



TECHNICAL BULLETIN

PRIMAAX® EX TORQUE SPECIFICATIONS

LIT NO: 97117-225B

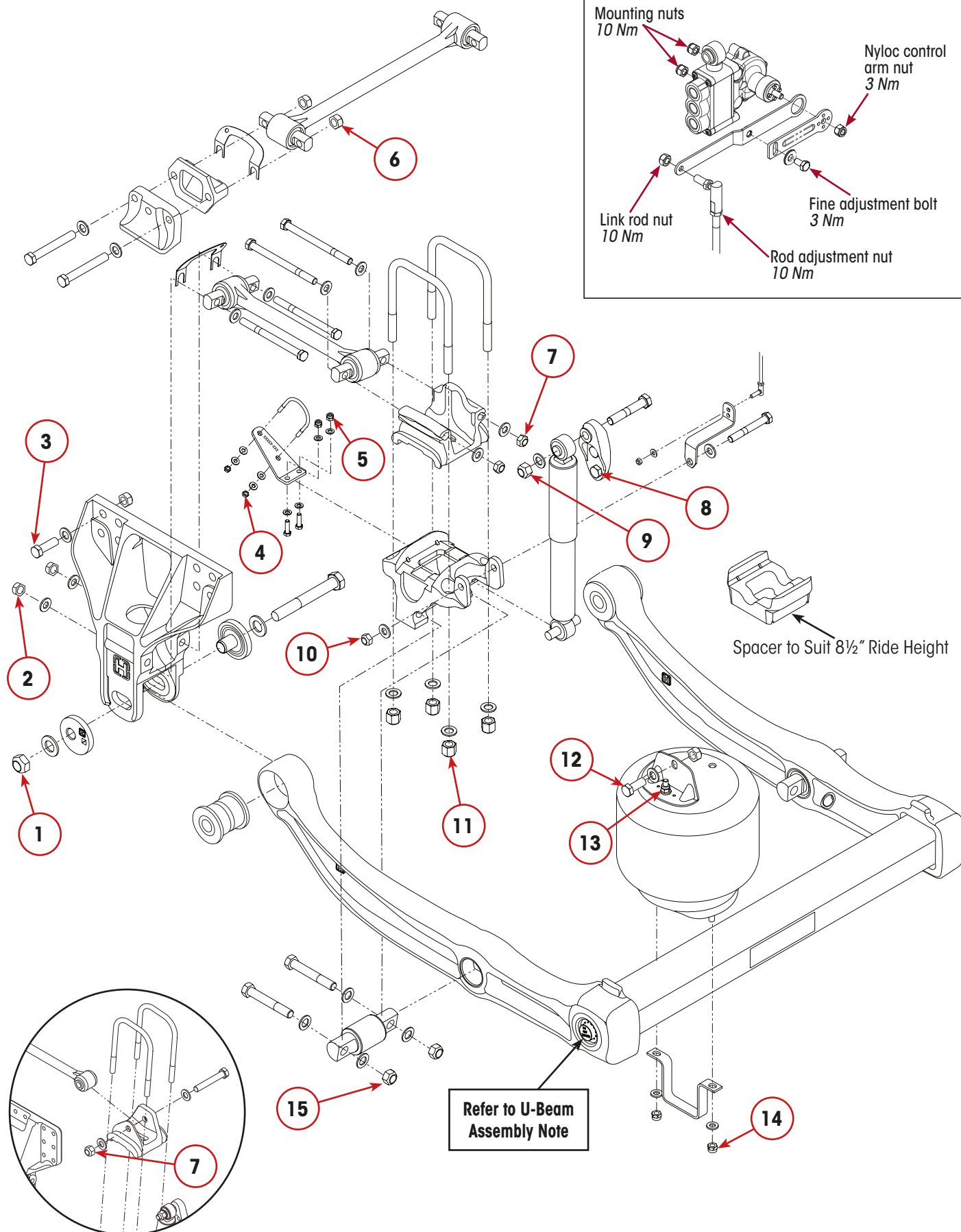
DATE: February 2025

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

TORQUE SETTINGS



**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 .	1-1/4"–12 UNF	1760	1300
2	Longitudinal Torque Rod to Frame Hanger	5/8"–11 UNC	285	210
3	Frame Hanger to Frame	3/4"–10 UNC	505	372
4	S-Cam Support Bracket U-Bolt Locknut	5/16"–18 UNC	35	25
5	S-Cam Support Bracket to Bottom Cap	3/8"–16 UNC	50	35
6	Axle Stop & Transverse Torque Rod to Frame	5/8"–11 UNC	285	210
7	Longitudinal Torque Rod to Top Pad – Standard – 232/462/692	5/8"–11 UNC	285	210
	Longitudinal Torque Rod to Top Pad – Standard – 262/522/782	3/4"–16 UNF	400	295
	Longitudinal Torque Rod to Top Pad – Through-Bolt Type (See Inset)	7/8"–14 UNF	780	575
8	Upper Shock Bracket to Frame	5/8"–11 UNC	285	210
9	Upper Shock Absorber to Shock Bracket	3/4"–10 UNC	250	185
10	Lower Shock Absorber to Bottom Cap	5/8"–11 UNC	285	210
11	U-Bolt Locknut	3/4"–16 UNF	510	375
12	Air Spring Bracket to Frame	5/8"–11 UNC	285	210
13	Air Spring Assembly to Upper Frame Bracket	1/2"–13 UNC	35	25
14	Air Spring Assembly to Lower Air Spring Mounting Bracket	1/2"–13 UNC	35	25
15	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 differs from the standard 1" bolt, which needs a final torque of 750 Nm. Use the bolt head size to determine QUIK-ALIGN bolt type. Use the bolt head size to determine QUIK-ALIGN bolt type. Refer to next page for 1-1/4" bolt torque details. For more details refer to PRIMAAX Maintenance manual [97117-212](#).

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

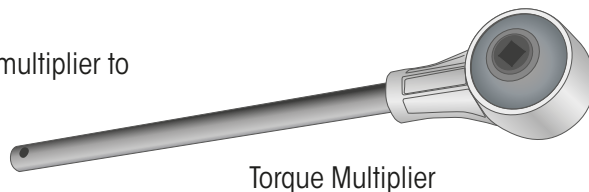
Vehicles built after March 2009 have integrated end caps that do not require re-torque. The bolt heads are covered with tamper resistant caps. Vehicles built prior to this date do not have tamper resistant caps and require a torque of 745 Nm applied at regular service intervals.

1 ¼" QUIK-ALIGN BOLT TORQUE

There are two possible methods for achieving the correct torque on the larger 1 ¼" 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-TURN TECHNIQUE FOR LARGER 1 ¼" QUIK-ALIGN BOLTS

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

Step 1
Tighten 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.**

Mark Nut

Step 2
Mark nut,
washer &
hanger

Mark Washer at 4th corner clockwise

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.**

Step 3
Tighten 2/3 Turn
(240 Degrees)



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