

Asia Pacific Region Only



TECHNICAL BULLETIN

KENWORTH PRIMAAX® EX CRITICAL TORQUE SPECIFICATIONS

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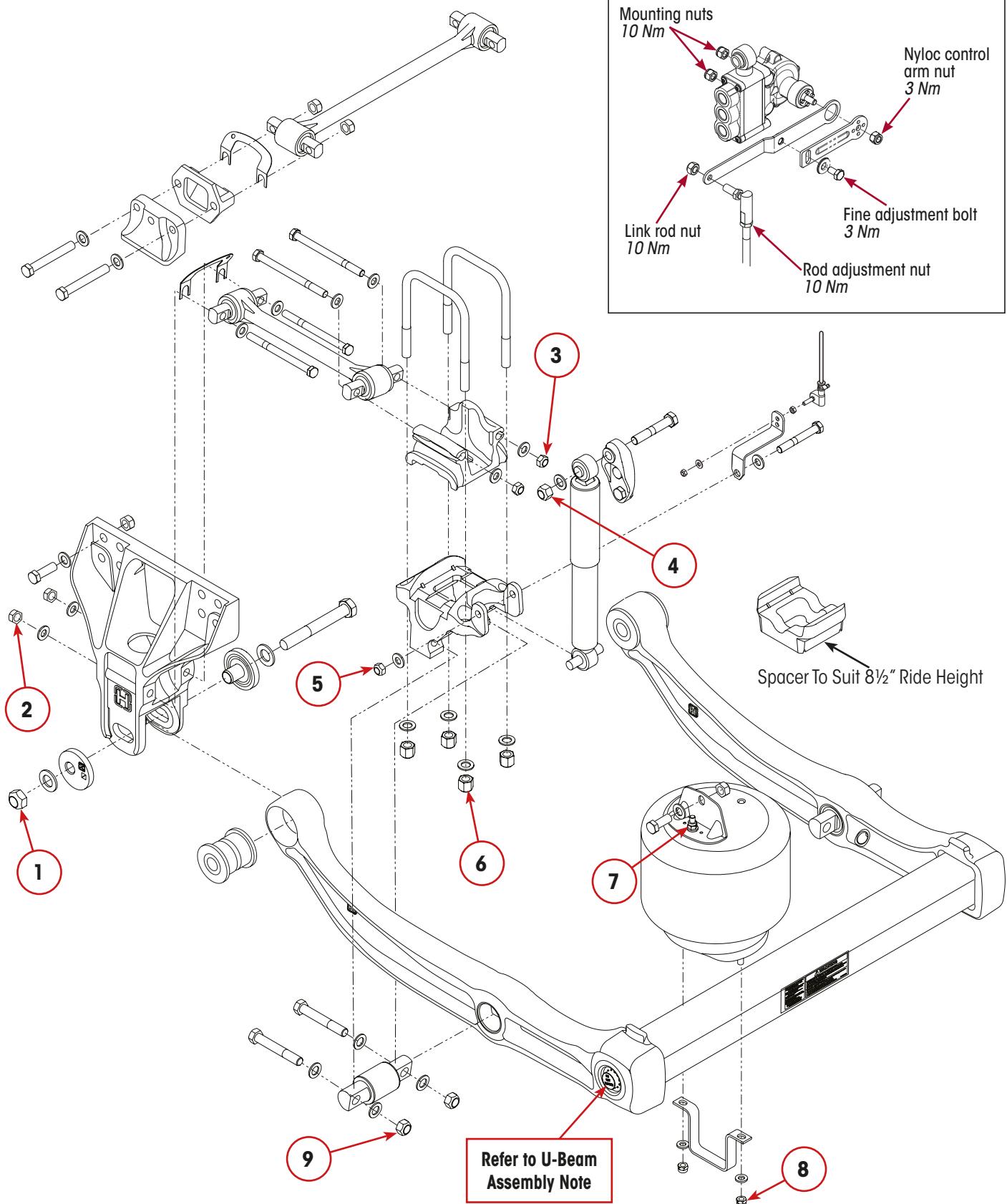


Refers to PRIMAAX EX suspensions as fitted to Kenworth vehicles that have been sold through Hendrickson Asia Pacific. For suspension identification, along with other service and maintenance information, refer to Hendrickson PRIMAAX EX Maintenance Manual, [97117-212](#).



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KENWORTH PRIMAAX® EX





KENWORTH PRIMAAX® EX

TORQUE NOTE

Torque values listed here apply only to Hendrickson OEM fasteners. Contact the vehicle manufacturer for torque specifications associated with fasteners not supplied by Hendrickson.

Item	Component	Thread	Torque	
			Nm	ft. lbs.
1	U-Beam Assembly to QUIK-ALIGN® Bush 38 mm (1-1/2") Bolt Head. Refer to QUIK-ALIGN Notes below.	1"-14 UNF	750	550
	U-Beam Assembly to QUIK-ALIGN Bush 47 mm (1-7/8") Bolt Head. Refer to QUIK-ALIGN Notes below and on page 4.	1-1/4"-12 UNF	1760	1300
2	Longitudinal Torque Rod to Frame Hanger	5/8"-11 UNC	285	210
3	Longitudinal Torque Rod to Top Pad – 232/462/692 Suspension [1]	5/8"-11 UNC	285	210
	Longitudinal Torque Rod to Top Pad – 262/522/782 Suspension [1]	3/4"-16 UNC	400	295
4	Upper Shock Absorber to Shock Bracket	3/4"-10 UNC	250	185
5	Lower Shock Absorber to Bottom Cap	5/8"-11 UNC	285	210
6	U-Bolt Locknut	3/4"-16 UNF	510	375
7	Air Spring Assembly to Upper Frame Bracket	1/2"-13 UNC	35	25
8	Air Spring Assembly to Lower Air Spring Mounting Bracket	1/2"-13 UNC	35	25
9	U-Beam Assembly to Centre D-Pin Bush	3/4"-16 UNF or 7/8"-14 UNF	400	295

QUIK-ALIGN® NOTES

Some vehicles may be fitted with a larger 1-1/4" QUIK-ALIGN® bolt that must be torqued to 1760 Nm. This includes Kenworth vehicles built between 2011 and 2017. This differs from the standard fitment 1" bolt, which needs a final torque of 750 Nm. Use the bolt head size to determine QUIK-ALIGN bolt type. Refer to next page for 1-1/4" bolt torque details.

In service the 1" bolt can be used in place of the 1-1/4" bolt. However, be sure to use the right amount of torque for the bolt size.

If replacing the pivot bush for use with the larger 1-1/4" QUIK-ALIGN bolt, verify that the bolt passes freely through the inner metal sleeve of the new bush. If it does not, then the bush inner sleeve must be reamed to a diameter of 31.75 mm (1-1/4") and then rechecked for clearance.

U-BEAM ASSEMBLY NOTE

Vehicles built after March 2009 have integrated end caps that do not require re-torque. The bolt heads are covered with tamper resistant caps. Vehicles built prior to this date do not have tamper resistant caps and require a torque of 745 Nm applied at regular service intervals.

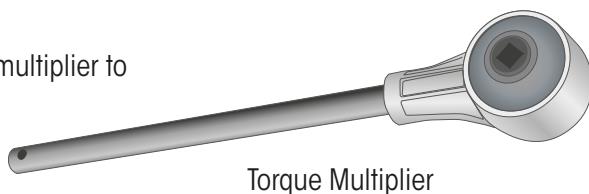
[1] For suspension identification, along with other service and maintenance information, refer to Hendrickson PRIMAAX EX Maintenance Manual, [97117-212](#).

1 1/4" QUIK-ALIGN BOLT TORQUE

There are two possible methods for achieving the correct torque on the larger 1 1/4" QUIK-ALIGN pivot bolt, with the 47 mm bolt head. They are a single-step high-torque or a torque-turn method. Either method may be used for assembly, depending on the equipment you have available. However, checking bolt torque in service requires using a torque multiplier and a calibrated torque wrench to check the absolute torque of 1760 Nm.

Refer to the instructions provided by the manufacturer of your torque multiplier to ensure accurate QUIK-ALIGN fastener torque.

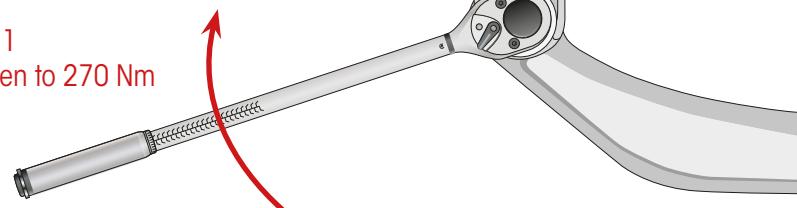
NOTE: Align suspension before applying the final torque to the QUIK-ALIGN fastener.



Torque Multiplier

TORQUE-TURN TECHNIQUE FOR LARGER 1 1/4" QUIK-ALIGN BOLTS

1/ Hold the bolt head and torque the QUIK-ALIGN nut to **270 Nm**.



2/ Mark one corner of the nut. Count four corners clockwise (240 degrees), mark the QUIK-ALIGN eccentric washer at that corner and extend that mark onto the hanger. **Refer Diagram.**



3/ Tighten the nut **2/3** of a turn (**240 degrees**) until the marks align. Check the marks on the QUIK-ALIGN washer and hanger to ensure that the eccentric washer has not moved. **Refer Diagram.**



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