TECHNICAL BULLETIN

KENWORTH PRIMAAX® EX CRITICAL TORQUE SPECIFICATIONS

LIT NO: 97117-225C
DATE: August 2018 **REVISION:** B

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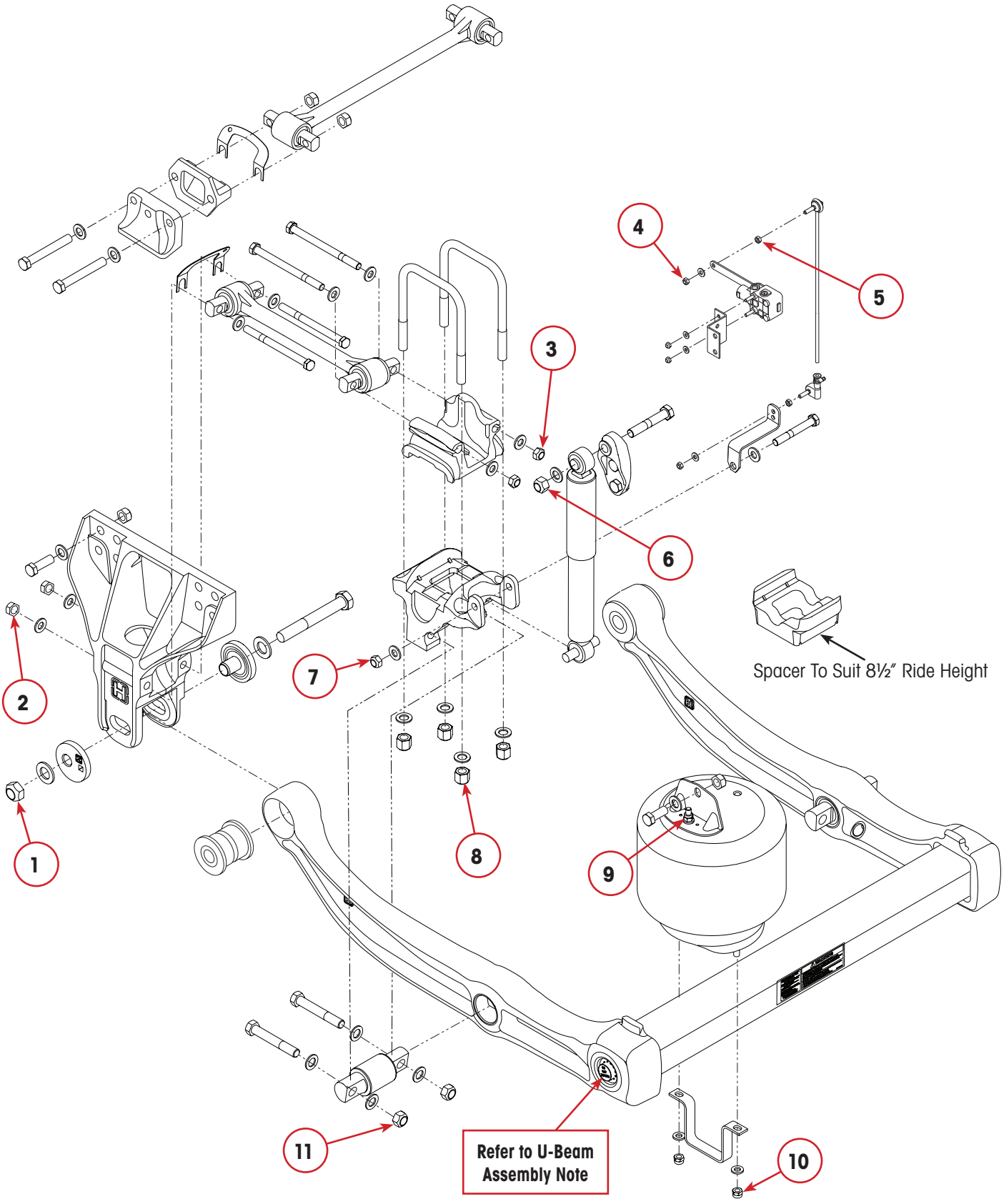
KENWORTH PRIMAAX® EX



KENWORTH PRIMAAX® EX

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)
1	U-Beam Assembly to Standard Service QUIK-ALIGN® Bush **38 mm** (1-1/2″) Bolt Head. Refer to QUIK-ALIGN Notes below.	1″–14 UNF	750
	U-Beam Assembly to Severe Service QUIK-ALIGN Bush **47 mm** (1-7/8″) Bolt Head. Refer to QUIK-ALIGN Notes below and on page 4.	1-1/4″–12 UNF	1760
2	Longitudinal Torque Rod to Frame Hanger	5/8″–11 UNC	285
3	Longitudinal Torque Rod to Top Pad	5/8″–11 UNC	285
4	Height Control Valve Linkage Jam Nut	5/16″–18 UNC	15
5	Height Control Valve Linkage Locknut	5/16″–18 UNC	15
6	Upper Shock Absorber to Shock Bracket	3/4″–10 UNC	250
7	Lower Shock Absorber to Bottom Cap	5/8″–11 UNC	285
8	U-Bolt Locknut	3/4″–16 UNF	510
9	Air Spring Assembly to Upper Frame Bracket	1/2″–13 UNC	35
10	Air Spring Assembly to Lower Air Spring Mounting Bracket	1/2″–13 UNC	35
11	U-Beam Assembly to Centre D-Pin Bush	3/4″–16 UNF	400

QUIK-ALIGN© NOTES

Between 2011 and 2017, Kenworth vehicles with Hendrickson PRIMAAX® suspension may be fitted with a Severe Duty 1-1/4″ QUIK-ALIGN® bolt that must be torqued to 1760 Nm. This differs from the Standard Service bolt, which was fitted before 2011 and after late 2017, which needs a final torque of 750 Nm. Use the bolt head size to determine QUIK-ALIGN bolt type. Refer to next page for severe service bolt torque details.

After replacing the pivot bush for use with the Severe Service QUIK-ALIGN bolt, verify that the bolt passes freely through the inner metal sleeve of the bush. If it does not, then the inner sleeve must be reamed to a diameter of 31.75 mm (1-1/4 Inch).

U-BEAM ASSEMBLY NOTE

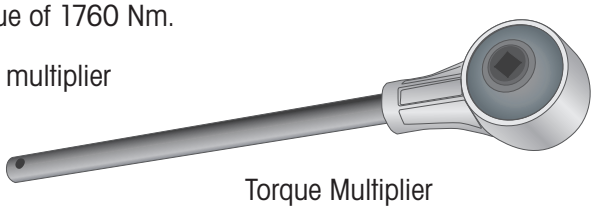
Vehicles built after March 2009 have integrated end caps that do not require re-torque. The bolt heads are covered with tamper resistant caps. Vehicles built prior to this date do not have tamper resistant caps and require a torque of 745 Nm applied at regular service intervals.

SEVERE SERVICE QUIK-ALIGN® BOLT TORQUE

There are two possible methods for achieving the correct torque on the Severe Service 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.

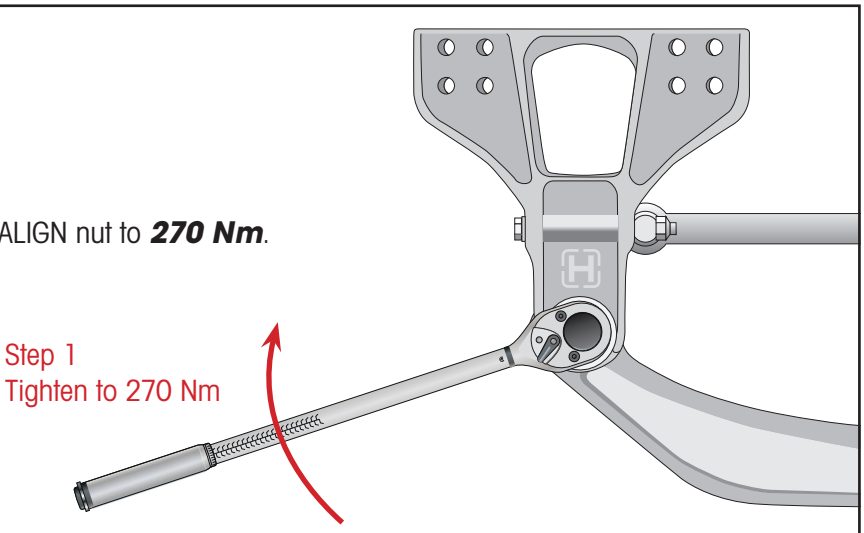
NOTE: Align suspension before applying the final torque to the QUIK-ALIGN fastener.



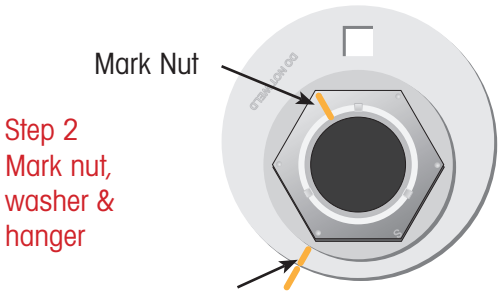
Torque Multiplier

Torque–Turn Technique

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

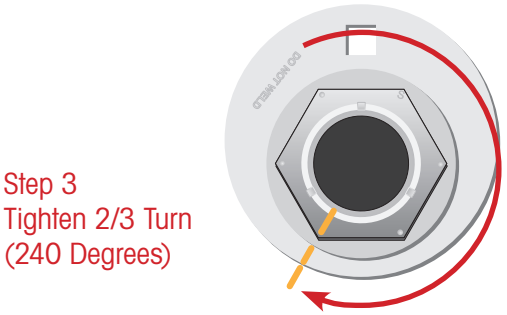


2/ Mark one corner of the nut. Count four corners clockwise (240 degrees), mark the QUIK-ALIGN eccentric washer at that corner and extend that mark onto the hanger. ***Refer Diagram.***



Mark 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***.



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HENDRICKSON COMMERCIAL VEHICLE SYSTEMS AUSTRALIA
ABN 21 004 992 769
32- 44 Letcon Drive, P.O. Box 1063
Dandenong, Victoria, 3175
61.3.8792.3600 • Fax 61.3.8792.3699

HENDRICKSON COMMERCIAL VEHICLE SYSTEMS NEW ZEALAND
Unit P, 24 Allright Place
Mt Wellington, Auckland, 1060
64.9.570.4721 • Fax 64.9.570.4816

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