

H ASSEMBLY INSTRUCTIONS

PRIMAAX®

SUBJECT: Severe Service Kit No. 60632-015

LIT NO: 59310-037

DATE: November 2007

REVISION: A

INTRODUCTION

This procedure is intended to assist maintenance personnel with the installation of the Severe Service QUIK-ALIGN® Pivot Bolt Kit No. 60632-015 for **PRIMAAX®** rear air suspensions.

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

SEVERE SERVICE QUIK-ALIGN PIVOT BOLT AXLE KIT NO. 60632-015

PART NO.	DESCRIPTION	QTY.
67035-000	QUIK-ALIGN Concentric Base	2
67034-000	QUIK-ALIGN Eccentric Base	2
18500-003	1 1/4"-12 UNF Bolt - 8.0"	2
22962-019	1 1/4" Hardened Washer	4
67635-000	1 1/4"-12 UNF Locknut	2

SEVERE SERVICE QUIK-ALIGN PIVOT BOLT KIT

DISASSEMBLY

1. Chock the wheels.
2. Support the frame of the vehicle at ride height.

⚠ WARNING

AIR SPRING ASSEMBLIES MUST BE DEFLATED PRIOR TO INSTALLING QUIK-ALIGN PIVOT BOLT 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.

3. 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.

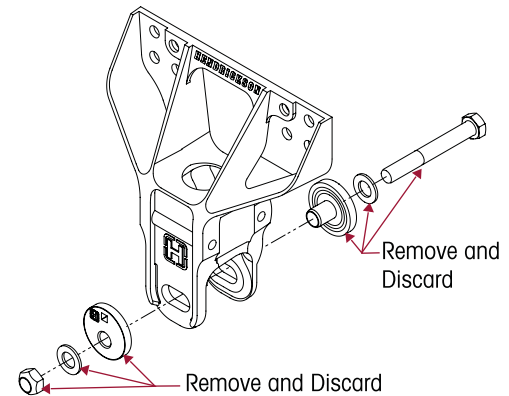
⚠ WARNING

PRIOR TO DISASSEMBLY OF THE SUSPENSION, VERIFY THAT THE AXLE BEING SERVICED IS SUPPORTED UNDER THE PINION HOUSING/DIFFERENTIAL SO THAT THE AXLE DOES NOT MOVE OR ROTATE. FAILURE TO DO SO CAN ALLOW THE AXLE TO ROTATE OR SHIFT, CAUSING COMPONENT DAMAGE, AND/OR SEVERE PERSONAL INJURY.

- Support the pinion of the axle being serviced so the axle will not shift or rotate during service.

FIGURE 1

- Before loosening the existing QUIK-ALIGN collars mark the position of the QUIK-ALIGN eccentric collars on the frame hangers. This will allow the new components to be installed in the same orientation, preserving the existing alignment of the axle.
- Remove and discard the existing 1" pivot bolt, locknut, washers, and QUIK-ALIGN collars, see Figure 1.



ASSEMBLY

NOTE

Prior to assembly, verify the new fasteners will pass through the existing inner metal of the pivot bushings, see Figure 2.

- Verify the new fasteners will pass through the existing inner metal of the pivot bushings. If the fastener will not pass through, reaming of the inner metal of pivot bushing to 1 1/4" (1.25") may be required.
- Assemble the new severe service bolts, washers, QUIK-ALIGN collars, and locknuts. See Figure 3. Ensure the QUIK-ALIGN eccentric collar is installed on the outboard side of the frame hanger.

FIGURE 2

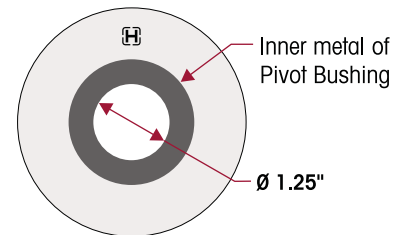
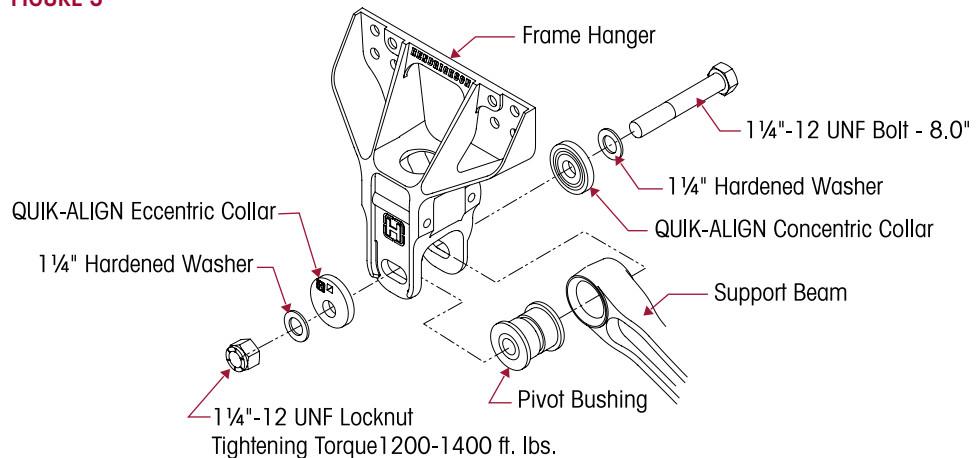


FIGURE 3





- Tighten the locknut until the QUIK-ALIGN components are snug against the frame hanger, but the QUIK-ALIGN eccentric collars can still be rotated.
- Adjust the QUIK-ALIGN eccentric collars to the same orientation as the eccentric collars which were removed in step 6. This will return the axle to the pre-disassembly alignment.



NOTE

If an axle alignment is going to be performed it should be completed before applying final torque to the QUIK-ALIGN fastener. Refer to Hendrickson publication 17730-238 for complete alignment instructions.

5. Torque the locknut to final torque using one of the following methods:
 - a. Using a torque wrench or torque multiplier tighten the locknut to  1200-1400 foot pounds torque.
 - b. Using the Torque and Tighten method pre-torque the locknuts to  190-210 foot pounds. After the pre-torque has been applied, tighten the locknut an additional $\frac{1}{2}$ of a turn (240 degrees).



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.



CAUTION

INFLATE THE SUSPENSION SLOWLY AND ENSURE THAT THE RUBBER BLADDER OF THE AIR SPRINGS INFLATE UNIFORMLY AND WITHOUT BINDING. FAILURE TO DO SO CAN CAUSE DAMAGE TO THE AIR SPRING OR THE MOUNTING BRACKET AND VOID WARRANTY.

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

Refer any questions on this publication to Hendrickson Tech Services at 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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