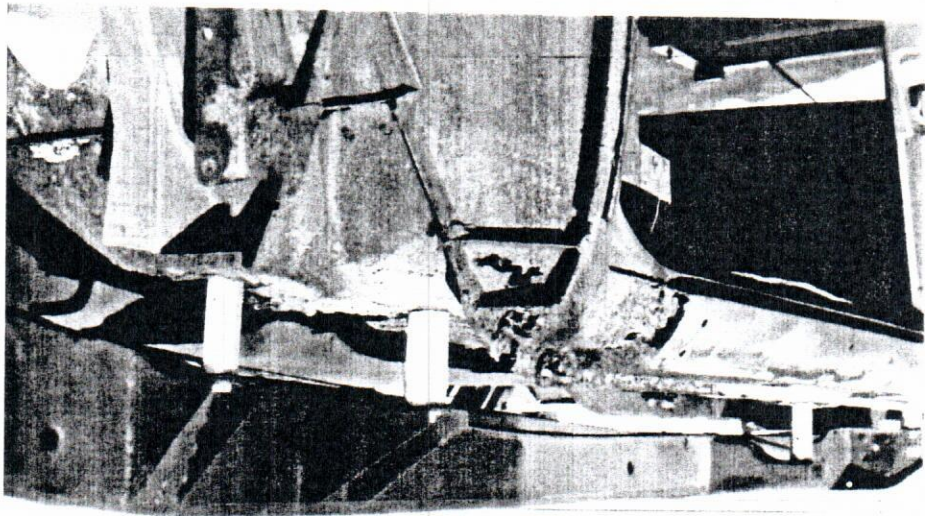
4. Unbolt body from frame at each of the mounting points.



5. With body supports in place, lower frame from under body by lowering each end of jig enough to install 4" to 6" spacers.



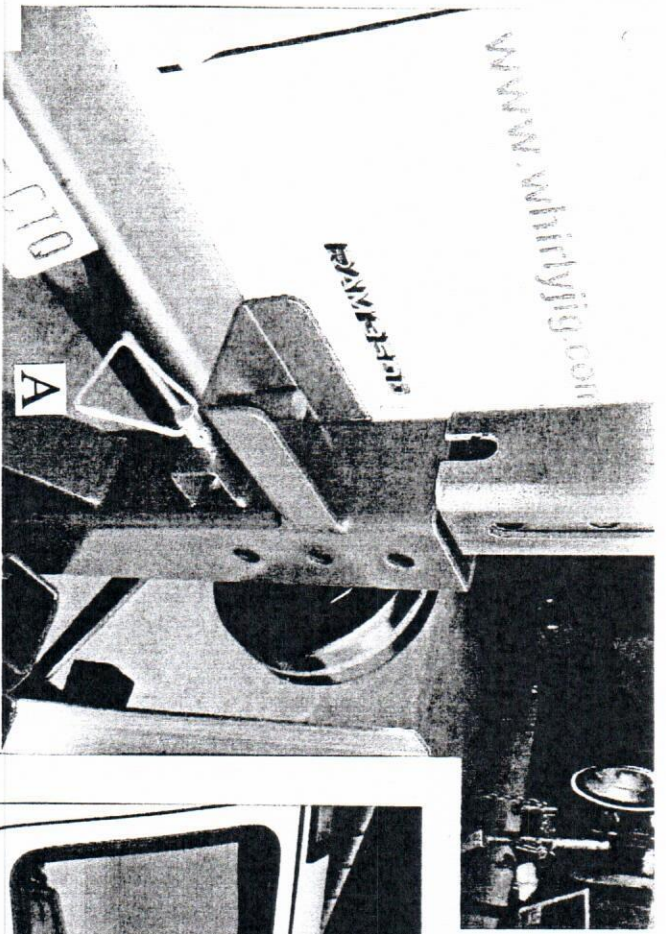
With only 4" space between body and frame, it is obvious there is enough room to cut, weld and grind with no risk of body distortion.



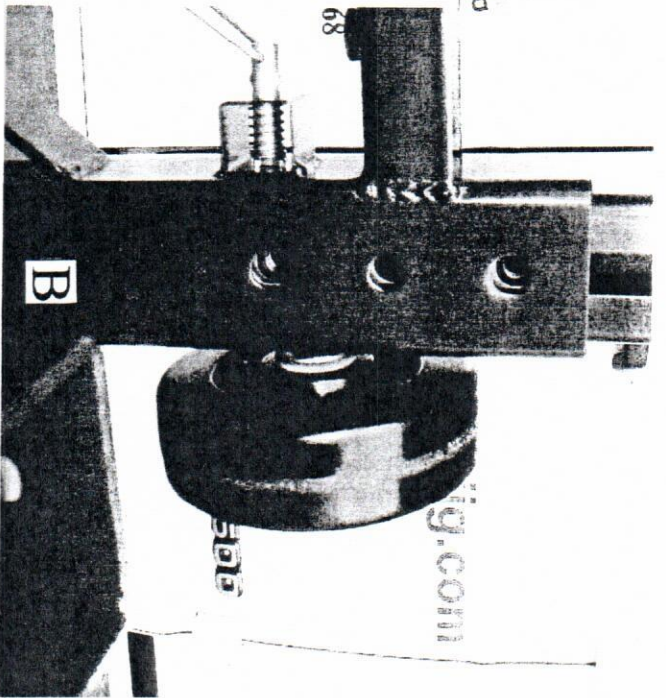
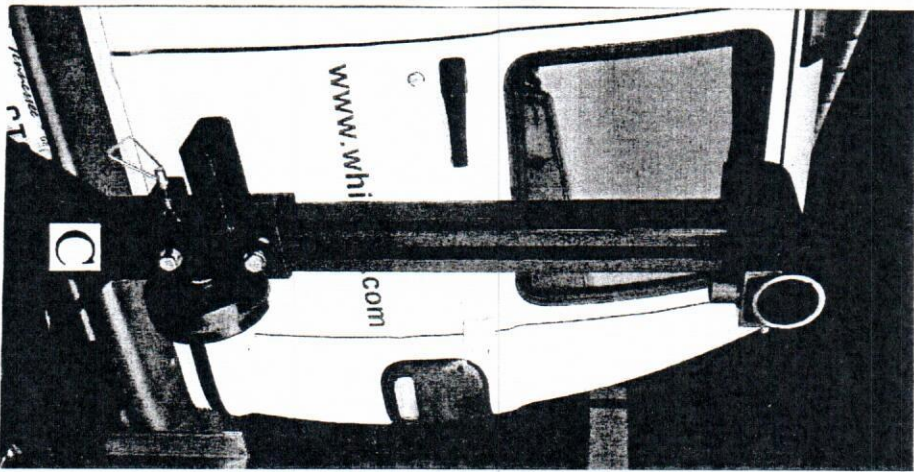
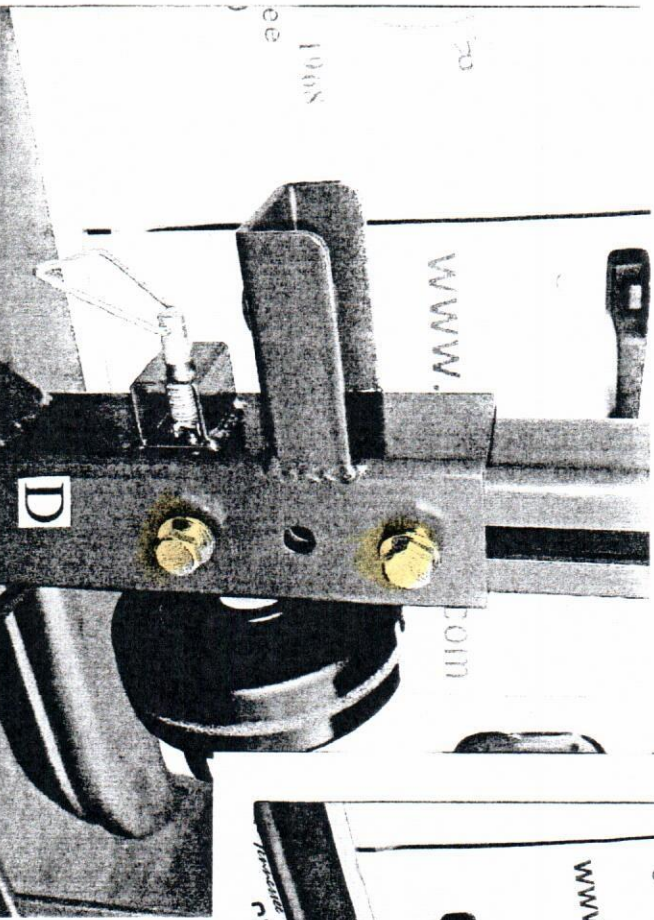
The body and frame may now be turned 360° to any position for cutting, welding, grinding, then painting.

ASSEMBLY OF YOUR WHIRLY JIG

1. Remove the two 6" wheels attached to the bases and set aside.
The nut that held the wheel is used for shipping only.
2. Pull spring loaded lock pin, lift out inner posts and set aside.
3. Cut all strapping bands.
4. Separate base stands just enough to remove cross bars and brackets.
5. Separate base stands.
6. Remove parts package from base receiver and safety bolt package from sprocket head.
7. ~~Remove strapping tape from clamping plate at lower end of inner post.~~
8. Be sure clamping plate stays at bottom of inner post.
9. Install inner posts into bases with long slot facing car body, until post rests on spring loaded safety stop.
10. Install (2) 1/2 - 13 x 1 1/2" bolts with washers into top and bottom nuts in clamping plate. Pull out spring loaded safety stop and lower inner posts into bases.
11. Install 1/2-20 x1 1/2" bolt into the under side of sprocket head. Do not tighten. On Pro models, this bolt goes into nut under the non-sprocket head. This is a resistance control, and should be used to control the amount of pressure required to rotate.



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INSTALLATION INSTRUCTIONS

1. Start with auto body on jack stands 18" - 20" off floor (Figure 1). Pg. 20
2. Set base stand, cross bars and brackets at each end of body (Figure 2).
3. Mount body bracket to body on one side. DO NOT TIGHTEN BOLTS AT THIS TIME. (Use appropriate size and thread bolts in grade 5 or higher only – not provided).
4. At this time, select from (mounting body/frame to cross bar instructions) the appropriate relationship of cross bar to body or frame and yoke to cross bar vertical for your particular car body or frame.

MOUNTING BODY/FRAME TO CROSS BAR INSTRUCTIONS

*Probable combinations of cross
bar and yoke connections for
various bodies and frames:*

- For most unbody cars from the 60's to the present, combine figures 1 and 3.
- For most full frame cars with body spaced 4" off frame, combine figures 1 and 4.
- For most frames with suspension only, combine figures 2 and 4.
- For body, frame and suspension, combine figures 1 and 3.
- For body only, the Body/Frame Stiffener is required. Combine figures 1 and 4. then install Stiffener under body.

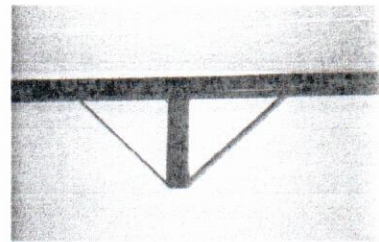


FIGURE 1
Crossbar Vertical Up

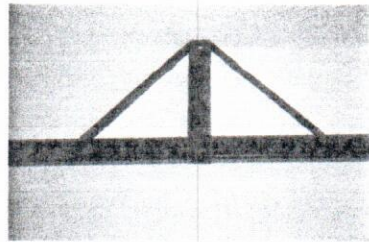


FIGURE 2
Crossbar Vertical Down

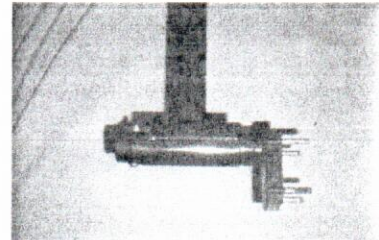


FIGURE 3
Yoke Vertical Up

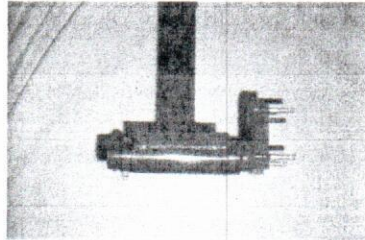


FIGURE 4
Yoke Vertical Down

The following two paragraphs describe mounting a unitbody car to the Whirly Jig.

5. Slide cross bar into body bracket with cross bar pointing up. Slide the other body bracket on cross bar and mount to body. Tighten body brackets to body and center cross bar between brackets. Tighten all bolts to 50 ft. lbs. (Figure 3)

6. Slide base stands to cross bar with long side of yoke up (Figure 4). Now mount the yoke at the highest point possible on the cross bar vertical. Install 2 bars, 4 washers and 4 nuts, tighten to 30 ft. lbs. DO NOT INSTALL WHEELS AT THIS TIME. Be sure bases are parallel both horizontally and vertically.

7. With both base stands secured to cross bars, you are now ready to lift body off jack stands. Install appropriate jacks, (Fig. 6) between jack support on base and receiver on inner post. (Fig. 7).

Be sure sprocket lock is engaged before lifting. Lift one end at a time observing mounting areas, no flexing or motion between body and mounts should occur.

8. Lift body clear of jack stands. Remove jack stands. Adjust inner posts so that the pivot points are at the same height. Measure from top of outer posts to top of inner posts.

IT IS IMPORTANT THAT THE MEASUREMENTS AT ONE END OF ROTISSERIE BE THE SAME AS THE OTHER END.

9. Install body balancing tool into cross bar assembly. Use oil on threads and grease on end of threaded shaft. In order to balance load on jig, stand at sprocket end of jig and take a firm grip on outer end of cross bar. (This should be done with 2 people). Unlock sprocket lock. Slowly roll body with a downward push on end of cross bar. If the body tends to return to the upright position (as it should), you will have to raise body and cross bar in yoke. To do so, loosen the 4 nuts on the yoke clamp bars at each end of rotisserie. Using the Body Balancing Tool, raise the cross bar assembly 1" at a time at each end of the rotisserie until you can rotate the body 45 degrees in each direction and it will stay there without having to lock it with the sprocket lock. Tighten all 4 nuts to 30 ft. lbs. at each end of the rotisserie. When balanced, both inner posts must be in the same position on both cross bar verticals. If not, adjust accordingly.

10. ALWAYS KEEP POST LOCK BOLTS TORQUED TO 50 LBS. WHEN NOT ADJUSTING HEIGHT.

11. Install (2) 2" I.D. round pipe (not included) long enough to connect both bases. DO NOT USE SQUARE TUBING. (Figure 5)

Be sure bases are parallel both horizontally and vertically.

12. To install wheels, use floor jack to lift jig clear of floor (Figure 8). Install wheels with one washer on either side of wheel and one at head of bolt, tightening to 20 ft. lbs. Lower jig to floor. By attaching floor jack to other end, your Whirly Jig is now portable and easy to move anywhere on hard surface.

13. To remove bumper jack from stand, loosen post lock bolts. Put jack lever in lower position; push down hard on handle, tighten bolts 50 ft. lbs. Release handle. Jack is now free.

CAUTION: ANY PARTS REMOVED OR ADDED AFTER LOAD HAS BEEN CENTERED WILL MAKE IT NECESSARY TO RE-ADJUST THE LOAD TO RETAIN THE BALANCE YOU PREVIOUSLY ACHIEVED.

CAUTION:

Do not use floor jack to compress suspension when sprocket lock is engaged. Disengage sprocket lock then support body/frame on jack stands.

**CENTER POST LOCKING BOLTS
INSTALL BOLTS BEFORE REMOVING JACKS**

Installation instructions

If you are using a mechanical bumper jack, first achieve desired working height, align bolt holes at each end, put jack lever in release position and push down on kack handle until center post raises, lower center post until holes realign, install safety bolt. **DO NOT OVER TIGHTEN BOLT.**

Caution

For your safety disassemble in reverse order only.

- 1 Remove all wheel systems.
- 2 Remove base ties (2" pipes.)
- 3 Remove Body / Frame stiffener, if used.
- 4 With Body Balancing tools in place, loosen yoke to cross bar clamps and using balancing tool lower body down to lowest possible position to pivot point.
- 5 Disengage lock pin from sprocket. With height adjusting jacks in place, lower body onto jacksstands.
- 6 Unbolt clamps to cross bar and move bases away from body.
- 7 Remove cross bar and brackets from body.

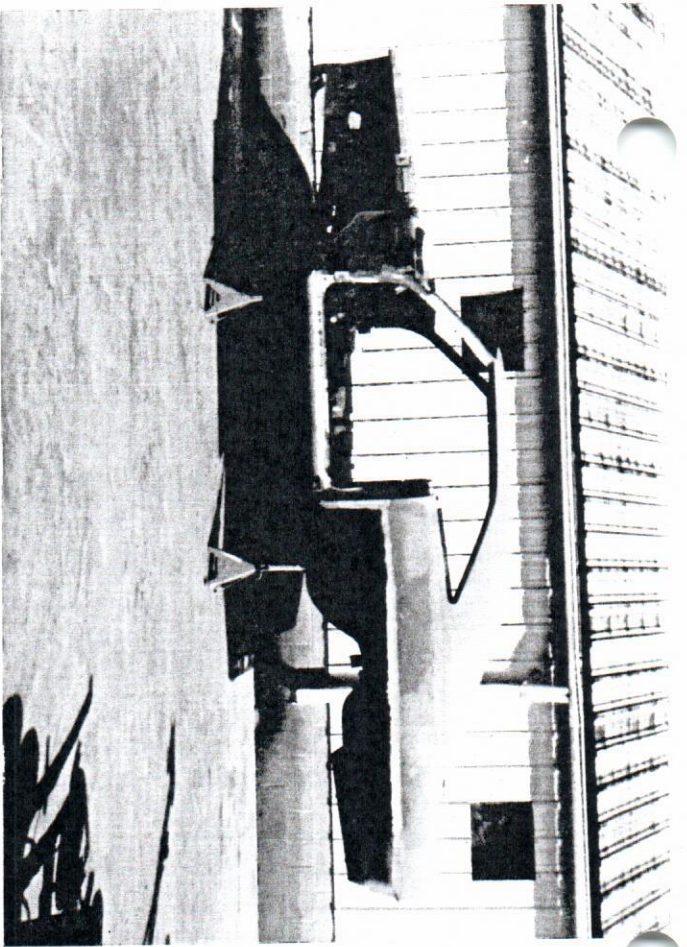


Figure 1

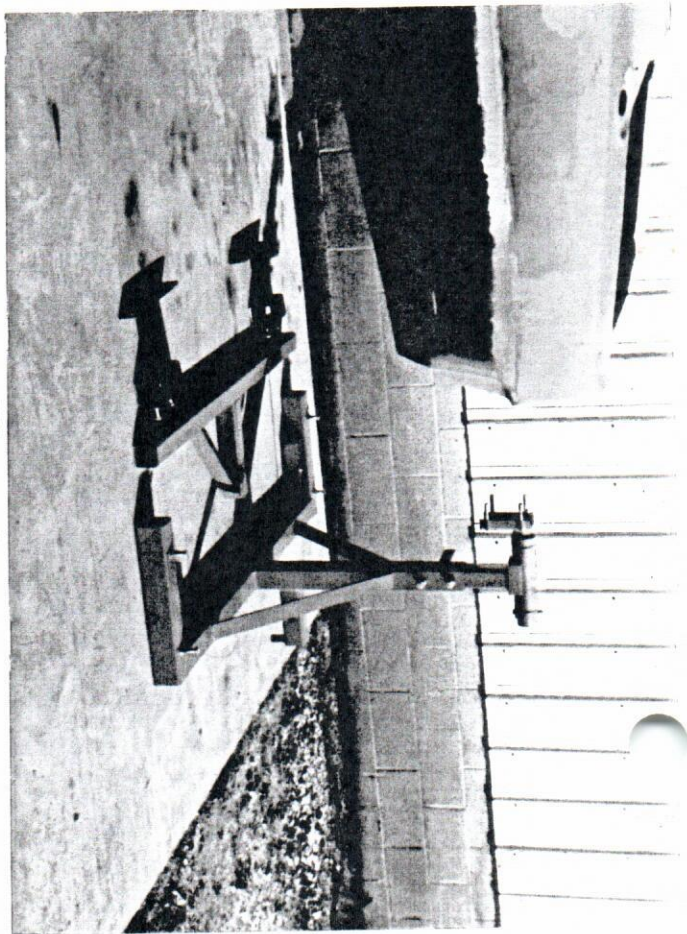


Figure 2

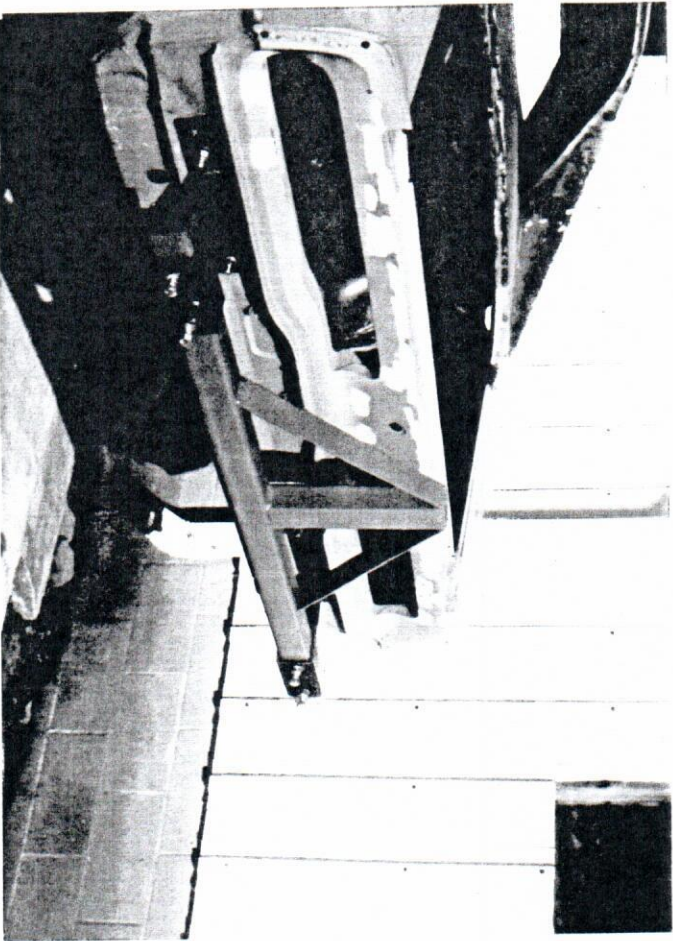


Figure 3

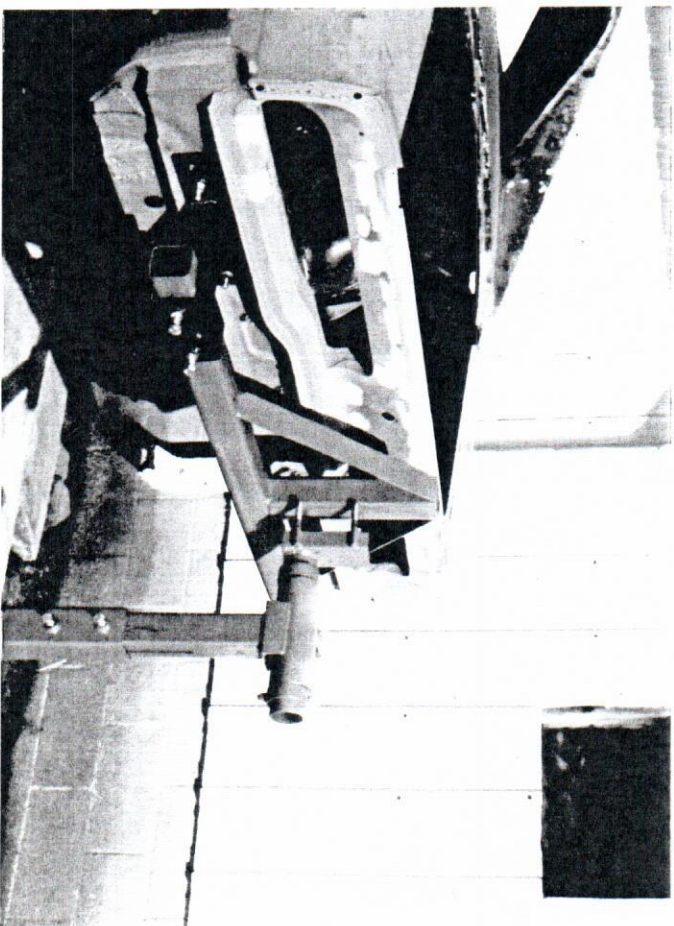


Figure 4

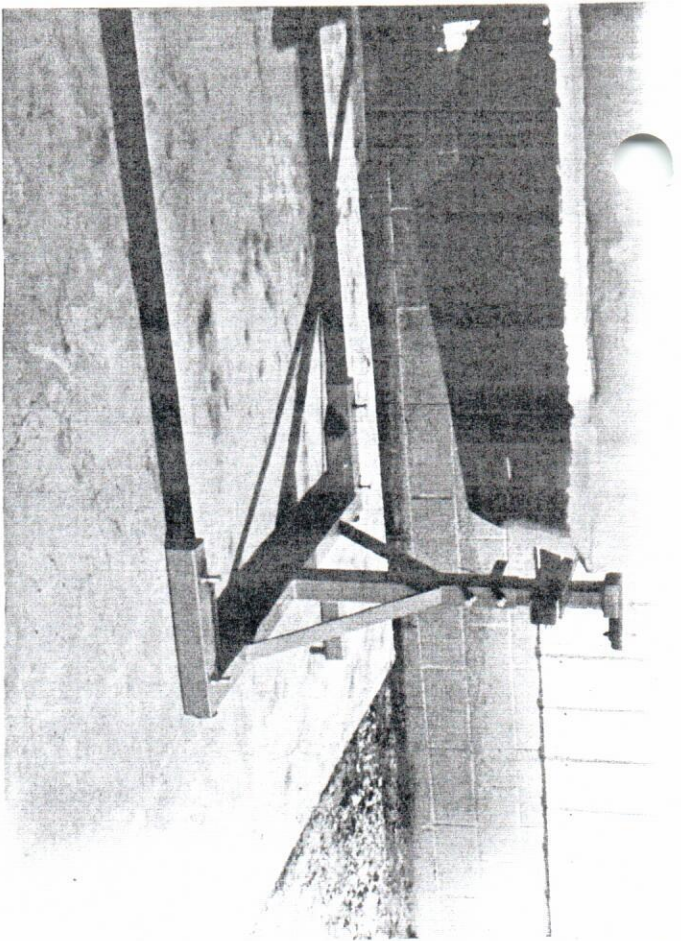


Figure 5

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Figure 6

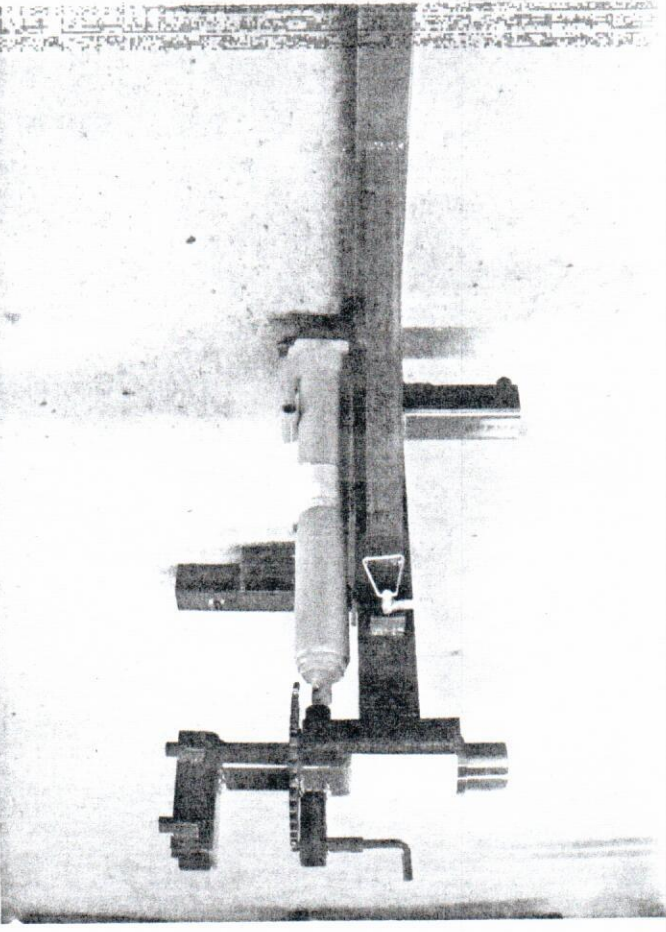


Figure 7

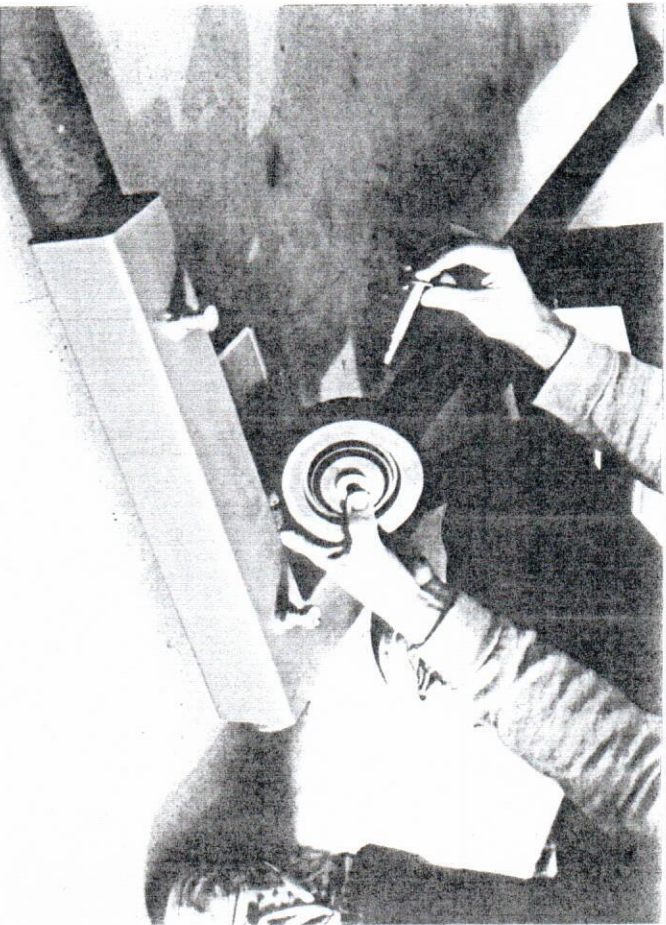


Figure 8