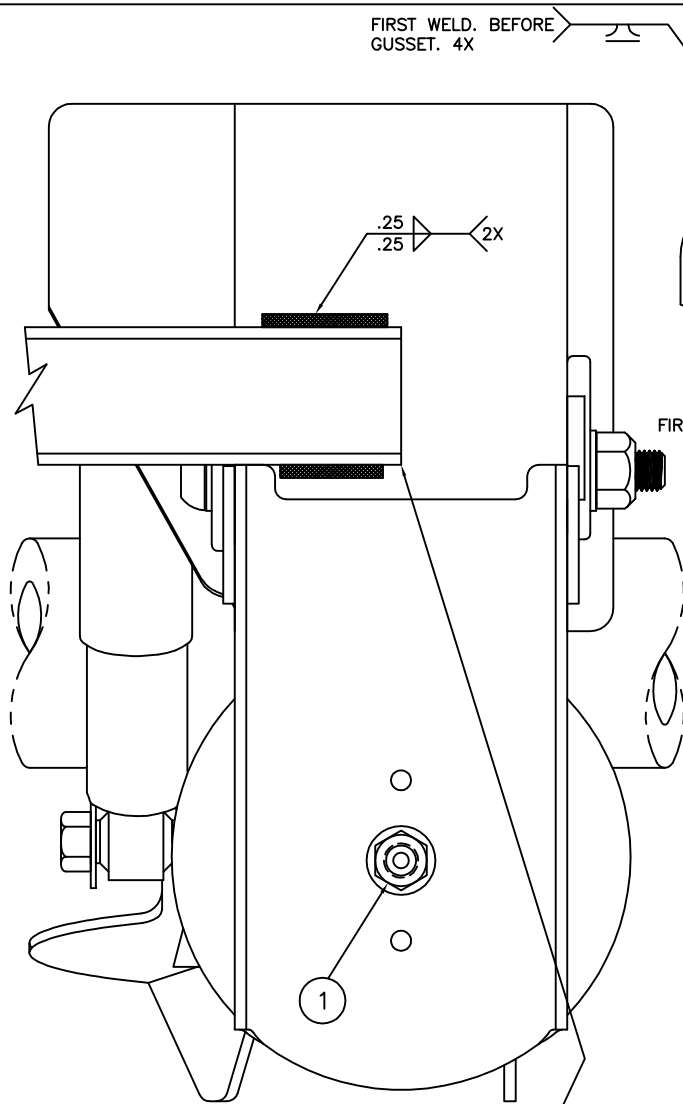
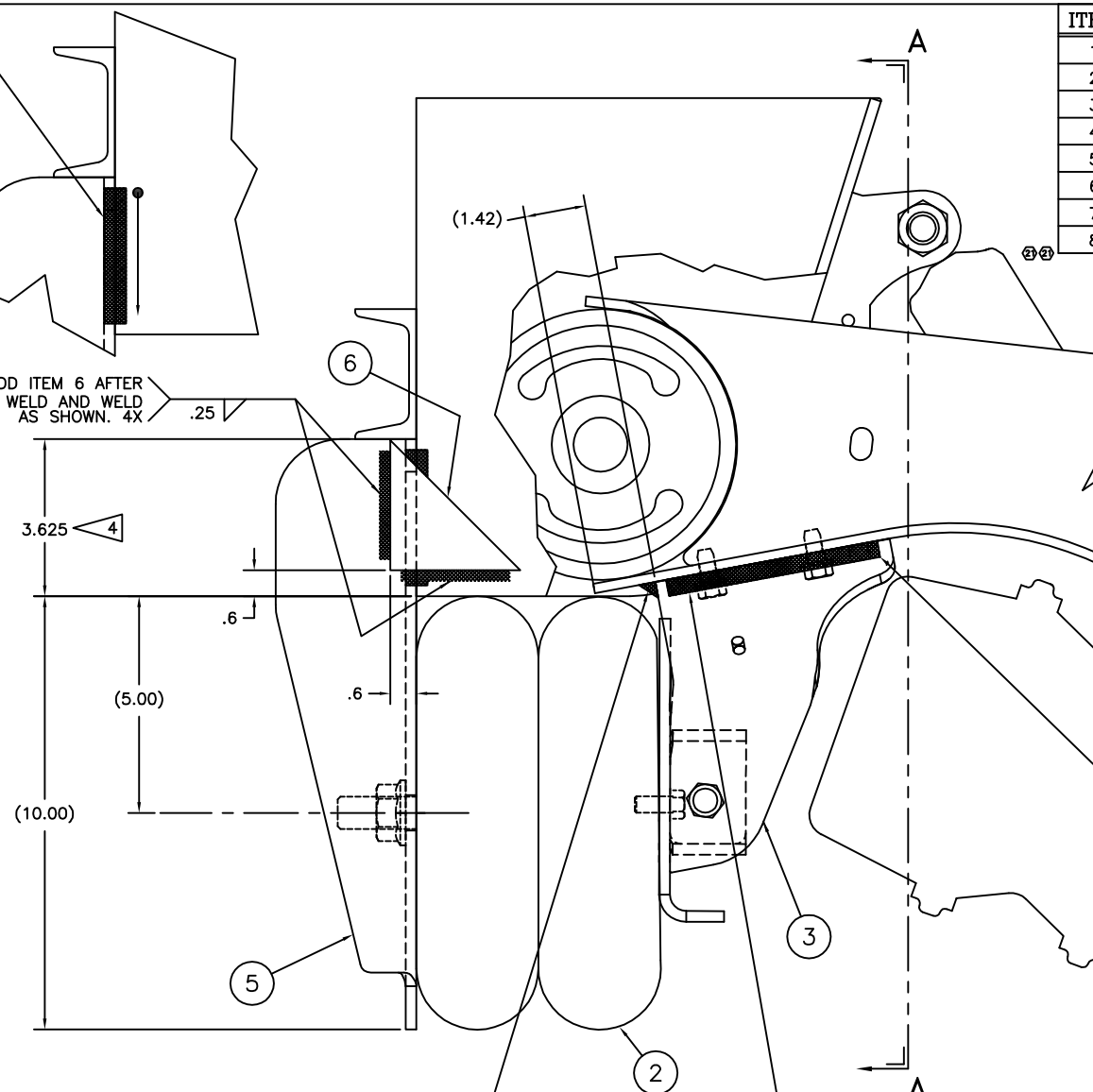


FIRST WELD. BEFORE GUSSET. 4X



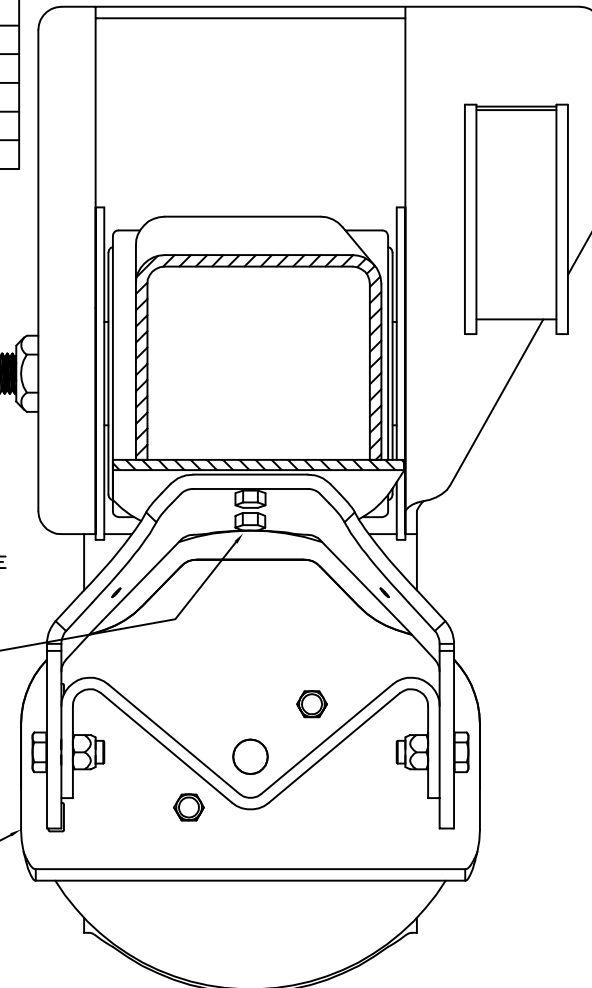
ADD ITEM 6 AFTER FIRST WELD AND WELD AS SHOWN. 4X



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	**DWG D-24657	UBL-002	1
8	*T91001	UBL HARDWARE KIT INFORMATION	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:
 - AAL 30K REQUIRES A CROSSOVER AIR CONTROL KIT.
STOP START
 - UBL-002 INTENDED FOR USE WITH CARBON STEEL FRAME BRACKETS ONLY. USE UBL-201 OR UBL-202 FOR STAINLESS STEEL FRAME BRACKETS.

SECTION AA



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.

IMPORTANT!

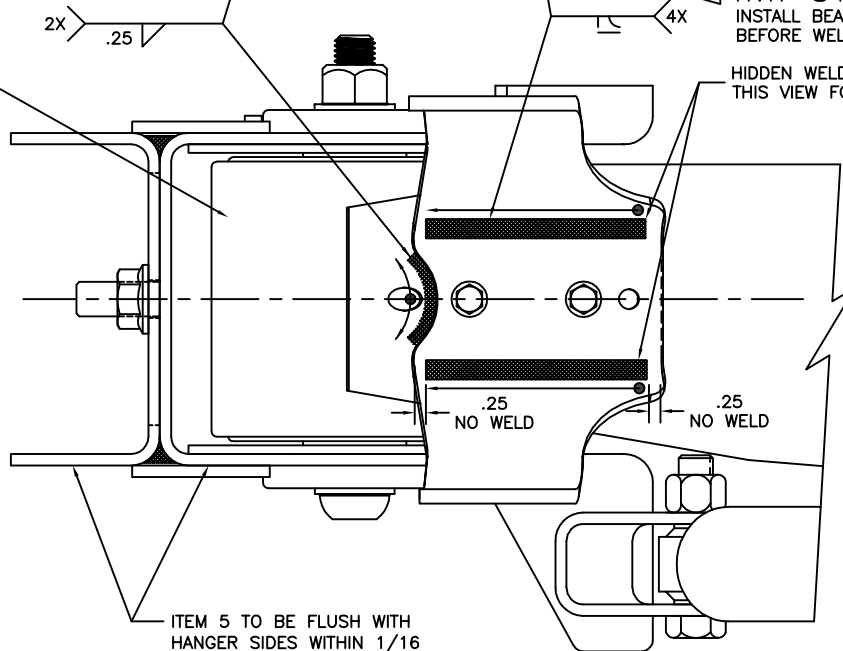
IF CROSS CHANNEL IS REQUIRED INSTALL HANGER SUPPORT BRACKET (ITEM 5) FIRST, REST CHANNEL ON TOP OF BRACKET SURFACE AND WELD AS SHOWN.

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



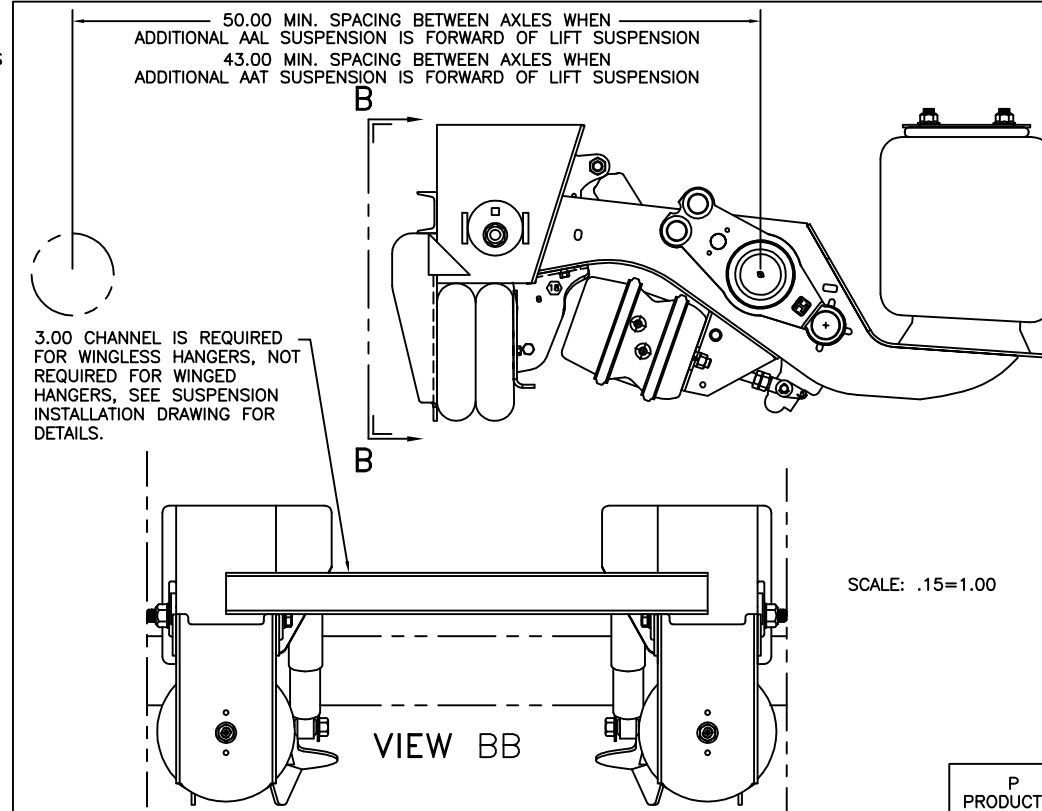
IMPORTANT!

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

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



SCALE: .15=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
BRAKE CHAMBER MTG. NUTS	5/8-11	100-110
SELF TAPPING SCREWS	3/8	160-180 IN-LB

PART NUMBER	REV
UBL-002	21

H. HENDRICKSON

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

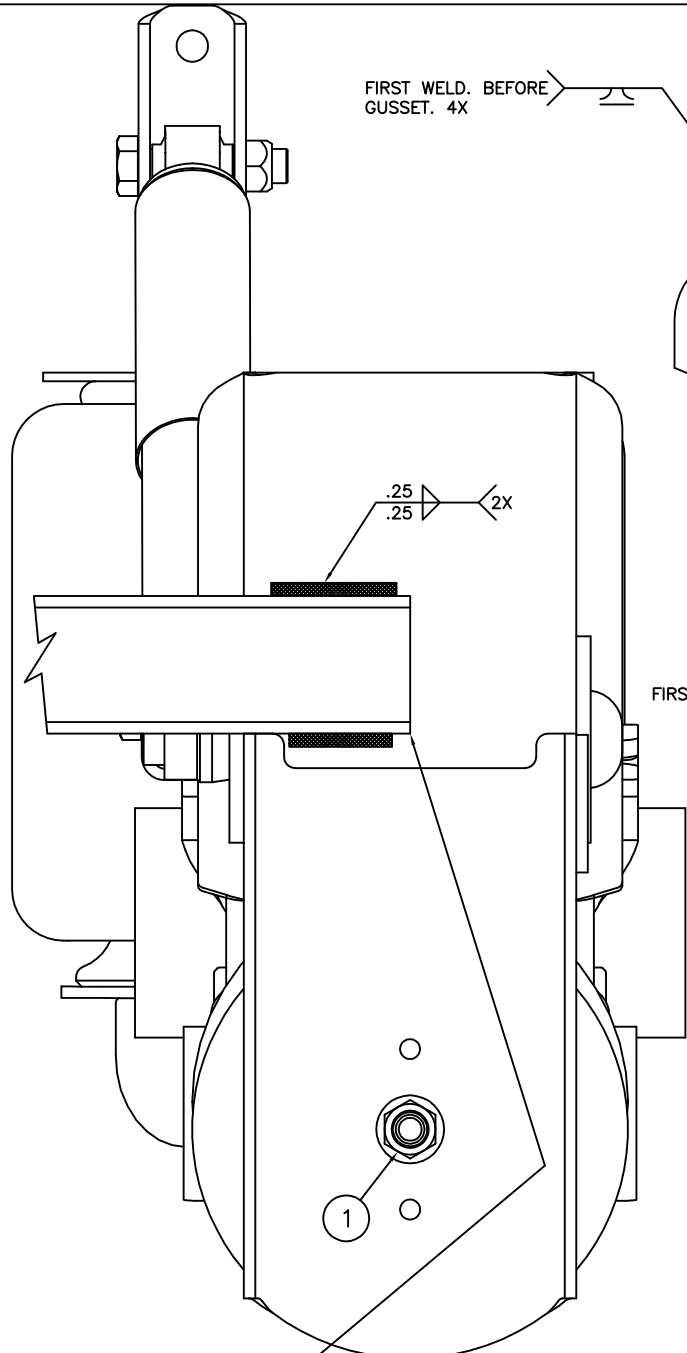
UNLESS OTHERWISE NOTED:
 TOLERANCES ARE: DIMENSIONS ARE: INCHES
 .X: ± .1
 .XX: ± .06
 .XXX: ± .030
 ANGULAR: ± 0.5°
 DIMENSIONS ADHERE TO ANSI Y14.5M-1982

REV	DATE	BY	DATE	APP'D BY
21	3-6-20	JAR	12/11/98	M. OYSTER
20	3/20/04	0LD	8-27-18	
19	3/28/03	0LD	8-28-18	G. SHENKLE
18	3/24/07	ZAG	8-23-17	J. RAMSEY

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SCALE: .50=1.00
 DRAWING NO. UBL-002
 P. PRODUCTION
 D-24657
 1 OF 2

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FIRST WELD. BEFORE GUSSET. 4X

.25
.25

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.

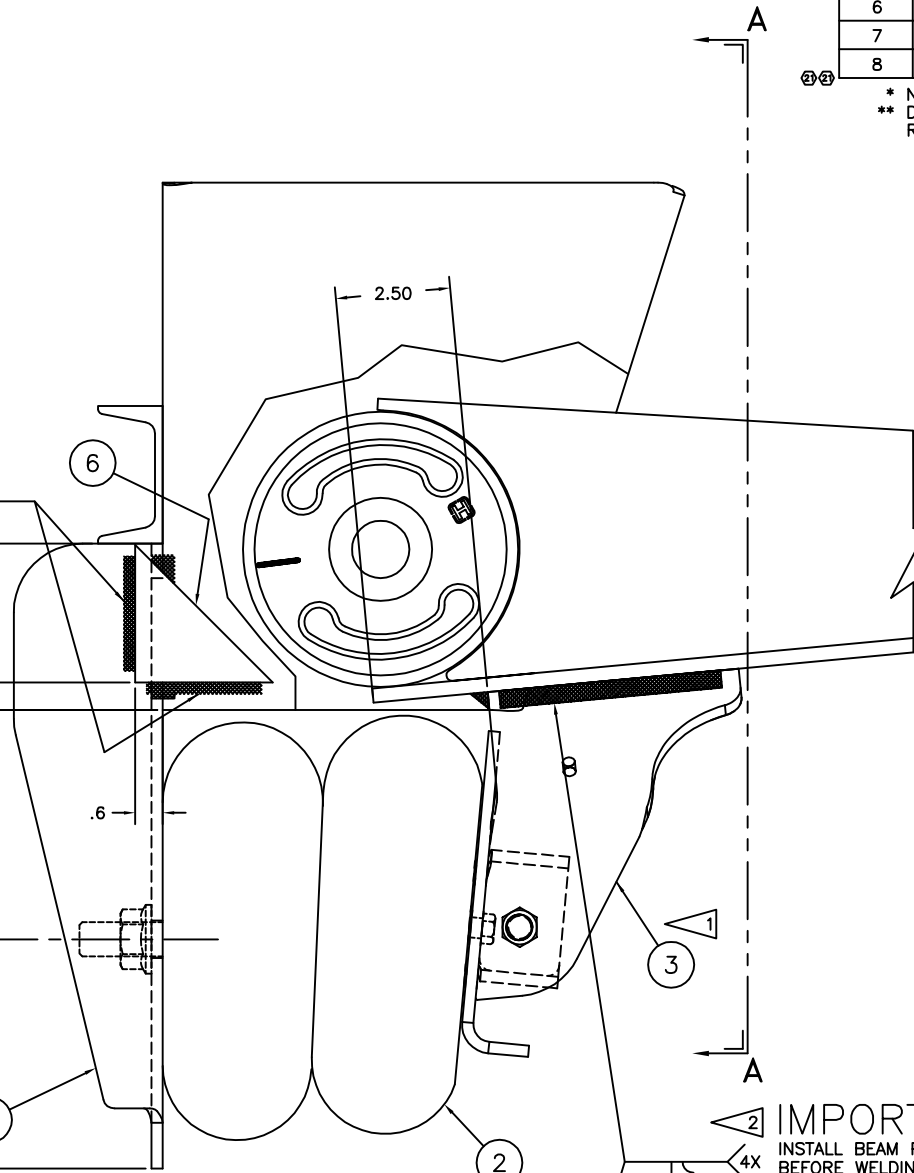
ASSEMBLY PROCEDURE:

- 1 LOCATE LIFT BRACKETS (ITEM 3) 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).

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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AIR SPRING NOT SHOWN FOR CLARITY



IMPORTANT!
INSTALL BEAM PLATE ASSEMBLIES BEFORE WELDING.

HIDDEN WELD SHOWN IN THIS VIEW FOR CLARITY

HOLES NOT USED (DO NOT DRILL BOTTOM OF BEAM)

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

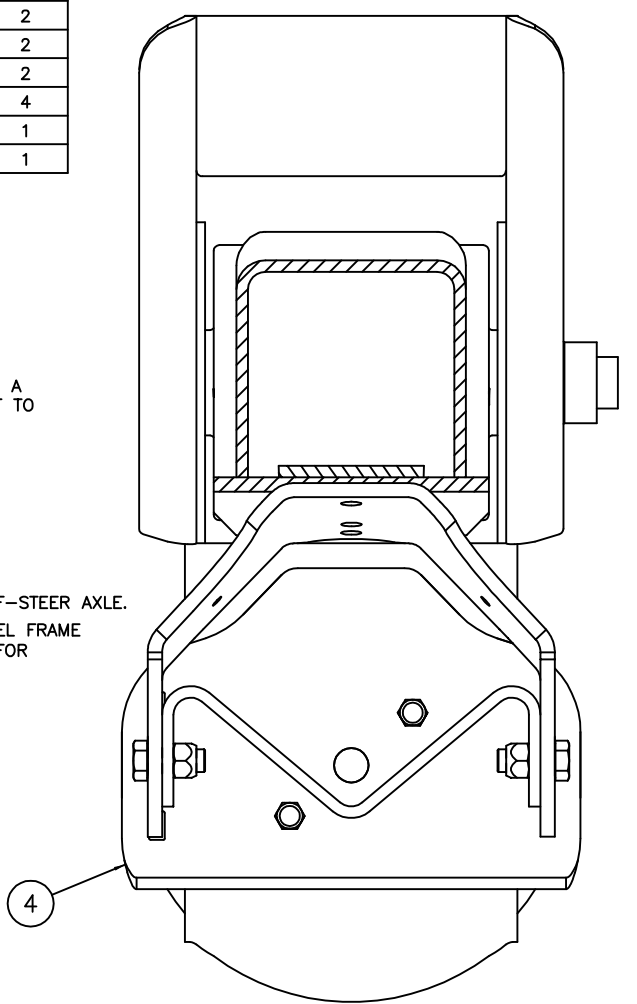
ITEM	PART NO.	DESCRIPTION	QTY.
1	A-24614	LIFT ASSEMBLY BOLT KIT	1
2	C-23114	AIR SPRING	2
3	C-28537C	LIFT BRACKET	2
4	B-27945	BEAM PLATE ASS'Y	2
5	D-24658C	HANGER SUPPORT, LIFT	2
6	B-2901-37	.25 GUSSET	4
7	**DWG D-24657	UBL-002	1
8	*T91001	UBL HARDWARE KIT INFORMATION	1

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

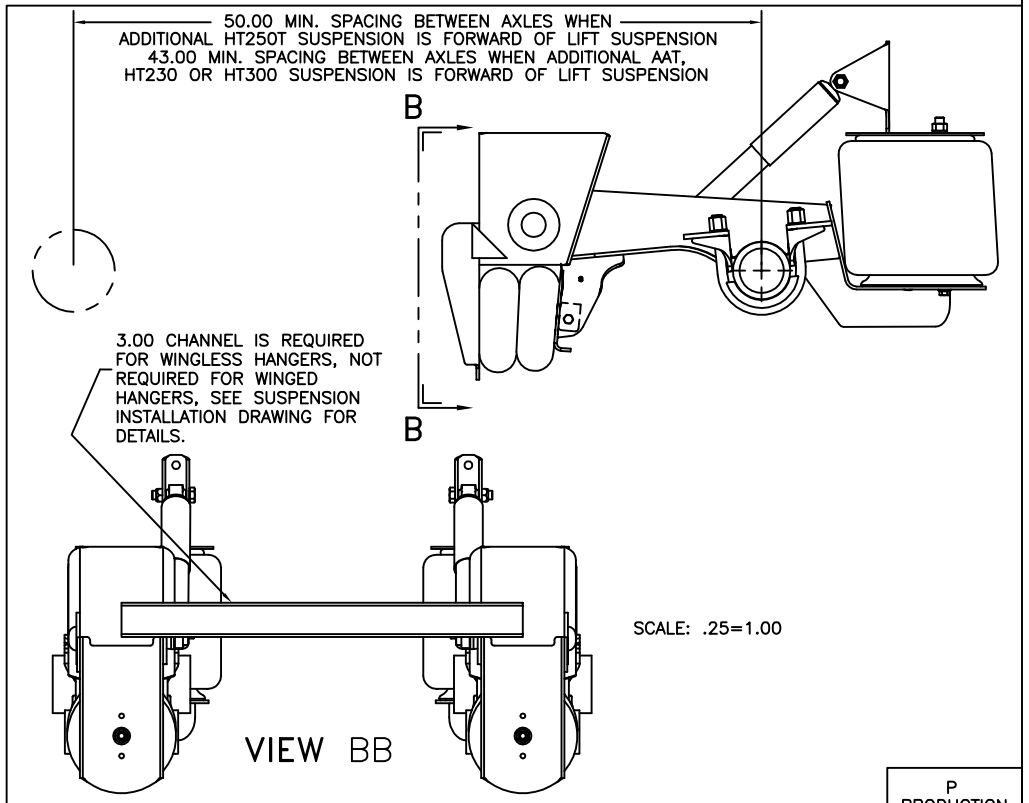
NOTES:

1. 12 RIDE HEIGHT SHOWN, INSTALLATION IS SAME FOR ALL RIDE HEIGHTS.
2. WEIGHT: 59.01 LB
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. DO NOT USE THIS LIFT KIT WITH DUAL TIRE SELF-STEER AXLE.
6. UBL-002 INTENDED FOR USE WITH CARBON STEEL FRAME BRACKETS ONLY. USE UBL-201 OR UBL-202 FOR STAINLESS STEEL FRAME BRACKETS.

SECTION AA



HT250T INSTALLATION



50.00 MIN. SPACING BETWEEN AXLES WHEN ADDITIONAL HT250T SUSPENSION IS FORWARD OF LIFT SUSPENSION
43.00 MIN. SPACING BETWEEN AXLES WHEN ADDITIONAL AAT, HT230 OR HT300 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: .25=1.00

P PRODUCTION

H. HENDRICKSON
TRAILER COMMERCIAL VEHICLE SYSTEMS
2070 INDUSTRIAL PLACE SE., CANTON, OH 44707-2600 U.S.A.

UNLESS OTHERWISE NOTED: 21 33569 JAR 3-6-20 DRAWN BY P.BILLMAN 3-10-05
TOLERANCES ARE DIMENSIONS ARE: 20 37624 0.0D 6-27-18
X: ± .1 INCHES 19 37683 0.0D 6-28-18
Y: ± .06 18 32447 0.0D 8-23-17
ANGULAR: ± 0.5 18 32447 2AG 8-23-17
3RD ANGLE PROJECTION
DIMENSIONS ADHERE TO ANSI Y14.5M-1982 REV. EDN NO. BY DATE

APPROVED BY: R.GORE
DATE: 3-10-05
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SCALE: .50=1.00 SIZE: D PAGE: 2 OF 2
D-24657