

# H PARTS LIST

## PRIMAAX® EX • PRIMAAX® Rear Air Suspension for International Truck Vehicles

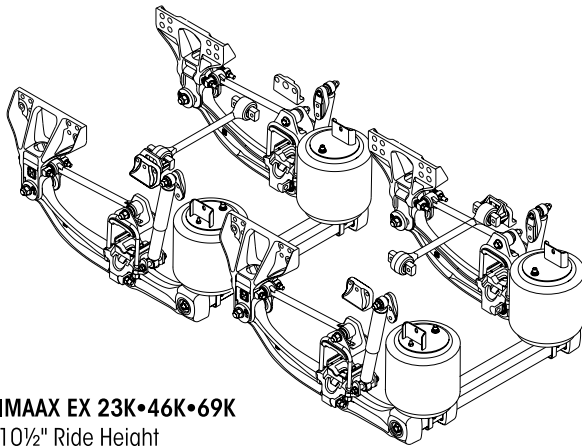
LIT NO: SP-233

DATE: February 2026

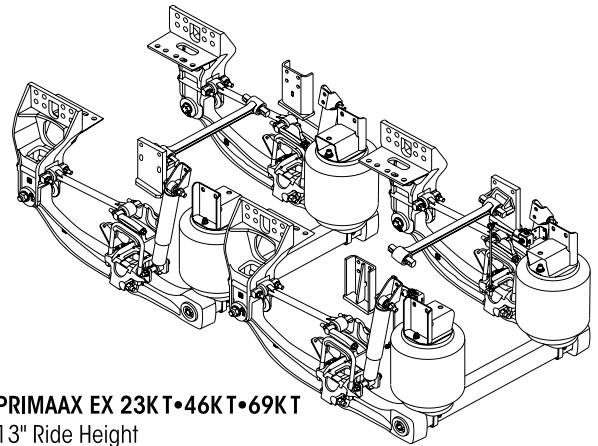
REVISION: F

### CONTENTS

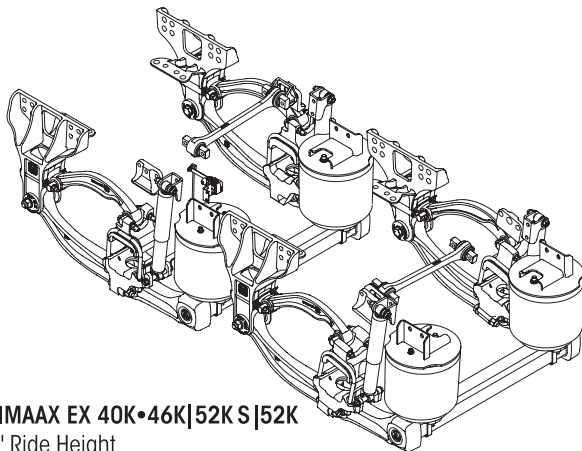
DESCRIPTION	PAGE	DESCRIPTION	PAGE
<b>PARTS LISTS</b>			
■ PRIMAAX EX 23K • 46K • 69K   26K S . . . . .	8	Technical Notes . . . . .	2
■ PRIMAAX EX 40K • 46K • 52K S • 52K . . . . .	10	Severe Service Kits . . . . .	3
■ PRIMAAX EX 23K T • 46K T • 69K T . . . . .	12	Notes . . . . .	3
■ PRIMAAX EX 26K • 52K • 78K . . . . .	18	<b>SELECTION GUIDES</b>	
■ PRIMAAX 230 • 460 • 690 . . . . .	20	■ Small Clamp Group . . . . .	4-7
		■ Large Clamp Group . . . . .	14-17
		Special Tools . . . . .	22



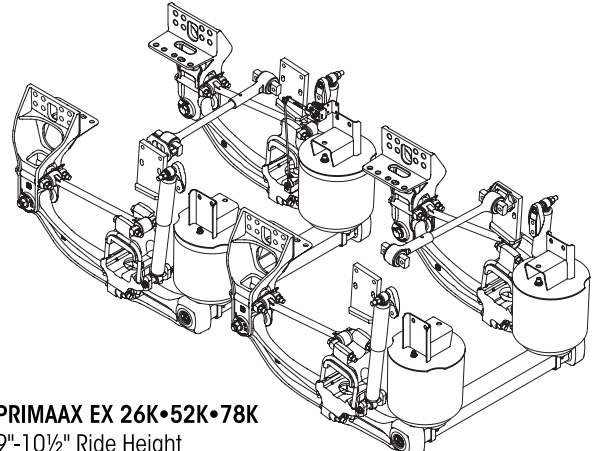
**PRIMAAX EX 23K • 46K • 69K**  
9"-10½" Ride Height



**PRIMAAX EX 23KT • 46KT • 69KT**  
13" Ride Height



**PRIMAAX EX 40K • 46K | 52K S | 52K**  
12" Ride Height

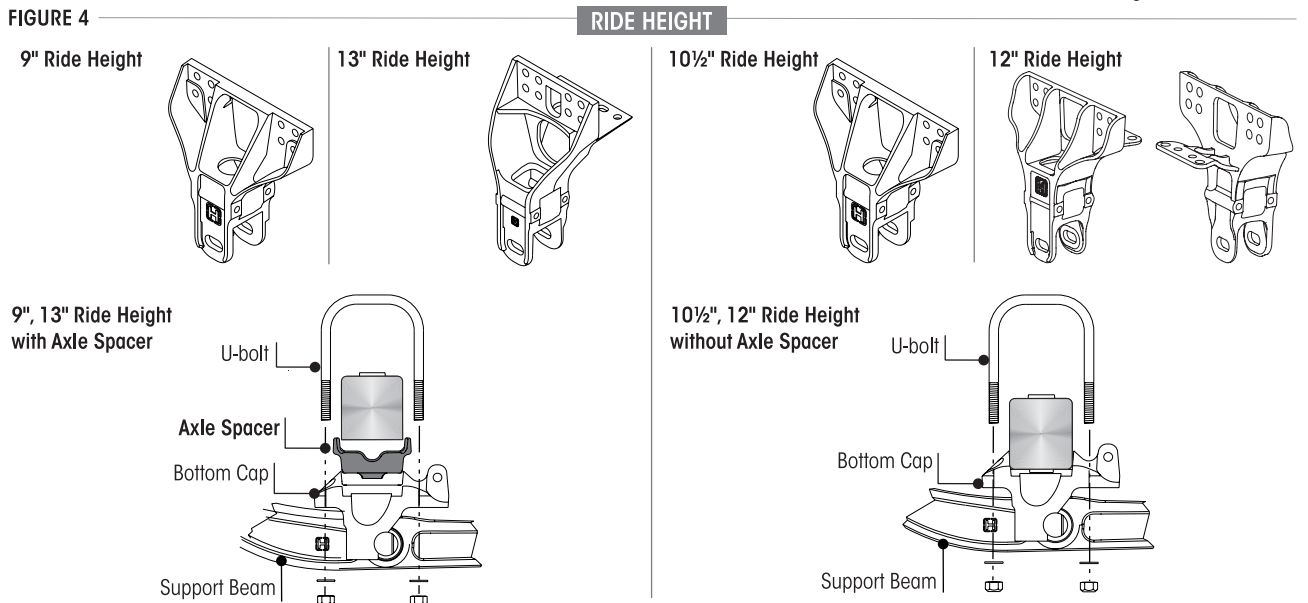
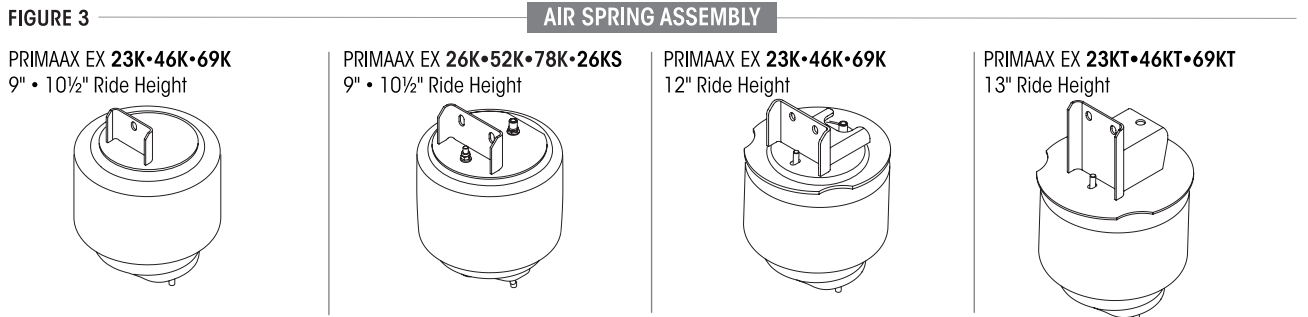
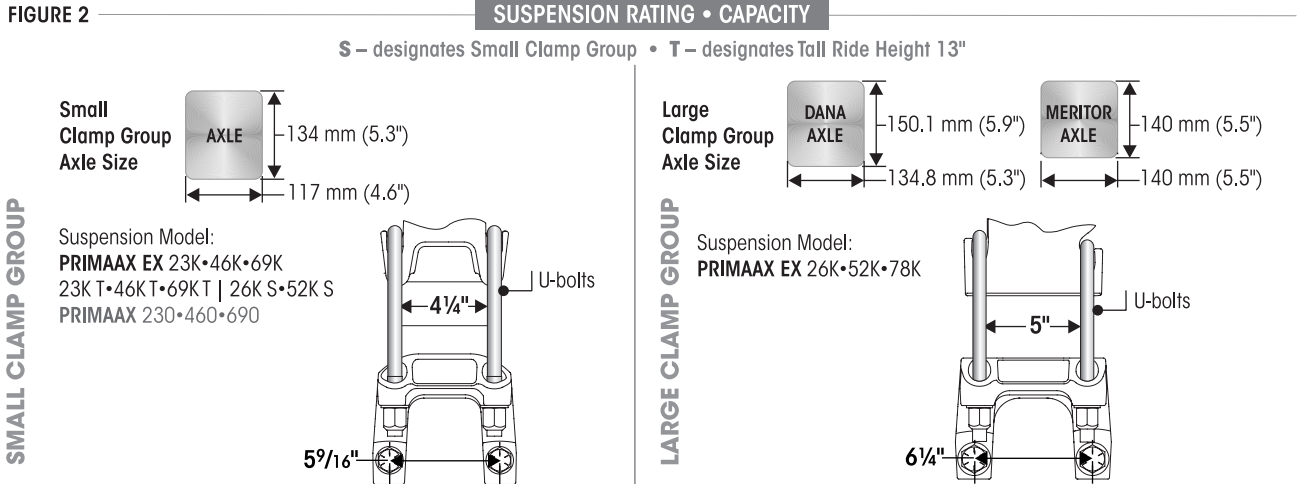
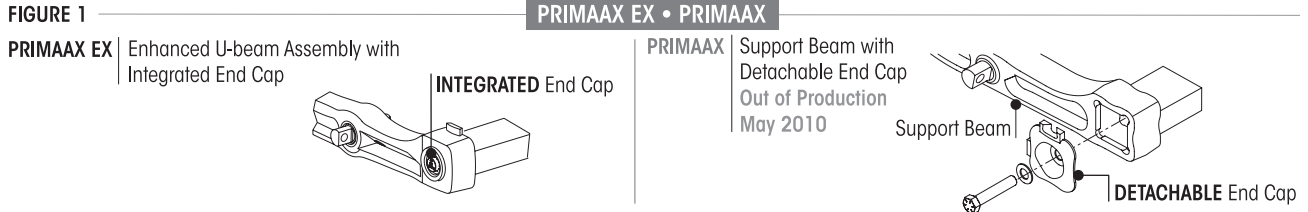


**PRIMAAX EX 26K • 52K • 78K**  
9"-10½" Ride Height



■ Technical Notes

The following information (Figure 1 through 3) is intended to assist in determining which suspension is equipped on the vehicle. As an example, Figure 2 identifies the suspension rating and capacity.

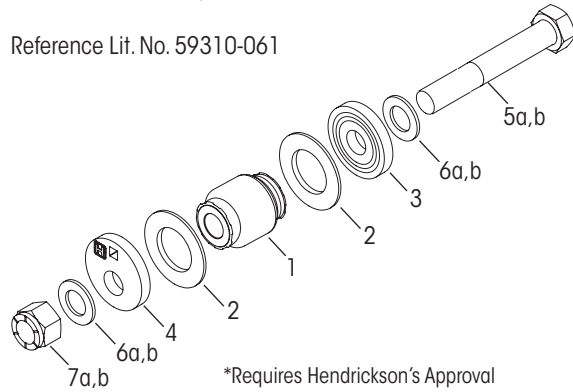




■ Severe Service Kits

Severe Service Kit | QUIK-ALIGN Pivot Bushing, Axle Set  
No. 60632-043 | 1" Fasteners  
No. 60632-033 | \*1 1/4" Fasteners

Reference Lit. No. 59310-061



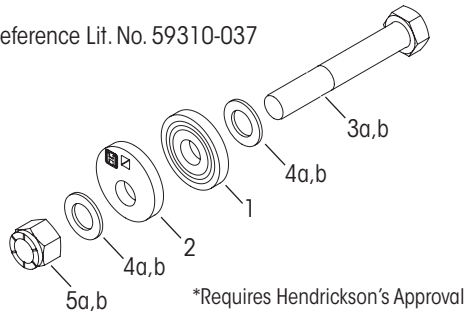
PRIMAAX EX • PRIMAAX Service Kit Nos.

60632-043 – 1" Fasteners, Includes Key Nos. 1-4, 5a-7a, 8  
60632-033 – 1 1/4" Fasteners (Requires Hendrickson Approval)  
Includes Key Nos. 1-4, 5b-7b, 8

KEY NO.	CONTENTS	KIT QTY.
1	QUIK-ALIGN Pivot Bushing	2
2	Confinement Washer	4
3	QUIK-ALIGN Concentric Collar	2
4	QUIK-ALIGN Eccentric Collar	2
5 a	1"-14 UNF x 7 1/2" Bolt	2
b	1 1/4"-12 UNF x 8" Bolt	2
6 a	1" Hardened Washer	4
b	1 1/4" Hardened Washer	4
7 a	1"-14 UNF Nylocknut	2
b	1 1/4"-12 UNF Nylocknut	2
8	P-80 Bushing Lubricant - 10 ml. (per Bushing 1)	2

Severe Service Kit | QUIK-ALIGN Collar, Axle Set  
No. 60632-021 | 1" Fasteners  
No. 60632-015 | \*1 1/4" Fasteners

Reference Lit. No. 59310-037



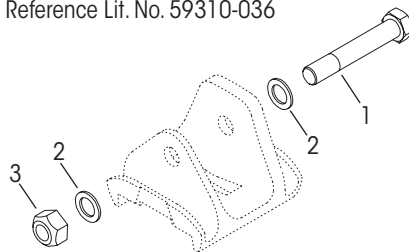
PRIMAAX EX • PRIMAAX Service Kits

60632-021 – 1" Fasteners, Includes Key Nos. 1-2, 3a-5a  
60632-015 – 1 1/4" Fasteners, Includes Key Nos. 1-2, 3b-5b

KEY NO.	CONTENTS	KIT QTY.
1	QUIK-ALIGN Concentric Collar	2
2	QUIK-ALIGN Eccentric Collar	2
3 a	1"-14 UNF x 7 1/2" Bolt	2
b	1 1/4"-12 UNF x 8" Bolt	2
4 a	1" Hardened Washer	4
b	1 1/4" Hardened Washer	4
5 a	1"-14 UNF Nylocknut	2
b	1 1/4"-12 UNF Nylocknut	2

Severe Service Kit | Top Pad Fasteners  
No. 58821-026 | Axle Set

Reference Lit. No. 59310-036



PRIMAAX 230 • 460 • 690 | 230T • 460T • 690T

8 1/2"-10 1/2"-12 1/2"-14 3/8"-15 1/2" Ride Height, Does Not Include Top Pad

Service Kit 58821-026

KEY NO.	CONTENTS	KIT QTY.
1	M24 x 3-6G Hendrickson Coated Hex Bolt	2
2	M24 Hardened Washer	4
3	M24 x 3-6H Locknuts	2

**NOTES:** Quantities specified are shown for a tandem suspension. Adjust quantities for single or tridem suspensions. Quantities of service kit components may vary from amount shown in lists.

\* Item included in assembly / kit only, part not sold separately.

\*\* Transverse rods are mandatory for the PRIMAAX EX • PRIMAAX suspensions regardless of axle spacing, see Literature No. 59310-004 and 59310-058 for more information. TRAAX ROD bushings are non-serviceable, the entire torque rod assembly requires replacement. Visit TRAAX ROD website [www.traaxrods.com](http://www.traaxrods.com) for more information.

\*\* S-cam is not required for disc brakes.

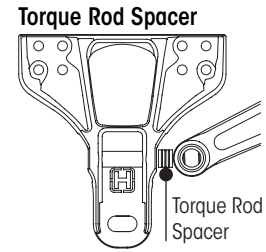
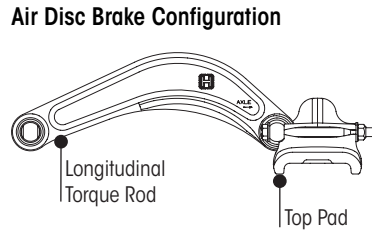
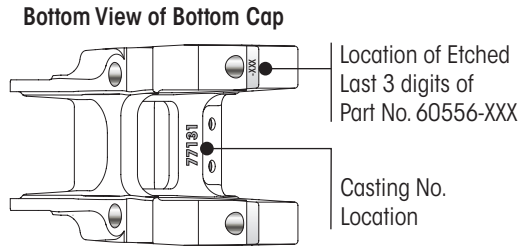
\*\*\* As originally equipped by vehicle manufacturer.

\*\*\*\* No longer available for service, see Replacement Guide on Page 21. For more information, refer to Hendrickson Technical Bulletin Literature No. SEU-0229 or contact Hendrickson Tech Services.

◆ Alternate configuration of the QUIK-ALIGN fasteners. The locknuts located inboard will allow additional clearance for wider tires or tires with chains. Tightening is still required ONLY on the locknut.



■ Bottom Cap, Longitudinal Torque Rod and Torque Rod Spacer | Small Clamp Group



AIR DISC BRAKES

FORWARD REAR DRIVE AXLE

● Longitudinal Torque Rod Part No. 67219-435

Pinion Angle	Bottom Cap Part No.	Pinion Angle	Bottom Cap Part No.	Pinion Angle	Bottom Cap Part No.	Pinion Angle	Bottom Cap Part No.	Torque Rod Spacer	
								Length (mm)	Part No.
0.4°	60556-025	0.9°	60556-030	1.3°	60556-035	3.1°	60556-055	0	—
1.5°		2.0°		2.4°		4.2°		6.35	67045-072
2.5°		3.1°		3.5°		5.3°		12.7	67045-071
3.6°		4.2°		4.5°		6.3°		19.05	67045-070
4.7°		5.3°		5.6°		7.4°		25.4	67045-069
3.3°	60556-025	3.9°	60556-030	4.2°	60556-035	6.0°	60556-055	0	—
4.4°		4.9°		5.3°		7.0°		6.35	67045-072
5.4°		6.0°		6.3°		8.1°		12.7	67045-071
6.5°		7.0°		7.4°		9.1°		19.05	67045-070
7.5°		8.1°		8.4°		10.2°		25.4	67045-069

REAR REAR DRIVE AXLE

● Longitudinal Torque Rod Part No. 67219-475

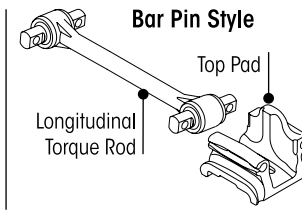
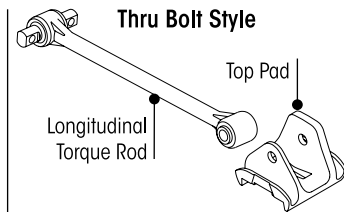
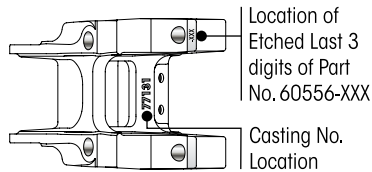
Axle Spacing			Bottom Cap Part No.	Axle Spacing			Bottom Cap Part No.	Torque Rod Spacer	
55"	60"	72"		55"	60"	72"		Length (mm)	Part No.
Pinion Angle			60556-100	Pinion Angle			60556-110	0	—
11.3°	11.4°	11.7°		12.2°	12.3°	12.6°		6.35	67045-072
12.3°	12.4°	12.7°		13.2°	13.3°	13.6°		12.7	67045-071
13.3°	13.4°	13.7°		14.2°	14.3°	14.6°		19.05	67045-070
14.3°	14.4°	14.7°		15.2°	15.3°	15.6°		25.4	67045-069
15.3°	15.4°	15.7°	60556-105	16.2°	16.3°	16.6°	60556-055	0	—
11.7°	11.8°	12.1°		14.0°	14.1°	14.4°		6.35	67045-072
12.7°	12.9°	13.2°		15.0°	15.1°	15.4°		12.7	67045-071
13.7°	13.9°	14.2°		16.0°	16.1°	16.4°		19.05	67045-070
14.8°	14.9°	15.2°		17.0°	17.1°	17.4°		25.4	67045-069
15.8°	15.9°	16.2°	18.0°	18.1°	18.4°				

● Non-serviceable torque rod bushings, requires replacement of complete torque rod assembly with bushings.

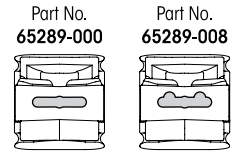


■ Bottom Cap, Longitudinal Torque Rod and Torque Rod Spacer | Small Clamp Group

Bottom View of Bottom Cap



Top View of Top Pad



Page 8  
Page 12  
Page 20

PRIMAAX EX 23K • 46K • 69K | 26K S ■ 9" • 10½" Ride Height  
PRIMAAX EX 23KT • 46KT • 69KT ■ 13" Ride Height  
PRIMAAX 230 • 460 • 6900 ■ 9" • 10½" Ride Height

DRUM BRAKES

FORWARD REAR DRIVE AXLE

① Thru Bolt Style Longitudinal Torque Rod Part No. 67274-510									
Pinion Angle	Bottom Cap Part No.	Pinion Angle	Bottom Cap Part No.	Pinion Angle	Bottom Cap Part No.	Pinion Angle	Bottom Cap Part No.	Torque Rod Spacer	
								Length (mm)	Part No.
2.2°	60556-025	2.8°	60556-030	3.1°	60556-035	4.9°	60556-055	0	—
3.3°		3.8°		4.2°		5.9°		6.35	67045-072
4.3°		4.9°		5.2°		7.0°		12.7	67045-071
5.4°		5.9°		6.3°		8.1°		19.05	67045-070
6.4°		7.0°		7.3°		9.1°		25.4	67045-069
① Thru Bolt Style Longitudinal Torque Rod Part No. 67274-515									
3.0°	60556-025	3.6°	60556-030	4.0°	60556-035	5.7°	60556-055	0	—
4.1°		4.7°		5.0°		6.8°		6.35	67045-072
5.2°		5.7°		6.1°		7.8°		12.7	67045-071
6.2°		6.8°		7.1°		8.9°		19.05	67045-070
7.3°		7.8°		8.2°		10.0°		25.4	67045-069

REAR REAR DRIVE AXLE

① Thru Bolt Style Longitudinal Torque Rod Part No. 67274-540									
Axle Spacing			Bottom Cap Part No.	Axle Spacing			Bottom Cap Part No.	Torque Rod Spacer	
55"	60"	72"		55"	60"	72"		Length (mm)	Part No.
Pinion Angle			Pinion Angle						
8.6°	8.7°	9.0°	60556-100	9.0°	9.1°	9.4°	60556-105	0	—
9.6°	9.7°	10.0°		10.1°	10.2°	10.5°		6.35	67045-072
10.6°	10.8°	11.1°		11.1°	11.2°	11.5°		12.7	67045-071
11.7°	11.8°	12.1°		12.1°	12.3°	12.6°		19.05	67045-070
12.7°	12.8°	13.1°		13.2°	13.3°	13.6°		25.4	67045-069
9.5°	9.6°	9.9°	60556-110	11.3°	11.4°	11.7°	60556-055	0	—
10.5°	10.6°	10.9°		12.3°	12.5°	12.8°		6.35	67045-072
11.5°	11.7°	12.0°		13.4°	13.5°	13.8°		12.7	67045-071
12.6°	12.7°	13.0°		14.4°	14.6°	14.9°		19.05	67045-070
13.6°	13.7°	14.0°		15.5°	15.6°	15.9°		25.4	67045-069

① Non-serviceable torque rod bushings, requires replacement of complete torque rod assembly with bushings.



■ Bottom Cap, Longitudinal Torque Rod and Torque Rod Spacer Selection Guide | Small Clamp Group

PRIMAAX EX 26K S ■ 9", 10½" Ride Heights									
DRUM BRAKES									
FORWARD REAR DRIVE AXLE									
Ride Height		Bottom Cap Part No.	Longitudinal Torque Rod Part No.❶	Ride Height		Bottom Cap Part No.	Longitudinal Torque Rod Part No.❶	Torque Rod Spacer	
9"	10½"			9"	10½"			Length (mm)	Part No.
Pinion Angle				Pinion Angle					
2.5°	2.0°	60556-025	62043-430N	3.4°	3.0°	60556-035	62043-430N	0	—
3.5°	3.2°			4.4°	4.3°			6.35	67045-072
4.6°	4.5°			5.5°	5.5°			12.7	67045-071
5.7°	5.7°			6.6°	6.7°			19.05	67045-070
6.7°	6.9°			7.6°	7.9°			25.4	67045-069
4.1°	3.9°	60556-025	62039-440N	5.1°	5.0°	60556-035	62039-440N	0	—
5.2°	5.2°			6.1°	6.2°			6.35	67045-072
6.3°	6.4°			7.2°	7.4°			12.7	67045-071
7.3°	7.6°			8.2°	8.6°			19.05	67045-070
8.3°	8.7°			9.2°	9.8°			25.4	67045-069
3.0°	2.6°	60556-030	62043-430N	5.2°	5.1°	60556-055	62043-430N	0	—
4.1°	3.9°			6.2°	6.3°			6.35	67045-072
5.1°	5.1°			7.3°	7.5°			12.7	67045-071
6.2°	6.3°			8.3°	8.7°			19.05	67045-070
7.2°	7.5°			9.4°	9.9°			25.4	67045-069
4.7°	4.6°	60556-030	62039-440N	6.8°	7.0°	60556-055	62039-440N	0	—
5.8°	5.8°			7.9°	8.2°			6.35	67045-072
6.8°	7.0°			8.9°	9.4°			12.7	67045-071
7.8°	8.2°			10.0°	10.6°			19.05	67045-070
8.9°	9.4°			11.0°	11.8°			25.4	67045-069

❶ Non-serviceable torque rod bushings, requires replacement of complete torque rod assembly with bushings.



■ Bottom Cap, Longitudinal Torque Rod and Torque Rod Spacer Selection Guide | Small Clamp Group

Page 8

PRIMAAX EX 26K S ■ 9", 10½" Ride Heights

DRUM BRAKES											
REAR REAR DRIVE AXLE											
Axle Spacing				Longitudinal Torque Rod Part No.❶	Axle Spacing				Longitudinal Torque Rod Part No.❶	Torque Rod Spacer	
55"		60"			55"		60"			Length (mm)	Part No.
Ride Height		Ride Height			Ride Height		Ride Height				
9"	10½"	9"	10½"		9"	10½"	9"	10½"			
Pinion Angle				Pinion Angle							
Bottom Cap Part No. 60556-100					Bottom Cap Part No. 60556-110						
5.5°	5.2°	5.6°	5.3°	62039-440N	6.4°	6.2°	6.5°	6.3°	62039-440N	0	—
6.6°	6.4°	6.7°	6.5°		7.5°	7.4°	7.6°	7.5°		6.35	67045-072
7.6°	7.6°	7.8°	7.7°		8.5°	8.6°	8.6°	8.7°		12.7	67045-071
8.7°	8.8°	8.8°	8.9°		9.6°	9.8°	9.7°	9.9°		19.05	67045-070
9.7°	10.0°	9.8°	10.1°		10.6°	11.0°	10.7°	11.1°		25.4	67045-069
11.3°	11.7°	11.4°	11.9°	62040-475N	12.2°	12.8°	12.3°	12.9°	62040-475N	0	—
12.3°	13.0°	12.4°	13.0°		13.8°	13.4°	13.3°	13.5°		6.35	67045-072
13.3°	14.0°	13.4°	14.2°		14.2°	14.6°	14.3°	14.7°		12.7	67045-071
14.3°	15.2°	14.4°	15.3°		15.2°	15.7°	15.3°	15.8°		19.05	67045-070
15.3°	16.4°	15.4°	16.5°		16.2°	16.9°	16.3°	17.0°		25.4	67045-069
13.7°	14.5°	13.8°	14.6°	62040-490N	14.6°	15.0°	14.7°	15.1°	62040-490N	0	—
14.7°	15.6°	14.8°	15.7°		15.6°	16.1°	15.7°	16.3°		6.35	67045-072
15.7°	16.8°	15.8°	16.9°		16.6°	17.3°	16.7°	17.4°		12.7	67045-071
16.7°	17.9°	16.8°	18.0°		17.6°	18.4°	17.7°	18.5°		19.05	67045-070
17.7°	19.0°	17.8°	19.2°		18.6°	19.6°	18.7°	19.7°		25.4	67045-069
Bottom Cap Part No. 60556-105					Bottom Cap Part No. 60556-055						
6.0°	5.7°	6.1°	5.8°	62039-440N	8.3°	8.3°	8.4°	8.4°	62039-440N	0	—
7.0°	6.9°	7.1°	7.0°		9.3°	9.5°	9.4°	9.6°		6.35	67045-072
8.1°	8.1°	8.2°	8.2°		10.4°	10.7°	10.5°	10.8°		12.7	67045-071
9.1°	9.3°	9.2°	9.4°		11.4°	11.9°	11.5°	12.0°		19.05	67045-070
10.2°	10.5°	10.3°	10.6°		12.4°	13.1°	12.5°	13.2°		25.4	67045-069
11.7°	12.3°	11.4°	12.7°	62040-475N	14.0°	14.8°	14.1°	14.9°	62040-475N	0	—
12.7°	13.4°	12.9°	13.5°		15.0°	16.0°	15.1°	16.1°		6.35	67045-072
13.7°	14.6°	13.9°	14.7°		16.0°	17.1°	16.1°	17.2°		12.7	67045-071
14.8°	15.7°	14.9°	15.8°		17.0°	18.3°	17.1°	18.4°		19.05	67045-070
15.8°	16.9°	15.9°	17.0°		18.0°	19.4°	18.1°	19.5°		25.4	67045-069
14.1°	15.0°	14.2°	15.1°	62040-490N	16.4°	17.5°	16.5°	17.6°	62040-490N	0	—
15.1°	16.1°	15.2°	16.3°		17.4°	18.7°	17.5°	18.8°		6.35	67045-072
16.1°	17.3°	16.3°	17.4°		18.4°	19.8°	18.5°	19.9°		12.7	67045-071
17.1°	18.4°	17.3°	18.5°		19.3°	20.9°	19.5°	21.0°		19.05	67045-070
18.1°	19.6°	18.2°	19.7°		20.3°	22.0°	20.5°	22.2°		25.4	67045-069

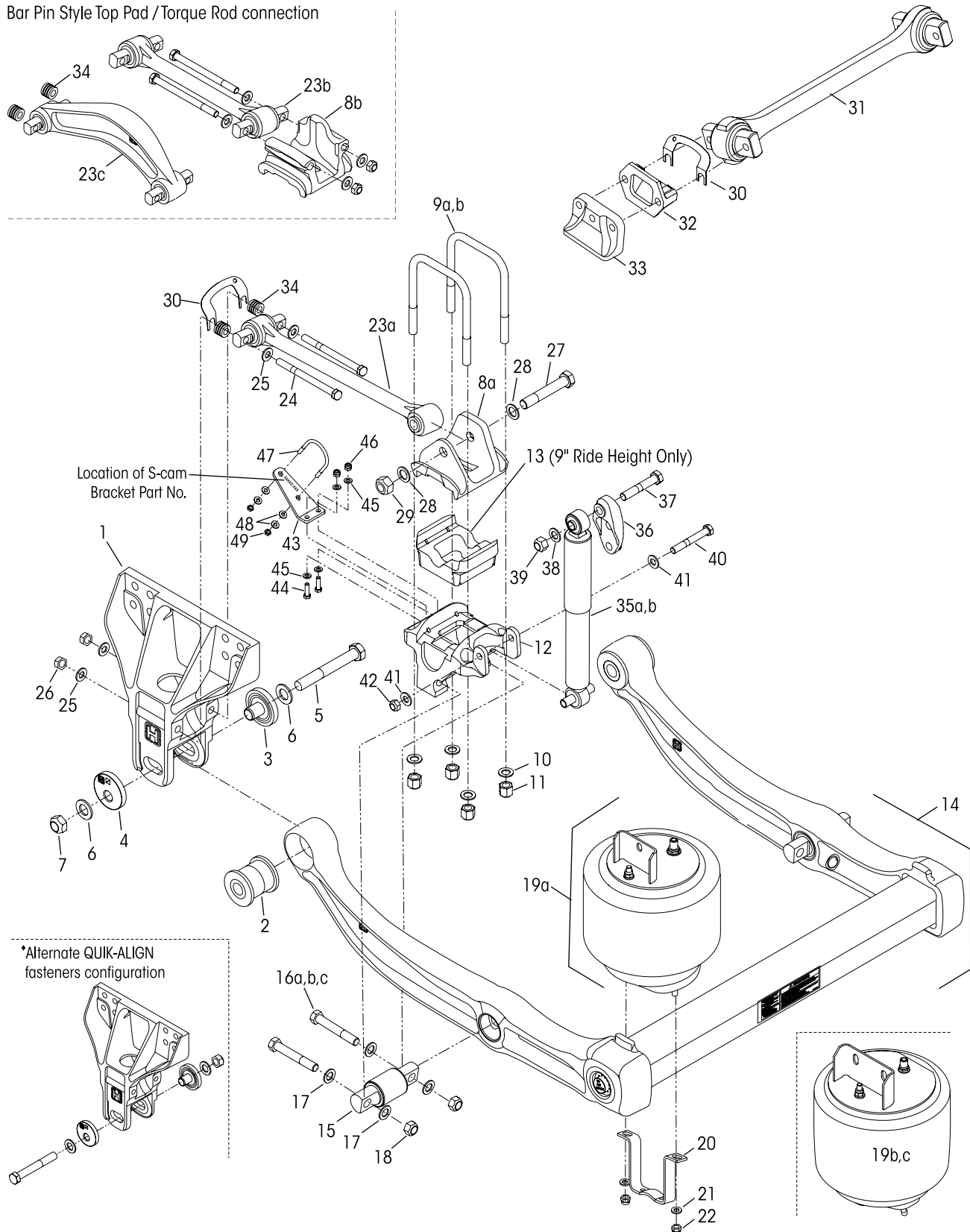
❶ Non-serviceable torque rod bushings, requires replacement of complete torque rod assembly with bushings.



PRIMAAX EX 23K • 46K • 69K lb Capacity  
 PRIMAAX EX 26KS • 52KS lb Capacity

9", 10½" Ride Height  
 9" Ride Height (S – designates Small Clamp Group)

Bar Pin Style Top Pad / Torque Rod connection





# PRIMAAX® EX 23K•46K•69K•26K S•52K S for International Truck Vehicles

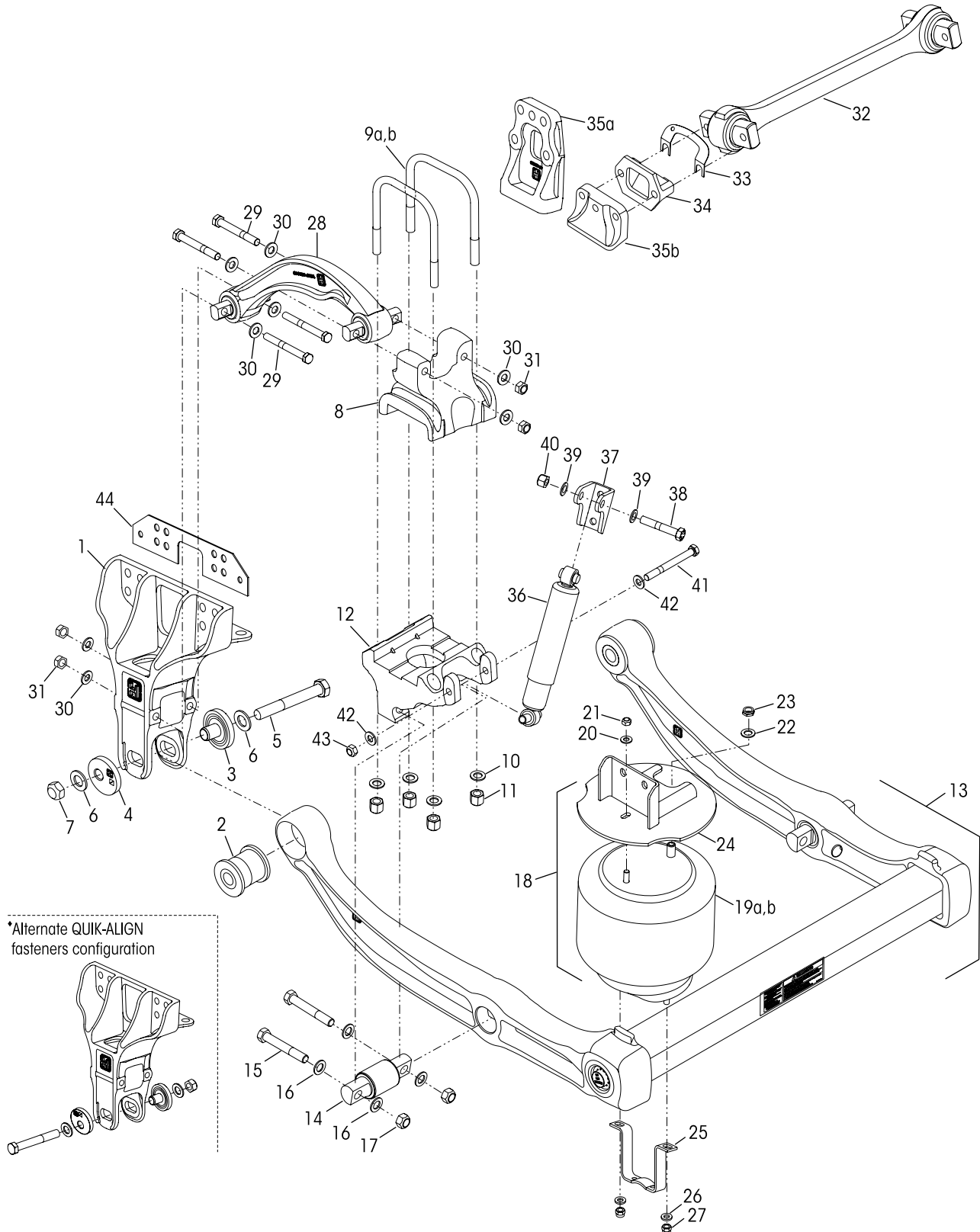
KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
1	67706-000	Frame Hanger	4
		<b>QUIK-ALIGN® Pivot Bushing Service Kits,</b> Includes Key Nos. 2-7, 50	
	60961-720	One Wheel End	
	60632-020	Axle Set	
		<b>QUIK-ALIGN Collar Service Kit,</b> Includes Key Nos. 3-7	
	60632-019	One Wheel End, <i>Replaces 60632-006</i>	
	60632-021	Axle Set	
	60632-018	<b>QUIK-ALIGN Fastener Service Kit, One Wheel End,</b> Includes Key Nos. 5-7, <i>Replaces 60632-005</i>	
2		*Pivot Bushing	4
3		*Concentric Collar	4
4		*Eccentric Collar	4
5		*1"-14 UNF x 7½" Hendrickson Coated Hex Bolt	4
6		*1" Hendrickson Coated Flat Washer	8
7		*1"-14 UNF-2B Hendrickson Coated Locknut	4
8		Top Pad, <i>see Graphic on Page 5</i>	4
a	65290-001	Thru Bolt Style	
b	65289-000	Bar Pin Style	
	65289-008	Bar Pin Style	
		<b>U-bolt Service Kit, One Wheel End,</b> Includes Kit No. 48718-501	
	91430-040	Includes Key Nos. 9a	
	91430-041	Includes Key Nos. 9b (Thru Bolt Style)	
	91430-048	Includes Key Nos. 9c (Bar Pin Style)	
9		*¾" Square U-bolt	
a		8⅞" Length - 10½" Ride Height	8
b		10⅜" Length - 9" Ride Height	8
c		10⅜" Length - 9" Ride Height	8
	48718-501	<b>U-bolt Fasteners Service Kit, One Wheel End,</b> Includes Key Nos. 10-11	
10		*¾" Flat Washer	16
11		*¾"-16 UNF U-bolt Locknut	16
12	60556-XXX	Bottom Cap - Front and Rear, <i>see Selection Guides on Pages 4 to 7</i>	4
13	65139-003	Axle Spacer, 9" Ride Height Only	4
14		U-beam Assembly, Includes Key Nos. 2, 15	2
		• Front Frame Width	
	67249-012	34.3"	
	67249-010	34.5"	
	67249-024	34.8"	
		• Rear Frame Width	
	67249-011	34.3"	
	67249-009	34.5"	
	67249-023	34.8"	
		<b>Single D-Pin Bushing Service Kit,</b> Includes Key Nos. 15, 16a, 17-18	
	34013-107	Includes Key Nos. 15, 16b, 17-18	
	34013-116	Includes Key Nos. 15, 16c, 17-18	
	34013-117	Includes Key Nos. 15, 16c, 17-18	
15		*D-Pin Bushing	4
		<b>D-Pin Fastener Service Kit, Axle Set,</b>	
	56659-009	Includes Key Nos. 16a, 17-18	
	56659-013	Includes Key Nos. 16b, 17-18	
	56659-012	Includes Key Nos. 16c, 17-18	
16		*¾"-16 UNF Bolt	8
a		5" Length	
b		5½" Length	
c		4¾" Length	
17		*¾" Flat Washer	16
18		*¾"-16 UNF Locknut	8
		<b>Single Air Spring Service Kit,</b> Includes Key Nos. 19a-22	
	60961-664	Includes Key Nos. 19a-22	
	60961-665	Includes Key Nos. 19b-22	

KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
19		Air Spring Assembly with Upper Frame Bracket	4
a	67234-002L	23K•46K•69K	
b	80602-002L	23K•46K•69K	
c	68056-002L	26K S• 52K S	
20	60911-002	Lower Air Spring Mounting Bracket	4
	49177-006	<b>Lower Air Spring Fastener Service Kit, Single,</b> Includes Key Nos. 21-22	
21		*½" Flat Washer	8
22		*½"-13 UNC Locknut	8
23		Longitudinal Torque Rod Assembly, <i>see Selection Guides on Pages 4 to 7</i>	4
a	67274-XXX	Thru Bolt Style	
b	620XX-XXXN	Bar Pin Style, Specify Length	
c	67219-XXX	Air Disc Brake	
		<b>Single Longitudinal Torque Rod Fastener Kit</b>	
	49176-026	Thru Bolt and Bar Pin Connection, Includes Key Nos. 24-29	
	49176-032	2-Bar Pin Connections, Includes Key Nos. 24-26	
	58821-012	Rear Thru Bolt Connection Only, Includes Key Nos. 27-29	
24		*⅝"-11 UNC-2B x 8" Bolt	8
25		*⅝" Flat Washer	16
26		*⅝"-11 UNC-2A Locknut	8
27		*⅞"-14 UNF-2A x 5½" Hex Bolt	4
28		*⅞" Hendrickson Coated Flat Washer	8
29		*⅞"-14 UNF-2B Locknut	4
30	49689-000L	Shim	As Req.
31	8240-0000-XXX	**TRAAX ROD®, Specify length in mm <i>Replaces 72000-XXXS</i>	
32	22186-000	Transverse Torque Rod Frame Bracket	2
33	60593-000L	Axle Stop, Frame Mounted	4
34	67045-XXX	Torque Rod Spacer, <i>see Selection Guides on Pages 4 to 7</i>	
35a	60657-003L	Shock Absorber	4
b	70807-001L	Heavy-duty Shock Absorber, Optional	4
c	60665-011L	Shock Absorber - 26K S	2
36	67463-002	Upper Shock Frame Bracket	4
	50754-030	<b>Single Shock Fastener Service Kit,</b> Includes Key Nos. 37-42	
37		*¾"-10 UNC x 4¼" Upper Shock Bolt	4
38		*¾" Flat Washer	4
39		*¾"-10 UNC Locknut	4
40		*⅝"-11 UNC x 6" Lower Shock Bolt	4
41		*⅝" Flat Washer	8
42		*⅝"-11 UNC-2B Locknut	4
	<b>NOTE</b>	<b>Key Nos. 43-49</b> are not required if equipped with 23c and Air Disc Brake	
43	64508-XXX	S-cam Support Bracket, <i>Locate part number on component</i>	4
	58821-017	<b>S-cam Fastener Service Kit, Axle Set,</b> Includes Key Nos. 44-49	
44		*⅜"-16 UNC x 1¼" Hex Bolt	8
45		*⅜" Hardened Washer	16
46		*⅜"-16 UNC Locknut	8
47		*⅝"-16 S-cam U-bolt	4
48		*⅝"-16 Hardened Washer	16
49		*⅝"-18 UNC Locknut	8
50	70867-001	P-80 Lubricant - 10 ml (Not Shown)	per Bushing 1



PRIMAAX EX Tandem 40K • 46K • 52KS • 52K lb Capacity  
 Equipped with Air Disc Brakes

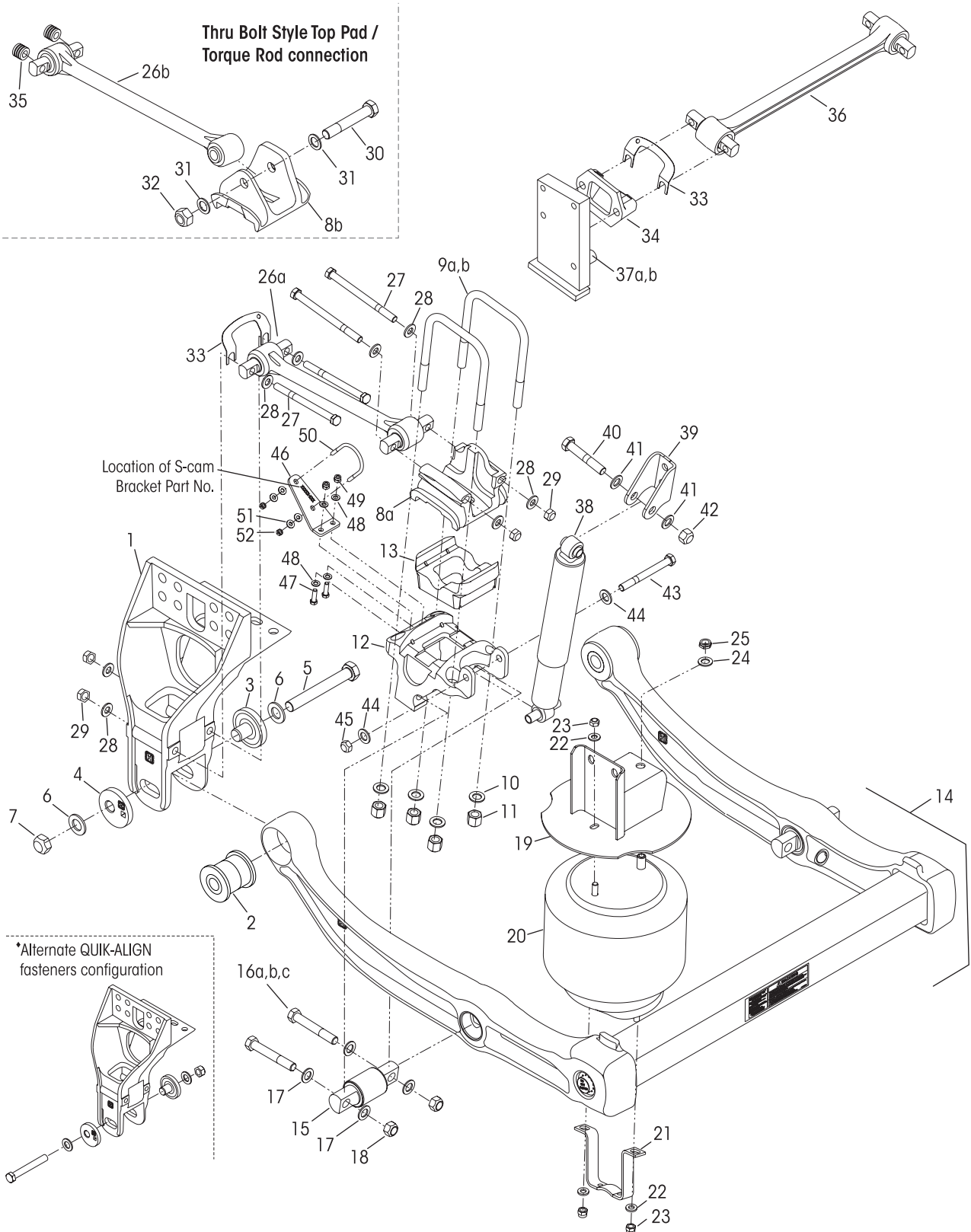
12" Ride Height  
 S – designates Small Clamp Group





# PRIMAAX® EX 40K•46K•52K•52KS for International Truck Vehicles

KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.	KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
1	80033-001	Frame Hanger	4	15		*Bolt	8
		<b>QUIK-ALIGN® Pivot Bushing Service Kits,</b>		a		3/4"-16 UNF 4 3/4" Length	
	60961-720	Includes Key Nos. 2-7, 45		b		7/8"-14 UNF x 5"	
	60632-020	One Wheel End		c		7/8"-14 UNF x 5 1/2"	
		<b>QUIK-ALIGN Collar Service Kit, Includes Key Nos. 3-7</b>		16		*Flat Washer	16
	60632-019	One Wheel End		a		3/4"	
	60632-021	Axle Set		b		7/8"	
	60632-018	<b>QUIK-ALIGN Fastener Service Kit, One Wheel End,</b>		17		*Locknut	8
		Includes Key Nos. 5-7		a		3/4"-16 UNF	
2		*Pivot Bushing	4	b		7/8"-14 UNF	
3		*Concentric Collar	4	18		Air Spring Assembly with Upper Frame Bracket	4
4		*Eccentric Collar	4		93745-002	46K, Includes Key Nos. 19a, 20-24	
5		*1"-14 UNF x 7 1/2" Hendrickson Coated Hex Bolt	4		91619-002	52K, Includes Key Nos. 19b, 20-24	
6		*1" Hendrickson Coated Flat Washer	8	19		Air Spring	
7		*1"-14 UNF-2B Hendrickson Coated Locknut	4	a	67391-002L	46K	
8		Top Pad, <i>see Graphic on Page 14</i>	4	b	67044-002L	52K	
a	65289-000	46K		20		*1/2" Flat Washer	8
b	91565-012A	52K, Forward Rear Straight		21		*1/2"-13 UNC Locknut	8
	91565-033B	52K, Forward Rear Transition		22		*3/4" Flat Washer	4
	91565-031A	52K, Rear Rear Straight		23		*3/4"-16 UNF Locknut	4
	91565-011B	52K, Rear Rear Transition		24	65031-014	Upper Air Spring Bracket	4
		<b>U-bolt Service Kit, One Wheel End, Includes</b>		25	60911-002	Lower Air Spring Mounting Bracket	4
		Kit No. 48718-501			49177-006	<b>Lower Air Spring Fastener Service Kit, Single,</b>	
	91430-047	40K•46K•52KS, Includes Key No. 9a				Includes Key Nos. 26-27	
	91430-042	52K, Includes Key No. 9b		26		*1/2" Flat Washer	8
9		*3/4"-16 UNF Square U-bolt	8	27		*1/2"-13 UNC Locknut	8
a		8.879" Length		28		Longitudinal Torque Rod Assembly	4
a		10" Length			67219-435	46K Forward Rear	
	48718-501	<b>U-bolt Fasteners Service Kit, One Wheel End,</b>			67219-475	46K Rear Rear	
		Includes Key Nos. 10-11			91277-002A	52K Left Hand Forward Rear	
10		*3/4" Flat Washer	16		91277-001B	52K Right Hand Forward Rear	
11		*3/4"-16 UNF U-bolt Locknut	16		91277-004A	52K Left Hand Rear Rear	
12		Bottom Cap	4		91277-004B	52K Right Hand Rear Rear	
		• Forward Rear			49176-032	<b>Single Longitudinal Torque Rod Fastener Kit,</b>	
	60556-030	40K•46K•52KS, 3.42° Pinion Angle				Includes Key Nos. 29-31	
	65208-102	52K Left Hand, 3.59° Pinion Angle		29		*5/8"-11 UNC-2B x 8" Bolt	8
	65208-108	52K Right Hand, 3.59° Pinion Angle		30		*5/8" Flat Washer	16
		• Rear Rear		31		*5/8"-11 UNC-2A Locknut	8
	60556-110	40K, 12.61° Pinion Angle		32		**Transverse TRAAX ROD®	2
	60556-120	46K•52KS, 12.45° Pinion Angle			8240-2626-645	46K•52KS	
	65208-303	52K Left Hand, 11.31° Pinion Angle			8240-2323-510	52K	
	65208-309	52K Right Hand, 11.31° Pinion Angle		33	49689-000	Torque Rod Shim	As Needed
13		U-beam Assembly, Includes Key Nos. 2, 14	2	34	22186-000	Transverse Torque Rod Frame Bracket	2
		• Forward Rear		35		Axle Stop, Frame Mounted	4
	67249-024	40K•46K•52KS Meritor Axle		a	80618-001	46K•52KS	
	67249-026	52K Dana Axle		b	60593-012	52K	
		• Rear Rear		36		Shock Absorber	4
	67249-023	40K•46K•52KS Meritor Axle			60657-018	46K Meritor Axle	
	67249-025	52K Dana Axle			60665-011	52KS Meritor Axle	
		<b>Single D-Pin Bushing Service Kit</b>			60665-034	52K Dana Axle	
	34013-117	40K•46K•52KS, Includes Key Nos. 14a-17a		37	59423-030	Upper Shock Frame Bracket	4
	34013-114	52K Forward Rear, Includes Key Nos. 14b-17b			50754-030	<b>Single Shock Fastener Service Kit,</b>	
	34013-479	52K Rear Rear, Includes Key Nos. 14b-15c, 16b-17b				Includes Key Nos. 38-43	
14		*D-Pin Bushing	4	38		*3/4"-10 UNC x 4 1/4" Upper Shock Bolt	4
a		40K•46K•52KS		39		*3/4" Flat Washer	8
b		52K		40		*3/4"-10 UNC Locknut	4
		<b>D-Pin Fastener Service Kit, Axle Set</b>		41		*5/8"-11 UNC x 6" Lower Shock Bolt	4
	56659-012	40K•46K•52KS, Includes Key Nos. 15a-17a		42		*5/8" Flat Washer	8
	56659-010	52K Forward Rear, Includes Key Nos. 15b-17b		43		*5/8"-11 UNC-2B Locknut	4
	56659-032	52K Rear Rear, Includes Key Nos. 15c, 16b-17b		44		Spacer for 34.25" Frame Width	
				45	70867-001	P-80 Lubricant - 10 ml (Not Shown)	per Bushing 1





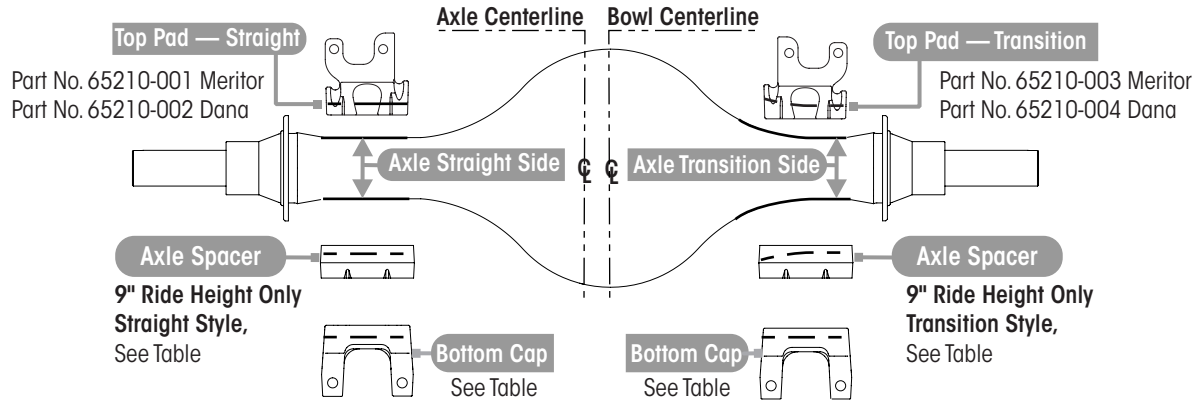
# PRIMAAX® EX 23KT•46KT•69KT for International Truck Vehicles

			VEHICLE				VEHICLE
KEY NO.	PART NO.	DESCRIPTION	QTY.	KEY NO.	PART NO.	DESCRIPTION	QTY.
1		Frame Hanger					
	67299-001	Left Hand	2		67923-002	Air Spring Assembly, Includes Key Nos. 19-20, 22-25	4
	67299-002	Right Hand	2	19	65031-008	Upper Air Spring Bracket Assembly <i>Replaces 65031-001</i>	4
		<b>QUIK-ALIGN® Pivot Bushing Service Kit,</b> Includes Key Nos. 2-7, 53			60961-724	<b>Single Air Spring Service Kit,</b> Includes Key Nos. 20-25	
	60961-720	One Wheel End		20	68070-002L	Air Spring	4
	60632-020	Axle Set		21	60911-002	Lower Air Spring Mounting Bracket	4
		<b>QUIK-ALIGN Collar Service Kit,</b> Includes Key Nos. 3-7 One Wheel End, <i>Replaces 60632-006</i>				<b>Single Air Spring Fastener Service Kit,</b> Lower, Includes Key Nos. 22-23	
	60632-019	One Wheel End, <i>Replaces 60632-006</i>			49177-006	Upper/Lower, Includes Key Nos. 22-25	
	60632-021	Axle Set		22		*1/2" Flat Washer	12
	60632-018	<b>QUIK-ALIGN Pivot Bolt Service Kit, One Wheel End,</b> Includes Key Nos. 5-7, <i>Replaces 60632-005</i>		23		*1/2"-13 UNC Locknut	12
2		*Pivot Bushing	4	24		*3/4" Flat Washer	4
3		*Concentric Collar	4	25		*3/4"-16 UNF Locknut	4
4		*Eccentric Collar	4	26 a,b		Longitudinal Torque Rod Assembly, Includes Bushing. Specify length in mm, <i>see Selection Guides on Pages 4 to 7</i>	4
5		*1"-14 UNF x 7 1/2" Hendrickson Coated Hex Bolt	4			<b>Single Longitudinal Torque Rod Fastener Kit</b> Thru Bolt and Bar Pin Connection, Includes Key Nos. 27-32	
6		*1" Hendrickson Coated Flat Washer	8		49176-026	2-Bar Pin Connections, Includes Key Nos. 27-29	
7		*1"-14 UNF-2B Hendrickson Coated Locknut	4		58821-012	Rear Thru Bolt Connection Only, Includes Key Nos. 30-32	
8		Top Pad, <i>see Graphic on Page 5</i>	4	27		*5/8"-11 UNC-2B x 8" Bolt	16
a	65289-000	Bar Pin Style		28		*5/8" Flat Washer	32
	65289-008	Bar Pin Style		29		*5/8"-11 UNC-2A Locknut	16
b	65290-001	Thru Bolt Style		30		*7/8"-14 UNF-2A x 5 1/2" Hex Bolt	4
		<b>U-bolt Service Kit, One Wheel End,</b> Includes Kit No. 48718-501		31		*7/8" Hendrickson Coated Flat Washer	8
	91430-048	Includes Key Nos. 9a (Bar Pin Style)		32		*7/8"-14 UNF-2B Locknut	4
	91430-041	Includes Key Nos. 9b (Thru Bolt Style)		33	49689-000L	Shim	As Req.
9		*3/4" Square U-bolt	8	34	22186-000	Transverse Torque Rod Frame Bracket	2
a		10 3/8" Length, Bar Pin Style		35	67045-XXX	Torque Rod Spacer, <i>see Selection Guides on Pages 4 to 7</i>	
b		10 3/8" Length, Thru Bolt Style		36	62011-XXXN	**Transverse Torque Rod Assembly, Includes Key No. 37, Specify length in mm	2
	48718-501	<b>U-bolt Fasteners Service Kit, One Wheel End,</b> Includes Key Nos. 10-11		37		Axle Stop, Frame Mounted	4
10		*3/4" Flat Washer	16	a	65510-001	0° Axle Tower	
11		*3/4"-16 UNF U-bolt Locknut	16	b	65510-002	20° Axle Tower	
12	60556-XXX	Bottom Cap, <i>see Selection Guides on Pages 4 to 7</i>	4	38	60665-011	Shock Absorber	4
13	65139-003	Axle Spacer (required)	4	39	59423-001	Upper Shock Frame Bracket	4
14		U-beam Assembly, Includes Key Nos. 2, 15	2		50754-030	<b>Single Shock Fastener Service Kit,</b> Includes Key Nos. 40-45	
		• Front Frame Width		40		*3/4"-10 UNC x 4 1/4" Upper Shock Bolt	4
	67249-012	34.3"		41		*3/4" Flat Washer	8
	67249-010	34.5"		42		*3/4"-10 UNC Locknut	4
	67249-024	34.8"		43		*5/8"-11 UNC x 6" Lower Shock Bolt	4
		• Rear Frame Width		44		*5/8" Flat Washer	8
	67249-011	34.3"		45		*5/8"-11 UNC-2B Locknut	4
	67249-009	34.5"		46	64508-XXX	S-cam Support Bracket, <i>Locate part number on component</i>	4
	67249-023	34.8"			58821-017	<b>S-cam Fastener Service Kit, Axle Set,</b> Includes Key Nos. 47-52	
		<b>Single D-Pin Bushing Service Kit,</b> Includes Key Nos. 15, 16a, 17-18		47		*3/8"-16 UNC x 1 1/4" Hex Bolt	8
	34013-107	Includes Key Nos. 15, 16b, 17-18		48		*3/8" Hardened Washer	16
	34013-116	Includes Key Nos. 15, 16c, 17-18		49		*3/8"-16 UNC Locknut	8
	34013-117	Includes Key Nos. 15, 16c, 17-18		50		*5/16" S-cam U-bolt	4
15		*D-Pin Bushing	4	51		*5/16" Hardened Washer	16
		<b>D-Pin Fastener Service Kit, Axle Set,</b> Includes Key Nos. 16a, 17-18		52		*5/16"-18 UNC Locknut	8
	56659-009	Includes Key Nos. 16b, 17-18		53	70867-001	P-80 Lubricant - 10 ml (Not Shown) per Bushing 1	
	56659-013	Includes Key Nos. 16c, 17-18					
	56659-012	Includes Key Nos. 16c, 17-18					
16		*3/4"-16 UNF Bolt	8				
a		5" Length					
b		5 1/2" Length					
c		4 3/4" Length					
17		*3/4" Flat Washer	16				
18		*3/4"-16 UNF Locknut	8				



Bottom Cap • Axle Spacer • Top Pad Selection Guide

Page 18 PRIMAAX EX 26K • 52K • 78K ■ 9", 10½" Ride Heights | Large Clamp Group



Axle Manufacturer	Beam Centers	Bottom Cap Part Number				Axle Spacer Part Number			
		Straight Side		Transition Side		Straight Side		Transition Side	
		FRONT	REAR	FRONT	REAR	FRONT	REAR	FRONT	REAR
MERITOR	40.0"	65208-001	65208-003	65208-006	65208-009	65276-000	—	65277-000	67973-004
	40.5"	—	—	—	—	—	—	—	—
DANA	40.0"	65208-002	65208-004	65208-008	65208-011	65274-000	—	65275-000	67973-002
	40.5"	—	—	—	—	—	—	—	—



■ Bottom Cap, Top Pad, Longitudinal Torque Rod and Torque Rod Spacer Selection Guide

Page 18 PRIMAAX EX 26K • 52K • 78K ■ 9", 10½" Ride Heights | Large Clamp Group  
See Graphic on Page 14

AIR DISC BRAKES									
FORWARD REAR DRIVE AXLE									
DANA AXLE									
Ride Height		Bottom Cap Part No.		ⓈLongitudinal Torque Rod Part No.		Top Pad Part No.		Torque Rod Spacer	
9"	10½"			Left Hand	Right Hand	Straight	Transition	Length (mm)	Part No.
Pinion Angle		Straight	Transition						
1.3°	1.5°	Ⓛ65208-102 Ⓜ65208-002	Ⓛ65208-108 Ⓜ65208-008	65302-460A	65302-460B	65210-002	65210-004	0	—
2.2°	2.5°							6.35	67045-072
3.0°	3.4°							12.7	67045-071
3.9°	4.4°							19.05	67045-070
4.7°	5.3°							25.4	67045-069
2.7°	3.1°	Ⓛ65208-102	Ⓛ65208-108	65302-470A	65302-470B	65210-002	65210-004	0	—
3.5°	4.0°							6.35	67045-072
4.4°	5.0°							12.7	67045-071
5.2°	5.9°							19.05	67045-070
6.1°	6.8°							25.4	67045-069
4.1°	4.6°	Ⓛ65208-102	Ⓛ65208-108	65302-480A	65302-480B	65210-002	65210-004	0	—
4.9°	5.5°							6.35	67045-072
5.8°	6.4°							12.7	67045-071
6.6°	7.4°							19.05	67045-070
7.5°	8.3°							25.4	67045-069
MERITOR AXLE									
1.3°	1.4°	Ⓛ65208-101 Ⓜ65208-001	Ⓛ65208-106 Ⓜ65208-006	65302-460A	65302-460B	65210-001	65210-003	0	—
2.2°	2.4°							6.35	67045-072
3.0°	3.3°							12.7	67045-071
3.9°	4.3°							19.05	67045-070
4.8°	5.3°							25.4	67045-069
2.7°	2.9°	Ⓛ65208-101	Ⓛ65208-106	65302-470A	65302-470B	65210-001	65210-003	0	—
3.6°	3.9°							6.35	67045-072
4.4°	4.9°							12.7	67045-071
5.3°	5.9°							19.05	67045-070
6.2°	6.8°							25.4	67045-069
4.1°	4.5°	Ⓛ65208-101	Ⓛ65208-106	65302-480A	65302-480B	65210-001	65210-003	0	—
5.0°	5.5°							6.35	67045-072
5.8°	6.4°							12.7	67045-071
6.7°	7.4°							19.05	67045-070
7.6°	8.4°							25.4	67045-069

- NOTES: Ⓛ Bottom caps with S-cam holes used for both the drum and/or air disc brakes.  
 Ⓜ Bottom caps without S-cam holes used for air disc brakes only.  
 Ⓢ Non-serviceable torque rod bushings, requires replacement of complete torque rod assembly with bushings.



■ Bottom Cap, Top Pad, Longitudinal Torque Rod and Torque Rod Spacer Selection Guide

Page 18

PRIMAAX EX 26K • 52K • 78K ■ 9", 10½" Ride Heights | Large Clamp Group  
See Graphic on Page 14

AIR DISC BRAKES

REAR REAR DRIVE AXLE

DANA AXLE

Axle Spacing				Bottom Cap Part No.		Ⓞ Longitudinal Torque Rod Part No.	Top Pad Part No.		Torque Rod Spacer	
55"		60"							Length (mm)	Part No.
Ride Height		Ride Height		Straight	Transition	Straight	Transition			
9"	10½"	9"	10½"						Pinion Angle	
8.0°	8.1°	8.6°	8.7°	Ⓛ65208-104 Ⓜ65208-004	Ⓛ65208-111 Ⓜ65208-011	65302-495A (LH) 65302-495B (RH)	65210-002	65210-004	0	—
8.8°	9.0°	9.6°	9.7°						6.35	67045-072
9.7°	9.8°	10.5°	10.6°						12.7	67045-071
10.5°	10.6°	11.4°	11.6°						19.05	67045-070
11.3°	11.5°	12.4°	12.5°						25.4	67045-069
10.0°	10.1°	10.8°	11.0°						0	—
10.8°	11.0°	11.8°	12.0°						6.35	67045-072
11.7°	11.8°	12.7°	12.9°						12.7	67045-071
12.5°	12.7°	13.6°	13.8°						19.05	67045-070
13.3°	13.5°	14.6°	14.7°						25.4	67045-069
10.7°	10.8°	11.6°	11.7°						0	—
11.5°	11.6°	12.5°	12.7°						6.35	67045-072
12.3°	12.5°	13.5°	13.6°						12.7	67045-071
13.2°	13.3°	14.4°	14.5°						19.05	67045-070
14.0°	14.2°	15.3°	15.5°						25.4	67045-069
11.3°	11.5°	12.3°	12.5°						0	—
12.2°	12.3°	13.3°	13.4°						6.35	67045-072
13.0°	13.1°	14.2°	14.3°						12.7	67045-071
13.8°	14.0°	15.1°	15.3°						19.05	67045-070
14.7°	14.8°	16.1°	16.2°						25.4	67045-069
12.0°	12.1°	13.1°	13.2°						0	—
12.8°	13.0°	14.0°	14.1°						6.35	67045-072
13.7°	13.8°	15.0°	15.1°						12.7	67045-071
14.5°	14.7°	15.9°	16.0°						19.05	67045-070
15.3°	15.5°	16.8°	17.0°						25.4	67045-069

- NOTES: Ⓛ Bottom caps with S-cam holes used for both the drum and/or air disc brakes.  
 Ⓜ Bottom caps without S-cam holes used for air disc brakes only.  
 Ⓞ Non-serviceable torque rod bushings, requires replacement of complete torque rod assembly with bushings.



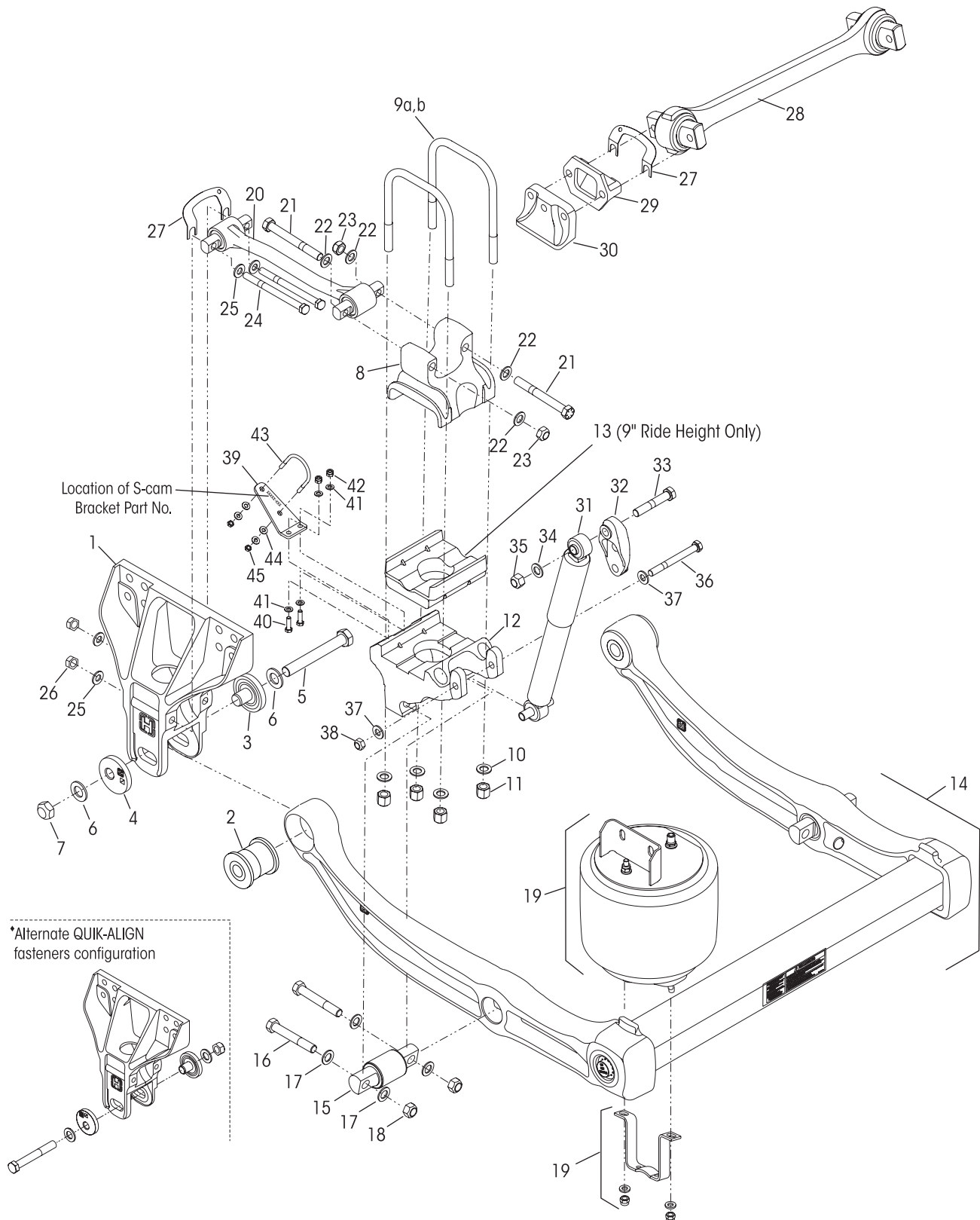
■ Bottom Cap, Top Pad, Longitudinal Torque Rod and Torque Rod Spacer Selection Guide

Page 18

PRIMAAX EX 26K • 52K • 78K ■ 9", 10½" Ride Heights | Large Clamp Group  
See Graphic on Page 14

AIR DISC BRAKES												
REAR REAR DRIVE AXLE												
MERITOR AXLE												
Axle Spacing				Bottom Cap Part No.		Ⓞ Longitudinal Torque Rod Part No.	Top Pad Part No.		Torque Rod Spacer			
55"		60"							Length (mm)	Part No.		
Ride Height		Ride Height		Straight	Transition	Straight	Transition					
9"	10½"	9"	10½"						Pinion Angle			
10.0°	10.1°	10.8°	11.0°	①65208-103 ②65208-003	①65208-109 ②65208-009	65302-510A (LH) 65302-510B (RH)	65210-001	65210-003	0	—		
10.8°	11.0°	11.8°	12.0°						6.35	67045-072		
11.7°	11.8°	12.7°	12.9°						12.7	67045-071		
12.5°	12.7°	13.6°	13.8°						19.05	67045-070		
13.3°	13.5°	14.6°	14.7°						25.4	67045-069		
10.3°	10.5°	11.1°	11.3°						0	—		
11.2°	11.4°	12.1°	12.2°						6.35	67045-072		
12.1°	12.2°	13.1°	13.2°						12.7	67045-071		
13.0°	13.1°	14.0°	14.2°						19.05	67045-070		
13.8°	14.0°	15.0°	15.1°						25.4	67045-069		
11.7°	11.9°	12.7°	12.8°						0	—		
12.6°	12.7°	13.6°	13.8°						6.35	67045-072		
13.5°	13.6°	14.6°	14.7°			12.7	67045-071					
14.3°	14.5°	15.5°	15.7°			19.05	67045-070					
15.2°	15.3°	16.5°	16.6°			25.4	67045-069					
12.4°	12.6°	13.4°	13.5°			0	—					
13.3°	13.4°	14.4°	14.5°			6.35	67045-072					
14.2°	14.3°	15.3°	15.5°			12.7	67045-071					
15.0°	15.2°	16.3°	16.4°			19.05	67045-070					
15.9°	16.0°	17.3°	17.4°			25.4	67045-069					
13.1°	13.2°	14.2°	14.3°			0	—					
14.0°	14.1°	15.1°	15.3°			6.35	67045-072					
14.8°	15.0°	16.1°	16.2°			12.7	67045-071					
15.7°	15.9°	17.1°	17.2°			19.05	67045-070					
16.6°	16.7°	18.0°	18.2°			25.4	67045-069					
								65302-520A (LH) 65302-520B (RH)				
								65302-525A (LH) 65302-525B (RH)				
								65302-530A (LH) 65302-530B (RH)				

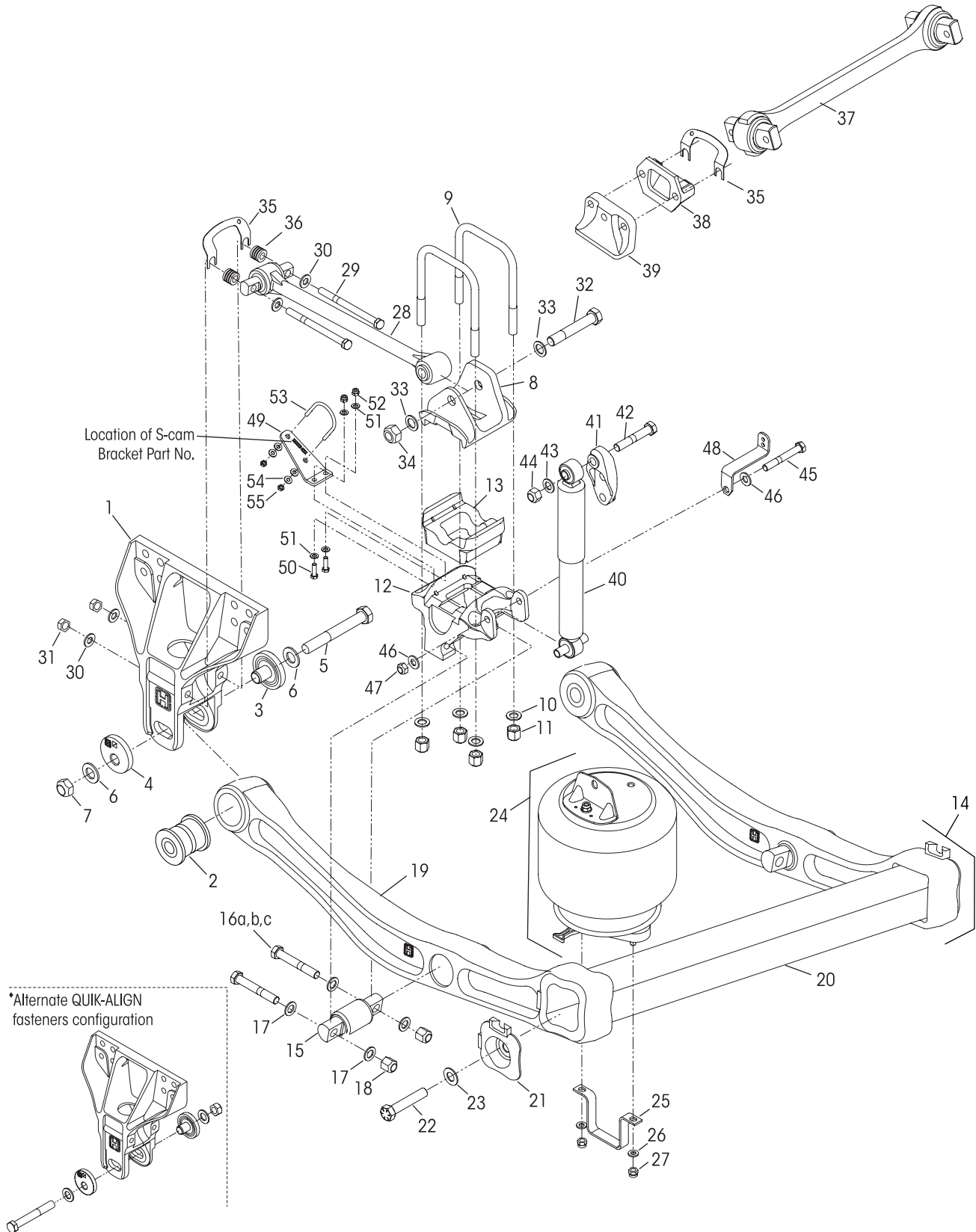
- NOTES: ① Bottom caps with S-cam holes used for both the drum and/or air disc brakes.  
 ② Bottom caps without S-cam holes used for air disc brakes only.  
 ③ Non-serviceable torque rod bushings, requires replacement of complete torque rod assembly with bushings.





# PRIMAAX® EX 26K•52K•78K for International Truck Vehicles

KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.	KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
1	67706-000	EX Frame Hanger	4		56659-010	<b>D-pin Fastener Service Kit, Axle Set</b> Includes Key Nos. 16-18	
	60961-720	One Wheel End		16		*7/8"-14 UNF x 5" Bolt	8
	60632-020	Axle Set		17		*7/8" Flat Washer	16
		<b>QUIK-ALIGN Collar Service Kit, Includes</b> Key Nos. 3-7		18		*7/8"-14 UNF Locknut	8
	60632-019	One Wheel End, <i>Replaces 60632-006</i>		19	68056-002	Air Spring Assembly with Upper Frame Bracket	4
	60632-021	Axle Set		20	65302-XXX	Longitudinal Torque Rod Assembly, <i>see Selection Guides on Pages 14 to 17</i>	4
	60632-018	<b>QUIK-ALIGN Fastener Service Kit, One Wheel End,</b> Includes Key Nos. 5-7, <i>Replaces 60632-005</i>				<b>Longitudinal Torque Rod Fastener Service Kit,</b> Axle Set, Includes Key Nos. 21-26	
2		*QUIK-ALIGN Pivot Bushing	4	21		*3/4"-16 UNF x 6" Hex Bolt	8
3		*QUIK-ALIGN Concentric Collar	4	22		*3/4" Flat Washer	16
4		*QUIK-ALIGN Eccentric Collar	4	23		*3/4"-16 UNF Locknut	8
5		*1"-14 UNF x 7 1/2" Hendrickson Coated Hex Bolt	4	24		*5/8"-11 UNC-2B x 8" Bolt	8
6		*1" Hendrickson Coated Flat Washer	8	25		*5/8" Flat Washer	16
7		*1"-14 UNF-2B Hendrickson Coated Locknut	4	26		*5/8"-11 UNC-2A Locknut	8
8		Top Pad, <i>see Graphic on Page 14</i>	4	27	49689-000L	Shim	As Req.
	48718-118	<b>U-bolt Service Kit, Axle Set</b> Includes Key Nos. 9a-9b, 10-11		28	8240-0000-XXX	**TRAAX ROD®, Specify length in mm <i>Replaces 72000-XXXS</i>	
9		*3/4" Square U-bolt	8	29	22186-000	Transverse Torque Rod Frame Bracket	2
a		11 1/2", Outboard		30	60593-000L	Axle Stop, Frame Mounted	4
b		12", Inboard		31	60665-013L	Shock Absorber	4
	48718-501	<b>U-bolt Fasteners Service Kit, One Wheel End,</b> Includes Key Nos. 10-11		32	67463-002	Upper Shock Frame Bracket	4
10		*3/4" Flat Washer	16		50754-036	<b>Single Shock Absorber Fastener Service Kit</b> Includes Key Nos. 33-38	
11		*3/4"-16 UNF U-bolt Locknut	16	33		*3/4"-10 UNC x 4 1/2" Upper Shock Bolt	4
12		Bottom Cap - Front and Rear <i>see Selection Guides on Pages 14 to 17</i>	4	34		*3/4" Flat Washer	As Req.
13		Axle Spacer - Front and Rear, 9" Ride Height Only <i>see Selection Guides on Pages 14 to 17</i>	4	35		*3/4"-10 UNC Locknut	4
14		U-beam Assembly, Includes Key Nos. 2, 15	2	36		*5/8"-11 UNC x 7" Lower Shock Bolt	4
		• Front		37		*5/8" Flat Washer	8
	67249-014	34.3" Frame Width		38		*5/8"-11 UNC-2B Locknut	4
	67249-016	34.5" Frame Width		39	64508-XXX	S-cam Support Bracket, <i>Locate part number on component</i>	4
	67249-026	34.8" Frame Width			58821-017	<b>S-cam Fastener Service Kit, Axle Set,</b> Includes Key Nos. 40-45	
		• Rear		40		*3/8"-16 UNC x 1 1/4" Hex Bolt	8
	67249-013	34.3" Frame Width		41		*3/8" Hardened Washer	16
	67249-015	34.5" Frame Width		42		*3/8"-16 UNC Locknut	8
	67249-025	34.8" Frame Width		43		*5/16" S-Cam U-bolt	4
	34013-114	<b>Single D-pin Bushing Service Kit,</b> Includes Key Nos. 15-18		44		*5/16" Hardened Washer	16
15		*D-pin Bushing	4	45		*5/16"-18 UNC Locknut	8
				46	70867-001	P-80 Lubricant - 10 ml (Not Shown)	per Bushing 1





# PRIMAAX® 230•460•690 for International Truck Vehicles

				VEHICLE					VEHICLE
KEY NO.	PART NO.	DESCRIPTION	QTY.	QTY.	KEY NO.	PART NO.	DESCRIPTION	QTY.	QTY.
1	67706-000	Frame Hanger, <i>Replaces 65891-000</i>	4	4	22		*7/8"-9 UNC x 3 1/2" Hex Bolt	4	
		<b>QUIK-ALIGN® Pivot Bushing Service Kit,</b>			23		*7/8" Hendrickson Coated Flat Washer	4	
		Includes Key Nos. 2-7, 56				60961-062	<b>Single Air Spring Service Kit,</b>		
	60961-720	One Wheel End					Includes Key Nos. 24-27		
	60632-020	Axle Set			24	60271-002L	Air Spring Assembly with Upper Frame Bracket	4	
		<b>QUIK-ALIGN Collar Service Kit,</b> Includes Key Nos. 3-7			25	60911-002	Lower Air Spring Mounting Bracket	4	
	60632-019	One Wheel End, <i>Replaces 60632-006</i>				49177-006	<b>Lower Air Spring Fastener Service Kit, Single,</b>		
	60632-021	Axle Set					Includes Key Nos. 26-27		
	60632-018	<b>QUIK-ALIGN Pivot Bolt Service Kit, One Wheel End,</b>			26		*1/2" Flat Washer	8	
		Includes Key Nos. 5-7, <i>Replaces 60632-005</i>			27		*1/2"-13 UNC Locknut	8	
2		*Pivot Bushing	4	4	28		Longitudinal Torque Rod Assembly,	4	
3		*Concentric Collar	4	4			<i>see Selection Guides on Pages 4 to 7</i>		
4		*Eccentric Collar	4	4			<b>Single Longitudinal Torque Rod Fastener Kit</b>		
5		*1"-14 UNF x 7 1/2" Hendrickson Coated Hex Bolt	4	4		49176-026	Thru Bolt and Bar Pin Connection,		
6		*1" Hendrickson Coated Flat Washer	8	8			Includes Key Nos. 29-34		
7		*1"-14 UNF-2B Hendrickson Coated Locknut	4	4		58821-012	Rear Thru Bolt Connection Only, Includes		
8		Top Pad	4	4			Key Nos. 32-34		
	65290-001				29		*5/8"-11 UNC-2B x 8" Bolt	8	
	91430-041	<b>U-bolt Service Kit, One Wheel End,</b> Includes			30		*5/8" Flat Washer	16	
		Kit No. 48718-501 and Key No. 9			31		*5/8"-11 UNC-2A Locknut	8	
9		*3/4" Square U-bolt, 10 3/8" Length	8	8	32		*7/8"-14 UNF-2A x 5 1/2" Hex Bolt	4	
	48718-501	<b>U-bolt Fasteners Service Kit, One Wheel End,</b>			33		*7/8" Hendrickson Coated Flat Washer	8	
		Includes Key Nos. 10-11			34		*7/8"-14 UNF-2B Locknut	4	
10		*3/4" Flat Washer	16	16	35	49689-000L	Shim	As Req.	
11		*3/4"-16 UNF U-bolt Locknut	16	16	36	67045-XXX	Torque Rod Spacer,		
12	60556-XXX	Bottom Cap - Front and Rear,	4	4			<i>see Selection Guides on Pages 4 to 7</i>		
13	65139-003	Axle Spacer	4	4	37	8240-0000-XXX	**TRAAX ROD®, Specify length in mm		
14		****U-beam Assembly, Includes Key Nos. 2, 15	2	2			<i>Replaces 72000-XXXS</i>		
		<i>(Replaces previous U-beam assembly,</i>			38	22186-000	Transverse Torque Rod Frame Bracket	2	
		<i>support beam and cross tube assembly,</i>			39	60593-000L	Axle Stop, Frame Mounted	4	
		<i>see Replacement Guide below)</i>			40	60657-003L	Shock Absorber	4	
		<b>Single D-Pin Bushing Service Kit,</b>			41	67463-002	Upper Shock Frame Bracket,	4	
	34013-107	Includes Key Nos. 15, 16a, 17-18					<i>Replaces 65000-002</i>		
	34013-116	Includes Key Nos. 15, 16b, 17-18				50754-030	<b>Single Shock Fastener Service Kit,</b>		
	34013-117	Includes Key Nos. 15, 16c, 17-18					Includes Key Nos. 42-47		
15		*D-Pin Bushing	4	4	42		*3/4"-10 UNC x 4 1/4" Upper Shock Bolt	4	
		<b>D-Pin Fastener Service Kit, Axle Set,</b>			43		*3/4" Flat Washer	4	
	56659-009	Includes Key Nos. 16a, 17-18			44		*3/4"-10 UNC Locknut	4	
	56659-013	Includes Key Nos. 16b, 17-18			45		*5/8"-11 UNC x 6" Lower Shock Bolt	4	
	56659-012	Includes Key Nos. 16c, 17-18			46		*5/8" Flat Washer	8	
16		*3/4"-16 UNF Bolt	8	8	47		*5/8"-11 UNC-2B Locknut	4	
	a	5" Length			48	60921-000	Height Control Valve Linkage Bracket	2	
	b	5 1/2" Length			49	64508-XXX	S-cam Support Bracket,	4	
	c	4 3/4" Length					<i>Locate part number on component</i>		
17		*3/4" Flat Washer	16	16		58821-017	<b>S-cam Fastener Service Kit, Axle Set,</b>		
18		*3/4"-16 UNF Locknut	8	8			Includes Key Nos. 50-55		
19		****Support Beam Assembly ( <i>66435-xxx, see</i>			50		*3/8"-16 UNC x 1 1/4" Hex Bolt	8	
		<i>Replacement Guide below)</i>			51		*3/8" Hardened Washer	16	
20		****Cross Tube ( <i>60912-xxx, see Replacement</i>			52		*3/8"-16 UNC Locknut	8	
		<i>Guide below)</i>			53		*5/16" S-cam U-bolt	4	
	46772-001	<b>End Cap and Fastener Kit, Axle Set,</b>			54		*5/16" Hardened Washer	16	
		Includes Key Nos. 21-23			55		*5/16"-18 UNC Locknut	8	
21		*End Cap	4	4	56	70867-001	P-80 Lubricant - 10 ml (Not Shown)	per Bushing 1	

## ■ Support Beam and Cross Tube Replacement Guide

Key Nos. 19, 20	DISCONTINUED May 2010				NEW		
	Support Beam Assembly Part Number				Cross Tube Part No.	U-beam Assembly Service Kit No.	
	60831-XXX • 66435-XXX				60912-XXX	60961-XXX	
*Frame Width (Inches)	LH Forward	LH Rear	RH Forward	RH Rear		Forward	Rear
34.3					-003	-261	-262
34.5	-003	-001	-004	-002	-002	-263	-264
34.8					-009	-243	-244

**NOTE:** \*Contact vehicle manufacturer to verify frame width.



■ Special Tools

**D-PIN / QUIK-ALIGN PIVOT BUSHING SERVICE TOOLS**

**PIN & BUSHING STARTER KIT**

**Tiger Tool Part No. 15000**  
For use with Pin & Bushing Adapter Kit

Visit [tigertool.com](http://tigertool.com)



**PIN & BUSHING ADAPTER KIT**

**Tiger Tool Part No. 15042**  
For use with Pin & Bushing Starter Kit

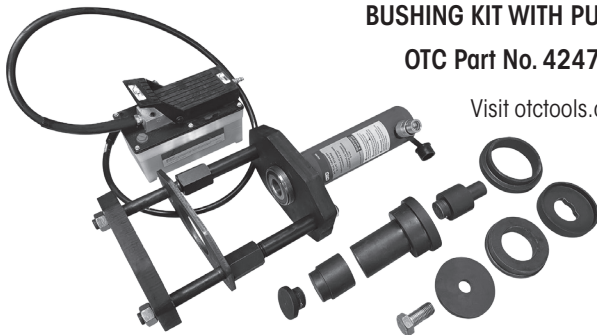
Visit [tigertool.com](http://tigertool.com)



**BUSHING KIT WITH PUMP**

**OTC Part No. 4247-FR**

Visit [otctools.com](http://otctools.com)



**BUSHING ADAPTER KIT**

**OTC Part No. 4254-FR**

For use with OTC Part No. 4247-fr

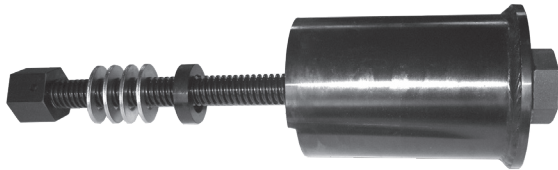
Visit [otctools.com](http://otctools.com)



**QUIK-ALIGN PIVOT BUSHING SERVICE TOOL**

**Hendrickson Part No. 66086-203L**

Reference Hendrickson Literature No. 59310-061



**QUIK-ALIGN SOCKET TOOL**

**OTC Part No. 1767**

Visit [otctools.com](http://otctools.com)

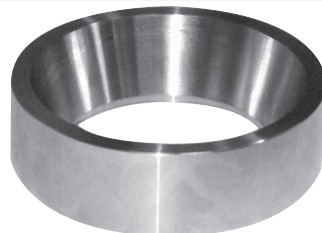


**TORQUE ROD BUSHING TOOLS**

**FUNNEL**

Hendrickson Part No. 66086-001L

**ULTRA ROD®**





This is a general parts list to provide directional information. Components may vary by model. Questions in regards to parts, contact Hendrickson Truck Parts at 855.743.3733 (Toll-free U.S. and Canada), 630.910.2800 (Outside U.S. and Canada) or email: [truckparts@hendrickson-intl.com](mailto:truckparts@hendrickson-intl.com).

Actual product performance may vary depending upon vehicle configuration, operation, service and other factors.

All applications must comply with applicable Hendrickson specifications and must be approved by the respective vehicle manufacturer with the vehicle in its original, as-built configuration.

Contact Hendrickson for additional details regarding specifications, applications, capacities, and operation, service and maintenance instructions.

*Call Hendrickson at **630.910.2800** or **855.RIDERED (855.743.3733)** for additional information.*



[www.hendrickson-intl.com](http://www.hendrickson-intl.com)

**TRUCK COMMERCIAL VEHICLE SYSTEMS**

800 South Frontage Road  
Woodridge, IL 60517-4904 USA  
855.743.3733 (Toll-free U.S. and Canada)  
630.910.2800 (Outside U.S. and Canada)  
Fax 630.910.2899

SP-233 Rev F 02-26

© 2012 – 2026 Hendrickson USA, L.L.C. All Rights Reserved. All trademarks shown are owned by Hendrickson USA, L.L.C., or one of the affiliates, in one or more countries.

Information contained in this literature was accurate at the time of publication. Product changes may have been made after the copyright date that are not reflected.

Printed in United States of America