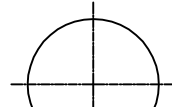
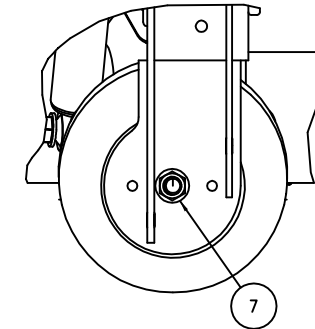
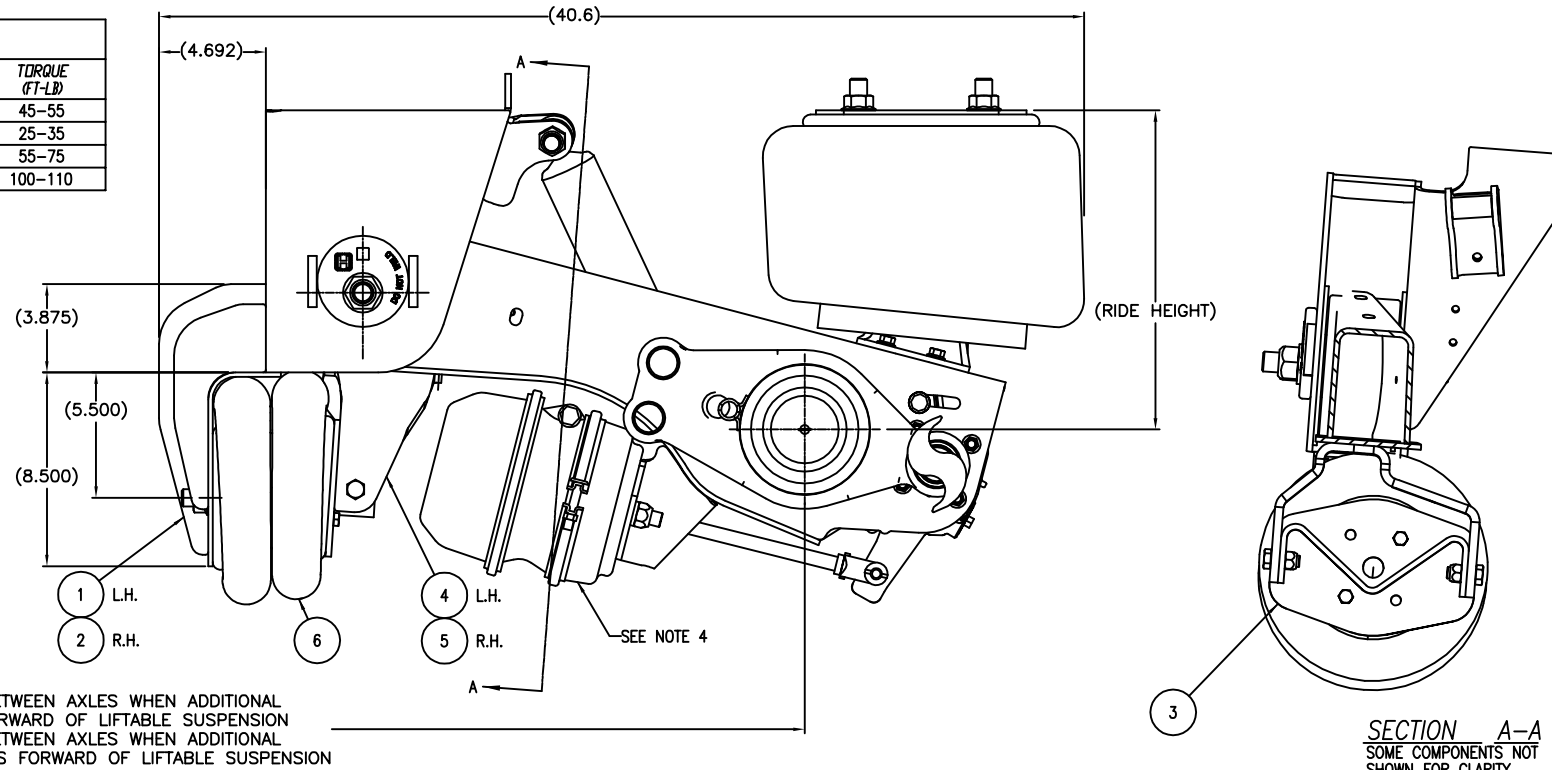


ALTERNATE INSTALLATION:
AIR INLET TOWARD REAR OF
SUSPENSION



TORQUE SPECIFICATIONS		
DESCRIPTION	SIZE	TORQUE (FT-LB)
AIR SPRING NUT, AIR INLET STUD	3/4-16	45-55
AIR SPRING MOUNTING BOLTS	3/8-16	25-35
REAR BRACKET ASSEMBLY BOLTS	1/2-13	55-75
BRAKE CHAMBER MOUNTING NUTS	5/8-11	100-110



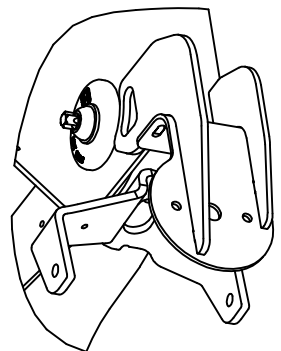
50.00 MIN SPACING BETWEEN AXLES WHEN ADDITIONAL
AAL SUSPENSION IS FORWARD OF LIFTABLE SUSPENSION
43.00 MIN SPACING BETWEEN AXLES WHEN ADDITIONAL
AANT OR AAT SUSPENSION IS FORWARD OF LIFTABLE SUSPENSION

BILL OF MATERIALS:			
ITEM	PART NUMBER	DESCRIPTION	QTY.
1	C-28610-1C	FRONT BRACKET ASSEMBLY, L.H.	1
2	C-28610-2C	FRONT BRACKET ASSEMBLY, R.H.	1
3	C-28614	REAR BRACKET ASSEMBLY	2
4	C-28617-1	LIFT BRACKET, L.H.	1
5	C-28617-2	LIFT BRACKET, R.H.	1
6	C-23114	AIR SPRING	2
7	A-24614	LIFT ASSEMBLY BOLT KIT	1
8	*A-26828	IDENTIFICATION TAG	1
9	*DWG D-28630	UBL-004 LIFT KIT DRAWING	1
10	*A-21066	RIVET, DRIVE	1
11	*T91001	UBL HARDWARE KIT INFORMATION	1

- NOTES
- * NOT SHOWN
 - 1. 14" RIDE HEIGHT SHOWN. INSTALLATION IS SAME FOR ALL RIDE HEIGHTS.
 - 2. WEIGHT: 52.39 LB. INCLUDES .33 LB FOR ATTACHMENT WELDS.
 - 3. WELDING PARAMETERS:
SETTINGS FOR .045 DIAMETER WIRE
STANDARD WIRE - AWS ER-70S-6; .045 DIAMETER
OPTIONAL WIRE - AWS ER-70S-3; .045 DIAMETER
GAS - 86 ARGON 14 CO2 (30-35 CFH)
VOLTS - 26 TO 30
WIRE FEED SPEED - 380 TO 420 IPM
CURRENT - 275 TO 325 AMPS
ELECTRODE EXTENSION: 3/4 TO 1 INCH
SETTINGS FOR .035 DIAMETER WIRE
STANDARD WIRE - ER80S-D2; .035 DIAMETER
GAS - 85 ARGON 15 CO2 (35 TO 45 CFH)
VOLTS - 25 TO 27.5
WIRE FEED SPEED - 390 TO 425 IPM
CURRENT - 160 TO 180 AMPS
ELECTRODE EXTENSION: 3/4 TO 1 INCH
FILL ALL CRATERS AT END OF WELDS.
 - 4. BRAKE CHAMBERS, IF ALREADY MOUNTED, MUST BE REMOVED BEFORE INSTALLING LIFT KIT.
 - 5. IF EXISTING LATERAL BRACING AT FRONT OF FRAME BRACKETS INTERFERES WITH INSTALLATION OF THE LIFT KIT FRONT BRACKETS, BRACING MUST BE MODIFIED OR REMOVED AND RELOCATED. CONTACT HENDRICKSON TRAILER SUSPENSION SYSTEMS AT 866-RIDEAIR (866-743-3247).
 - 6. IF POSSIBLE, IT IS HIGHLY RECOMMENDED THAT THE LIFT BRACKET WELDING SHOWN ON PAGE 2 BE PERFORMED WITH THE SUSPENSION INVERTED, TO ALLOW THE WELDS TO BE APPLIED IN THE DOWNHAND POSITION.
 - 7. UBL-004 INTENDED FOR USE WITH CARBON STEEL FRAME BRACKETS ONLY. USE UBL-401 OR UBL-402 FOR STAINLESS STEEL FRAME BRACKETS.

FRONT BRACKET INSTALLATION

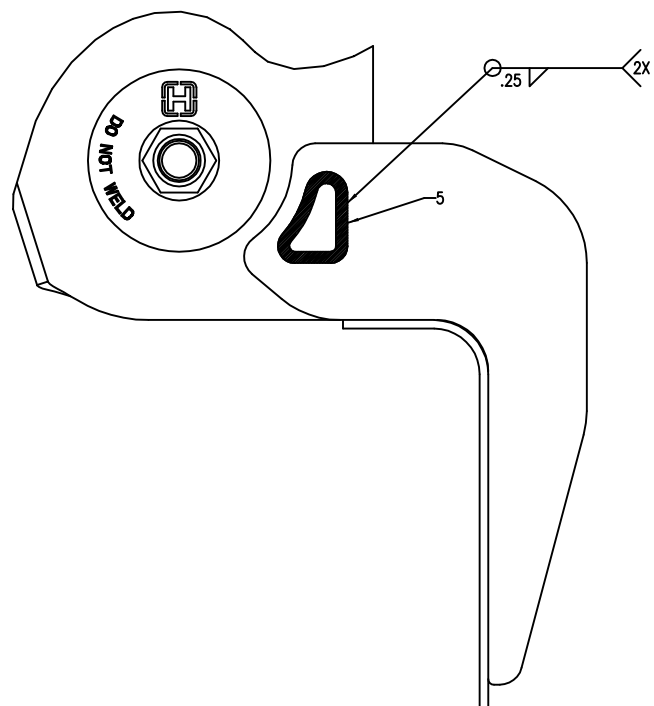
STEPS 7 & 8



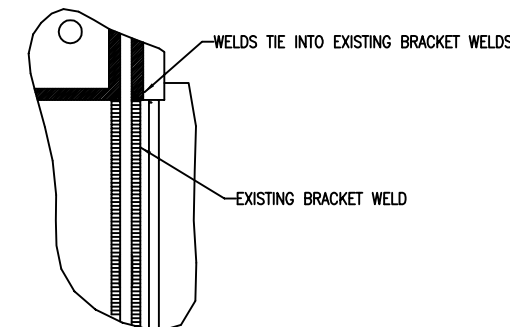
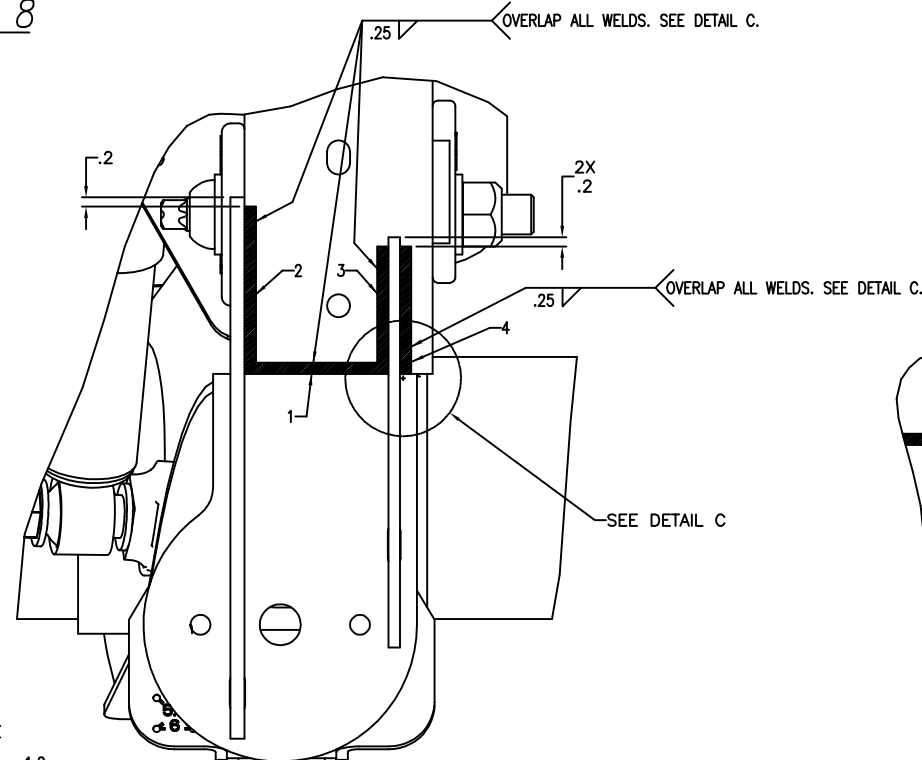
SCALE 1:4

ASSEMBLY PROCEDURE

- SEE PAGE 2 FOR ASSEMBLY STEPS 1 THROUGH 5. LIFT BRACKET MUST BE INSTALLED PRIOR TO FRONT BRACKET ASSEMBLY TO MAXIMIZE WELDING TORCH ACCESS TO LIFT BRACKET.
- *UBL CANNOT BE INSTALLED WITH SUSPENSION ASSEMBLED TO FRAME BRACKET (UNITIZED), AS EXCESSIVE WELDING HEAT WILL DAMAGE THE PIVOT BUSHING. SUSPENSION MUST BE DISASSEMBLED FROM FRAME BRACKETS BEFORE WELDING.
- PREPARING THE FRAME BRACKET SURFACES. REMOVE PAINT FROM ALL AREAS OF FRAME BRACKET TO BE WELDED
 - POSITIONING THE FRONT BRACKET ASSEMBLY. LOCATE THE FRONT BRACKET ASSEMBLY AGAINST THE FRAME BRACKET, AS SHOWN, TACK INTO PLACE.
 - WELDING THE FRONT BRACKET ASSEMBLY. PLACE WELDS IN THE INDICATED SEQUENCE, STARTING WITH THE HORIZONTAL FRONT WELD, AND ENDING WITH THE SLOT WELD ON THE INBOARD SIDE OF THE HANGER.
 - ASSEMBLY OF REMAINING COMPONENTS. ALIGN THE MOUNTING HOLES OF THE REAR BRACKET ASSEMBLY WITH THE LIFT BRACKET HOLES AND INSERT THE TWO 1/2-13 x 1.25 BOLTS AND NUTS. TIGHTEN TO THE VALUE CALLED OUT IN THE TORQUE SPECIFICATIONS CHART. ASSEMBLE THE AIR SPRING WITH THE AIR INLET FACING TO THE FRONT OR REAR, DEPENDING ON AIR LINE ORIENTATION PREFERENCE. TIGHTEN THE 3/4-16 FLANGE NUT AND 3/8-16 x .88 BOLTS TO SPECIFIED



SCALE 1:2



DETAIL C
OVERLAPPING WELDS
SCALE 1:2

This Print remains the property of Hendrickson. All information contained thereon is confidential. It is loaned, subject to return on demand and on express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.



TRAILER SUSPENSION SYSTEMS
2070 INDUSTRIAL PLACE S.E., CANTON, OH 44707-2820 U.S.A.

UNLESS OTHERWISE NOTED:		7	31904	D/D	9-27-18	DESIGNED BY	E.FABRIS
TOLERANCES ARE:	DIMENSIONS ARE:	8	31583	D/D	6-28-18	DRAWN BY	CLA
XX: ± .1	INCHES	9	31103	PK	02-15-18	APPROVED BY	G.COPELAND
XXX: ± .030	MILLIMETERS	4	19856	MDS	6-8-11	DATE	
ANGULAR: ± .02°							

PART NUMBER	REV.
UBL-004	7

P
PRODUCTION

UBL-004
LIFT KIT FOR AANT 23K

SCALE	SIZE	PAGE
.25=1.00	D	1 OF 3

D-28630

LIFT BRACKET INSTALLATION

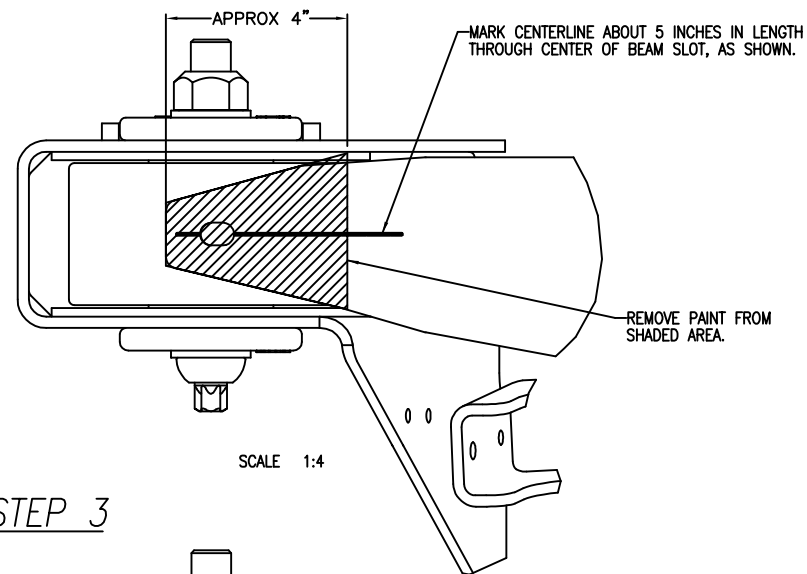
ASSEMBLY PROCEDURE

*UBL CANNOT BE INSTALLED WITH SUSPENSION ASSEMBLED TO FRAME BRACKET (UNITIZED), AS EXCESSIVE WELDING HEAT WILL DAMAGE THE PIVOT BUSHING. SUSPENSION MUST BE DISASSEMBLED FROM FRAME BRACKETS BEFORE WELDING.

1. **PREPARING THE BEAM SURFACE.**
REMOVE PAINT FROM UNDERSIDE OF TRAILING ARM BEAM AS INDICATED BY THE SHADED AREA.
2. **MARKING THE CENTERLINE.**
MARK OR SCRIBE A LINE THROUGH THE CENTER OF THE SMALL OVAL SLOT ON THE UNDERSIDE OF THE TRAILING ARM BEAM, AS SHOWN. THE LINE SHOULD BE AT LEAST 5 INCHES IN LENGTH AND PARALLEL TO THE OUTBOARD SIDE OF THE BEAM.
3. **POSITIONING THE LIFT BRACKET.**
LOCATE LIFT BRACKET (ITEM 4 - L.H., ITEM 5 - R.H.) TO UNDERSIDE OF BEAM, ALIGNING TAB AT REAR OF LIFT BRACKET TO MARKED LINE. MAKE SURE BRACKET SLOT IS PARALLEL TO MARKED LINE, AND FRONT OF THE BRACKET SLOT LINES UP WITH THE FRONT OF THE BEAM SLOT. TACK INTO PLACE.
4. **FILLING THE SMALL SLOT.**
PRIOR TO MAKING THE 3-PASS WELD, COMPLETELY FILL THE SMALL SLOT ON THE UNDERSIDE OF THE BEAM.
5. **WELDING THE LIFT BRACKET.**
COMPLETE ATTACHMENT OF LIFT BRACKET BY WELDING THE LARGE OVAL SLOT IN THE BRACKET TO THE BEAM. THIS IS A 3-PASS WELD. ALL THREE PASSES MUST BE UNINTERRUPTED AROUND THE FRONT OF THE SLOT, AS INDICATED IN "STEP 5" ILLUSTRATION. NO WELDING IS REQUIRED OUTSIDE OF THE SLOT AREA.

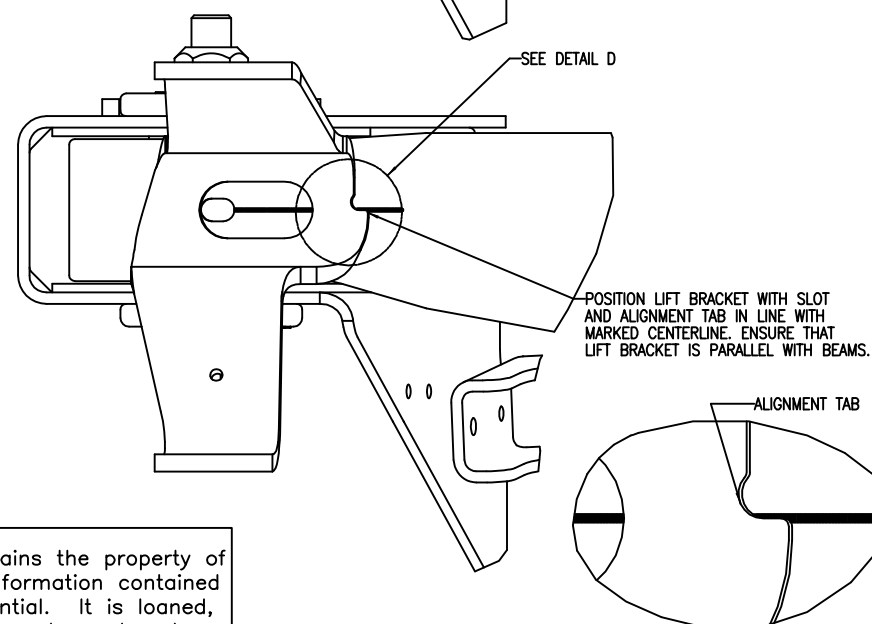
SEE PAGE 1 FOR FRONT BRACKET ASSEMBLY WELDING INSTRUCTIONS.

STEPS 1 & 2

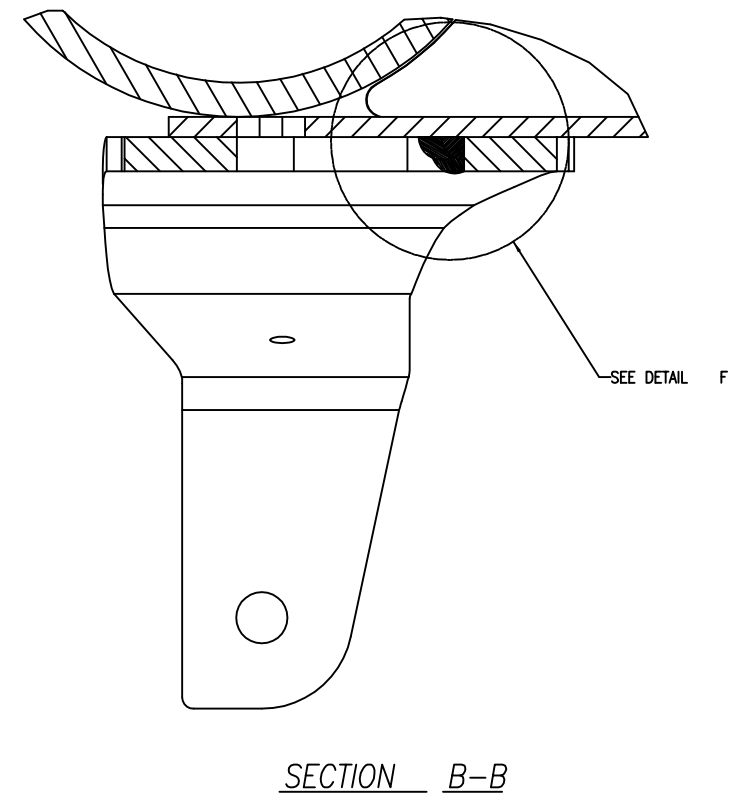
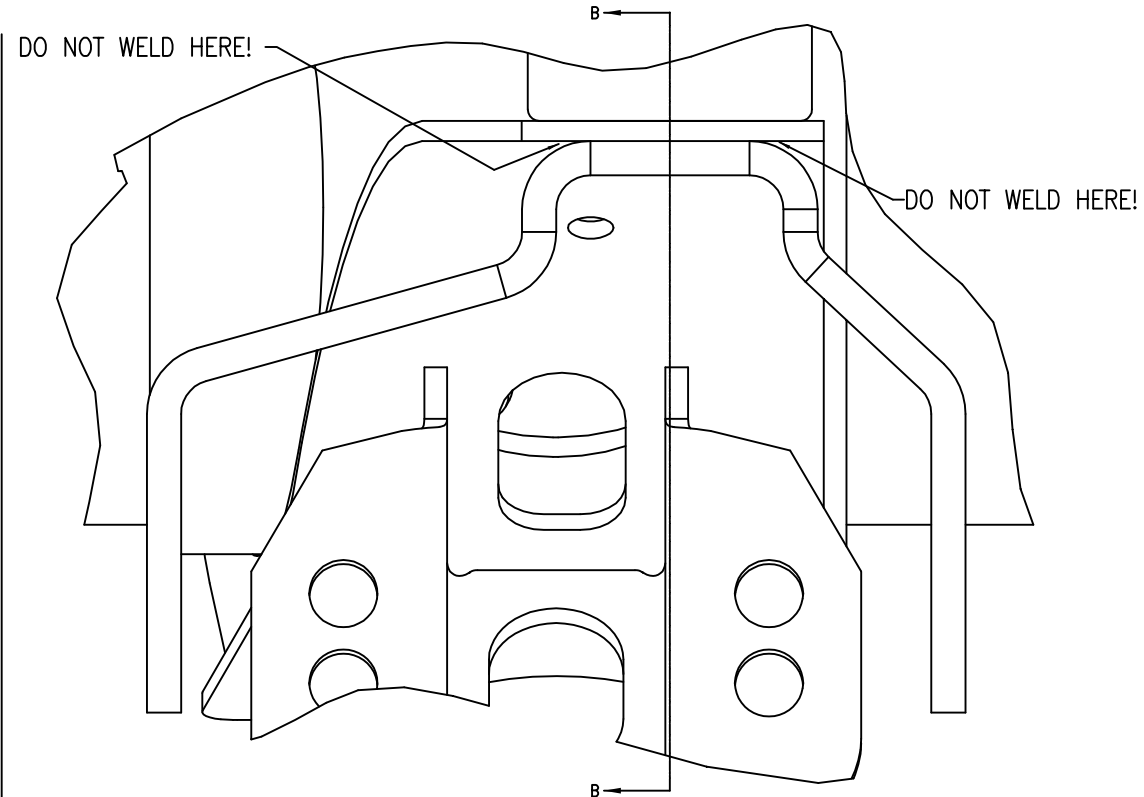


SCALE 1:4

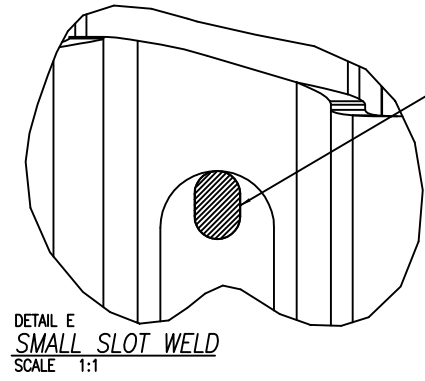
STEP 3



DETAIL D
ALIGNMENT TAB
SCALE 3:2

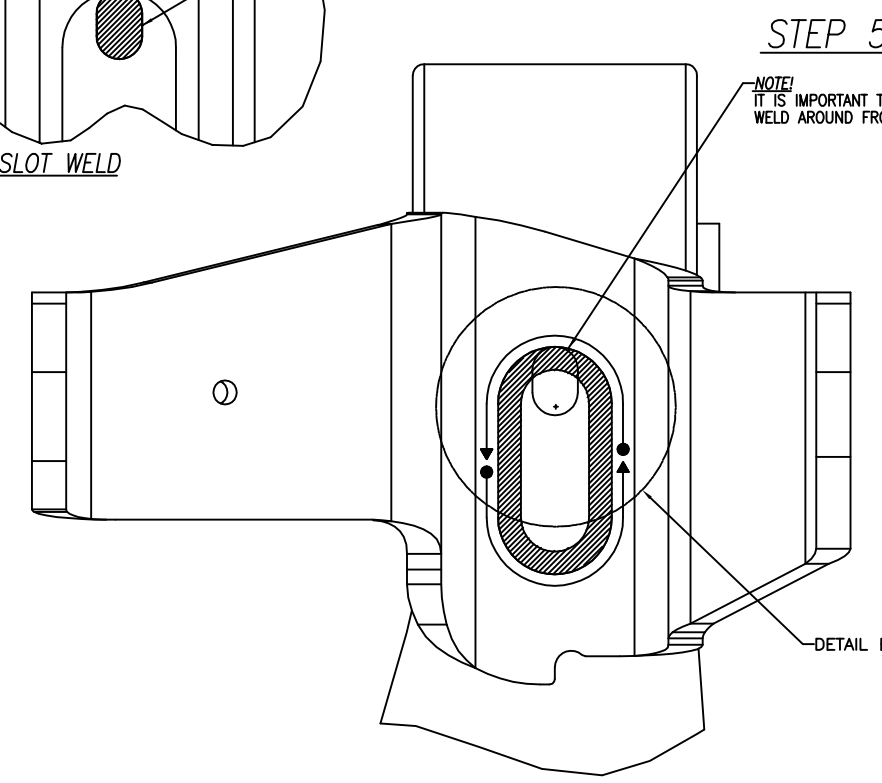


SECTION B-B



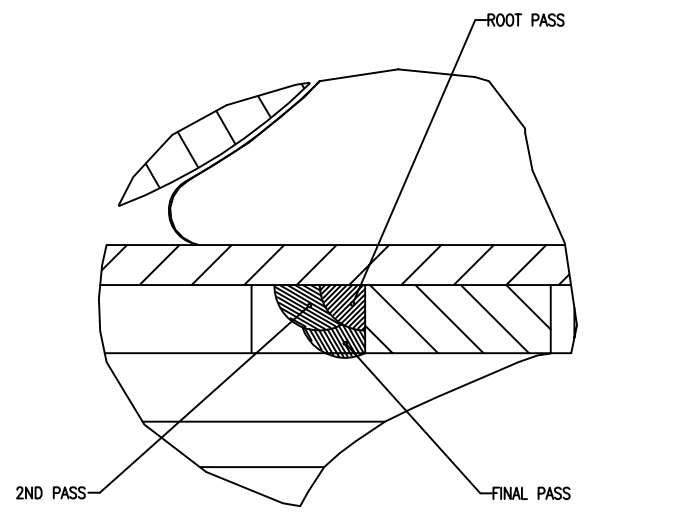
DETAIL E
SMALL SLOT WELD
SCALE 1:1

STEP 4
FILL SLOT COMPLETELY



STEP 5

FRAME BRACKET, BRAKES, AND ASSOCIATED COMPONENTS NOT PICTURED FOR CLARITY.
SCALE 1:1



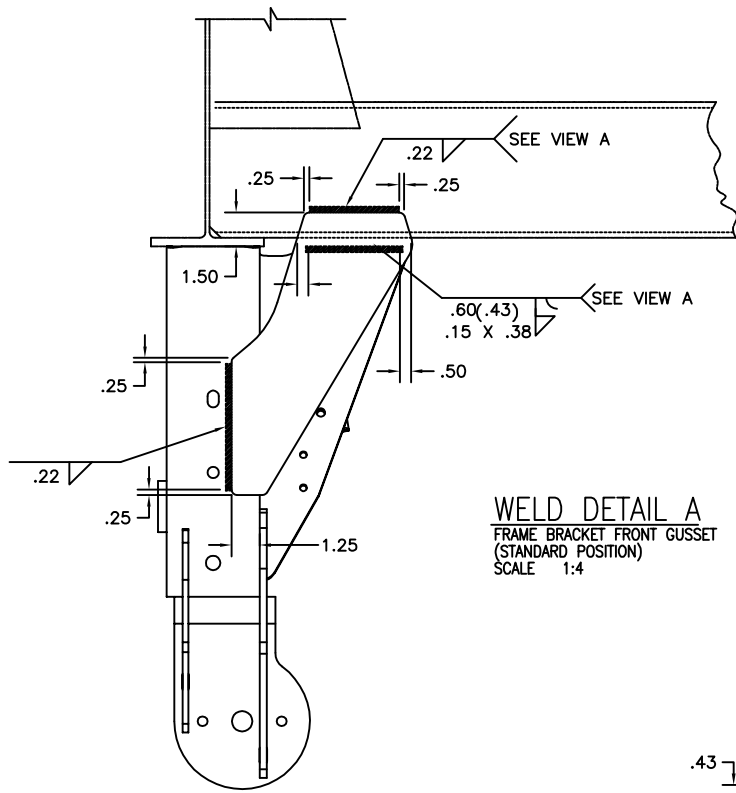
DETAIL F
TRIPLE-PASS WELD SEQUENCE
SCALE 2:1

This Print remains the property of Hendrickson. All information contained thereon is confidential. It is loaned, subject to return on demand and on express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.

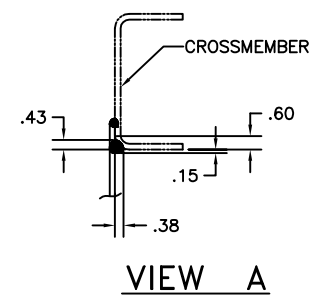
H. HENDRICKSON		UNLESS OTHERWISE NOTED, DIMENSIONS ARE IN INCHES		7	31904	D/D	9-27-18	DRAWN BY	E. FABRIS	08-Mar-06	SCALE	.25=1.00	REV	D	PAGE	2 OF 3
TRAILER SUSPENSION SYSTEMS		TOLERANCES ARE:		8	31587	D/D	6-28-18	CHK'D BY	CLA							
2070 INDUSTRIAL PLACE S.E., CANTON, OH 44707-2800 U.S.A.		X: ± .1		3	31103	PK	02-13-18	APP'D BY	G. COPELAND							
		Y/Z: ± .06		4	19826	MDT	6-8-11									
		ANGULAR: ± .05°														
		DIMENSIONS ADHERE TO ANSI Y14.5M-1982														

UBL-004
LIFT KIT FOR AANT 23K

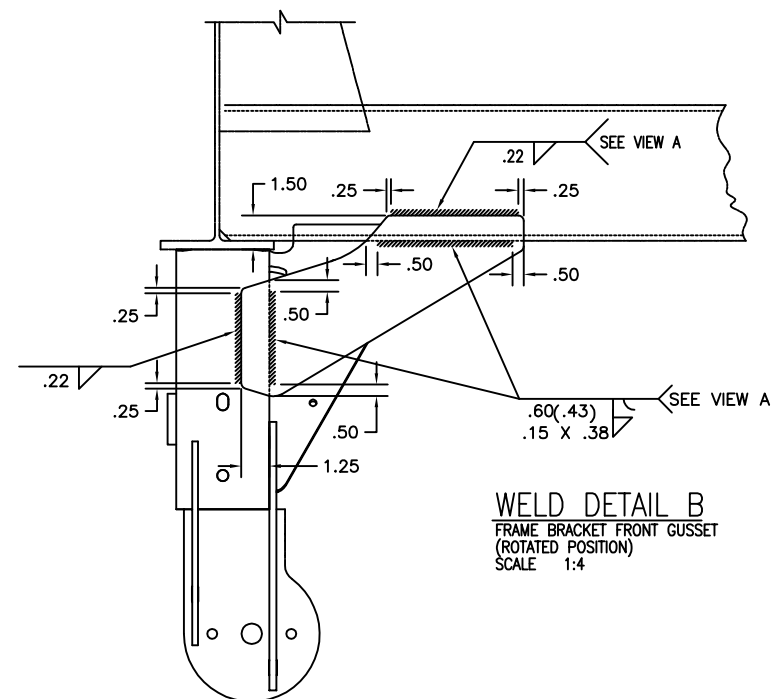
P
PRODUCTION
D-28630



WELD DETAIL A
 FRAME BRACKET FRONT GUSSET
 (STANDARD POSITION)
 SCALE 1:4

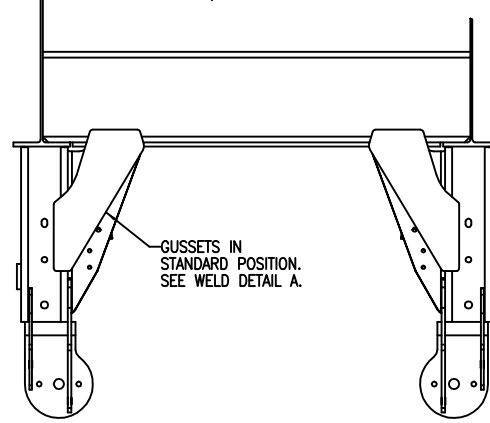


VIEW A

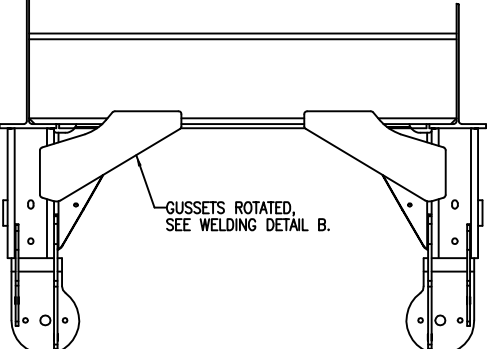


WELD DETAIL B
 FRAME BRACKET FRONT GUSSET
 (ROTATED POSITION)
 SCALE 1:4

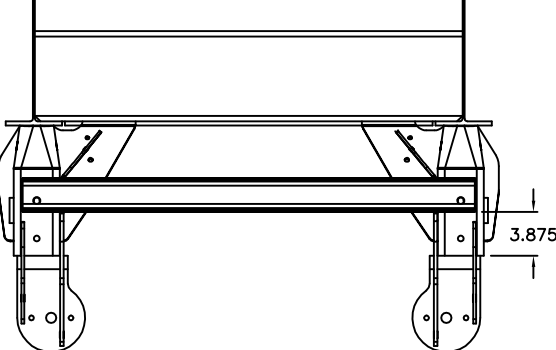
ON FRAME BRACKETS REQUIRING LATERAL SUPPORT GUSSETS, INCLUDING STRAIGHT-SIDED AND TAPERED WELD-ON FRAME BRACKETS, GUSSETS CAN BE ATTACHED IN STANDARD POSITIONS FOR 12" PIVOT HEIGHT ONLY (18" AND 19" RIDE HEIGHTS). FOR OTHER RIDE HEIGHTS, SEE VIEWS BELOW.



ON STRAIGHT-SIDED WELD-ON FRAME BRACKETS WITH A PIVOT HEIGHT OF 10" OR LESS (13.5" THROUGH 17.0" RIDE HEIGHTS), GUSSETS MUST BE ROTATED, AS SHOWN, TO AVOID UBL INTERFERENCE.



FOR TAPERED WELD-ON FRAME BRACKETS WITH A PIVOT HEIGHT OF 10" OR LESS (13.5" THROUGH 17.0" RIDE HEIGHTS), THE GUSSETS CANNOT BE USED, AND LATERAL SUPPORT MUST BE PROVIDED BY A CHANNEL.



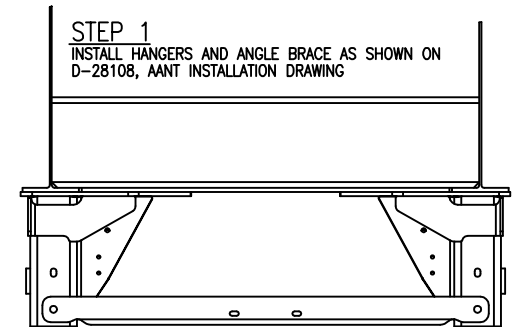
CERTAIN UBL APPLICATIONS MAY REQUIRE ALTERNATIVE FRAME BRACKET BRACING, DEPENDING ON FRAME HEIGHT AND STYLE.

FOR BOLT-ON SUSPENSIONS THAT REQUIRE A BRACING ANGLE OR CHANNEL:

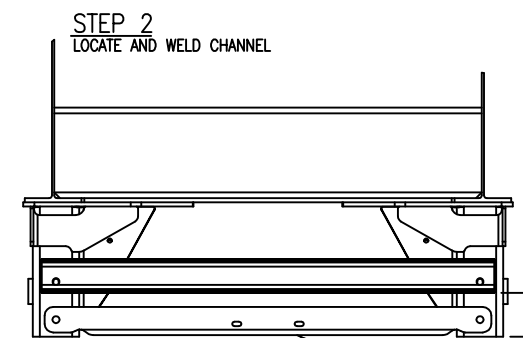
1. FOLLOW PROCEDURE FOR INSTALLING FRAME BRACKETS AS OUTLINED IN THE INSTALLATION SEQUENCE, UNDER BRACING ANGLE INSTALLATION ON PAGE 2 OF D-28108, AANT INSTALLATION DRAWING, LEAVING THE BRACING ANGLE BOLTED IN PLACE.
2. WITH BRACING ANGLE IN PLACE, LOCATE C-CHANNEL AS SHOWN IN STEP 2. WELD C-CHANNEL IN PLACE AND REMOVE BRACING ANGLE.
3. INSTALL UBL FRONT BRACKET AS SHOWN.

FOR WELD-ON SUSPENSIONS THAT REQUIRE A FRONT GUSSET:

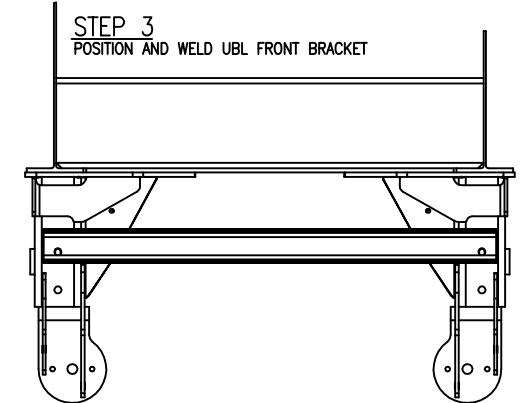
BEFORE INSTALLING FRONT GUSSETS, DETERMINE WHETHER THE UBL FRONT BRACKET WILL INTERFERE WITH THE RECOMMENDED FRONT GUSSET. SOME APPLICATIONS REQUIRE THE FRONT GUSSETS TO BE ROTATED TO PROVIDE CLEARANCE TO THE UBL BRACKET. IN CASES WHERE THERE IS INSUFFICIENT SPACE FOR A ROTATED GUSSET, A CHANNEL BRACE MUST BE USED. SEE ILLUSTRATIONS.



STEP 1
 INSTALL HANGERS AND ANGLE BRACE AS SHOWN ON D-28108, AANT INSTALLATION DRAWING



STEP 2
 LOCATE AND WELD CHANNEL



STEP 3
 POSITION AND WELD UBL FRONT BRACKET

REMOVE AFTER WELDING C-CHANNEL IN PLACE

This Print remains the property of Hendrickson. All information contained thereon is confidential. It is loaned, subject to return on demand and on express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.