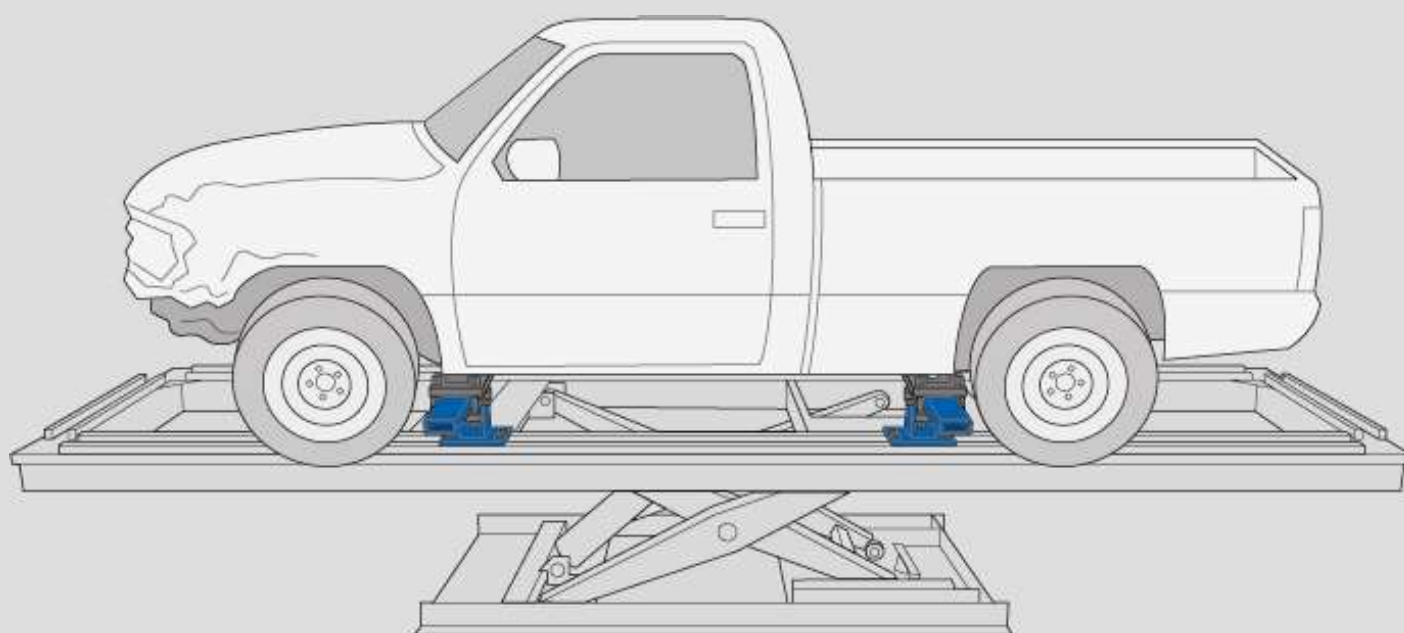


# B73 and B731

## Clamping and Support Systems

### Instruction Manual



(50094, rev 0) 2020-03 EN

**CAR-O-LINER®**

## Foreword

This equipment is used to facilitate high quality repairs to collision-damaged vehicles. All other use of the equipment, or use that is contrary to the instructions in this manual, can cause personal injury and/or equipment damage.

Car-O-Liner Group AB including any company within the Car-O-Liner Group of companies ("Car-O-Liner") can not be held responsible for any claims for loss or damages as a result from incorrect use of this equipment or its use in a manner not intended. Save for product liability claims for loss or damages as a result of personal injury or damage to property to the extent caused by the negligence, gross negligence, breach of contract, or other wrongdoing of Car-O-Liner (as prescribed by the Product Liability Act (1992:18) or similar legislation applicable on other markets), Car-O-Liner shall in no event be liable for any loss or damage to revenues, profits or goodwill or other special, incidental, indirect or consequential damages of any kind.

### Warranty

Car-O-Liner offers a one-year limited guarantee from the date of installation of the equipment at end users premises. This guarantee covers only material defects and assumes normal care and maintenance according to Car-O-Liner specification.

The guarantee assumes that:

- The equipment is correctly installed and inspected in accordance with current local laws and regulations.
- The equipment has not been altered or rebuilt without prior written approval from Car-O-Liner.
- Genuine Car-O-Liner spare parts are used in any repairs and conducted by Car-O-Liner certified technician.
- Operation and maintenance have been carried out according to the instructions in this manual.

All claims on warranty shall be notified through your authorized Car-O-Liner Distributor by use of Car-O-Liner's VisionWeb platform without undue delay and shall verify that the fault has occurred within the guarantee period and that the unit has been used within its operating range as stated in the specifications.

All claims shall include the product type and article number as well as a detailed description of the problem and actions taken trying to solve it.

### Note

This instruction manual provides advice as well as instructions for installation, operation and spare parts.

**IMPORTANT!** Read this manual carefully to become familiar with the proper operation of the equipment. It is recommended that you use your authorized Car-O-Liner Distributor for maintaining, servicing and upgrading your products. Never perform repairs, adjustments or any other work on the products which may result in personal injury and damage to the product.

Your Car-O-Liner Distributor employs factory trained technicians and is focused on offering you the best overall experience with your new Car-O-Liner product. Any revisions or upgrades of the products, as required by Car-O-Liner, shall be performed by your authorized Car-O-Liner Distributor.

The photographs and drawings in this manual are intended only to be illustrative and do not necessarily show the design of the equipment available on the market at any given time. The equipment is intended for use in accordance with current trade practice, applicable laws and safety regulations. The equipment illustrated in the manual may be changed without prior notice.

The contents in this publication can be changed without prior notice.

This publication contains information which is protected by copyright laws. No part of this publication may be reproduced, stored in a system for information retrieval or be transmitted in any form, in any manner, without Car-O-Liner's prior written consent.

### Conformity with directives and standards

The equipment is designed and manufactured by Car-O-Liner, which is an EN-ISO 9001 and 14001 accredited development and manufacturing organisation.

It is required that only Car-O-Liner approved spare parts and accessories are used with the equipment.

# Contents

<b>1 Introduction .....</b>	<b>4</b>
<b>2 Safety .....</b>	<b>5</b>
2.1 Warnings and important notices .....	5
<b>3 Operation .....</b>	<b>6</b>
3.1 B73 and B731 Clamping and Support System – typical setup examples	7
Typical front clamping with B250 .....	7
B260 used as B250 .....	9
Typical rear clamping with B260 .....	10
B34 Bench Mountings .....	11
3.2 Vehicle Setup Procedure for the Clamping and Support System .....	12
3.3 Improvement of B34BR Bench Mounting .....	13
3.4 Reinforcement Plate for B34BR .....	13
3.5 Improvement of B250/B260 attachment .....	14
3.6 How to use B260 .....	16
3.7 Support for high anchoring with Torque Bar E175 .....	18
3.8 Support Spacer conversion examples for B731 users .....	19
3.9 Clamping Jaw Conversion examples for B731 users .....	20
<b>4 Spare parts .....</b>	<b>23</b>
4.1 B73 Clamping and Support System .....	23
4.2 B731 Clamping and Support System .....	25
4.3 B250 Complete .....	27
4.4 B260 Complete .....	28

# 1 Introduction

The B73 and B731 Clamping and Support Systems are intended for clamping of full frame vehicles, pick-up trucks, sports utilities and vans to all Car-O-Liner bench repair systems except the Speed bench repair system.

**B731:** Configuration of the kit is mainly based on the vehicle population of North America.

**B73:** Configuration of the kit is mainly based on the vehicle population of the rest of the world.

All parts and spare parts of the B73 and B731 Clamping and Support Systems are described in section 4 Spare Parts.

Vehicle Setup is described in section 3.2 Vehicle Setup Procedure for the Clamping and Support System.

## 2 Safety

### 2.1 Warnings and important notices

The following types of safety signs are used on the equipment and in Car-O-Liner's instruction manuals:

**Prohibited**

Prohibits behaviour that can cause injury.

**Command**

Prescribes a specific responsibility or action.

**Warning**

Warns of risks for personal injuries and or damages to equipment.

The following warnings and important notices are used in the instruction manual:



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**WARNING!** Before alignment work, ensure that all clamps and bench mountings are fully tightened. Risk of material damage and personal injuries.

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**IMPORTANT!** When an air wrench is used to tighten the bench mountings to the bench, ensure that it is set to a maximum of 200 Nm to avoid damage to the equipment.

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**IMPORTANT!** All bolts attached to B250/B260 must be tightened by hand, max torque 150 Nm.

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**NOTE!** For information regarding Safety, Installation and Operation of the BenchRack, Mark6 and Quick 42, *see separate instruction manuals.*

## 3 Operation

Section 3.2 Vehicle Setup Procedure for the Clamping and Support System describes the setup procedure for the B73/B731 Clamping and Support system applicable for BenchRack.

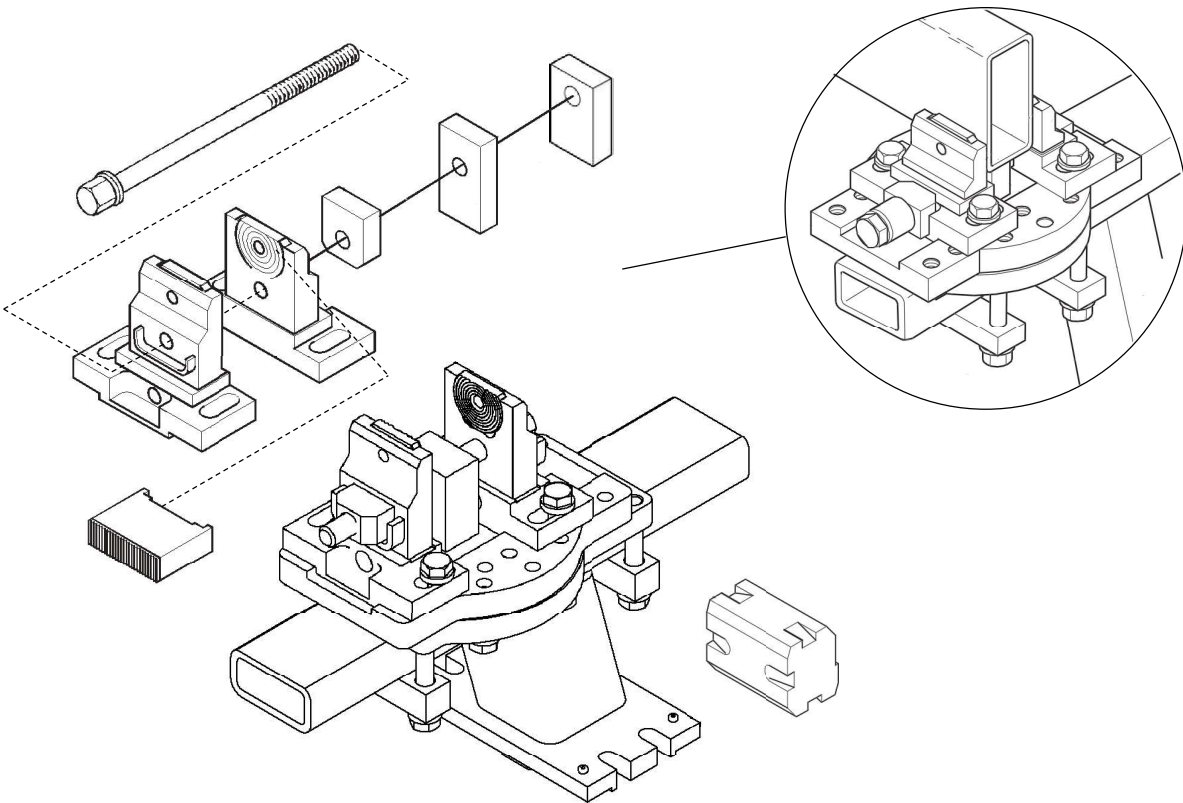
For Mark6 and Quick42 set up, *see separate instruction manuals*.

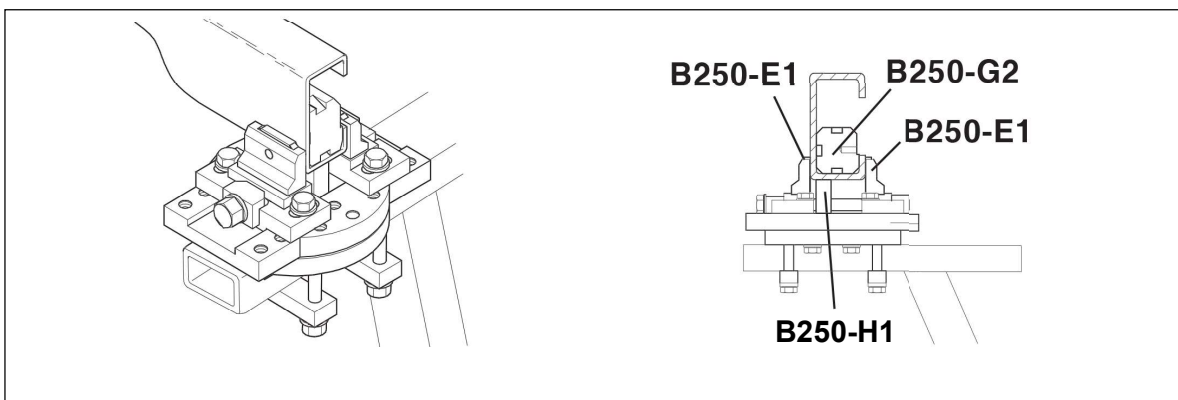
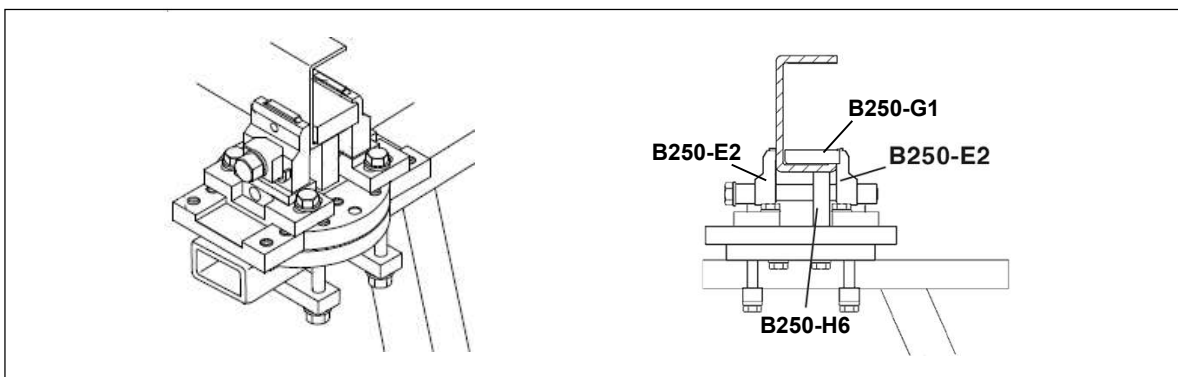
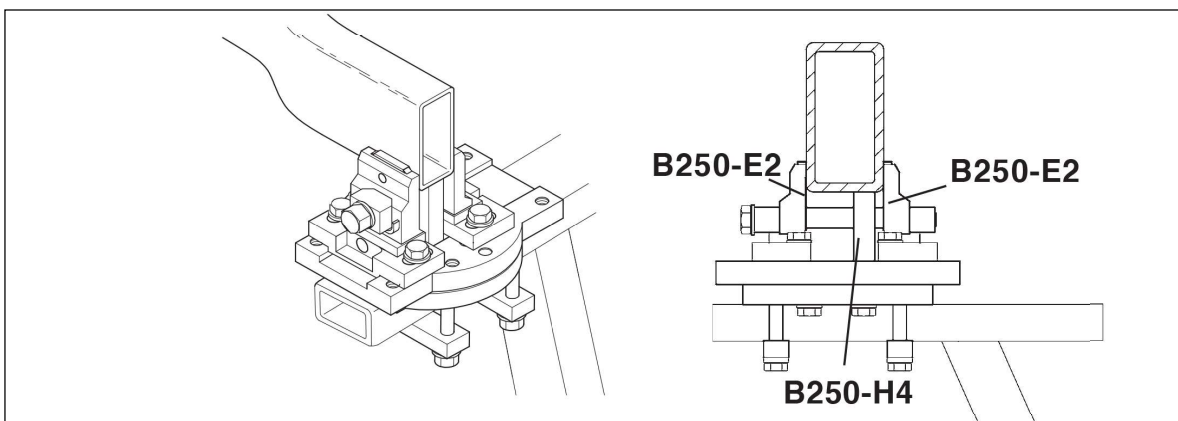
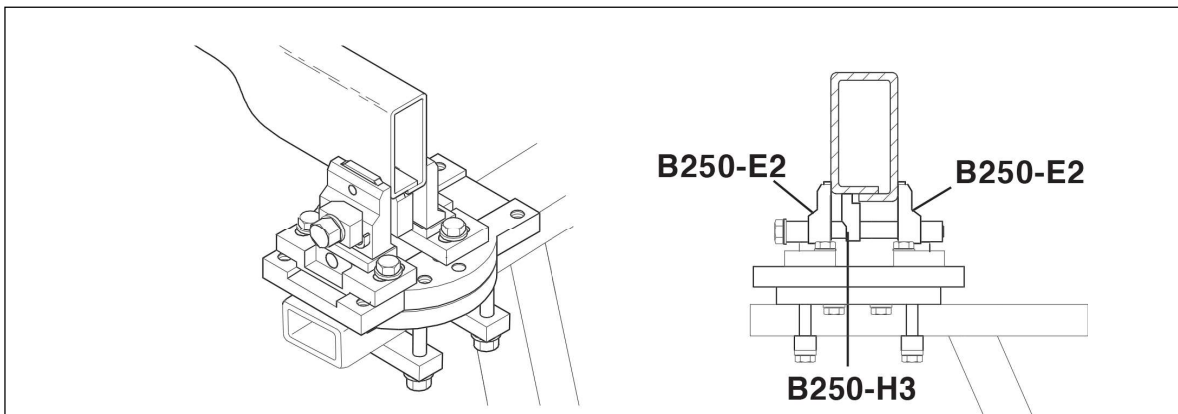
For information regarding Safety, Installation and Operation of the BenchRack, Mark6 and Quick 42, *see separate instruction manuals*.

### 3.1 B73 and B731 Clamping and Support System – typical setup examples

The general functions of B73 and B731 Clamping and Support systems are described in the pictures below.

Typical front clamping with B250

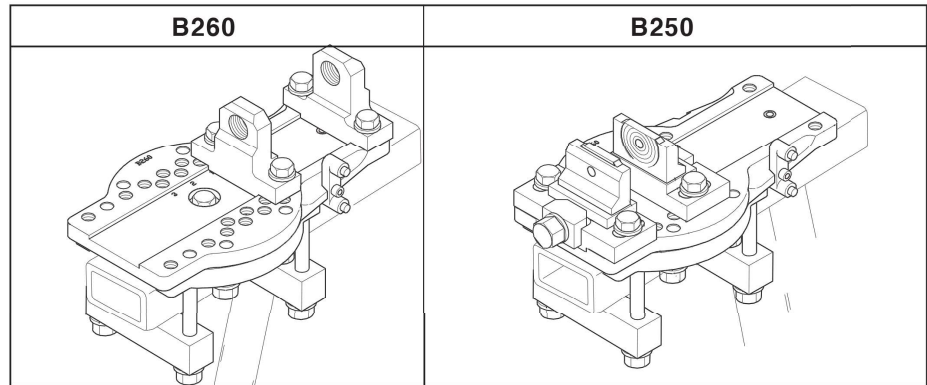






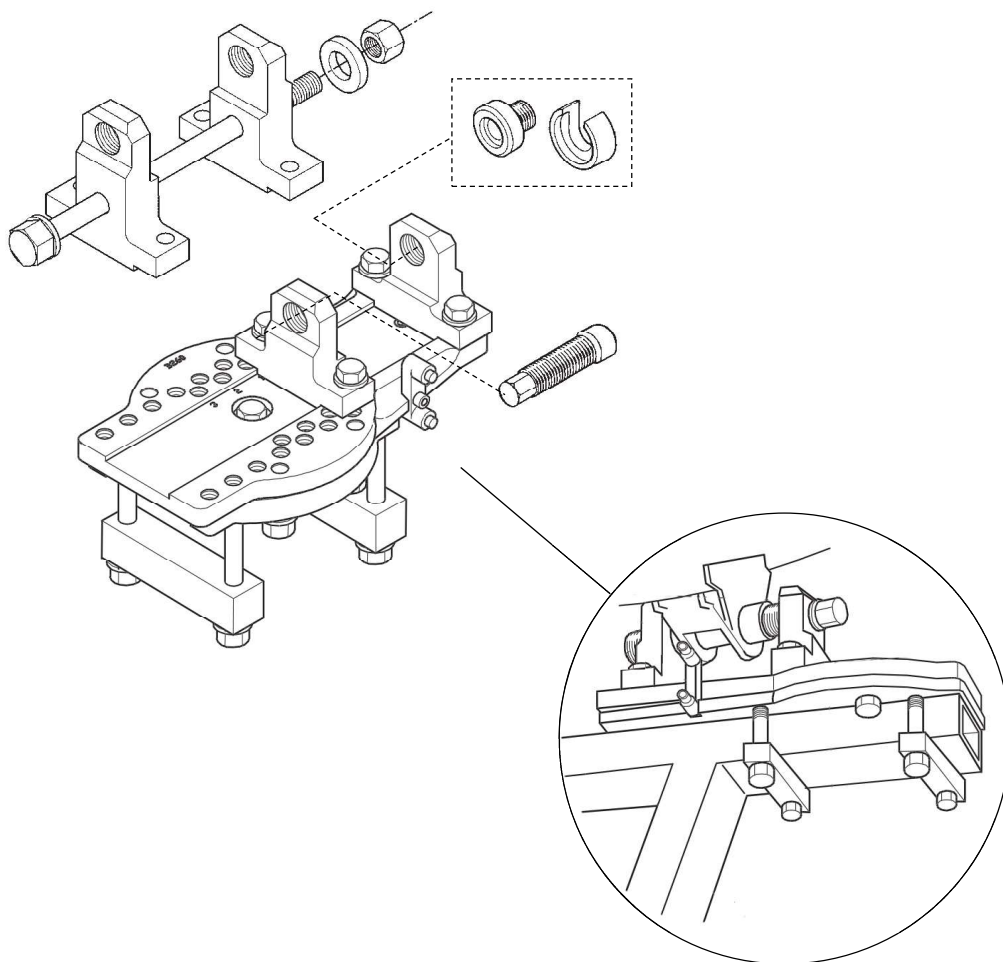
**B260 used as B250**

Some setups need 4 x B250-E1/E2 clamping. Use B260 as B250 base plate, *see illustration below.*



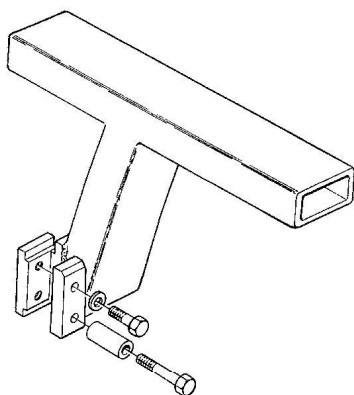
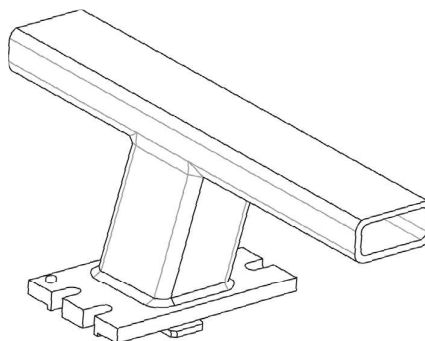
**Note!** B250 is mainly used for front clamping.

## Typical rear clamping with B260



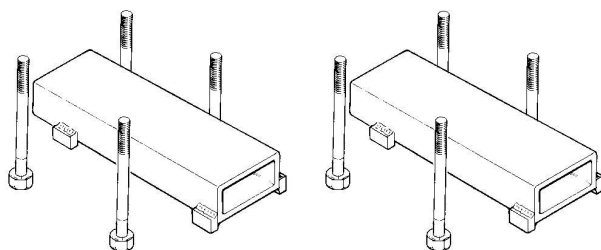
**Note!** B260 is mainly used for rear clamping to the leaf spring bracket.

## B34 Bench Mountings

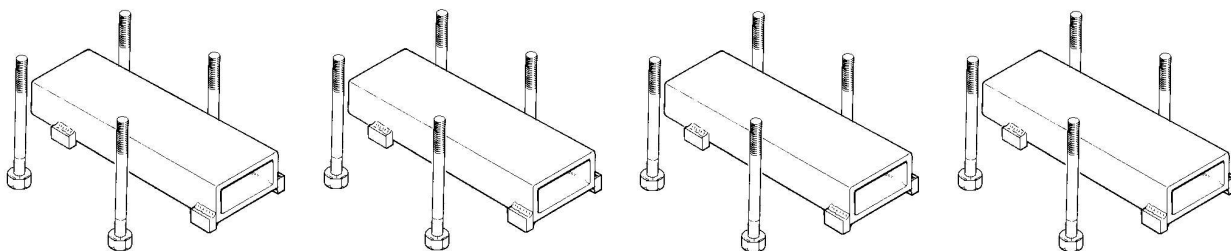
**B34MK****B34BR**

**NOTE!** Bench Mountings are different from standard Mark 6 and Bench Rack/Quick42. Bench Mountings are not included in the B73 or B731 kits.

**B73 kit:** B213 x 2 is included



**B731 kit:** B213 is not included. B62 kit, part no. 49956, (B213 x 4) is recommended.



### 3.2 Vehicle Setup Procedure for the Clamping and Support System

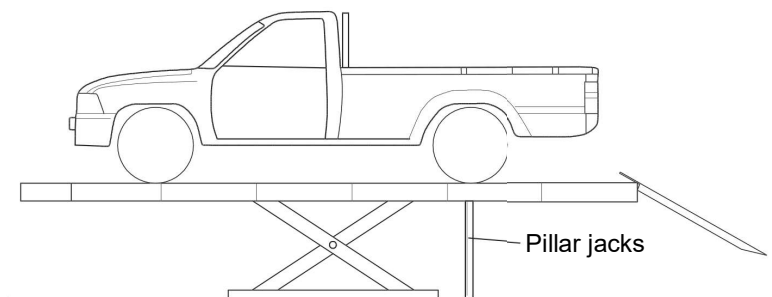


**NOTE!** Vehicle Setup Procedure described below is applicable for BenchRack.  
For Mark6 and Quick42 set up, *see separate instruction manuals.*

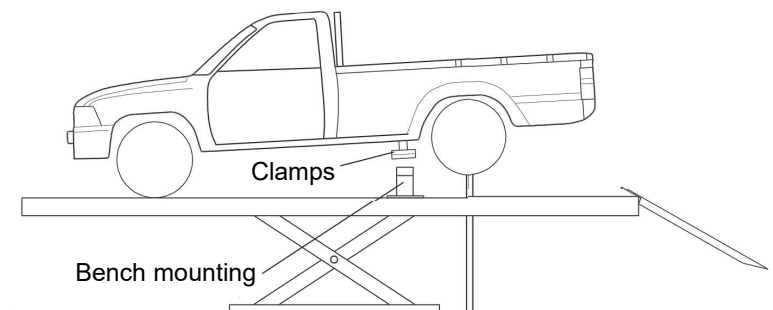
#### **BenchRack**

Front axle member and rear axle are recommended lifting points.

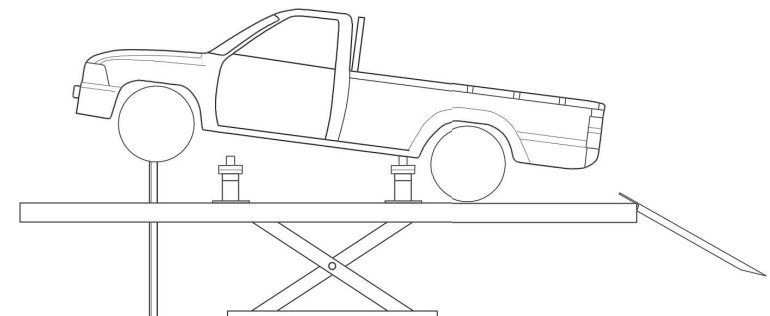
1. *Position the pillar jacks under the lifting points. Tighten the pillar jacks to the bench.*



2. *Lower the lift carefully to raise the vehicle from the ramps to allow the bench mountings and rear chassis clamps to be fitted.*



3. *Remove the side ramps from under the rear wheels. Raise the bench carefully so that the chassis clamps are correctly positioned.*

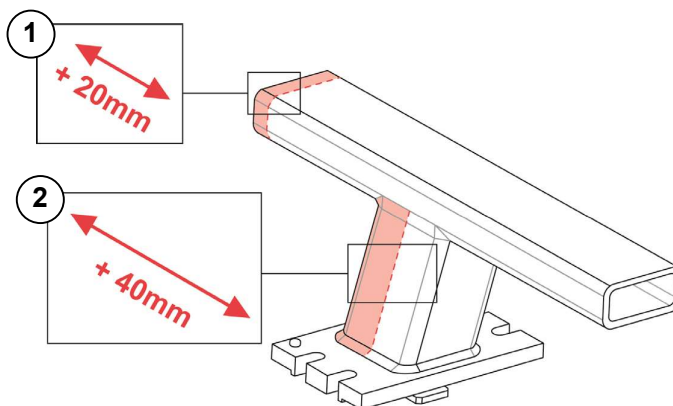


4. *Remove the pillar jacks from the rear. Position them at the front lifting points and repeat the procedure.*

### 3.3 Improvement of B34BR Bench Mounting

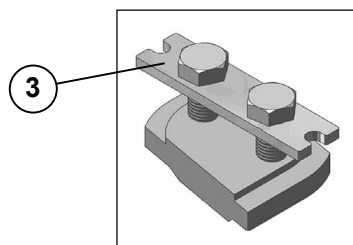
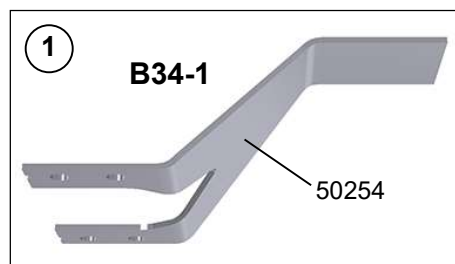
The B34 Bench Mounting are extended inwards by 20 mm [1].

The vertical center pillar is widened 40 mm for increased stiffness [2].



### 3.4 Reinforcement Plate for B34BR

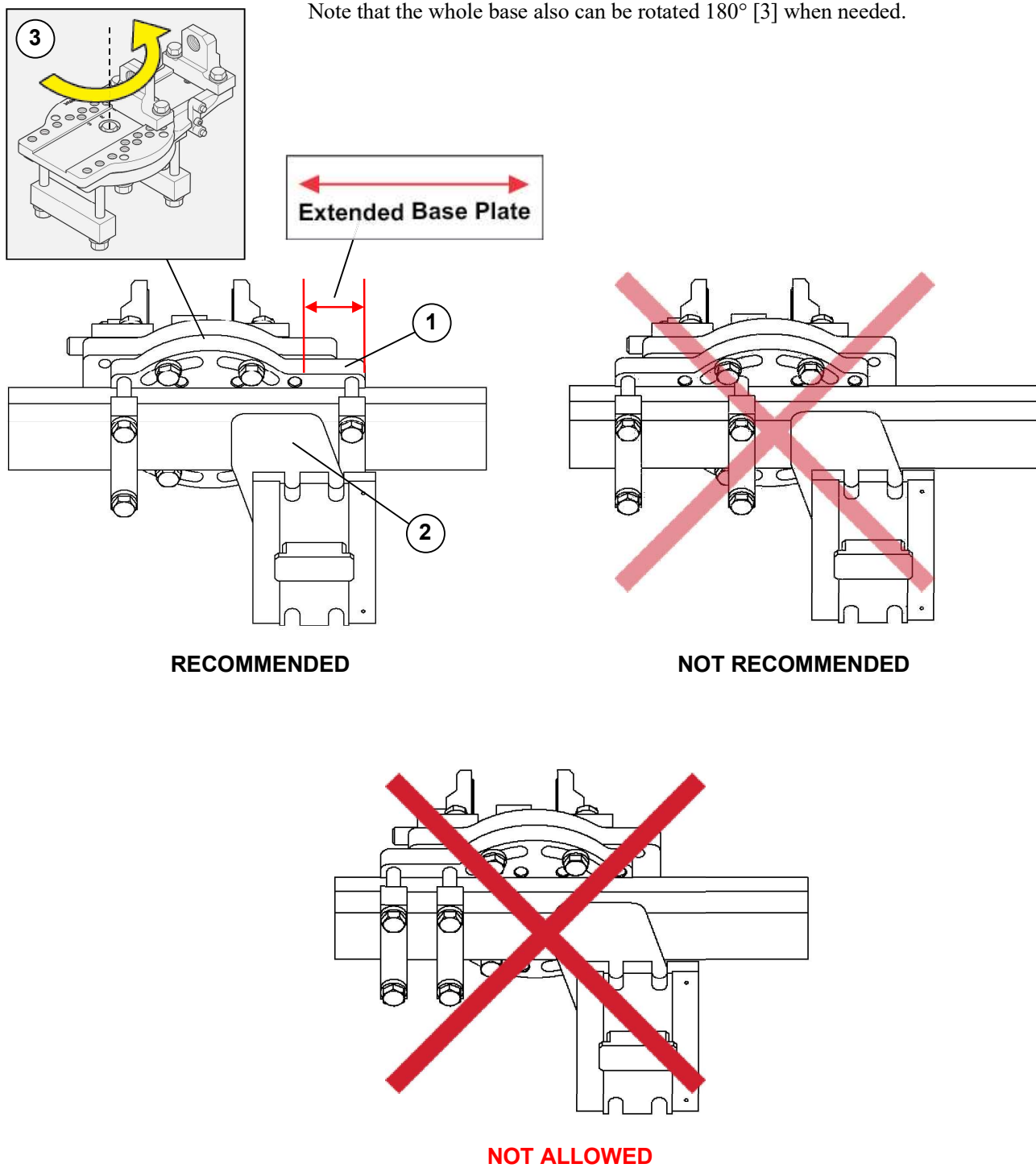
The Reinforcement Plate B34-1 (part no 50254) [1] shall always be used on wide anchoring with B250/B260 when the outer bracket [2] is wider than the bend of the reinforcement plate, *see illustration below*.



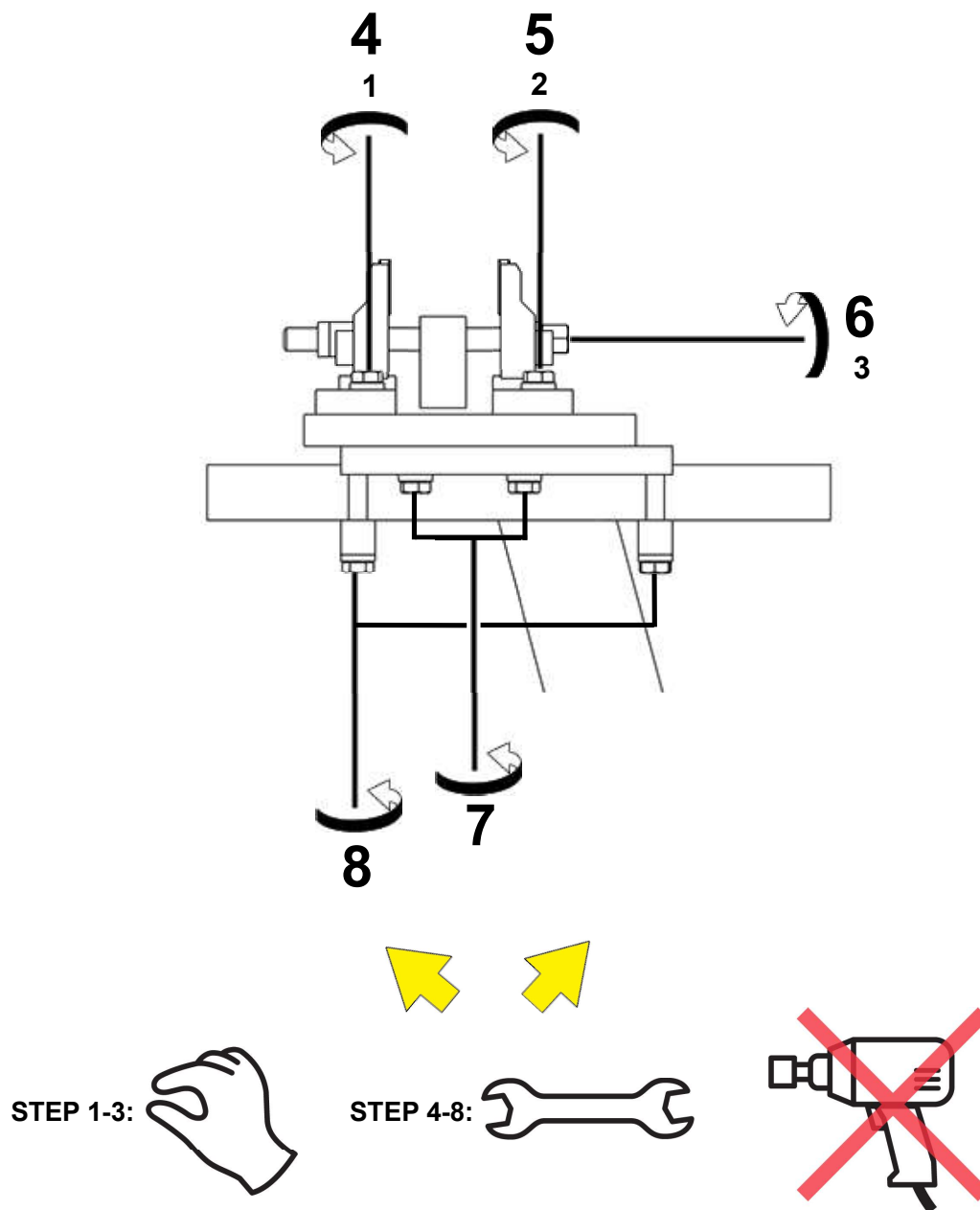
Remove washers [3] from the standard cam locks and from the bracket [4] before tightening the reinforcement plate to the bench mounting.

### 3.5 Improvement of B250/B260 attachment

The new extended B250/B260 baseplate [1] makes it possible to get a strong and wide clamping around the wider vertical center pillar [2].  
Note that the whole base also can be rotated 180° [3] when needed.

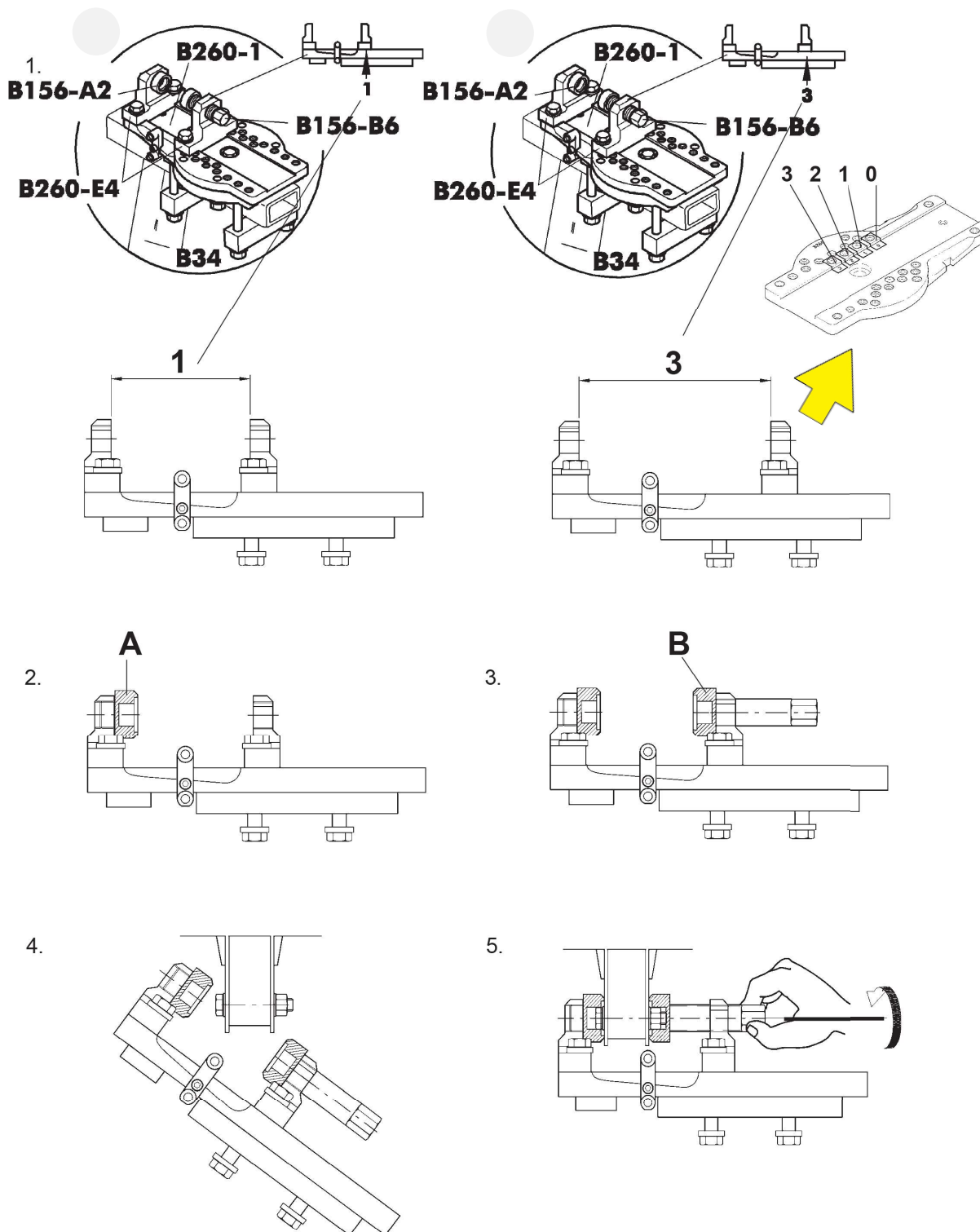


Figures 1-8 show tightening order for B250:



**NOTE!** Step 1-3, tighten loosely. Step 4-8, tighten to max torque 150 Nm.  
All bolts must be tightened by hand.

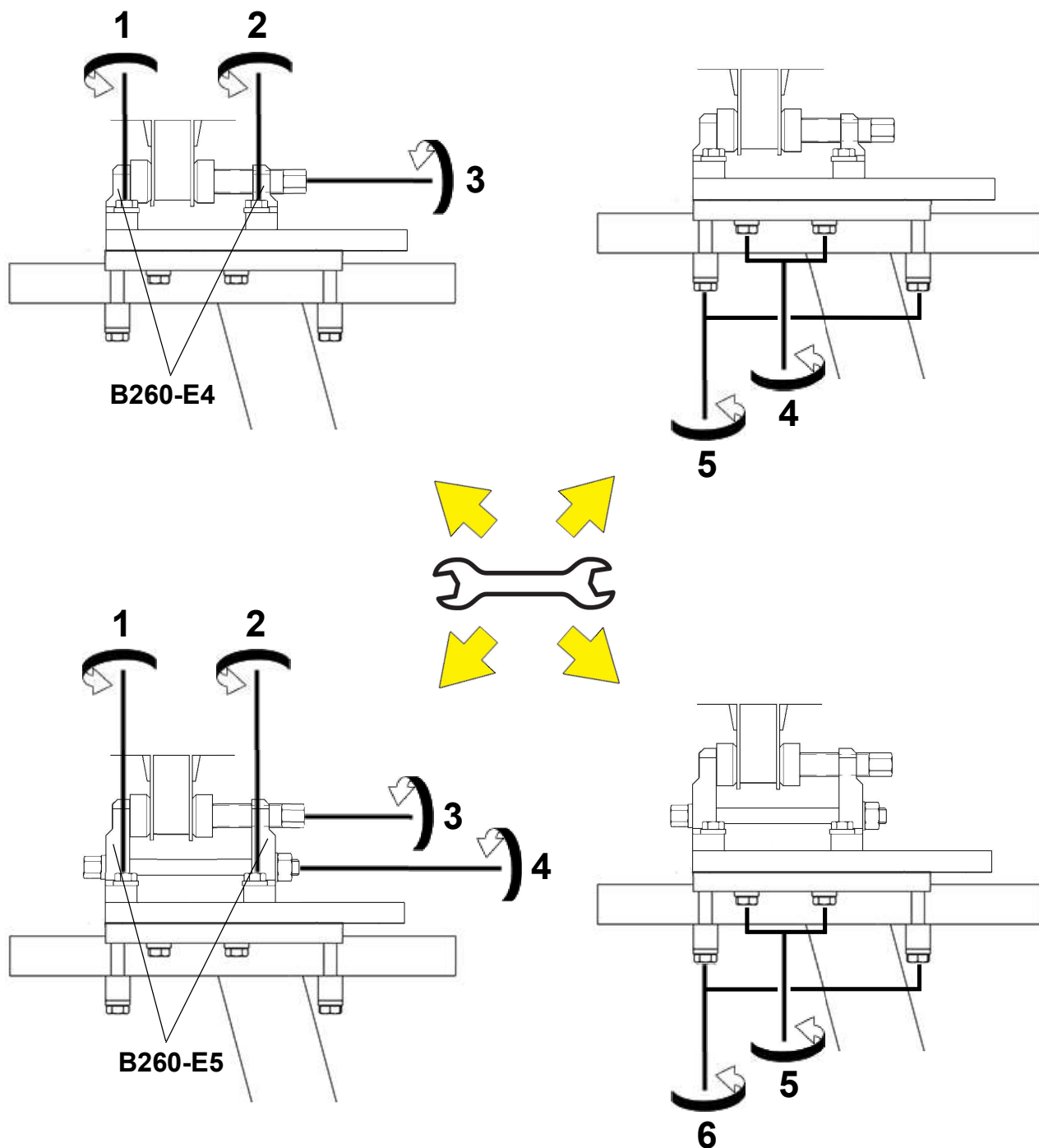
### 3.6 How to use B260



**NOTE!** Clamp positions 0, 1, 2, 3 are shown on the datasheet.



Figures 1-6 show tightening order for B260:

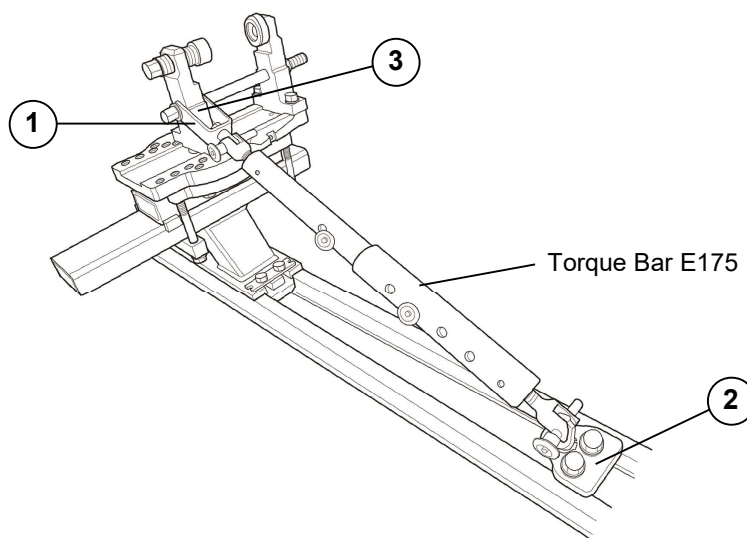


**Note!** All bolts must be tightened by hand, max torque 150 Nm.

### 3.7 Support for high anchoring with Torque Bar E175

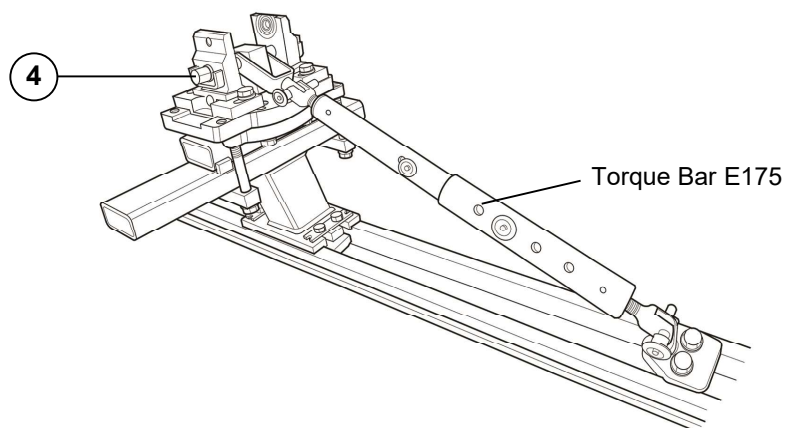
In the B731 kit 2 pcs E175, E141 [1] and E130 [2] are included.  
For best recommended use of the pulling support, *see illustrations below.*

#### For B260 setup



*Place the Clamp Support around one of the clamps [3] when supporting the high clamp B260 setup.*

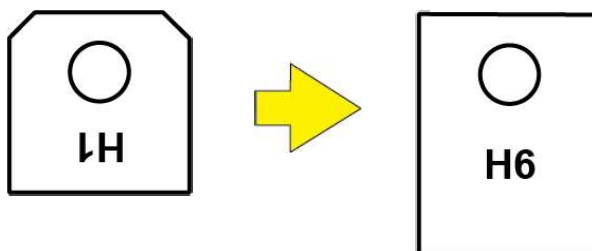
#### For B250 setup



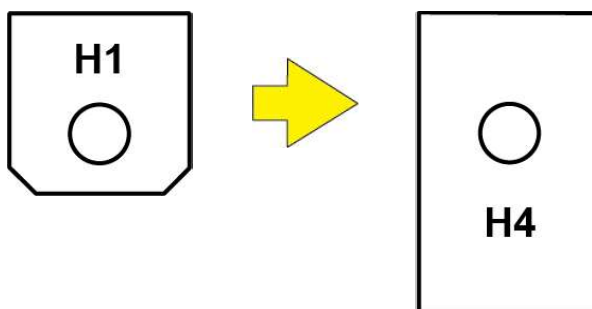
*Place the Clamp Support on the bolt [4] when supporting the high clamp B250 setup.*

### 3.8 Support Spacer conversion examples for B731 users

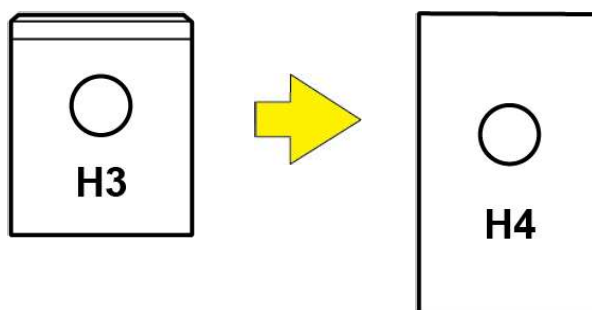
Conversion examples when data sheet are showing B250-H1 and H3 Support Spacers.



H1 mounted upside down in the E2 Clamp are replaced by H6.



B250-H1 is replaced by B250-H4.

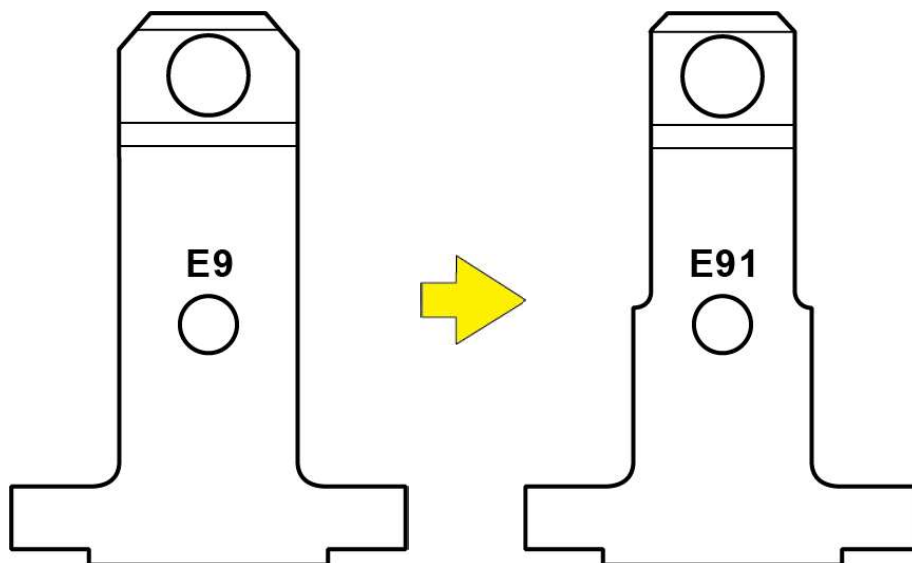


B250-H3 is replaced by B250-H4.



**Note!** The difference in clamping height will only affect Car-O-Mech users.

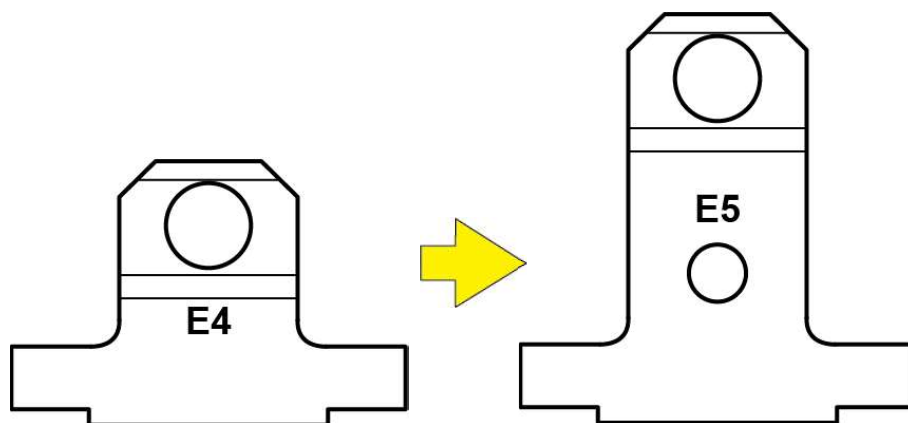
### 3.9 Clamping Jaw Conversion examples for B731 users



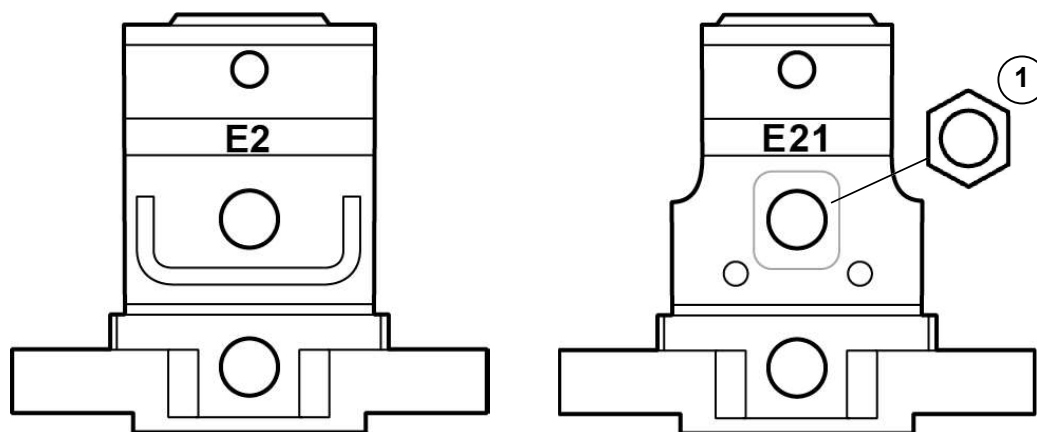
B260-E9 is replaced by B260-E91



**Note!** B260-E91 can always replace B260-E9, but not the opposite.

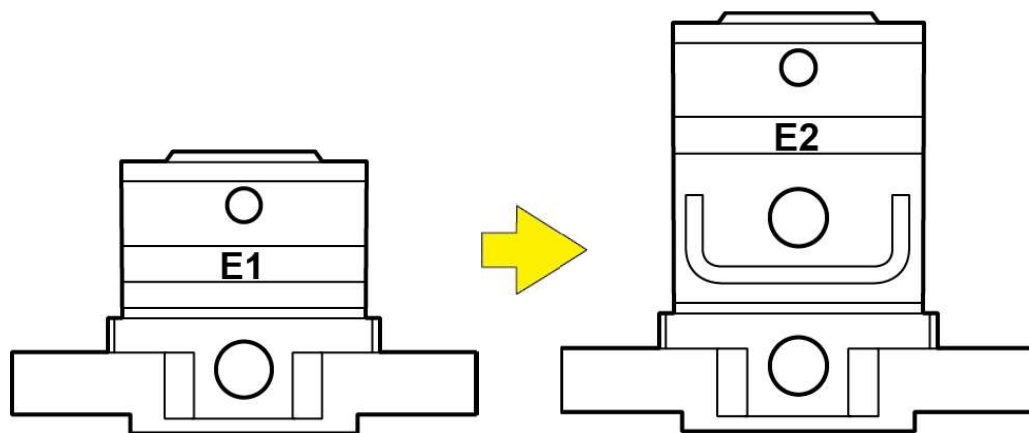


B260-E4 is replaced by B260-E5.



B250-E2 has a new partner:

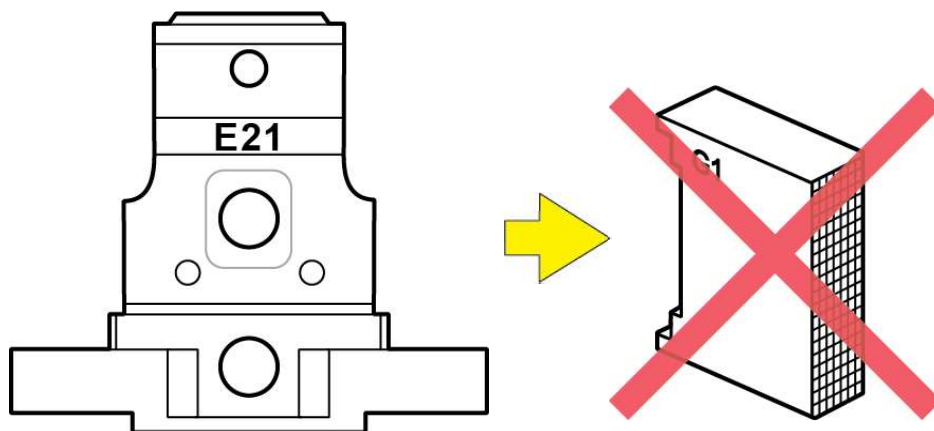
B250-E21



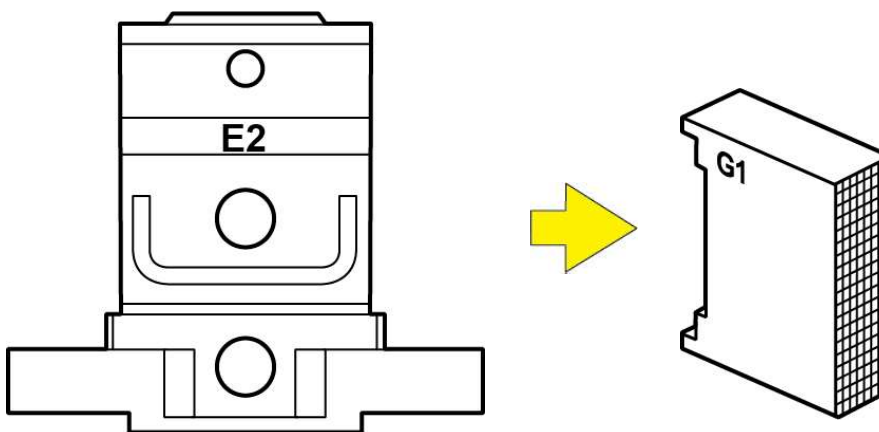
B250-E1 is replaced by B250-E2 and B250-E21.



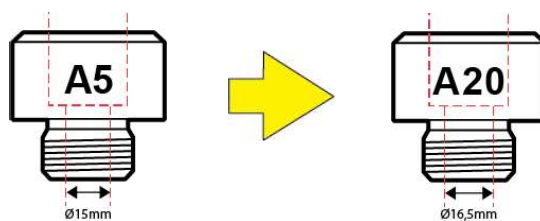
**Note!** B250-E21 can be used as B250-E2. It is made for the tight clamping. For really tight clamping, use the standard M20 nut [1] in the recessed pocket.



B250-E21 can not be used together with B250-G1.



Please use B250-E2 together with B250-G1.



B156-A5 is replaced by B156-A20.



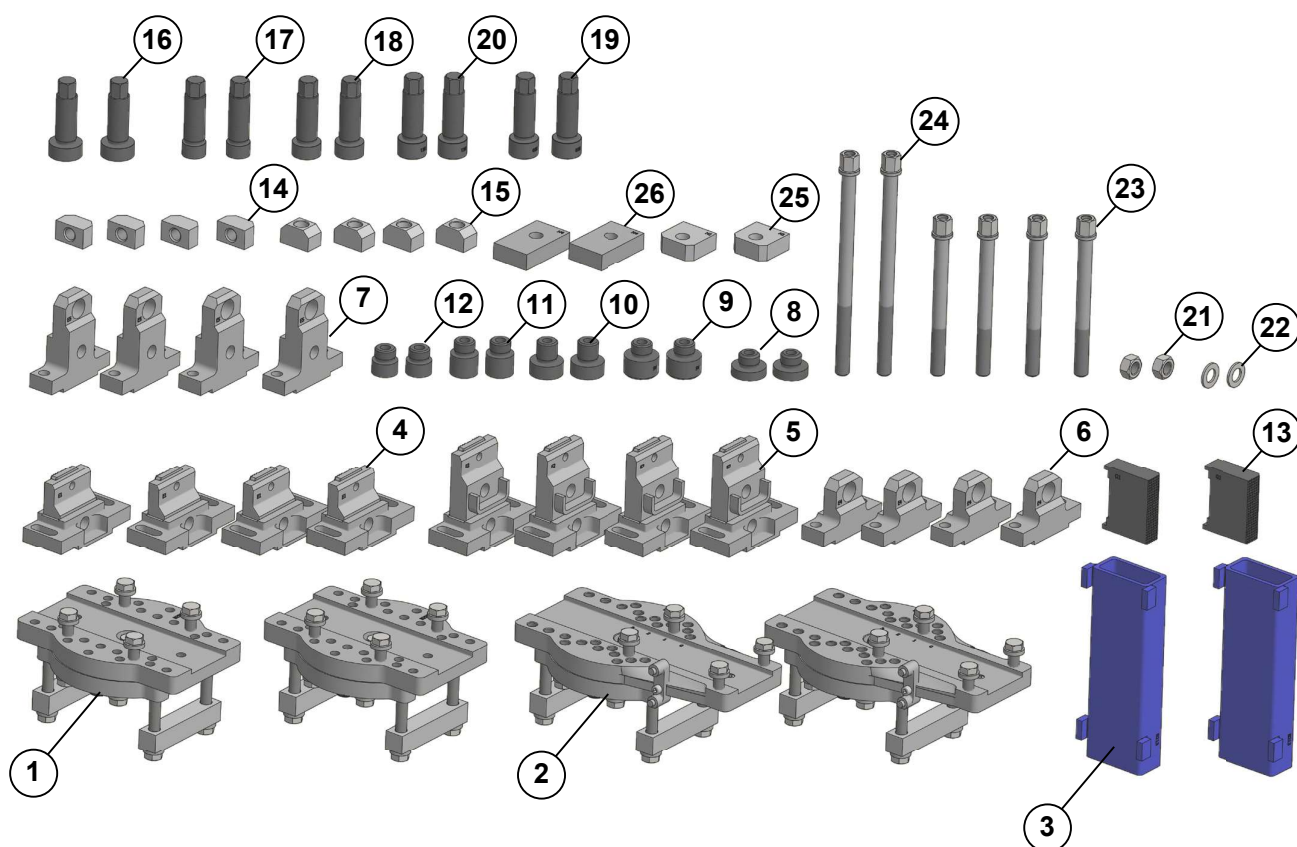
**Note!** A20 can always replace A5, but not the opposite.

## 4 Spare parts

The spare parts required for maintaining the Clamping and Support Systems are listed in this chapter.

**Note!** Use only genuine Car-O-Liner spare parts in any repairs.

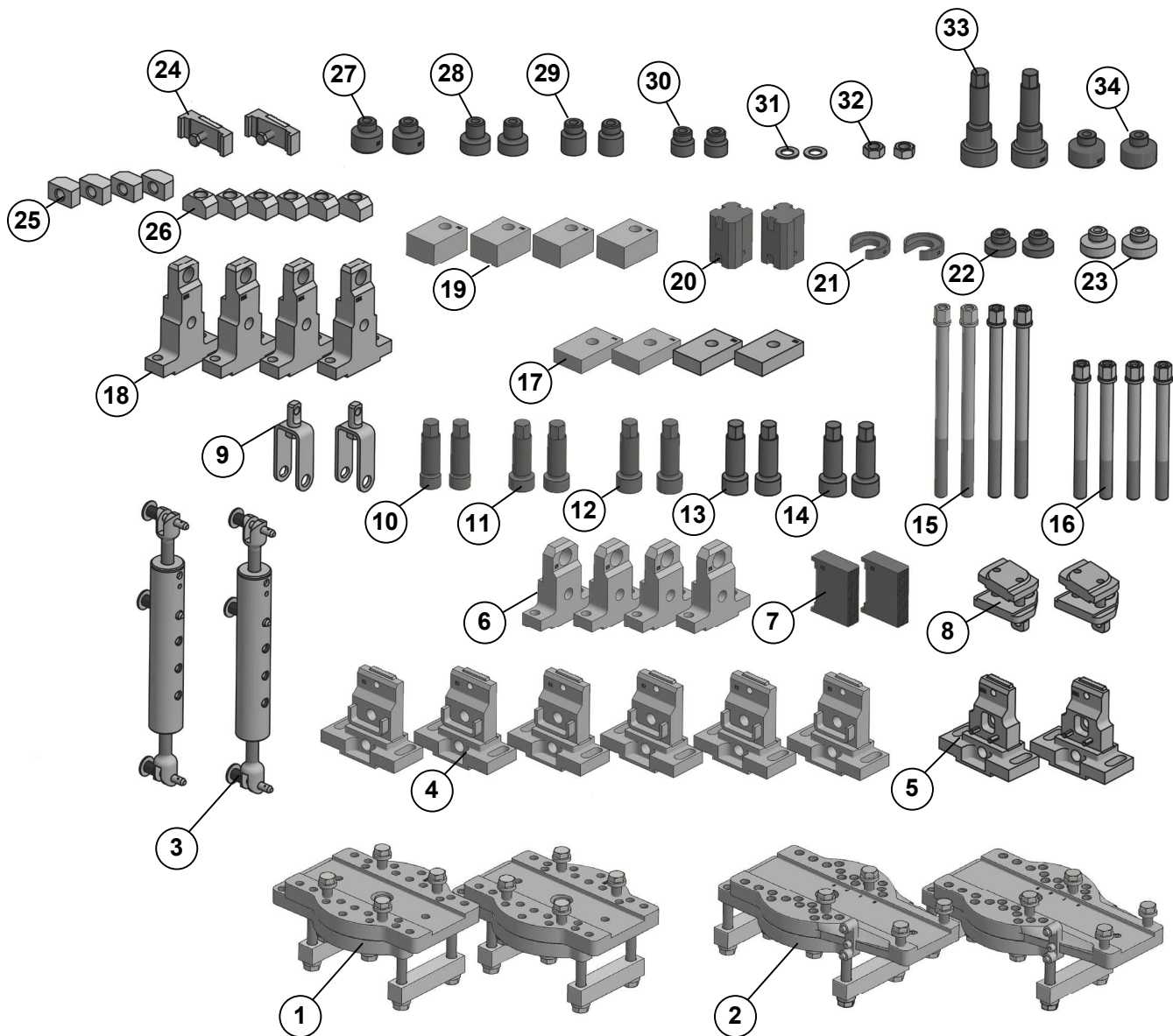
### 4.1 B73 Clamping and Support System



Position	Quantity	Part No.	Object
1	2	30722	Clamp B250
2	2	30724	Clamp B260
3	2	30668	Distance 50mm B213
4	4	30718	Clamping jaw B250-E1
5	4	30717	Clamping jaw B250-E2
6	4	30715	Clamping jaw B250-E4
7	4	30716	Clamping jaw B250-E5
8	2	30651	Adapter B156-A2
9	2	30657	Adapter A5
10	2	30658	Adapter A6
11	2	30662	Threaded bushing A10
12	2	32258	Adapter A14
13	2	30706	Support B250-G1
14	4	30696	Nut
15	4	30701	Support
16	2	30649	Threaded bushing B156-B3
17	2	30656	Threaded bushing B5
18	2	30660	Threaded bushing B6
19	2	30664	Threaded bushing B10
20	2	30665	Threaded bushing B11
21	2	31540	Nut M6M M20 Class-8 FZB
22	2	31509	Washer BRB 21x37x3 (M20) FZB
23	4	30719	Screw M20x220
24	2	30720	Screw M20x320
25	2	30695	Support B250-H1
26	2	30714	Support B250-H4

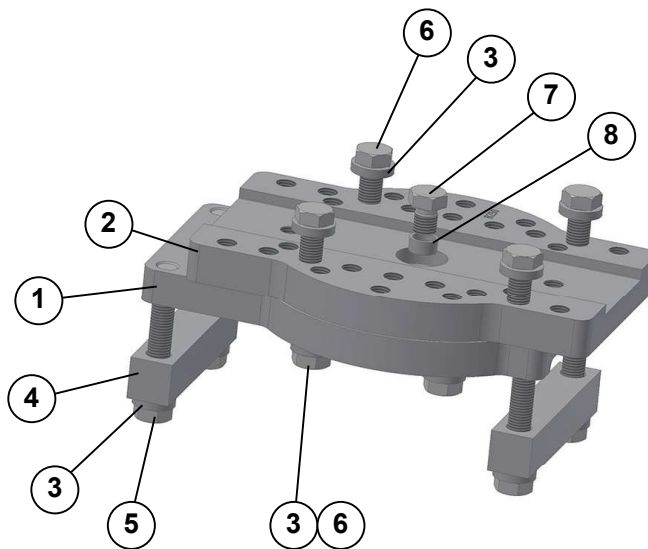


## 4.2 B731 Clamping and Support System



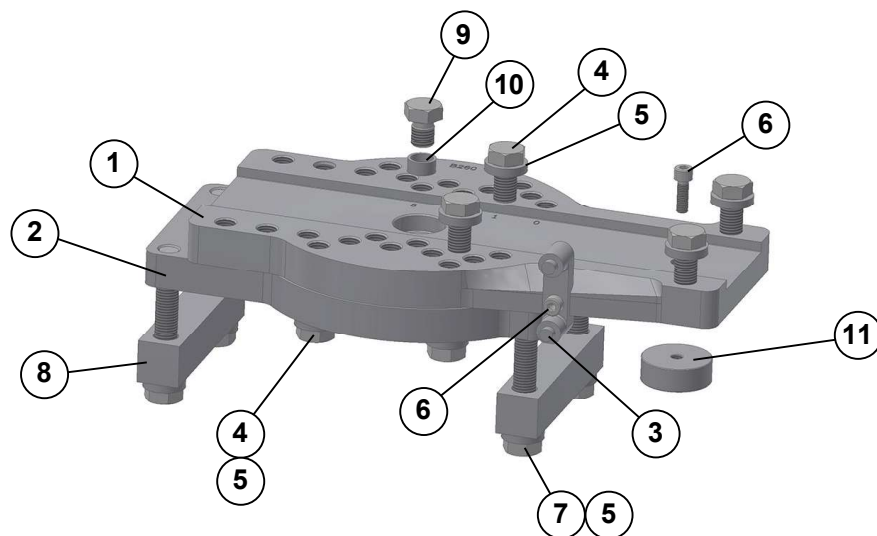
Position	Quantity	Part No.	Object
1	2	30722	Clamp B250
2	2	30724	Clamp B260
3	2	35390	Torque bar E175
4	6	30717	Clamping jaw B250-E2
5	2	49961	Clamping jaw B250-E21
6	4	30716	Clamping jaw B250-E5
7	2	30706	Support B250-G1
8	2	35395	Support anchoring cpl E130
9	2	36448	Clamp support E141
10	2	30656	Threaded bushing B5
11	2	30660	Threaded bushing B6
12	2	30665	Threaded bushing B11
13	2	36445	Threaded bushing B15
14	2	36444	Threaded bushing B14
15	4	30720	Screw M20x320
16	4	30719	Screw M20x220
17	4	30714	Support B250-H4
18	4	49962	Clamping jaw E91
19	4	33642	Support B250-H6
20	2	30707	Support B250-G2
21	2	30653	Washer B156-C1
22	2	30651	Adapter B156-A2
23	2	30652	Adapter B156-A3
24	2	36440	Wedge B250-G3
25	4	30696	Nut
26	6	30701	Support
27	2	50058	Adapter B156-A20
28	2	30658	Adapter B156-A6
29	2	30662	Adapter B156-A10
30	2	32258	Adapter B156-A14
31	2	31509	Washer DIN 125-2 - B 21 FZB
32	2	31540	DIN 934 - M20x2.5 cl.8 FZB
33	2	49039	Threaded bushing B156-B17
34	2	49038	Adapter B156-A18

### 4.3 B250 Complete



Position	Quantity	Part No.	Object
1	1	49845	Bottom plate
2	1	30710	Prism B250
3	12	31497	Washer TBRUB 17x30x6 fzb
4	2	30704	Mounting plate
5	3	31367	Screw M6S 16x100 8.8 FZB
6	8	31391	Screw M6S 16x50 10.9 Geomet
7	1	31387	Screw M6S 16x20 8.8 FZB
8	1	30711	Socket

#### 4.4 B260 Complete



Position	Quantity	Part No.	Object
1	1	30700	Prism B260
2	1	49845	Bottom plate
3	1	30705	Measuring adapter B260
4	8	31391	Screw M6S 16x50 10.9 Geomet
5	12	31497	Washer TBRUB 17x30x6 FZB
6	2	31420	Screw MC6S M8x25 8.8 FZB
7	4	31367	Screw M6S 16x100 8.8 FZB
8	2	30704	Mounting plate
9	1	31387	Screw M6S 16x20 8.8 FZB
10	1	30711	Socket
11	1	30703	Washer B260

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