



No: 97117-229  
Subject: AIRTEK AXLE GROUP CLAMP BOLTS  
Date: JUNE - 2011 Revision: B

1. The Airtek Axle Group clamp bolts, fitted to the IVECO 2350 Family of Vehicles, are currently configured with M20 bolts with a course 2.5 MM pitch thread. To reduce the dependency on maintenance these bolts are to be replaced with a M20 bolt with a fine 1.5 MM pitch. An additional lock nut is also to be fitted.
2. The purpose of this bulletin is to highlight the change in torque with the new mounting bolts and summarise the installation procedure. This procedure should be read in conjunction with the Hendrickson Airtek Technical Bulletin 49441-388 Dec 2008 Revision B. The premise for this procedure is that the vehicle is on flat ground, secured on safety stands, air removed from the air springs, and the existing clamp bolt hardware removed. Proceed as follows:
  - a. Install new bottom axle wrap liner on the bottom axle wrap.
  - b. Install the bottom axle wrap on the axle.
  - c. Install the new M20 clamp group bolts and the new M20 nuts. Snug the bolts, DO NOT tighten at this time.
  - d. Install the 3/4 inch lower shock mounting bolts, washer and locknuts and tighten to 320 N.m.
  - e. Ensure that the clamp group is properly aligned, the hex bolts are seated in the top pad and, the bottom axle wrap is centered with the top axle wrap. See Figures One and Two.
  - f. Tighten the clamp group main nuts evenly in 70 N.m increments, to a final torque of **340 N.m**, in the proper pattern to achieve uniform bolt tension. See Figure Three.
  - g. Apply Loctite thread-locker 242 to the exposed thread form. Whilst holding the main nut install the additional lower M20 locknuts. **Torque to 260 N.m**

Figure One

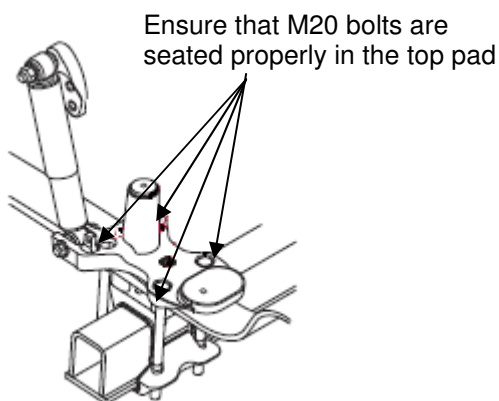
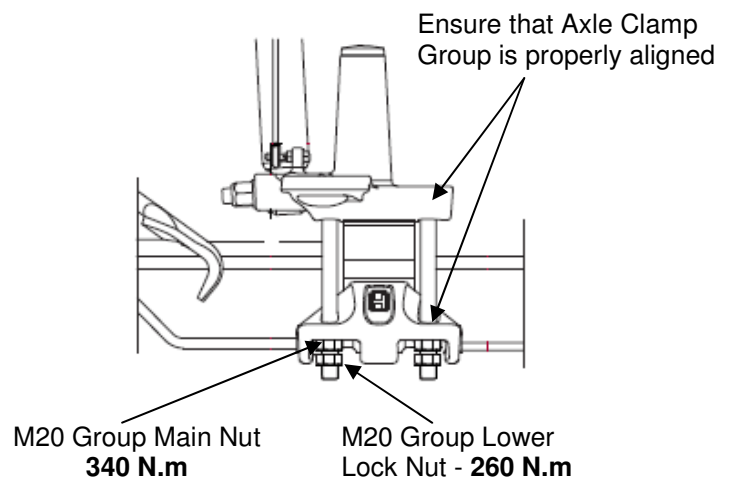


Figure Two



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### Figure Three

### Torque Pattern

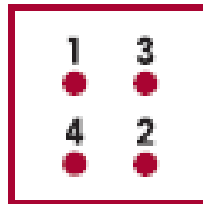


Table One. New 1.5 MM Thread-Form Fasteners.

Serial	Item	Part No.	Quantity (Per Single Axle)
(a)	(b)	(c)	(d)
1.	M20 X 1.5 X 270 Bolt	97023-014	Eight
2.	M20 X 1.5 Nut	97024-003	Sixteen
3.	M20 Washer Narrow	98573-005	Eight

### HENDRICKSON DOES NOT AUTHORISE RE-USE OF NUTS & BOLTS

#### WARNING

WHEN A SHOCK BOLT AND NUT IS REMOVED, HENDRICKSON DO NOT AUTHORISE ITS RE-USE. RE-USING MOUNTING HARDWARE MAY RESULT IN INCORRECT CLAMP LOADS, STRETCHED THREADS, AND PREMATURE FAILURE.

#### WARNING

ENSURE CLAMP GROUP IS ALIGNED PROPERLY PRIOR TO TIGHTENING HARDWARE. FAILURE TO DO SO CAN CAUSE LOSS OF VEHICLE CONTROL, PERSONAL INJURY, OR PROPERTY DAMAGE

Any questions in relation to this Technical Bulletin please forward to the Hendrickson Product Support Group: Telephone (03) 8792 3600 or email to: [technicalservice@hendrickson.com.au](mailto:technicalservice@hendrickson.com.au)

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