

# TECHNICAL PROCEDURE

## HENDRICKSON TRAILER AXLES HCA® AND HTA®

**SUBJECT:** Weld-on ABS Bracket  
Field Installation Procedure

**LIT NO:** L1094

**DATE:** November 2017

**REVISION:** B

### INSTALLING THE ABS BRACKET

This kit is intended for field installation of weld-on ABS brackets on HCA® Hendrickson Chassis Axle™ and HTA® Hendrickson Trailer Axle™ loose axles.

**NOTE:** 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. Refer to *L64 Welding Procedures* general weld guidelines and specifications.

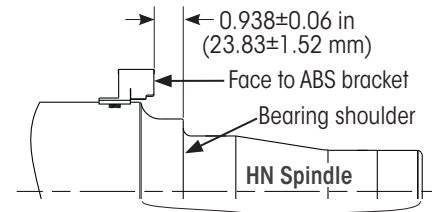
**IMPORTANT:** This procedure **does not apply** to rotor mounted tone rings with ABS sensors inserted into the torque plate.

For general safety and precautionary statements, refer to Hendrickson literature number [T12007](#), available at [www.Hendrickson-intl.com/TrailerLit](http://www.Hendrickson-intl.com/TrailerLit).

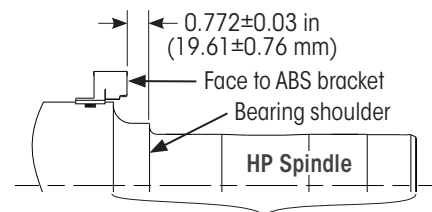
1. **Remove** wheel, brake drum, brake shoes and hub.

**NOTE:** For applicable wheel-end maintenance procedures, refer to available literature online at [www.hendrickson-intl.com/TrailerLit](http://www.hendrickson-intl.com/TrailerLit).

2. **Prepare** mating surfaces for welding. The mounting area on the axle and the ABS bracket must be free of moisture, dirt, scale, paint and grease. The axle and the ABS bracket must also have a minimum temperature of 60°F (16°C).



**NOTICE:** Cover spindle before welding



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Figure 1: Positioning ABS bracket along length of the axle

3. To position the ABS bracket along the length of the axle, **measure** back (inboard) from the bearing shoulder to the face of the ABS bracket the distance indicated in Figure 1.

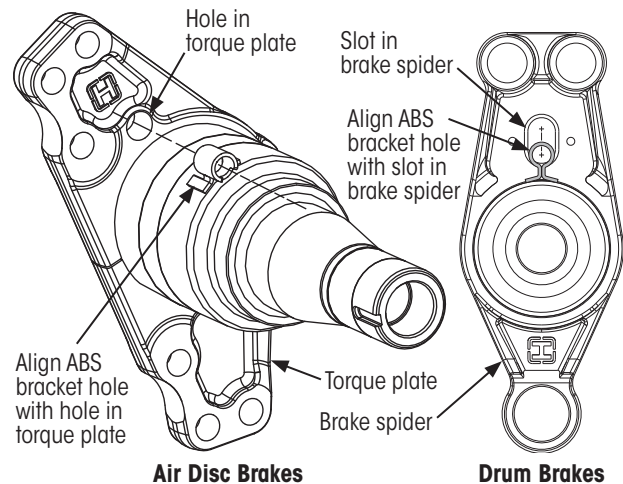


Figure 2: Aligning ABS bracket with brake spider slot

- To position the ABS bracket around the outside diameter of the axle (Figure 2), align the center of the ABS bracket hole with the center of the slot in the brake spider or with the center of the hole in the torque plate.

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

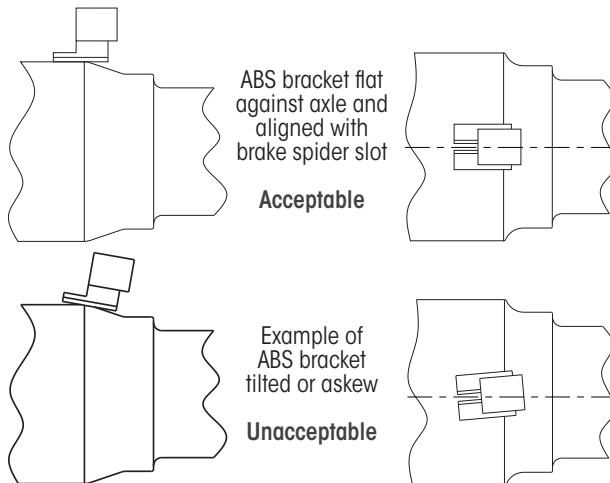
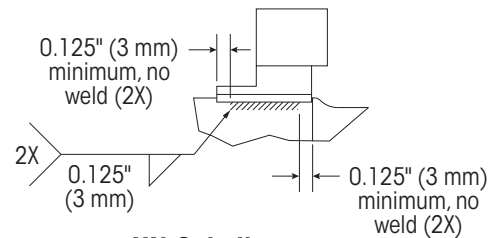


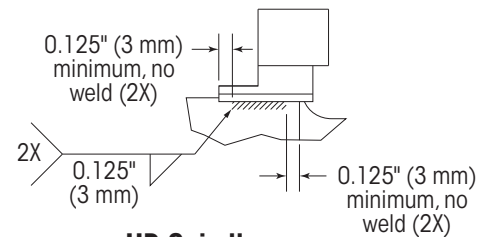
Figure 3: Properly positioning ABS bracket

- Ensure the ABS bracket is flat against the axle and properly aligned. The ABS bracket must not be tilted or askew (Figure 3).
- Temporarily **clamp** the bracket in place.
- Verify** the ABS bracket is in the proper location.
- Insert** an ABS sensor into the bracket to ensure adequate clearance with the brake spider and the hub.
- Cover** spindle area.

**IMPORTANT:** It is necessary to cover the entire spindle area (as shown in Figure 1) to avoid weld spatter damage.



HN Spindle



HP Spindle

////// Denotes weld placement

Figure 4: Weld details

- Verify ABS bracket location and sensor clearance, then **weld** the ABS bracket to the axle with a 1/8 inch (3 mm) fillet weld (Figure 4).
- When cool, **remove** the clamp.
- Apply** surface coat as needed.

For any questions, please contact **Hendrickson Trailer Technical Services**, in the United States and Canada at 866-RIDEAIR (743-3247) or e-mail

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Call Hendrickson at **866.RIDEAIR (743.3247)** for additional information.



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