

ASSEMBLY INSTRUCTIONS

PRIMAAX® 230/460/690

SUBJECT: Severe Service Kit No. 58821-026

LIT NO: 59310-036

DATE: October 2007

REVISION: A

INTRODUCTION

This publication is intended to assist maintenance personnel with the installation of the Severe Service Top Pad Bolt Kit No. 58821-026 for **PRIMAAX 230/460/690** rear air suspensions.

See Hendrickson publication 17730-238 for complete safety and service instructions for the PRIMAAX suspension.

SEVERE SERVICE TOP PAD BOLT KIT NO. 58821-026

PART NO.	DESCRIPTION	QTY.
65170-002	M24 x 3.0-6G Hex Bolt 140mm	2
58246-017	M24 Hardened Washer	4
65169-000	M24 x 3.0-6H Locknuts	2

SEVERE SERVICE TOP PAD BOLT KIT

DISASSEMBLY

WARNING

THE PROCEDURE TO INSTALL THE SEVERE SERVICE TOP PAD KIT IS DONE ON ONE TOP PAD CONNECTION AT A TIME, ALL OTHER COMPONENTS OF THE SUSPENSION ARE TO REMAIN CONNECTED DURING SERVICE. FAILURE TO DO SO CAN CAUSE THE AXLE TO ROTATE AND/OR SHIFT, RESULTING IN POSSIBLE DAMAGE TO COMPONENTS AND/OR PERSONAL INJURY. IF BOTH TOP PAD CONNECTIONS ON AN AXLE ARE SERVICED AT THE SAME TIME, IT WILL BE NECESSARY TO SUPPORT THE AXLE PINION TO KEEP THE AXLE FROM SHIFTING.

1. Place the vehicle on a level floor.
2. Chock the wheels.
3. Support the frame of the vehicle at ride height.

WARNING

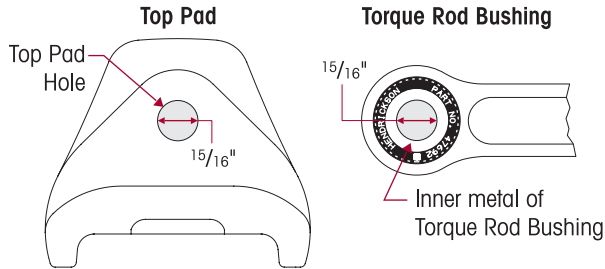
AIR SPRING ASSEMBLIES MUST BE DEFLATED PRIOR TO INSTALLING TOP PAD SEVERE SERVICE KIT. UNRESTRICTED AIR SPRING ASSEMBLIES CAN VIOLENTLY SHIFT. DO NOT INFLATE AIR SPRING ASSEMBLIES WHEN THEY ARE UNRESTRICTED. AIR SPRING ASSEMBLIES MUST BE RESTRICTED BY SUSPENSION OR OTHER ADEQUATE STRUCTURE. DO NOT INFLATE BEYOND PRESSURES RECOMMENDED BY AIR SPRING MANUFACTURER, CONTACT HENDRICKSON TECHNICAL SERVICES FOR DETAILS. IMPROPER USE OR OVER INFLATION MAY CAUSE AIR SPRING ASSEMBLIES TO BURST, CAUSING PROPERTY DAMAGE AND/OR SEVERE PERSONAL INJURY.

WARNING

PRIOR TO AND DURING DEFLATION AND INFLATION OF THE AIR SUSPENSION SYSTEM, ENSURE THAT ALL PERSONNEL AND EQUIPMENT ARE CLEAR FROM UNDER THE VEHICLE AND AROUND THE SERVICE AREA, FAILURE TO DO SO CAN CAUSE SERIOUS PERSONAL INJURY, DEATH, OR PROPERTY DAMAGE.

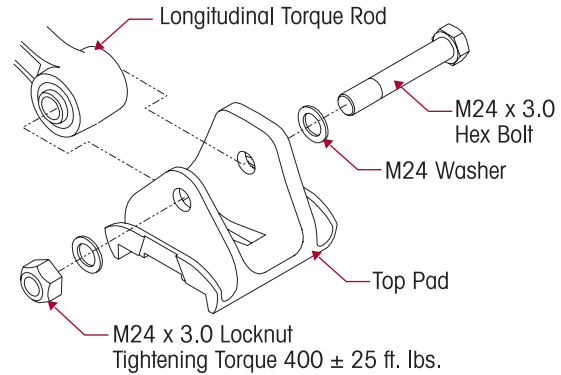
4. Disconnect the height control linkage assembly from the height control valve arm. Lower the leveling valve arm to exhaust the air in the air springs and deflate the rear suspension.
5. Remove the existing fasteners connecting the longitudinal torque rod to the top pad and discard.

FIGURE 1



NOTE: The new M24 bolt should pass through the top pad hole and the inner metal of the torque rod bushing.

FIGURE 2



ASSEMBLY

NOTE

Prior to assembly, verify the new M24 bolt will pass through the existing top pad and inner metal of the torque rod bushing. See Figure 1.

1. Verify the new M24 bolt will pass through the existing top pad and inner metal of the torque rod bushing. If the fastener will not pass through the part(s), enlarge the hole(s) to $\frac{15}{16}$ " (0.937"). See Figure 1. To access top pad hole, clamp group disassembly may be required. Refer to Hendrickson publication 17730-238 for proper clamp group service instructions.
2. Assemble the new severe service fastener through the top pad and longitudinal torque rod. Tighten the locknut to \mathbb{N} 400 ± 25 foot pounds. See Figure 2.

SERVICE HINT

Raising or lowering the pinion may assist in aligning the top pad and longitudinal torque rod to ease fastener installation.

WARNING

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CAUTION

INFLATE THE SUSPENSION SLOWLY AND ENSURE THAT THE RUBBER BLADDER OF THE AIR SPRING INFLATES UNIFORMLY AND IS NOT BINDING. FAILURE TO DO SO CAN CAUSE DAMAGE TO THE UPPER AIR SPRING MOUNTING BRACKET AND VOID WARRANTY.

3. Inflate the suspension by connecting the height control valve linkage to the height control valve arm. Verify the air springs inflate uniformly without binding.
4. Remove the frame supports.
5. Remove the wheel chocks.
6. Verify proper ride height adjustment. See Ride Height Adjustment in the Alignment & Adjustments Section of Hendrickson publication no. 17730-238.

Refer any questions on this publication to Hendrickson Tech Services (630.910.2800 or email techservices@hendrickson-intl.com). For more information on Hendrickson products go to www.hendrickson-intl.com.

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