



H ASSEMBLY INSTRUCTIONS

STEERTEK™ NXT • STEERTEK™ Axle

SUBJECT: Kingpin Bushing and Thrust Bearing
Service Kits

LIT NO: 59310-011

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INTRODUCTION

This publication is intended to assist maintenance personnel with the installation of Kingpin Bushing and Thrust Bearing Service Kits to service STEERTEK™ NXT • STEERTEK front steer axles equipped on AIRTEK® NXT • AIRTEK • SOFTEK™ NXT • SOFTEK suspension systems or approved proprietary vehicle OEM suspensions.

Proper maintenance, service, and repair are important to the reliable operation of the suspension and axle.

For complete safety and service instructions, see (1) the particular Hendrickson AIRTEK NXT • AIRTEK • SOFTEK NXT • SOFTEK • STEERTEK NXT • STEERTEK Technical Publications (available online at www.hendrickson-intl.com) applicable to your make of vehicle and (2) applicable vehicle OEM technical publications.

NOTE

Refer to the relevant part bulletin on the Hendrickson website for applicable parts available for the Australian market.

STEERING KNUCKLE & KINGPIN

Refer to the Steering Knuckle Disassembly, Kingpin Preparation and Measurement procedure in the appropriate AIRTEK NXT • AIRTEK • SOFTEK NXT • SOFTEK • STEERTEK NXT • STEERTEK Technical Publication (available online at www.hendrickson-intl.com) applicable to your make of vehicle.

CAUTION

A TECHNICIAN USING A SERVICE PROCEDURE OR TOOL WHICH HAS NOT BEEN RECOMMENDED BY HENDRICKSON MUST FIRST SATISFY HIMSELF THAT NEITHER HIS SAFETY NOR THE VEHICLE'S SAFETY WILL BE JEOPARDIZED BY THE METHOD OR TOOL SELECTED. INDIVIDUALS DEVIATING IN ANY MANNER FROM THE INSTRUCTIONS PROVIDED ASSUME ALL RISKS OF POTENTIAL PERSONAL INJURY OR DAMAGE TO EQUIPMENT INVOLVED.





SPECIAL TOOLS

KINGPIN BUSHING TOOL — ADJUSTABLE STRAIGHT FLUTE REAMER

The dimension of cutting diameter must facilitate a range of 1.802"-1.812"

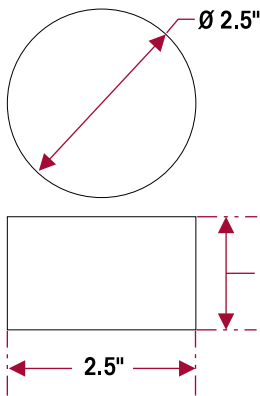


SHOP MADE TOOLS

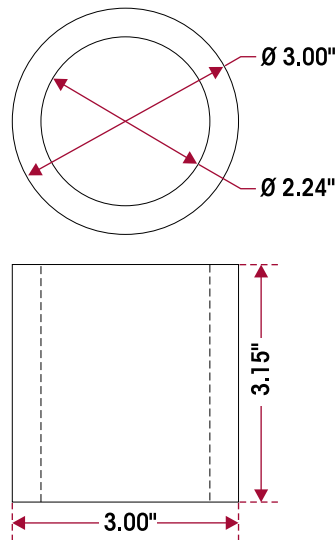
These shop made tools are designed to install and remove kingpin bushings. Bushing tools are made from cold rolled steel or equivalent. Drawings are for reference only. Hendrickson does not supply these tools.

STEERTEK NXT

***Bushing Driver**

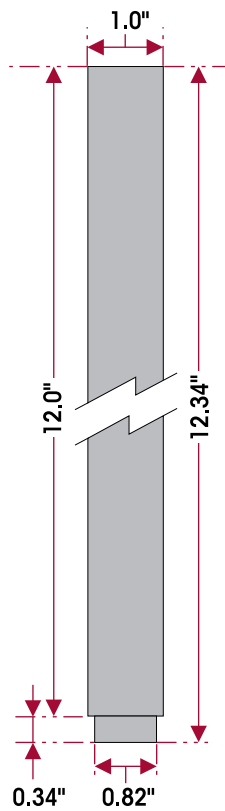


Bushing Receiving Tool
(for press bushing replacement)

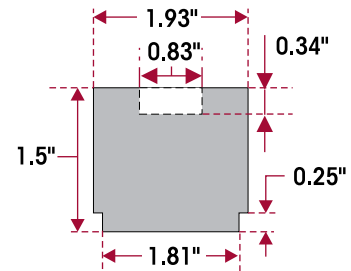


NOTE: Kingpin Handle is used for both bushing installer / remover and seal installer tools

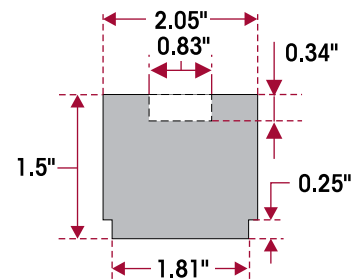
Kingpin Handle



Bushing Installer / Remover Tool
(to seat bushing)

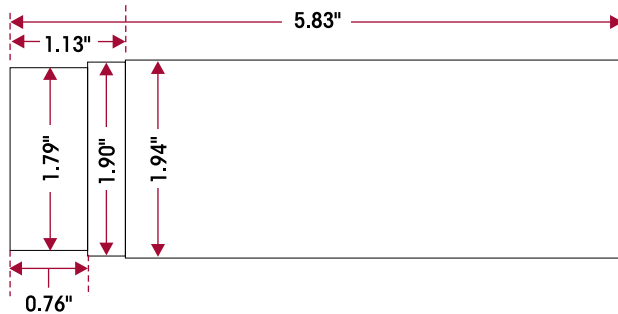


Seal Installer Tool
(to seat seal)



NOTE: *The bushing driver is necessary to sink the kingpin bushing flush into the steering knuckle bore.

STEERTEK





WARNING

KINGPIN BUSHING

BEFORE APPLYING HYDRAULIC PRESSURE TO ANY TOOLING SET-UP, ALWAYS CHECK TO ENSURE THE PRESS PLATE, TOOLS, AND COMPONENTS BEING WORKED ON ARE POSITIONED PROPERLY, I.E. "IN LINE" WITH THE RAM OF THE PRESS. IMPROPER POSITIONING CAN CAUSE PERSONAL INJURY OR COMPONENT DAMAGE.

CAUTION

PRIOR TO APPLYING HYDRAULIC PRESSURE TO REMOVE OR INSTALL THE KINGPIN BUSHING, SUPPORT THE LOWER STEERING KNUCKLE AS SHOWN IN FIGURE 1. IMPROPER SUPPORT TO THE STEERING KNUCKLE CAN CAUSE COMPONENT DAMAGE.

REMOVAL

You will need: (see Special Tools on Page 2)

- A hydraulic shop press with a minimum forcing capacity of 2.5 tons (or an arbor press) or optional method - use hand tools
- Kingpin handle, bushing installer/remover, driver and receiving tools

NOTE

If a shop press is not available to remove/install the kingpin bushings, an acceptable optional method is to use a hammer along with the shop made tools (kingpin bushing driver, receiving tool, kingpin handle, bushing installer/remover and seal installer tools) on a work bench.

NOTE

To remove the kingpin bushing, always drive the bushing from the non-machined side of the steering knuckle.

FIGURE 1



FIGURE 2



FIGURE 3



FIGURE 4

1. Remove the threaded grease cap and grease Zerk.
2. With the machined side of the steering knuckle face down (axle side down), ensure that each part of the steering knuckle assembly is squarely supported on the bushing receiving tool before applying hydraulic pressure to press out the kingpin bushings, see Figures 1 and 2.
3. From the non-machined side of the steering knuckle, use the kingpin bushing installer/remover tool (see Special Tools Section of this publication) to drive the kingpin bushing and kingpin seal out of the steering knuckle, see Figure 3.
4. Clean the parts and inspect for reassembly, see Figure 4.





KINGPIN BUSHING REAMING

You will need: (see Special Tools on Page 2)

- Vice with brass jaws (soft jaws)
- Adjustable Straight Flute Reamer

CAUTION

REAM THE KINGPIN BUSHINGS WITH AN ADJUSTABLE STRAIGHT FLUTE REAMER. (SEE SPECIAL TOOLS IN THIS PUBLICATION) DO NOT HONE OR BURNISH THE KINGPIN BUSHINGS. HONING OR BURNISHING WILL DAMAGE THE BUSHINGS AND VOID ANY APPLICABLE WARRANTY.

WARNING

WHEN INSTALLING STEERING KNUCKLE COMPONENTS IN A VISE IT IS NECESSARY TO PROTECT THE MACHINED SURFACES FROM GOUGES OR MARRING BY USING BRASS JAWS (SOFT JAWS). FAILURE TO DO SO CAN CAUSE PREMATURE PART DAMAGE, DAMAGE TO THE STEERING KNUCKLE COMPONENTS, LOSS OF WARRANTY, LOSS OF VEHICLE CONTROL, CAUSING PERSONAL INJURY OR PROPERTY DAMAGE.

1. Install the upper/lower steering knuckle in a vise with brass jaws.

SERVICE HINT

It is acceptable to mount the upper/lower steering knuckle in a vise either vertically or horizontally when performing the reaming procedure.

2. Install the reamer into the upper/lower steering knuckle until the blades touch the kingpin bushing.
3. Rotate the reamer with light downward pressure. Rotate the reamer smoothly. **DO NOT** apply too much pressure, see Figures 5 and 6.

FIGURE 5

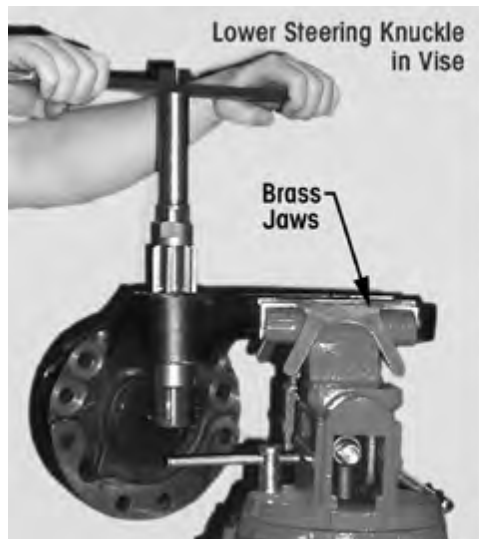
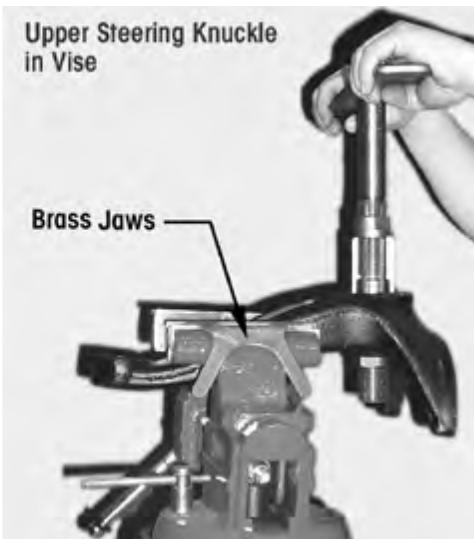


FIGURE 6



4. Slide the reamer out of the upper/lower steering knuckle. If it is necessary to remove the reamer from the top, rotate the reamer opposite of cutting rotation.

WARNING

PRIOR TO INSTALLATION ENSURE THAT ALL RESIDUAL LOCTITE® MATERIAL IS REMOVED FROM THE MOUNTING BOLTS AND THE THREAD BORES IN THE UPPER STEERING KNUCKLES, AND NEW LOCTITE 277 OR EQUIVALENT IS APPLIED TO HELP ENSURE THAT THE BOLTS SUSTAIN THE PROPER TORQUE REQUIREMENT. FAILURE TO DO SO CAN CAUSE LOSS OF VEHICLE CONTROL RESULTING IN PERSONAL INJURY OR PROPERTY DAMAGE.

5. Clean and remove all kingpin bushing material from the knuckle assembly. Take special attention to remove material from the grease channels and dimples.
6. Clean the 5/8" brake backing plate bolts with a wire wheel and run a tap through the threads of the upper/lower steering knuckle and then flush out with brake cleaner and dry with compressed air.

NOTE

The Hendrickson Genuine part, socket head cap screw comes with a pre-applied Loctite compound.

7. Temporarily install the upper/lower knuckle on the kingpin to check for fit.



8. Rotate the upper/lower knuckle back and forth to verify there is no binding on the kingpin, see Figures 7 and 8.
9. If the bushing is too tight repeat Steps 1 through 8 until the proper clearance is achieved.

NOTE

Bushing size is to be 0.001" larger than the kingpin size.

10. Proceed to Kingpin Seal installation.

FIGURE 7**FIGURE 8**

KINGPIN SEAL

INSTALLATION

You will need: (see Special Tools on Page 2)

- Vise with brass jaws (soft jaws)
- Kingpin handle and seal installer tool

WARNING

WHEN INSTALLING STEERING KNUCKLE COMPONENTS IN A VISE IT IS NECESSARY TO PROTECT THE MACHINED SURFACES FROM GOUGES OR MARRING BY USING BRASS JAWS (SOFT JAWS). FAILURE TO DO SO CAN CAUSE PREMATURE PART DAMAGE, DAMAGE TO THE STEERING KNUCKLE COMPONENTS, LOSS OF WARRANTY, LOSS OF VEHICLE CONTROL, CAUSING PERSONAL INJURY OR PROPERTY DAMAGE.

1. Place the upper/lower steering knuckle in a vise with brass jaws or place on a suitable workbench. The steering knuckle will have the machined surface facing up (axle side up).
2. Lay the kingpin seal into the bore of the steering knuckle. The seal lip should face outward or toward the axle, see Figure 9.
3. Use a kingpin bushing driver tool and press seal firmly into the upper/lower steering knuckle.
4. **STEERTEK NXT** — Double Lip design, see Figure 10. Install the kingpin seal until it bottoms out in the kingpin bore.
5. **STEERTEK** — Single Lip design, see Figure 11. Install the kingpin seal until it makes contact with the kingpin bushing.

FIGURE 9
Magnification
of lip seal
Lip seal faces
toward axle



FIGURE 10
STEERTEK NXT
Magnification of the
kingpin bushing
and a **DOUBLE**
lip seal installed in
the steering knuckle.



FIGURE 11
STEERTEK
Magnification of the
kingpin bushing and
a **SINGLE** lip seal
installed in the
steering knuckle.





STEERING KNUCKLE

ASSEMBLY

To install the remaining items in the Service Kit, follow the Steering Knuckle Assembly procedure in the appropriate Hendrickson AIRTEK NXT • AIRTEK • SOFTEK NXT • SOFTEK • STEERTEK NXT • STEERTEK Technical Publication available online at www.hendrickson-intl.com.

Refer any questions on this publication, contact Hendrickson Tech Services:



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Additional Hendrickson
Product Information
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Actual product performance may vary depending upon vehicle configuration, operation, service and other factors. All applications must comply with applicable Hendrickson specifications and must be approved by the respective vehicle manufacturer with the vehicle in its original, as-built configuration. Contact Hendrickson for additional details regarding specifications, applications, capacities, and operation, service and maintenance instructions.

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