



1. Hendrickson Asia Pacific (HAPPL) and Iveco Trucks Australia Limited (ITAL) have four configurations of Primaax suspension installed on the Iveco 2350 Family of Vehicles. The configurations are categorised as follows:

- a. **Primaax Generation I and II.** The changes between Gen I and II are limited to the design of the main support beam. Fasteners and torque requirements remain the same for both iterations. Customers may have upgraded the build through the addition of the severe duty rear mount longitudinal top mount M 24 fastener
- b. **Primaax Generation II.5.** The unique aspect of this design is the use of a straddle to straddle longitudinal torque rod with local designed top pad. This includes the replacement of the longitudinal mount fasteners.
- c. **Primaax Hybrid.** This system is a combination of Generation II and Primaax EX. The changes include the following:
 - i. Main Support Beam,
 - ii. Air Spring, and
 - iii. Air Spring Base Mount to main support beam.
- d. **Primaax EX.** A complete standalone system that replaces the Primaax Gen I, II, and II.5.

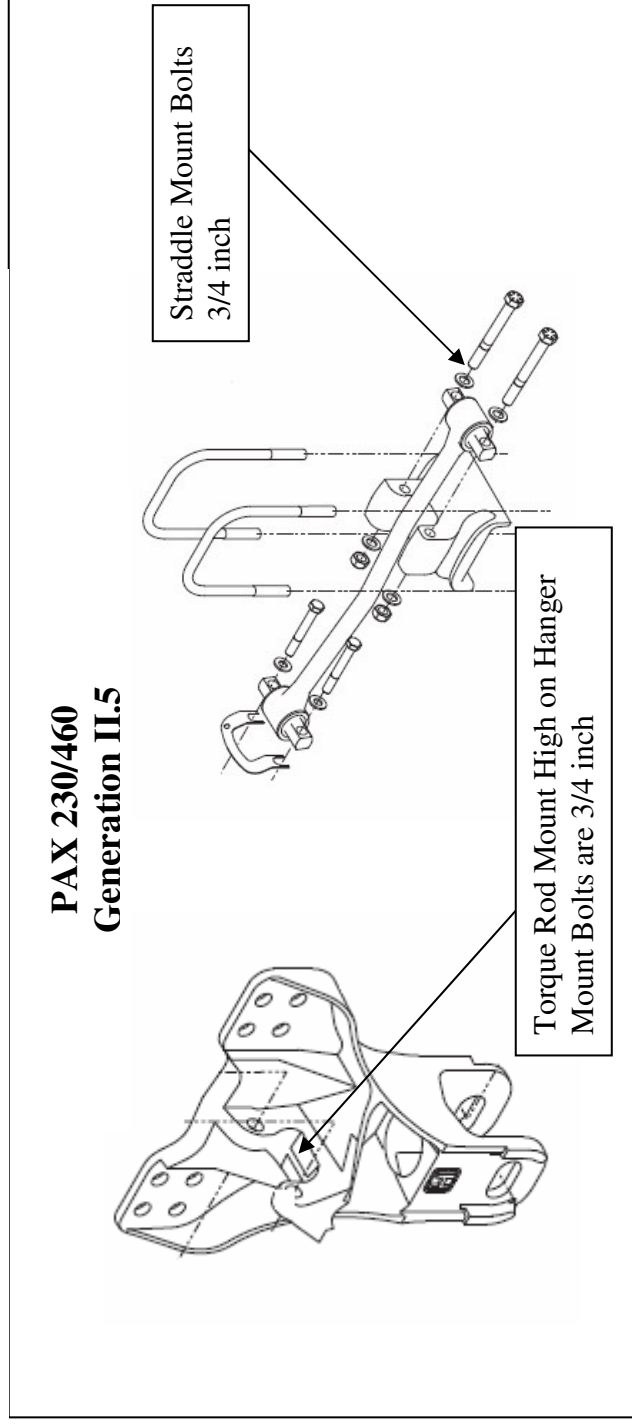
2. Each configuration of Primaax has unique fasteners and therefore specific torque requirements for the application. With the exception of significant changes to parent material and production processes, the differences in the configurations can be easily identified through the style of the longitudinal torque rod and the mount point on the hanger assembly. This is depicted at table one and described as follows:

- a. **Primaax Generation I and II.** The Gen I and II Primaax longitudinal front mount fasteners are 3/4 inch with the rod mount point high on the hanger assembly. The rear top pad mount hardware may either be the standard 7/8 inch or severe duty M 24 fastener.
- b. **Primaax Generation II.5** The Gen II.5 has a straddle to straddle longitudinal rod that is mounted with 3/4 inch fasteners to the hanger and local design top pad.
- c. **Primaax Hybrid.** The hybrid system has longitudinal front mount fasteners that are 3/4 inch with the rod mount point high and upwardly inclined on the hanger assembly. The rear top pad mount hardware may either be the standard 7/8 inch or severe duty M 24 fastener.
- d. **Primaax EX.** The Primaax EX longitudinal torque rod is mounted low and horizontal on the front hanger. Front and rear mount fasteners are both 5/8 inch.

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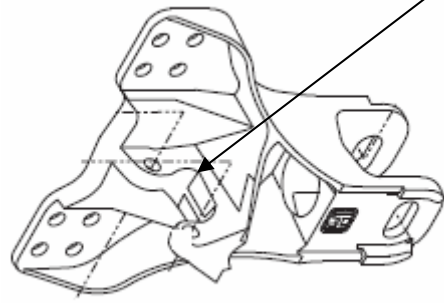


TABLE ONE – PRIMAAX FAMILY TORQUE REQUIREMENTS

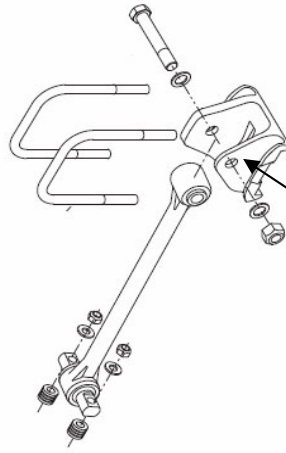


**PAX 232/462
Primaax EX**

**PAX 230/460
Generation I, II and Hybrid**



Torque Rod Mount High on Hanger Mount Bolts are 3/4 inch



Top Pad Mount Bolt 7/8 Inch or 24 MM

Ser.	Component	Qty	Size	Gen I and II Torque N.m (ft. lb)	Gen II.5 Torque N.m (ft. lb)	Hybrid Torque N.m (ft. lb)	Primaax EX Torque N.m (ft. lb)
(a)	(b)	(c)	(d)	(e)	(f)	(g)	(h)
1.	Frame Hanger to Frame	16	3/4 -10 UNC	505 (375)	505 (375)	505 (375)	505 (375)
2.	Longitudinal Torque Rod						
	A. To Forward Hanger Mount	4	3/4 -16 UNF	400 (300)	400 (300)	400 (300)	
	A1 To Forward Hanger Mount	4	5/8 - 11 UNC	750 (550)	750 (550)	750 (550)	285 (210)
	B. To Rear Top Pad Mount	2	7/8-14 UNF	980 (725)	980 (725)	980 (725)	
	B1. To Rear Top Pad mount	2	M24				
	C. To Rear Top Pad Mount	2	5/8-11 UNC	850 (625)	850 (625)	850 (625)	285 (210)
3.	Beam Assembly						
	A. QUIK-ALIGN	2	1 - 8 UNC	850 (625)	850 (625)	850 (625)	
	A1 QUIK-ALIGN	2	1-14 UNF				750 (550)
	B1. QUIK-ALIGN Extreme Duty	2	1 1/4 -12 UNF	1760 (1300)	1760 (1300)	1760 (1300)	1760 (1300)
	C. Centre D-Pin Bushing	2	3/4 -16 UNF	400 (300)	400 (300)	400 (300)	400 (300)
	D. Cross Tube End Cap	2	7/8 - 9 UNC	750 (550)	750 (550)	750 (550)	750 (550)
4.	U Bolt Lock Nuts	8	3/4 -16 UNF	440 (325)	440 (325)	440 (325)	510 (375)
5.	Shock Absorber						
	A. Upper Mount Locknuts	2	3/4 -10 UNC	250 (185)	250 (185)	250 (185)	250 (185)
	B. Lower Mount Locknuts	2	5/8 -11 UNC	285 (210)	285 (210)	285 (210)	285 (210)
6.	Upper Shock Absorber Bracket to Frame	4	5/8 - 11 UNC	285 (210)	285 (210)	285 (210)	285 (210)
7.	Air Spring Assembly						
	A. To Frame	2	5/8 - 11 UNC	285 (210)	285 (210)	285 (210)	285 (210)
	B. Lower Cross Tube	4	1/2 - 13 UNC	35 (25)	35 (25)	35 (25)	35 (25)
8.	Axle Stop to frame	6	5/8 - 11 UNC	285 (210)	285 (210)	285 (210)	285 (210)
9.	Height Control Valve to Frame Bracket	2	1/4 -20 UNC	15 (10)	15 (10)	15 (10)	15 (10)
10	HCV Linkage						
	A. Jam Nut	2	5/16 18 UNC	15 (10)	15 (10)	15 (10)	15 (10)
	B. Locknut to HCV	2	5/16 18 UNC	15 (10)	15 (10)	15 (10)	15 (10)
	C. Linkage Clamp	1					

Until Securely Fastened

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

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