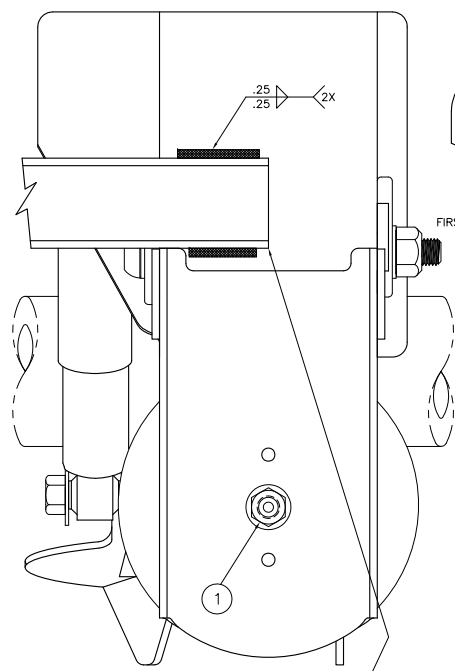
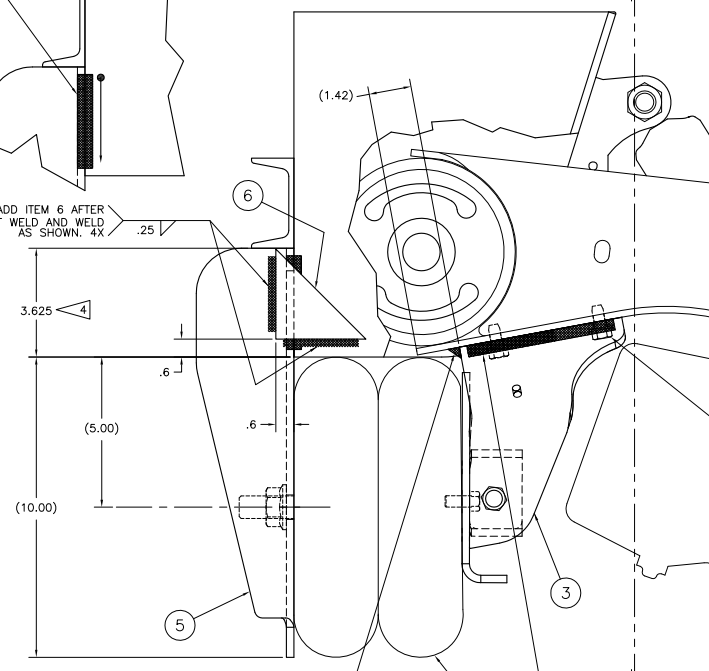


FIRST WELD. BEFORE GUSSET. 4X



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



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

- NOTES:
1. 12 RIDE HEIGHT SHOWN. INSTALLATION IS SAME FOR ALL RIDE HEIGHTS.
  2. WEIGHT: 59.02 LB
  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:  
5. AAL 30K REQUIRES A CROSSOVER AIR CONTROL KIT.

**WARNING!**

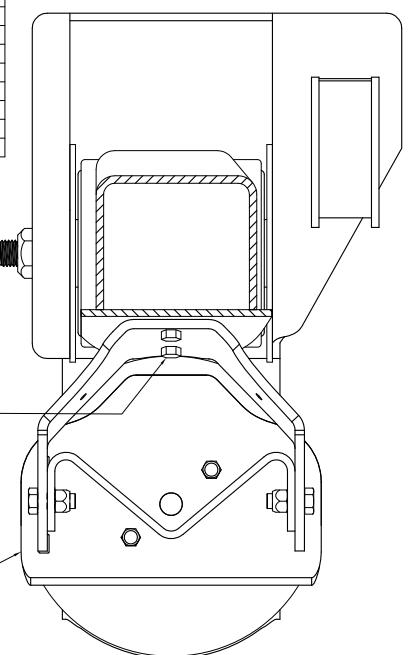
SELF TAPPING SCREWS ARE FOR LOCATION ONLY. LIFT BRACKET (ITEM 3) MUST BE WELDED AS SHOWN.

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

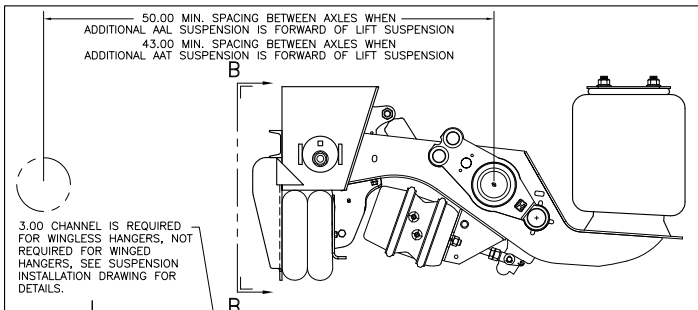
**IMPORTANT!**

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

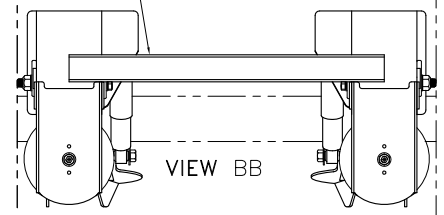
**SECTION AA**



**INTRAAAX AAL INSTALLATION**



SCALE: .15=1.00



**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:**

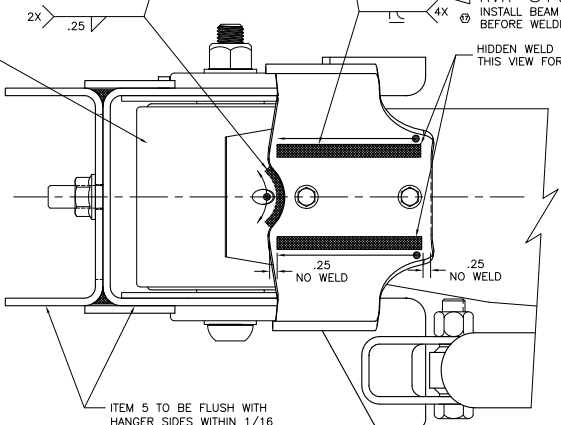
1. LOCATE LIFT BRACKETS (ITEM 3) WITH SELF-TAPPING SCREWS.
2. INSTALL BEAM PLATE ASSEMBLIES (ITEM 4) TO LIMIT DISTORTION OF LIFT BRACKETS (ITEM 3) DURING WELDING.
3. WELD TO BEAMS AS SHOWN.
4. LOCATE TOP OF HANGER SUPPORT ASSEMBLY (ITEM 5) 3 5/8 FROM BOTTOM OF HANGERS AND WELD AS SHOWN.
5. LOCATE AND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

AIR SPRING NOT SHOWN FOR CLARITY

**IMPORTANT!**

INSTALL BEAM PLATE ASSEMBLIES BEFORE WELDING.

HIDDEN WELD SHOWN IN THIS VIEW FOR CLARITY



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

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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

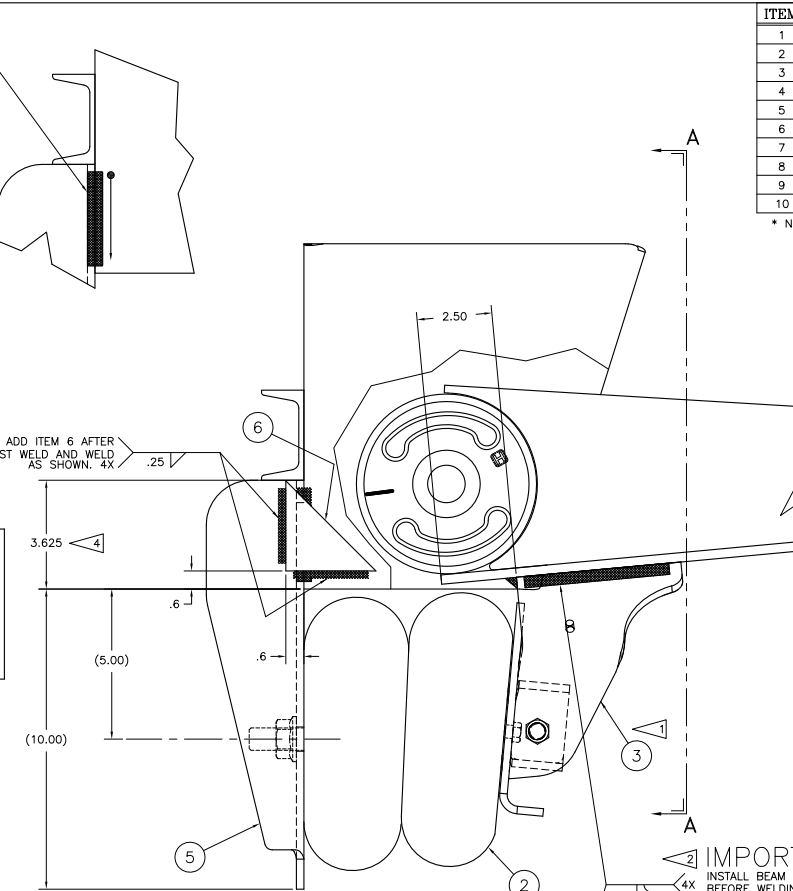
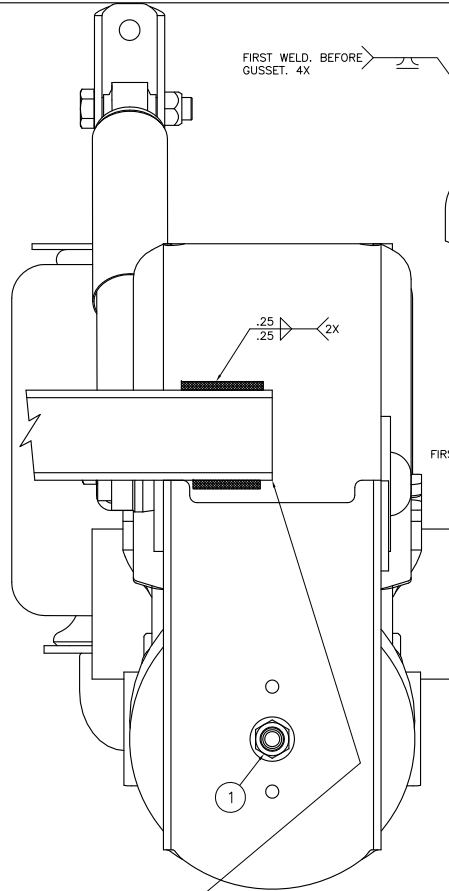
**HENDRICKSON**  
TRAILER COMMERCIAL VEHICLE SYSTEMS

UNLESS OTHERWISE NOTED, TOLERANCES ARE: DIMENSIONS IN INCHES: .005; DIMENSIONS IN MILLIMETERS: .10; ANGULAR: ± 0.5°; 1/8 MIN. WELD PROTRUSION; DIMENSIONS APPLICABLE TO THIS DRAWING UNLESS OTHERWISE NOTED.

17 20460 COP 2/14/92  
16 19856 MDS 6-8-11  
15 19853 MDS 2-22-11  
14 19853 L02 7-22-10

DESIGNED BY: M. OYSTER  
12/11/98  
DRAWN BY: G. SENEKLE  
12/15/98  
CHECKED BY: J. RAMSEY

SCALE: 30=1.00  
D  
1 OF 2  
UBL-002  
D-24657



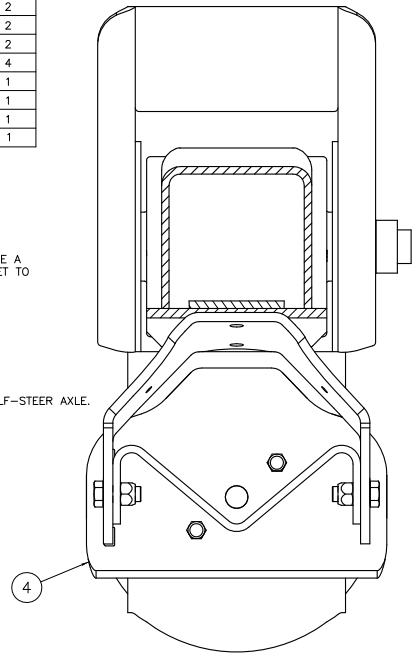
ITEM	PART NO.	DESCRIPTION	QTY.
1	A-24614	LIFT ASSEMBLY BOLT KIT	1
2	C-23114	AIR SPRING	2
3	C-28537C	LIFT BRACKET	2
4	B-27945	BEAM PLATE ASS'Y	2
5	D-24658C	HANGER SUPPORT, LIFT	2
6	B-2901-37	.25 GUSSET	4
7	*A-26828	IDENTIFICATION TAG	1
8	*L719	UBL INSTALLATION INSTRUCTIONS	1
9	*DWG D-24657	UBL-002	1
10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

\* NOT SHOWN

NOTES:

- 12 RIDE HEIGHT SHOWN, INSTALLATION IS SAME FOR ALL RIDE HEIGHTS.
- WEIGHT: 59.02 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



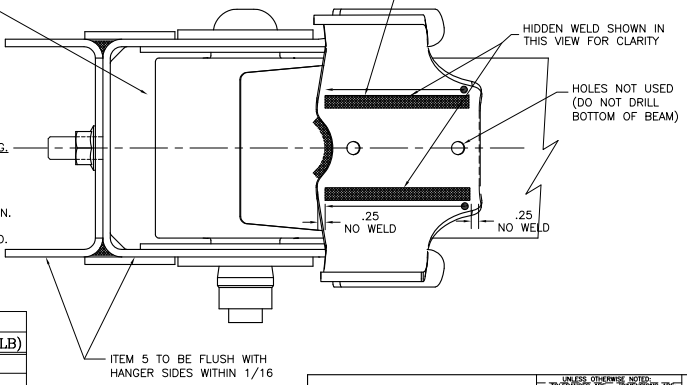
**IMPORTANT!**  
IF CROSS CHANNEL IS REQUIRED INSTALL HANGER SUPPORT BRACKET (ITEM 5) FIRST. REST CHANNEL ON TOP OF BRACKET SURFACE AND WELD AS SHOWN.  
IF RETROFIT, TAKE OFF CHANNEL AND RELOCATE.

ASSEMBLY PROCEDURE:

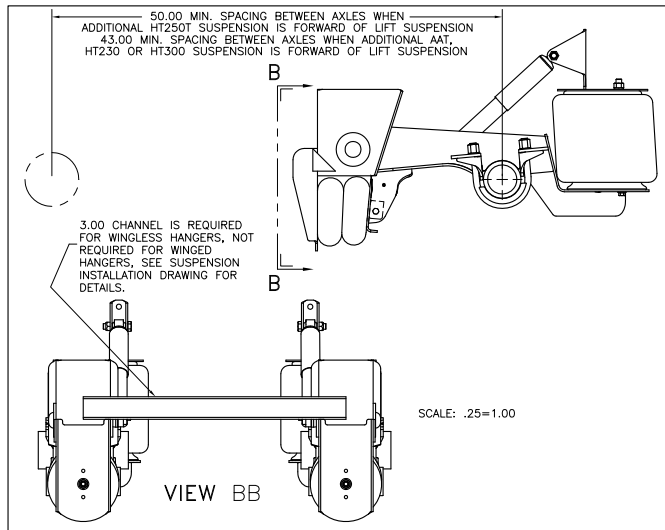
- 1 LOCATE LIFT BRACKETS (ITEM 3) AND CLAMP INTO PLACE. HOLES IN LIFT BRACKETS NOT USED (DO NOT DRILL BEAM).
- 2 INSTALL BEAM PLATE ASSEMBLIES (ITEM 4) TO LIMIT DISTORTION OF LIFT BRACKETS (ITEM 3) DURING WELDING.
- 3 WELD TO BEAMS AS SHOWN.
- 4 LOCATE TOP OF HANGER SUPPORT ASSEMBLY (ITEM 5) 3 5/8 FROM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



SCALE: .25=1.00

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

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