



825, 875 HEADLAMP KIT INSTALLATION INSTRUCTIONS



CONTENTS:

2- LAMP BASES



2- LAMP RETAINERS



2- TRIM RINGS



6- #8 X 1.5" SM SCREWS



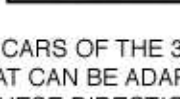
6- #6 x 3/4" SM SCREWS



6-COMPRESSION SPRINGS



6- MOUNT TABS



WHICH LAMPS WILL YOU NEED?
OUR HEADLAMP SETS UTILIZE STANDARD LAMPS OR UPGRADE TO OUR "BLUE DOT" OR "SNAKE EYE" LAMPS. USE THIS CHART TO SELECT THE CORRECT LAMPS.

HAGAN SYSTEM	BLUE DOT	SNAKE EYE	SEALED BEAM
775	575LBDT	575LSE	H5006
825	LBDT	LSE	H6024
875	LBDT	LSE	H6024


OPTIONAL ACCESSORIES:
ADDITIONAL BARE STEEL OR CHROME TRIM
CUSTOM TRIBAR LAMPS OR SNAKE EYE WITH OR WITHOUT TURN SIGNALS



BLUE DOT LAMPS



SNAKE EYE LAMPS



TURN SIGNALS

To order: 1-888-464-2426

A WORD ABOUT THE CARS OF THE 30'S. THE HEAD LAMPS OF THESE CARS ARE SIMILAR, WHICH HAS ALLOWED US TO DESIGNED KITS THAT CAN BE ADAPTED TO MANY MAKES AND MODELS. BECAUSE OF THIS IT WILL BE NECESSARY FOR YOU TO READ THESE DIRECTIONS THROUGH BEFORE STARTING, AND HAVE A GOOD UNDERSTANDING OF THE MODIFICATIONS THAT MAY BE REQUIRED TO INSTALL YOUR HEAD LAMPS PROPERLY.

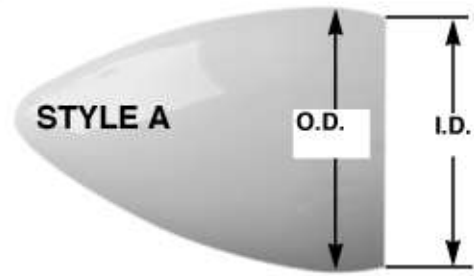
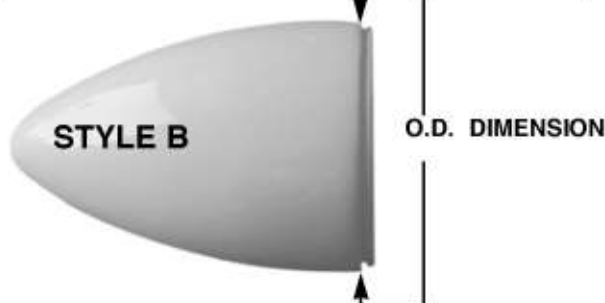
STAGE 1 BUCKET IDENTIFICATION. DO YOU HAVE THE CORRECT PARTS?

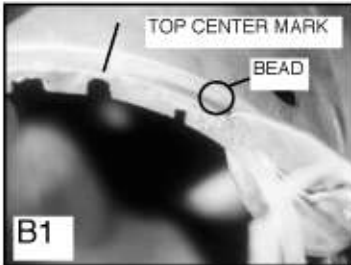
1937-39 GM BUCKETS HAVE A BEADED FRONT EDGE. WE CALL THEM **STYLE B**. THE CHART BELOW WILL HELP YOU CHOOSE THE CORRECT HEAD LAMP SET.

MOST 1934-39 MOPAR BUCKETS HAVE A RAW EDGE AT THE FRONT AND TEND TO BE WIDER ABOUT 1" BACK FROM THE EDGE. WE CALL THESE **STYLE A**. YOU MUST MEASURE THE I.D. AND THE O.D. OF THE BUCKET TO DETERMINE THE RIGHT KIT TO USE. THE CHART BELOW WILL HELP YOU CHOOSE THE CORRECT HEAD LAMP SET.

USE KIT	O.D. DIMENSION
775	7.75" USE
825	8.25"
850	8.5" (CURRENTLY UNAVAILABLE)
875	8.75"

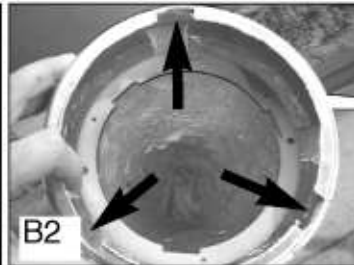
USE KIT	O.D.	I.D.
775	8"	7.25" OR LESS
825	8-1/2"	8 OR LESS
875	9"	8.25" OR LESS



STAGE 2**GM (STYLE B)****TRIM RING INSTALLATION**

MARK TOP CENTER OF BUCKET AS IT SETS ON THE VEHICLE.

DOES THE NEW LAMP BASE SLIDE STRAIGHT INTO THE BUCKET? IF THE ANSWER IS NO, THEN YOU WILL NEED TO TRIM AWAY **JUST ENOUGH** OF THE FRONT LIP OF THE BUCKET TO ALLOW IT TO FIT. **DO NOT CUT THE BEAD!**



SOME GM (STYLE B) BUCKETS LIKE THE '37-'38 CHEVY WILL REQUIRE THREE NOTCHES IN THE FRONT LIP TO ALLOW THE TRIM CLIPS TO SLIP INTO THE BUCKET. HOLD THE TRIM RING UP TO THE BUCKET WITH ONE OF THE TRIM CLIPS AT THE 12 O'CLOCK POSITION. MARK THE POSITION OF THE THREE CLIPS. WITH A SQUARE FILE, CUT THREE NOTCHES. **CUT THE FRONT LIP ONLY!**



TO INSTALL THE TRIM, SLIP THE TOP CLIP IN PLACE AND ASSIST THE SECOND AND THIRD CLIP WITH A BLUNT INSTRUMENT. **NOTE: ON FINAL ASSEMBLY IT IS BEST TO PUT TWO LAYERS OF MASKING TAPE ON THE PAINTED EDGE OF THE BUCKET SO YOU DO NOT SCRATCH THE PAINT!**



TRIM SHOULD NOW FIT WELL.

PROCEED WITH STAGE 3 LAMP ASSEMBLY INSTALLATION

STAGE 2**MOPAR (STYLE A)****TRIM RING INSTALLATION**

MARK TOP CENTER OF BUCKET AS IT SETS ON THE VEHICLE.

MEASURE THE ID OF THE BUCKET. IT MUST BE **1/2" LESS** THAN THE TRIM RING OD.

875 KIT BUCKET MUST BE 8-1/4"
850 KIT BUCKET MUST BE 8"
925 KIT BUCKET MUST BE 7-3/4"
MOST BUCKETS WILL REQUIRE TRIMMING 1/4" TO 1/2" OFF THE FRONT TO REACH THE PROPER ID. CUT 1/8" AT A TIME, DO NOT TRIM TOO MUCH!!!!



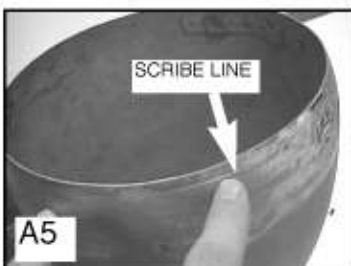
EXAMPLE: THIS IS A '37 DODGE/CHRYSLER BUCKET. ITS ID WAS 8", THE OD IS 9". WE WILL USE THE 875 KIT. TO FIT THE TRIM WE HAD TO TRIM OFF 1/2" TO OPEN THE ID TO 8-1/4". **FOR BEST RESULTS TRIM OFF 1/8" AT A TIME UNTIL YOU REACH THE DESIRED ID.**



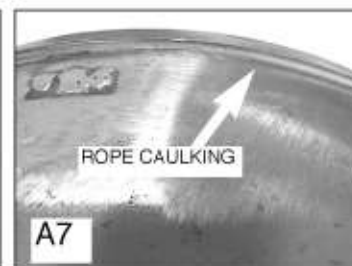
TO INSTALL THE TRIM, SLIP THE TOP CLIP IN PLACE AND ASSIST THE SECOND AND THIRD CLIP WITH A BLUNT INSTRUMENT. TRIM RING MAY TEND TO SEE-SAW BUT SHOULD BE SNUG. **NOTE: ON FINAL ASSEMBLY IT IS BEST TO PUT TWO LAYERS OF MASKING TAPE ON THE PAINTED EDGE SO YOU DO NOT SCRATCH THE PAINT!**



ON SOME BUCKETS LIKE THE '37 DODGE THE TRIM DOES NOT FIT PERFECTLY TO THE BUCKET AS SHOWN ABOVE. IF YOU WANT A MORE TAILORED FIT YOU WILL NEED TO BACK FILL THE BUCKET.

OPTIONAL**(MOPAR STYLE A)****BACK FILLING BUCKET TO FIT**

SCUFF THE FIRST 4 INCHES OF THE BUCKET. SCRIBE A LINE 1/4" FROM THE EDGE. INSTALL THE TRIM RING AND LINE IT UP WITH THE SCRIBE LINE. YOU CAN BACK FILL WITH **LEAD OR BODY FILLER**. HERE WE WILL BE USING "EVERCOAT METAL TO METAL BODY FILLER."



PREP BUCKET FOR FILLER. USE ROPE CAULKING AND FILL THE GAP BETWEEN THE RING AND BUCKET TO KEEP BODY FILLER FROM GOING UNDER THE RING. THIS WILL KEEP THE RING FROM STICKING TO THE BUCKET AND LEAVE A CLEAN EDGE. MAKE SURE THE RING STAYS IN LINE WITH THE SCRIBE LINE.



MASK OFF THE TRIM RING. THIS WILL KEEP IT CLEAN WHILE YOU SPREAD THE FILLER.

CONT.

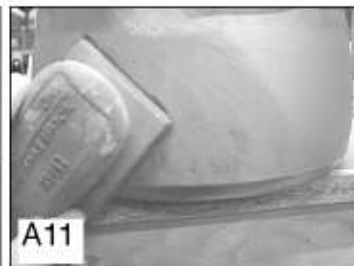
BACK FILLING BUCKET TO FIT



A9
MAKE SURE BUCKET IS CLEAN AND SCUFFED. IT IS BEST TO CLEAN THE BUCKET WITH LACQUER THINNER PRIOR TO FILLER APPLICATION. NOTICE THAT THE SPREADER IS HELD IN THE SHAPE OF THE BUCKET, AND THE FILLER IS SPREAD SMOOTH. THIS WILL GREATLY REDUCE YOUR SANDING TIME AND USE LESS MATERIALS.



A10
HERE YOU CAN SEE HOW THE FILLER WAS APPLIED. REMOVE THE TAPE JUST AS THE FILLER BEGINS TO HARDEN. REMOVE THE TRIM RING AND THE CAULKING.



A11
BEGIN BLOCK SANDING JUST AS SOON AS THE FILLER TACKS UP. HIT THE HIGH SPOTS FIRST. AS THE FILLER CONTINUES TO HARDEN YOU CAN SAND MORE AGGRESSIVELY. YOU WILL HAVE TO SAND THE EDGE OF THE FILLER BACK SO YOU HAVE A CLEAN GAP BETWEEN THE BUCKET AND THE TRIM RING.

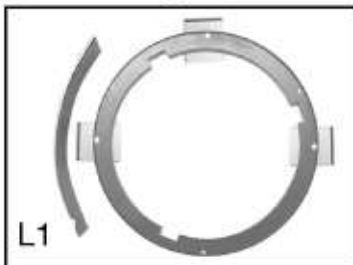


A12
HERE IS THE FINISHED EDGE OF THE BUCKET. WE NOW HAVE A CLEAN EDGE. THE FILLER IS ONLY 1/8" THICK AND WON'T GIVE YOU ANY PROBLEMS AS LONG AS YOU APPLIED IT PROPERLY.

**PROCEED WITH STAGE 3
LAMP ASSEMBLY INSTALLATION**

STAGE 3

LAMP ASSEMBLY INSTALLATION

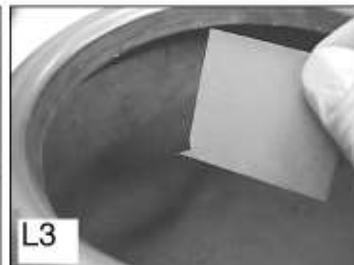


L1
THIS IS HOW THE LAMP BASE AND MOUNT TABS ARE POSITIONED IN THE BUCKET. RINGS ARE MARK "TOP FRONT".

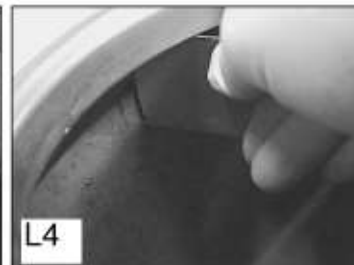
NOTE:
FOR SIDE MOUNTING BUCKETS ON SOME BUCKETS YOU WILL NEED TO INSTALL THE FILLER STRIP TO MOUNT THE TAB ON THE RADIATOR SIDE OF THE BUCKET. SHAPE THE STRIP TO MATCH THE BUCKET THEN BOND OR WELD IN PLACE.



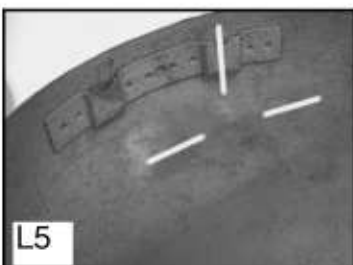
L2
HOLD THE LAMP BASE IN THE BUCKET, AND LINE UP THE TOP MOUNT HOLE WITH YOUR TOP CENTER MARK OF THE BUCKET. WITH THE LAMP BASE CENTERED, MARK THE 3 AND 9 O'CLOCK HOLE POSITIONS ON THE BUCKET.



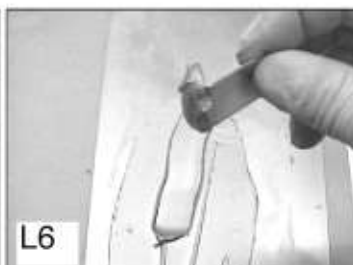
L3
NOW INSTALL THE TRIM RING. TAKE THE 1-5/8" SCRIBE TOOL PROVIDED AND MARK THE BUCKET, HOLDING THE SCRIBE FLAT AGAINST THE BUCKET AND THE ID OF THE TRIM RING.



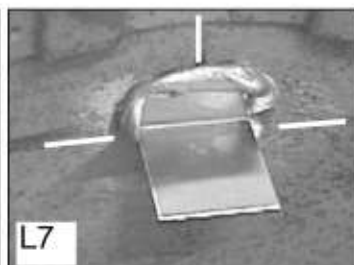
L4
MAKE A SCRIBE MARK AT 9, 3, AND 12 O'CLOCK. THIS LINE WILL BE 1-5/8" IN FROM THE INSIDE EDGE OF THE TRIM RING. THIS POSITION MUST NOT VARY!



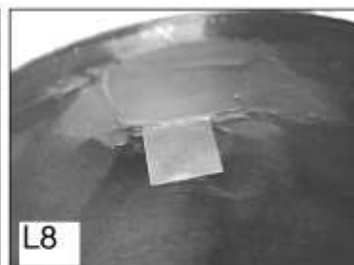
L5
YOU SHOULD NOW HAVE ALL THREE POSITIONS MARKED AS SHOWN ABOVE. SCUFF THE BUCKET IN THESE AREAS AND SCUFF THE BOTTOMS OF THE MOUNT TABS.



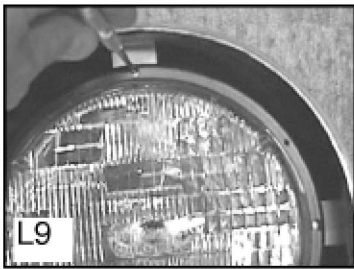
L6
TO INSTALL THE MOUNT TABS MIX A SMALL AMOUNT OF METAL TO METAL FILLER. USE 3 TIMES THE RECOMMENDED HARDENER SO IT WILL HARDEN VERY FAST.



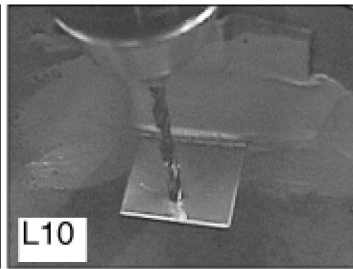
L7
STICK THE MOUNT BRACKET IN PLACE. NOTE: FLANGE IS POINTING TOWARD THE FRONT OF THE BUCKET.



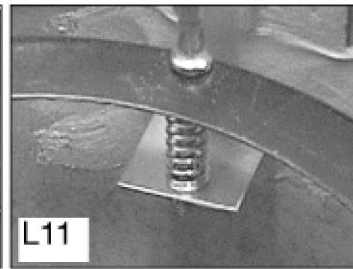
L8
USE MORE FILLER AND SPREAD A LAYER OVER THE FLANGE AND USE YOUR FINGER TO SMOOTH THE FILLER BEHIND THE MOUNT TAB. YOU WANT THE FLANGE OF THE TAB TO BE COMPLETELY ENCASED IN THE FILLER AS SHOWN. WORK QUICKLY! THE EXTRA HARDENER WILL MAKE IT HARDEN IN ABOUT 60 SECONDS.



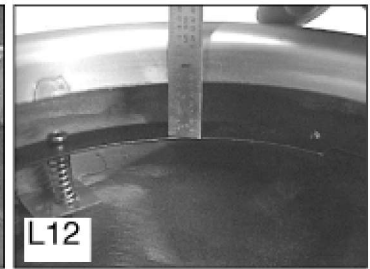
L9
ONCE ALL THREE TABS ARE INSTALLED HOLD THE LAMP BASE AND LAMP AGAINST THE TABS. CENTER AND ALIGN THE LAMP. NOW MARK THE THREE MOUNT HOLES.



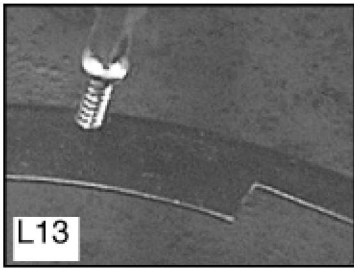
L10
DRILL A 1/8" PILOT HOLE IN THE TABS.



L11
INSTALL THE LAMP BASE WITH THE THREE SPRINGS AND THE 1.5" SCREWS



L12
IF YOU ARE USING SEALED BEAMS ADJUST THE LAMP BASE TO 1" FROM THE TRIM RING ID. IF YOU ARE INSTALL HAGANS BLUE DOT OR SNAKE EYE LAMPS ADJUST THE LAMP BASE TO 3/4" FROM THE TRIM RING ID.



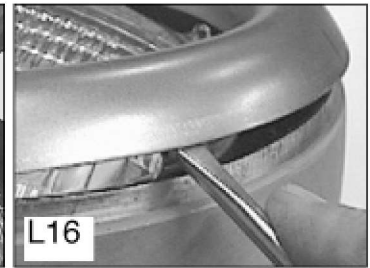
L13
BEFORE INSTALLING THE LAMPS, INSTALL THE THREE LAMP RETAINER SCREWS INTO THE LAMP BASES. THIS WILL PRE-SEAT THE THREADS.



L14
REMOVE THE SCREWS AND INSTALL THE LAMPS. INSTALL THE LAMP RETAINER RING.

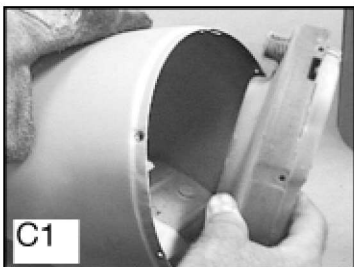


L15
SNAP THE TOP TRIM CLIP IN FIRST.

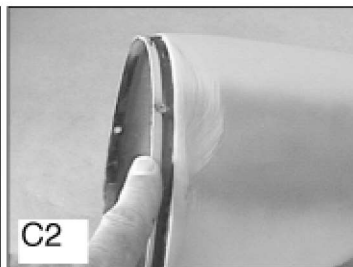


L16
ASSIST THE SECOND AND THIRD WITH A BLUNT INSTRUMENT. CHECK THE GAPS AND MAKE ANY NECESSARY ADJUSTMENT BEFORE PAINTING.

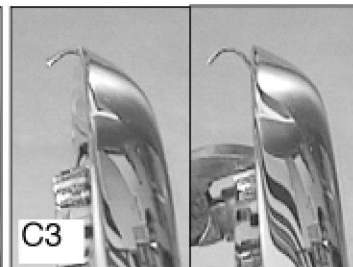
OPTIONS EXTEND AND EMBED TRIM CLIPS (EXAMPLE ON '40CHEVY BUCKET)



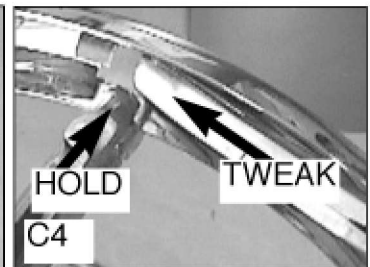
C1
('40 CHEVY BUCKET)
DRILL OUT RIVETS AND REMOVE LAMP ASSEMBLY.



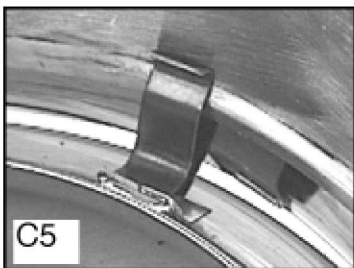
C2
('40 CHEVY BUCKET)
ON THE '40 CHEVY BUCKET YOU MUST TRIM BACK THE LIP LEAVING 3/16" TO 1/4" .



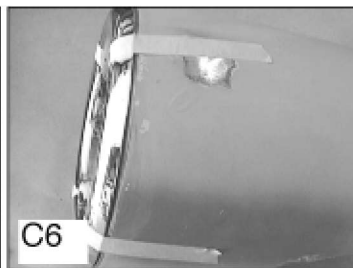
C3
(MOPAR AND '40 CHEVY)
TO GET THE CLIPS TO REACH FURTHER INTO THE BUCKET YOU WILL NEED TO TWEAK THEM.



C4
TO DO SO HOLD THE BASE OF THE CLIP FIRM WITH PADDED PLIERS AND BEND THE CLIP BASE TO BRING THE HEAD OF THE CLIP OUT FURTHER. IF RINGS FIT TOO LOOSE TAKE CLIPS OUT OF RING AND BEND THEM TO OPEN THEM MORE THEN REINSTALL.



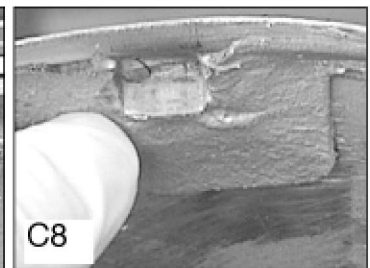
C5
CLIPS SHOULD NOW FIT SNUG AND REACH FURTHER INTO THE BUCKET. SCUFF AREA AROUND CLIPS WITH A COARSE GRIT PAPER OR GRINDING DISK.



C6
YOUR RING MAY WANT TO SEE-SAW ON THE BUCKET. TO ELIMINATE THIS MOVEMENT YOU MUST EMBED THE CLIPS SO THEY CAN NOT MOVE. ALIGN THE RING AND TAPE TO HOLD IN PLACE.



C7
MIX A SMALL AMOUNT OF METAL TO METAL BODY FILLER AND FILL AROUND THE CLIPS. BE SURE TO TAPER THE FILLER AS SHOWN. MIX JUST ENOUGH FILLER TO DO ONE CLIP AT A TIME. DO NOT ALLOW FILLER TO GO OVER THE TOP OF THE CLIPS.



C8
COMPLETE ALL THREE CLIPS AND ALLOW THE FILLER TO CURE COMPLETELY. POP OUT TRIM AND CLEAN UP DIVOTS AS NECESSARY. THESE DIVOTS WILL HOLD THE TRIM IN THE PROPER POSITION AND KEEP THE RING FROM MOVING.