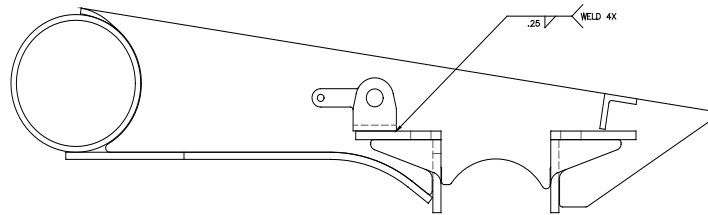




No: 97117-177
Subject: HT 230 Lower Shock Absorber Bracket
Date: February – 2009 Revision D

Figure 1.



Instances of a cracked weld around the trailing arm shock absorber bracket have been reported. The clevis can be effectively replaced if the lower shock absorber clevis becomes detached or a crack is detected at the connection to the trailing arm (see Figure 1).

Kit Part number 98544-021 is available to complete the repair. The kit contains a replacement clevis, shock absorber bolt and reinforcement gusset block. Where the weld retaining the original clevis has cracked, or the clevis has become detached, grind off the remaining weld. It is paramount that cracks or damage to the trailer arm plate are ground, welded and the area is smooth and flat prior to the new clevis being fitted.

In accordance with attached Welding Instruction Drawing 49441-249 assemble as follows:

- Position the reinforcement gusset, Part No. 98870-004, with the chamfered edge toward the trailing arm.
- Apply a weld around the block in one continuous bead commencing and terminating ten millimetres from the existing beam weld.
- Bolt the clevis to the gusset block with the bolt provided. Weld the clevis to the gusset block in one continuous bead.
- Clean and paint the repaired area.

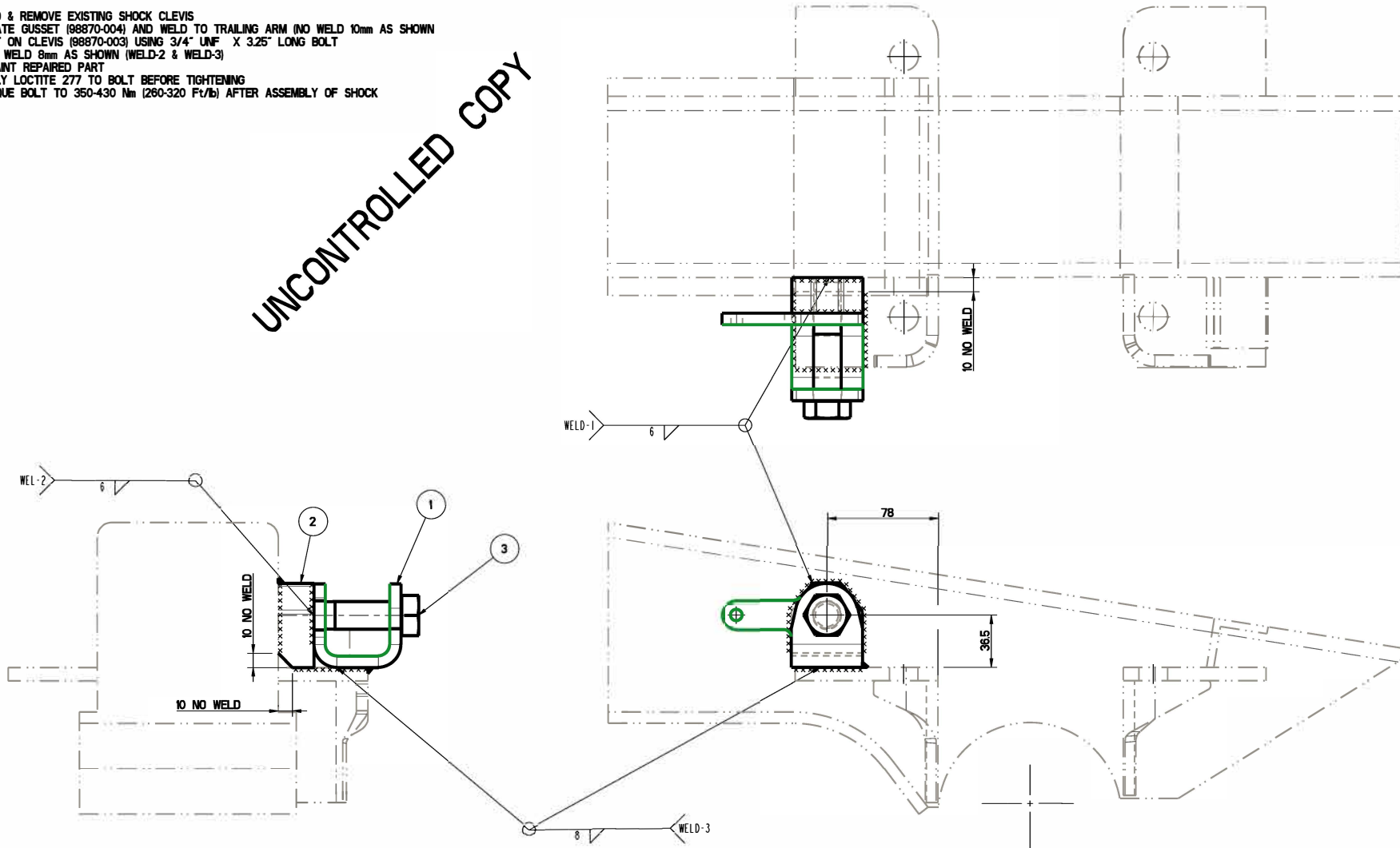
If further assistance is required, please do not hesitate to contact the Hendrickson Product Support Department: Telephone: (03) 8792 3600

| Item | Part # | Description | Qty |
|------|-----------|--|-----|
| 1 | 98870-003 | SHOCK CLEVIS WITH HC/LINK SUPPORT 12mm | 1 |
| 2 | 98870-004 | GUSSET SHOCK CLEVIS SUPPORT | 1 |
| 3 | 98559-002 | BOLT 3/4" UNF X 3/4" LONG GRADE 8 | 1 |

PROCEDURE FOR WELDING NEW SHOCK CLEVIS

- 1) GRIND & REMOVE EXISTING SHOCK CLEVIS
- 2) LOCATE GUSSET (98870-004) AND WELD TO TRAILING ARM (NO WELD 10mm AS SHOWN)
- 3) BOLT ON CLEVIS (98870-003) USING 3/4" UNF X 3.25" LONG BOLT
- 4) NOW WELD 8mm AS SHOWN (WELD-2 & WELD-3)
- 5) REPAINT REPAIRED PART
- 6) APPLY LOCTITE 277 TO BOLT BEFORE TIGHTENING
- 7) TORQUE BOLT TO 350-430 Nm (260-320 Ft/Lb) AFTER ASSEMBLY OF SHOCK

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|--|--|---|--|--|--|
| | | WELDING INST. FOR HT230 SHOCK CLEVIS | | 49441-249 | |
| REVISIONS 03 98870-003 & 004 WERE 98873-003 & 004 7756 02 LOCTITE NOTE ADDED FOR BOLT 7145 01 Release 7008 | 01-10991 01-10991 01-10991 01-10991 | Revision Record 01-10991 01-10991 01-10991 01-10991 | 01-10991 01-10991 01-10991 01-10991 | 01-10991 01-10991 01-10991 01-10991 | 01-10991 01-10991 01-10991 01-10991 |