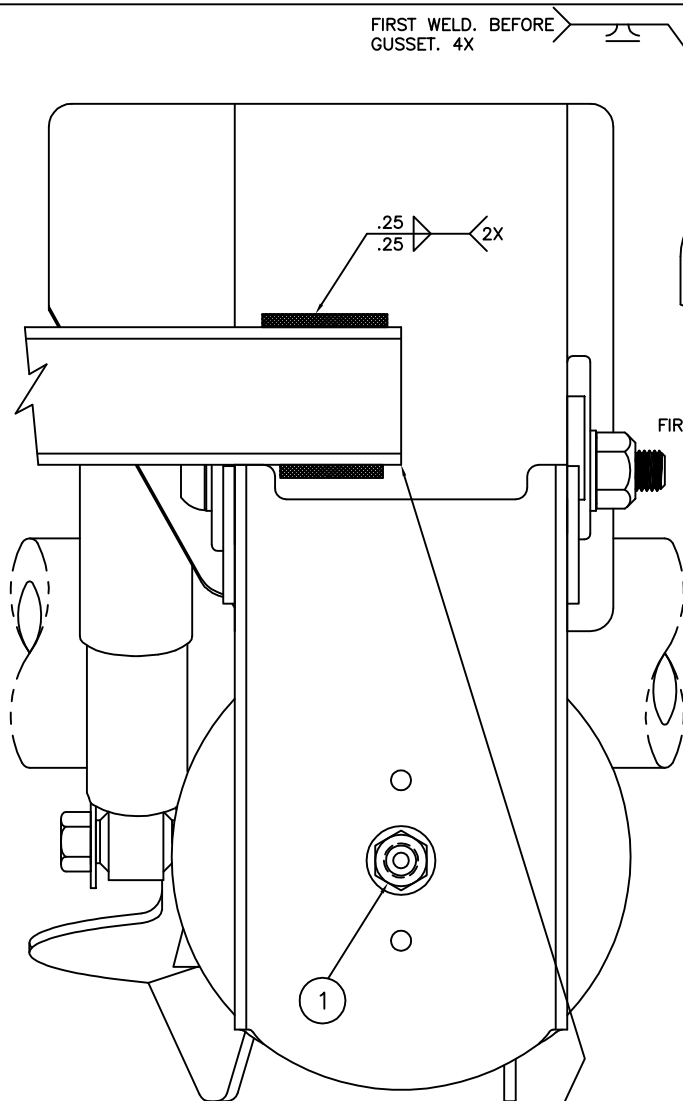


FIRST WELD. BEFORE GUSSET. 4X



ADD ITEM 6 AFTER FIRST WELD AND WELD AS SHOWN. 4X

3.625

(5.00)

(10.00)

**IMPORTANT!**

IF CROSS CHANNEL IS REQUIRED INSTALL HANGER SUPPORT BRACKET (ITEM 5) FIRST, REST CHANNEL ON TOP OF BRACKET SURFACE AND WELD AS SHOWN.

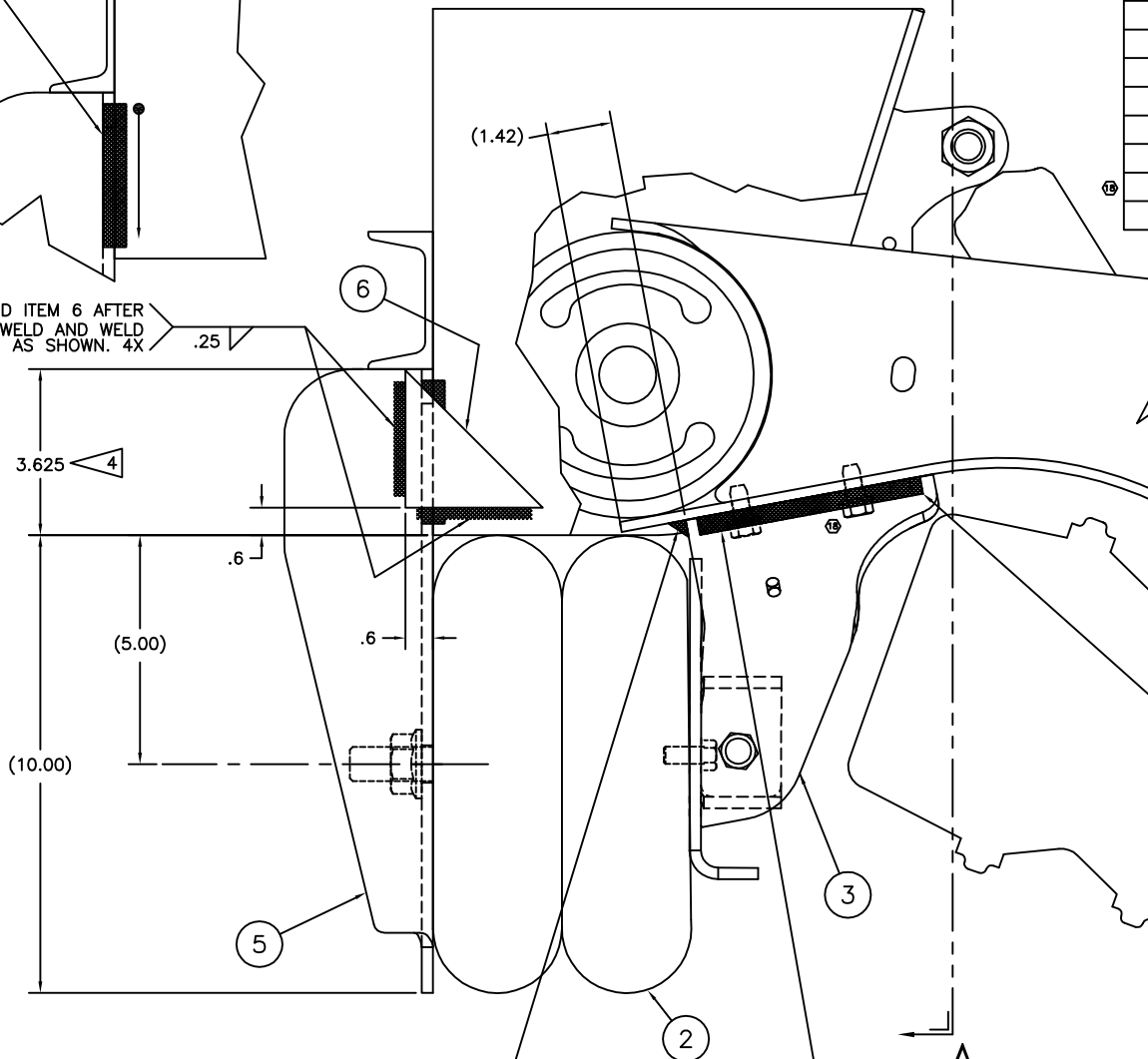
IF RETROFIT, TAKE OFF CHANNEL AND RELOCATE.

ASSEMBLY PROCEDURE:

- 1 LOCATE LIFT BRACKETS (ITEM 3) WITH SELF-TAPPING SCREWS.
- 2 INSTALL BEAM PLATE ASSEMBLIES (ITEM 4) TO LIMIT DISTORTION OF LIFT BRACKETS (ITEM 3) DURING WELDING.
3. WELD TO BEAMS AS SHOWN.
- 4 LOCATE TOP OF HANGER SUPPORT ASSEMBLY (ITEM 5) 3 5/8 FROM BOTTOM OF HANGERS AND WELD AS SHOWN.
- 5 LOCATE AND WELD "C" CHANNEL AS SHOWN IF REQUIRED.
- 6 IF PARKING BRAKES ARE REQUIRED, INSTALL AT THIS TIME.
7. INSTALL AIR SPRINGS (ITEM 2).

TORQUE SPECIFICATIONS		
DESCRIPTION	SIZE	TORQUE(FT-LB)
AIR SPRING BOLTS	3/8-16	25-35
AIR SPRING NUT	3/4-16	45-55
BEAM PLATE ASSEMBLY BOLTS	1/2-13	55-75
BRAKE CHAMBER MTG. NUTS	5/8-11	100-110
SELF TAPPING SCREWS	3/8	160-180 IN-LB

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AIR SPRING NOT SHOWN FOR CLARITY

HIDDEN WELD SHOWN IN THIS VIEW FOR CLARITY

ITEM 5 TO BE FLUSH WITH HANGER SIDES WITHIN 1/16

PART NUMBER	REV
UBL-002	18

**H. HENDRICKSON**

TRAILER COMMERCIAL VEHICLE SYSTEMS  
2070 INDUSTRIAL PLACE SE., CANTON, OH 44707-2800 U.S.A.

ITEM	PART NO.	DESCRIPTION	QTY.
1	A-24614	LIFT ASSEMBLY BOLT KIT	1
2	C-23114	AIR SPRING	2
3	C-28537C	LIFT BRACKET	2
4	B-27945	BEAM PLATE ASS'Y	2
5	D-24658C	HANGER SUPPORT, LIFT	2
6	B-2901-37	.25 GUSSET	4
7	*A-26828	IDENTIFICATION TAG	1
8	*L719	UBL INSTALLATION INSTRUCTIONS	1
9	**DWG D-24657	UBL-002	1
10	*A-21066	RIVET, DRIVE	1

\* NOT SHOWN  
\*\* DWG PART NUMBER REVISION MUST MATCH REVISION OF DOCUMENT.

NOTES:

1. 12 RIDE HEIGHT SHOWN, INSTALLATION IS SAME FOR ALL RIDE HEIGHTS.
2. WEIGHT: 59.01 LB (1) INCLUDES 1.16 LB FOR WELD
3. IF GAP EXISTS BETWEEN LIFT BRACKET (ITEM 3) AND BEAM PLATE ASS'Y (ITEM 4), USE A C-CLAMP TO COMPRESS LEGS OF LIFT BRACKET TO ALLOW BEAM PLATE ASSEMBLY TO FIT.
4. WELD:  
28.5 VOLTS, 400 IPM, 275-300 AMPS, 35 CFH (GAS FLOW), .045 WIRE  
FILL ALL CRATERS AT END OF WELDS.  
WELD DIRECTION:  
STOP START
5. AAL 30K REQUIRES A CROSSOVER AIR CONTROL KIT.

**WARNING!**

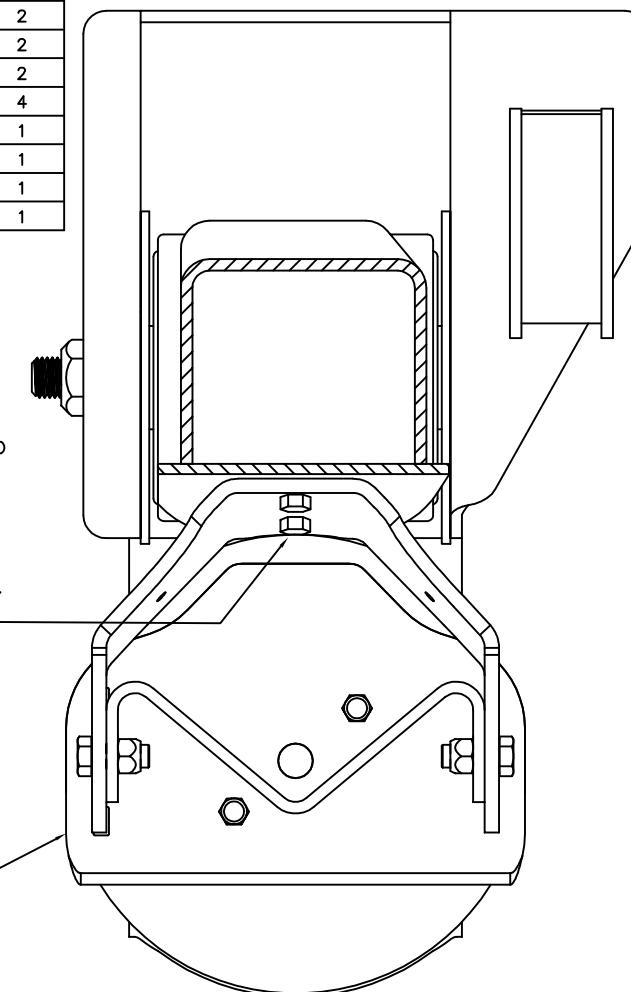
SELF TAPPING SCREWS ARE FOR LOCATION ONLY. LIFT BRACKET (ITEM 3) MUST BE WELDED AS SHOWN.

REAR SELF-TAPPING SCREW MAY NEED TO BE REMOVED AFTER WELDING OPERATION WHEN LONG STROKE BRAKE CHAMBERS ARE USED.

**IMPORTANT!**

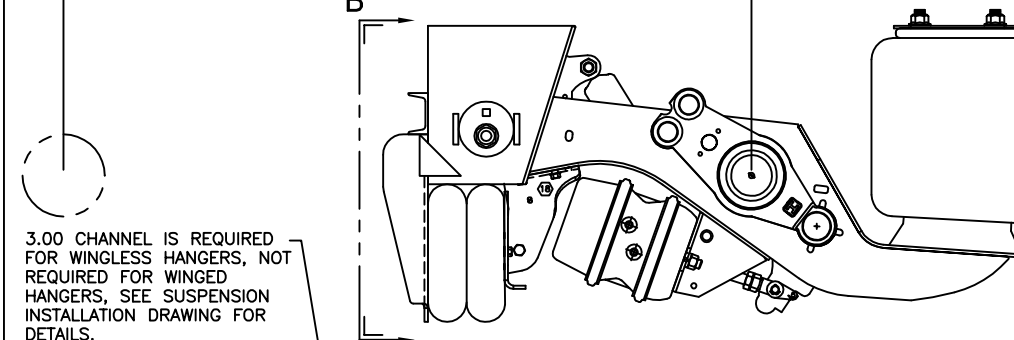
REMOVE BEAM PLATE ASSEMBLIES (TWO 1/2 BOLTS) TO INSTALL OR REMOVE PARKING BRAKE CHAMBERS. DOES NOT APPLY TO SERVICE BRAKE CHAMBERS.

**SECTION AA**



**INTRAAAX AAL INSTALLATION**

50.00 MIN. SPACING BETWEEN AXLES WHEN ADDITIONAL AAL SUSPENSION IS FORWARD OF LIFT SUSPENSION  
43.00 MIN. SPACING BETWEEN AXLES WHEN ADDITIONAL AAT SUSPENSION IS FORWARD OF LIFT SUSPENSION



3.00 CHANNEL IS REQUIRED FOR WINGLESS HANGERS, NOT REQUIRED FOR WINGED HANGERS, SEE SUSPENSION INSTALLATION DRAWING FOR DETAILS.

SCALE: .15=1.00

**VIEW BB**

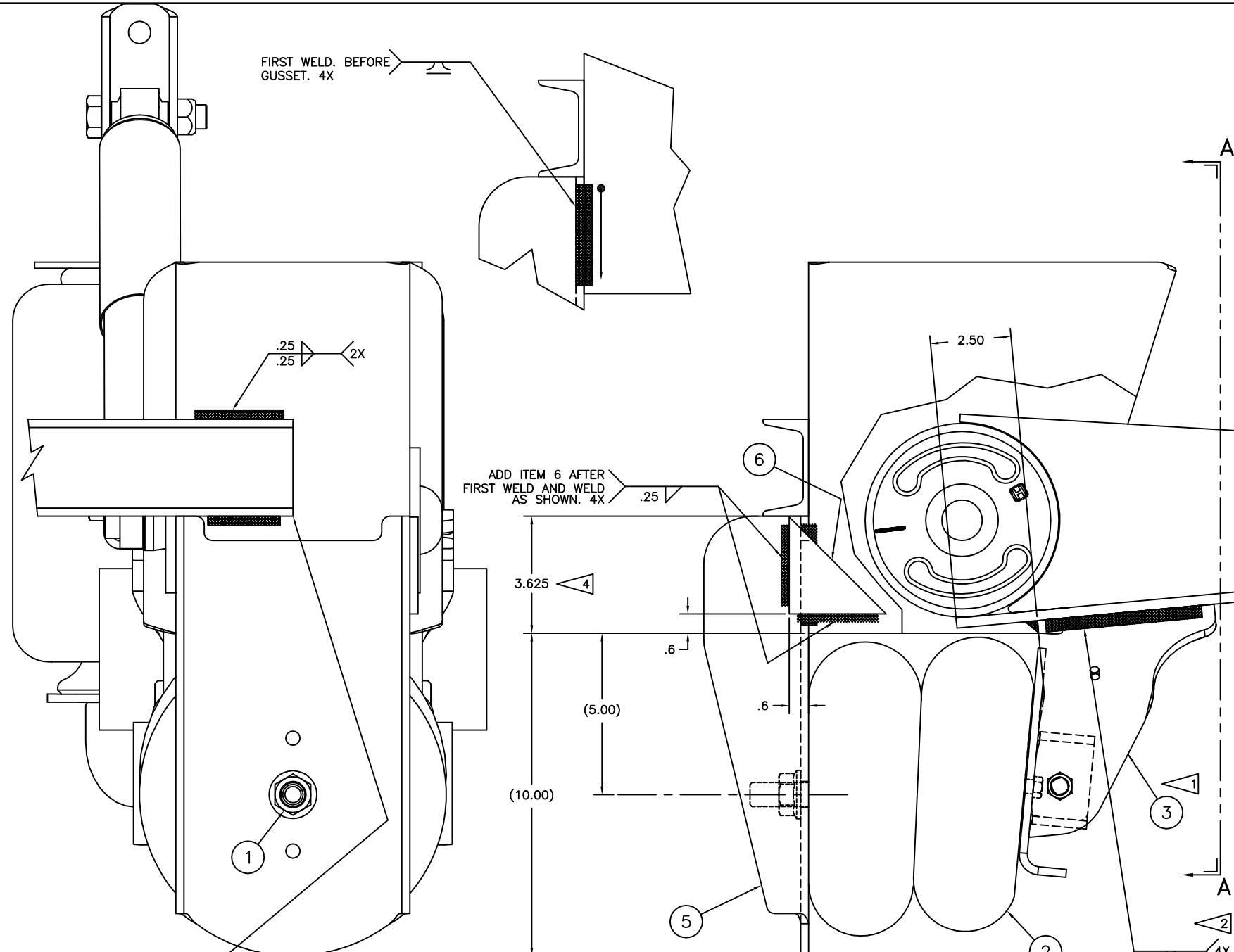
UBL-002

D-24657

UNLESS OTHERWISE NOTED:	TOLERANCES ARE:	DIMENSIONS ARE:	INCHES	MM
XX: ± .006	XX: ± .006	XX: ± .006	XX: ± .006	XX: ± .006
XX: ± .003	XX: ± .003	XX: ± .003	XX: ± .003	XX: ± .003
ANGULAR: ± 0.5°	ANGULAR: ± 0.5°	ANGULAR: ± 0.5°	ANGULAR: ± 0.5°	ANGULAR: ± 0.5°

DATE	BY	DATE	BY	DATE	BY
12/11/98	M. OYSTER	12/11/98	G. SHENKLE	12/11/98	J. RAMSEY

SCALE	SIZE	PAGE
.50=1.00	D	1 OF 2

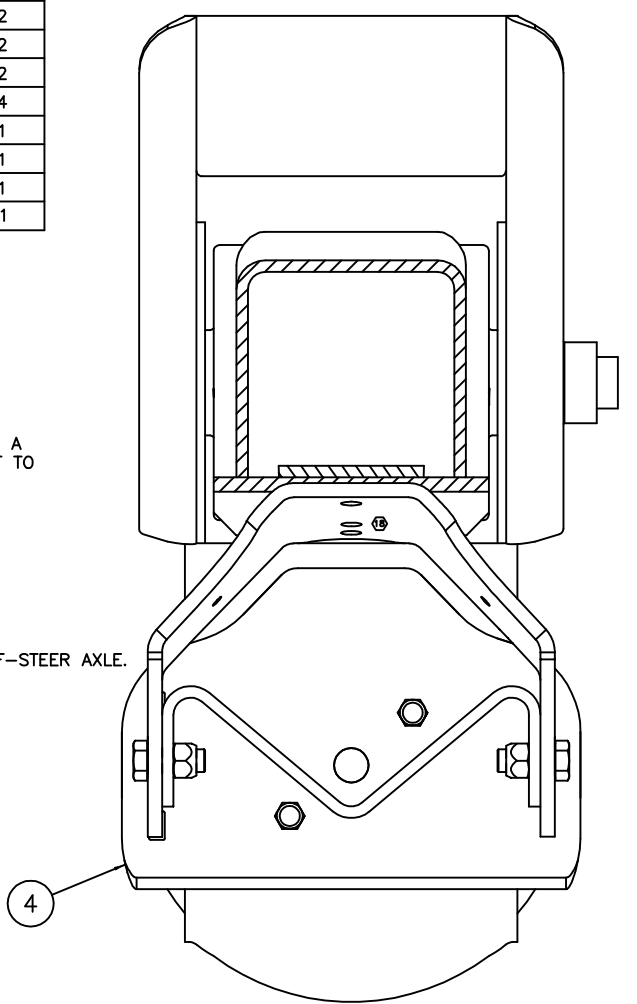


ITEM	PART NO.	DESCRIPTION	QTY.
1	A-24614	LIFT ASSEMBLY BOLT KIT	1
2	C-23114	AIR SPRING	2
3	C-28537C	LIFT BRACKET	2
4	B-27945	BEAM PLATE ASS'Y	2
5	D-24658C	HANGER SUPPORT, LIFT	2
6	B-2901-37	.25 GUSSET	4
7	*A-26828	IDENTIFICATION TAG	1
8	*L719	UBL INSTALLATION INSTRUCTIONS	1
9	**DWG D-24657	UBL-002	1
10	*A-21066	RIVET, DRIVE	1

\* NOT SHOWN  
 \*\* DWG PART NUMBER REVISION MUST MATCH REVISION OF DOCUMENT.

- NOTES:
- 12 RIDE HEIGHT SHOWN, INSTALLATION IS SAME FOR ALL RIDE HEIGHTS.
  - WEIGHT: 59.01 LB  
 INCLUDES 1.16 LB FOR WELD
  - IF GAP EXISTS BETWEEN LIFT BRACKET (ITEM 3) AND BEAM PLATE ASS'Y (ITEM 4), USE A C-CLAMP TO COMPRESS LEGS OF LIFT BRACKET TO ALLOW BEAM PLATE ASSEMBLY TO FIT.
  - WELD:  
 28.5 VOLTS, 400 IPM, 275-300 AMPS, 35 CFH (GAS FLOW), .045 WIRE  
 FILL ALL CRATERS AT END OF WELDS.  
 WELD DIRECTION:  
 STOP      START
  - DO NOT USE THIS LIFT KIT WITH DUAL TIRE SELF-STEER AXLE.

SECTION AA



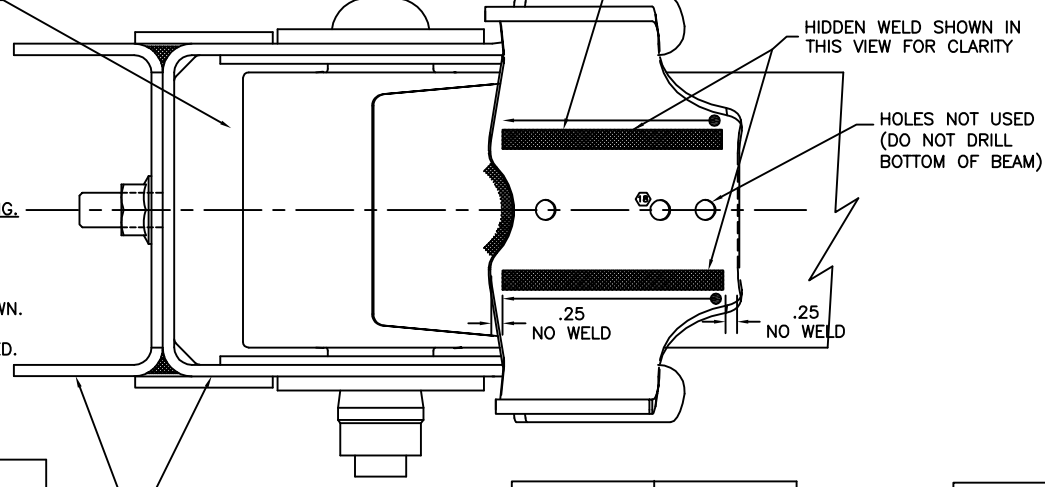
**IMPORTANT!**  
 IF CROSS CHANNEL IS REQUIRED INSTALL HANGER SUPPORT BRACKET (ITEM 5) FIRST, REST CHANNEL ON TOP OF BRACKET SURFACE AND WELD AS SHOWN.  
 IF RETROFIT, TAKE OFF CHANNEL AND RELOCATE.

ASSEMBLY PROCEDURE:

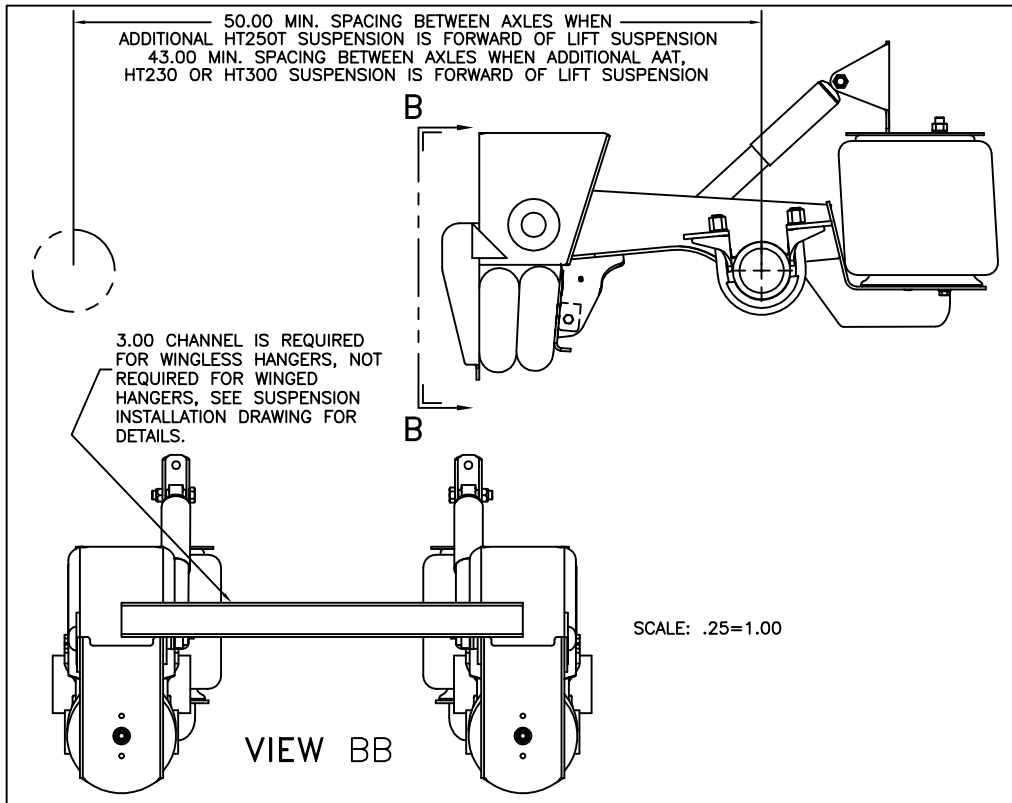
- 1 LOCATE LIFT BRACKETS (ITEM 3) AND CLAMP INTO PLACE. HOLES IN LIFT BRACKETS NOT USED (DO NOT DRILL BEAM).
- 2 INSTALL BEAM PLATE ASSEMBLIES (ITEM 4) TO LIMIT DISTORTION OF LIFT BRACKETS (ITEM 3) DURING WELDING.
3. WELD TO BEAMS AS SHOWN.
- 4 LOCATE TOP OF HANGER SUPPORT ASSEMBLY (ITEM 5) 3 5/8 FROM BOTTOM OF HANGERS AND WELD AS SHOWN.
- 5 LOCATE AND WELD "C" CHANNEL AS SHOWN IF REQUIRED.
6. INSTALL AIR SPRINGS (ITEM 2).

AIR SPRING NOT SHOWN FOR CLARITY

**IMPORTANT!**  
 INSTALL BEAM PLATE ASSEMBLIES BEFORE WELDING.



HT250T INSTALLATION



TORQUE SPECIFICATIONS		
DESCRIPTION	SIZE	TORQUE(FT-LB)
AIR SPRING BOLTS	3/8-16	25-35
AIR SPRING NUT	3/4-16	45-55
BEAM PLATE ASSEMBLY BOLTS	1/2-13	55-75

PART NUMBER	REV
UBL-002	18

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