

TECHNICAL PROCEDURE

HENDRICKSON CHASSIS AXLE™ (HCA™) and HENDRICKSON TRAILER AXLE™ (HTA™)

SUBJECT: Weld-on ABS Bracket
Field Installation Procedure

LIT NO: L1094

DATE: August 2008

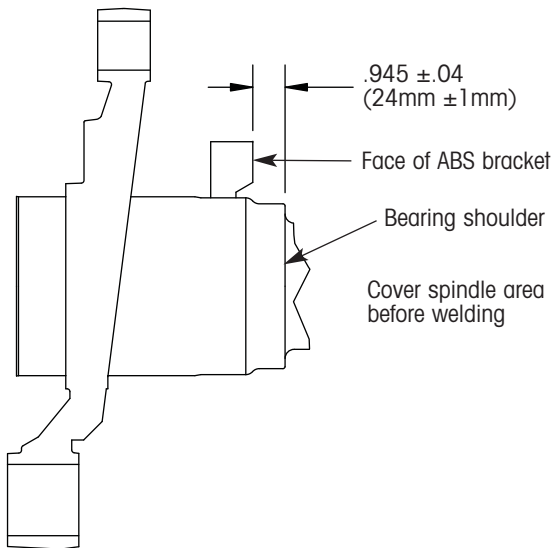


Figure 1. Positioning the ABS block along the length of the axle

INSTALLING THE ABS BRACKET

NOTE: This kit (part number S-30036) is intended for installation on HENDRICKSON CHASSIS AXLE™ (HCA™) or HENDRICKSON TRAILER AXLE™ (HTA™) products only. It is not to be installed on any other make, model or type of suspension.

1. Remove the tire / wheel assembly, brake drum, brake shoes and hub.
2. Prepare the mating surfaces for welding. The mounting area on the axle and the ABS block

must be free of moisture, dirt, scale, paint and grease. The axle and the ABS block must also have a minimum temperature of 60°F (16°C).

3. To position the ABS block along the length of the axle, measure back (inboard) from the bearing shoulder to the face of the ABS block .945 ±.04 inches (24 ±1 mm). Refer to figure 1.
4. To position the ABS block around the outside diameter of the axle, align the center of the ABS block hole with the center of the slot in the brake spider. Refer to figure 2.

IMPORTANT: The ABS block hole must be aligned with the slot in the brake spider. If off center, the ABS sensor may not clear the brake spider during installation.

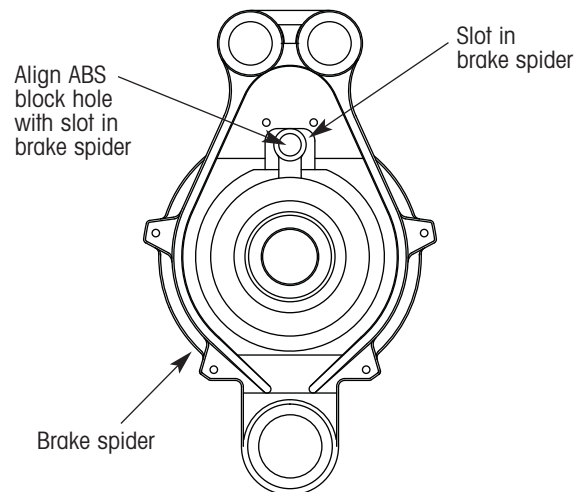


Figure 2. Aligning the ABS block with the brake spider slot

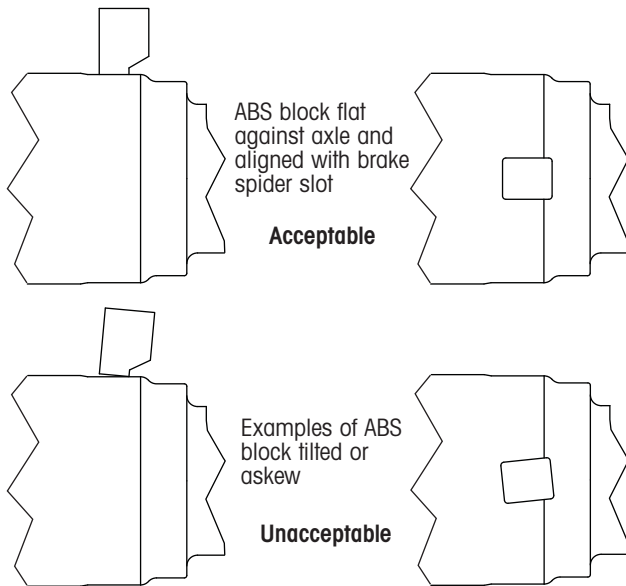


Figure 3. Properly positioning the ABS block

5. Temporarily clamp the bracket in place. The ABS block must not be tilted or askew (figure 3).
6. Verify that the ABS block is in the proper location. Insert an ABS sensor into the block to ensure adequate clearance with the brake spider and the hub.
7. When ABS block location and sensor clearance are verified, weld the ABS block to the axle with a 1/4-inch (6mm) fillet weld. Refer to figure 4 for weld placement.

Only a properly trained and certified welder should perform the welding. Follow all applicable safety rules and regulations for welding, including but not limited to, wearing proper eye protection and other personal protective equipment, working in a well ventilated area and keeping all flammable and combustible materials out of the work area.

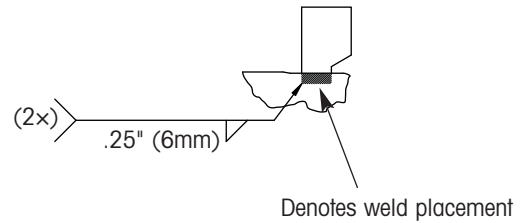


Figure 4. Welding details

IMPORTANT: Before welding, cover the entire spindle area (as shown in figure 1) to avoid weld splatter damage.

8. When cool, remove the clamp, prime and paint.

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