

BILL OF MATERIALS: UBL--			601	602
ITEM	PART NUMBER	DESCRIPTION	QTY.	QTY.
1	C-37625-1C	FRONT BRACKET ASSEMBLY, L.H.	1	-
1	C-37625-1GV	FRONT BRACKET ASSEMBLY, L.H.	-	1
2	C-37625-2C	FRONT BRACKET ASSEMBLY, R.H.	1	-
2	C-37625-2GV	FRONT BRACKET ASSEMBLY, R.H.	-	1
3	C-28614	REAR BRACKET ASSEMBLY	2	2
4	C-28617-1	LIFT BRACKET, L.H.	1	1
5	C-28617-2	LIFT BRACKET, R.H.	1	1
6	C-23114	AIR SPRING	2	2
7	A-37955-1	LIFT ASSEMBLY BOLT KIT	1	1
8	*A-26828	IDENTIFICATION TAG	1	1
9	*DWG D-37932	UBL-6XX LIFT KIT DRAWING	1	1
10	*A-21066	RIVET, DRIVE	1	1
11	*T91001	UBL INFORMATION AND INSTALLATION	1	1

* NOT SHOWN

NOTES:

- 16" RIDE HEIGHT SHOWN. INSTALLATION IS SAME FOR ALL RIDE HEIGHTS.
- WEIGHT: 74.97 LB. INCLUDES .25 LB FOR ATTACHMENT WELDS.
- WELDING PARAMETERS:
NOTE: A WELDER QUALIFIED IN 2G POSITION PER ANSI/AWS D1.1-94 SECTION 5 PART C "WELDER QUALIFICATIONS" MUST PERFORM THE WELDING.

FOR ALL WELDED CONNECTIONS, USE THE FOLLOWING PARAMETERS TO ACHIEVE SPRAY ARC TRANSFER:

SURFACE PREP: THE ITEMS TO BE WELDED MUST BE AT A MINIMUM TEMPERATURE OF 60°F (16°C) AND MUST BE FREE OF MOISTURE, DIRT, SCALE, PAINT AND GREASE.

STANDARD ELECTRODE: AWS E-7018 (OVEN DRIED); .125 DIAMETER; 120-140 AMPS DC; ELECTRODE POSITIVE
.156 DIAMETER; 120-160 AMPS DC; ELECTRODE POSITIVE

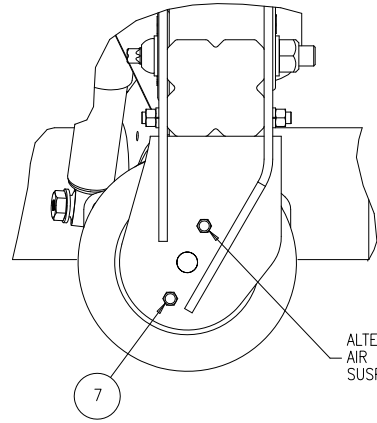
STANDARD WIRE: AWS ER-70S-6; .045 DIAMETER
OPTIONAL WIRE: AWS ER-70S-3; .045 DIAMETER

VOLTS: 26 - 30 DCRP
CURRENT: 275 - 325 AMPS
WIRE FEED SPEED: 380 - 420 IPM
ELECTRODE EXTENSION: 3/4 - 1 INCH

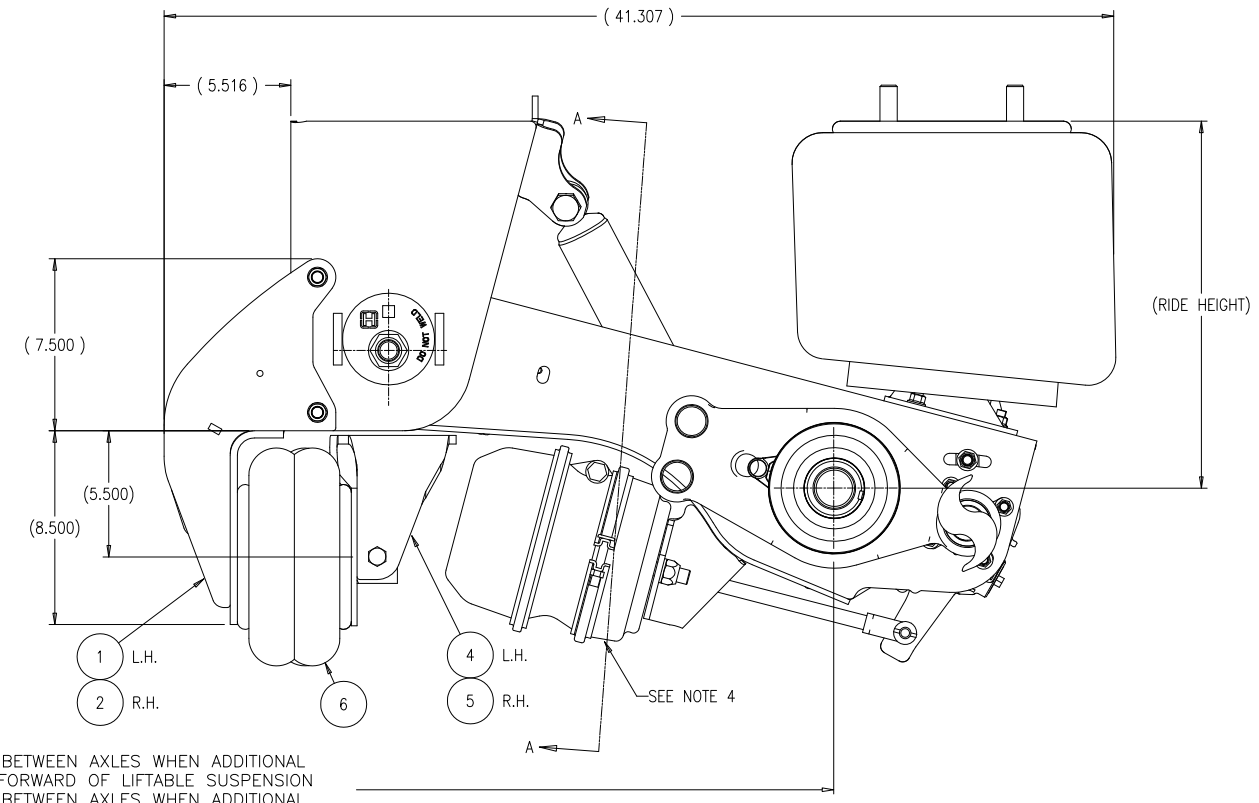
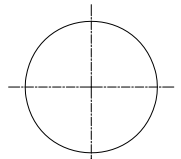
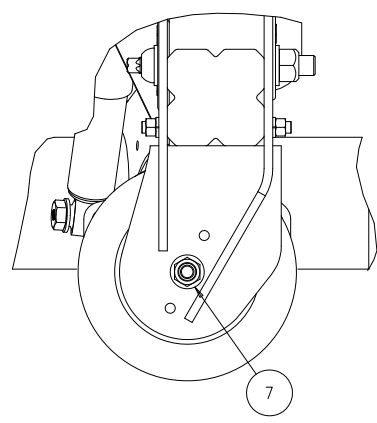
GAS: 86 PERCENT ARGON AND 14 PERCENT CO2 AT 30 TO 35 CFH

NOTE: ANY DEVIATION FROM THESE WELDING PARAMETERS MUST BE APPROVED IN WRITING BY HENDRICKSON TRAILER COMMERCIAL VEHICLE SYSTEMS.

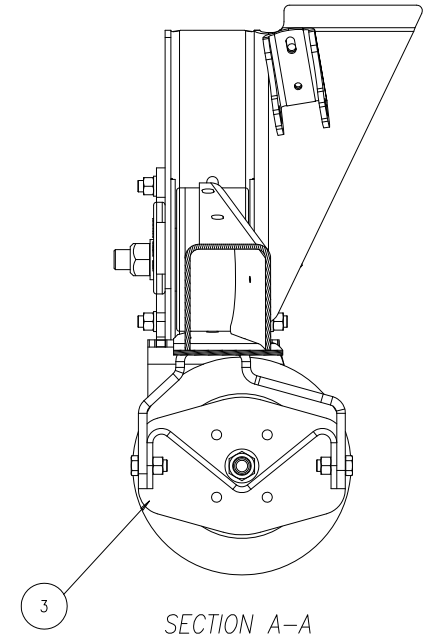
WELD DIRECTION:
STOP START
←-----→
4. BRAKE CHAMBERS, IF ALREADY MOUNTED, MUST BE REMOVED BEFORE INSTALLING LIFT KIT.
- BOLT-ON FRONT BRACKET ASSEMBLY CAN BE USED IN CONJUNCTION WITH BOLT-ON LATERAL BRACE. IN SUCH CASES, THE FRONT MOUNTING BOLT (SHOWN IN STEP 4, PAGE 3) IS USED FOR ATTACHING BOTH UBL BRACKET AND LATERAL BRACE. FOR LATERAL BRACES OTHER THAN THOSE SUPPLIED BY HENDRICKSON, CARE MUST BE TAKEN NOT TO OBSTRUCT THE FRONT MOUNTING HOLE. SEE VIEW B-B.
- 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.



ALTERNATE INSTALLATION:
AIR INLET TOWARD REAR OF SUSPENSION



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



SECTION A-A
SOME COMPONENTS NOT SHOWN FOR CLARITY.

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UNLESS OTHERWISE NOTED: TOLERANCES ARE: X: ± .1 XX: ± .06 XXX: ± .030 ANGULAR: ± .05°	DIMENSIONS ARE: INCHES	0	26013	JLW	11/11/16	DATE	BY	REV.	ECN NO.	3RD ANGLE PROJECTION	DRAWN BY J WIGGINS	11-NOV-18	CHK'D BY J. RAMUS	APPR'D BY T. HESS	THIS DRAWING IS THE CONFIDENTIAL PROPERTY OF HENDRICKSON
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UBL-601 AND-602
LIFT KIT FOR AANT

UNDER BEAM LIFT

SCALE .25=1.00	SIZE D	PAGE 1 OF 3
D-37932		

LIFT BRACKET INSTALLATION

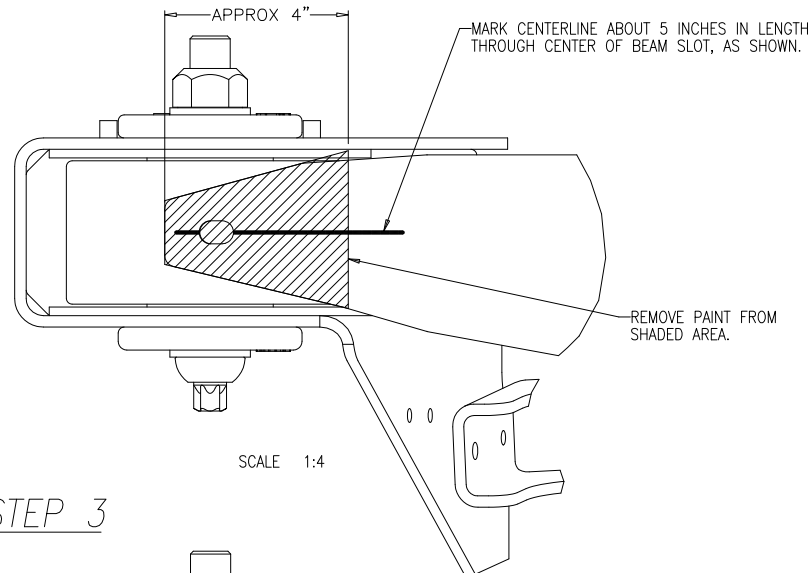
ASSEMBLY PROCEDURE

*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.
6. ASSEMBLING AIR SPRING MOUNTING PLATE.
INSTALL REAR BRACKET ASS'Y (ITEM-3) USING (4) 1/2-13 X 1.25 HEX CAP SCREWS AND (4) 1/2-13 NUTS AND TIGHTEN TO SPECIFIED TORQUE.

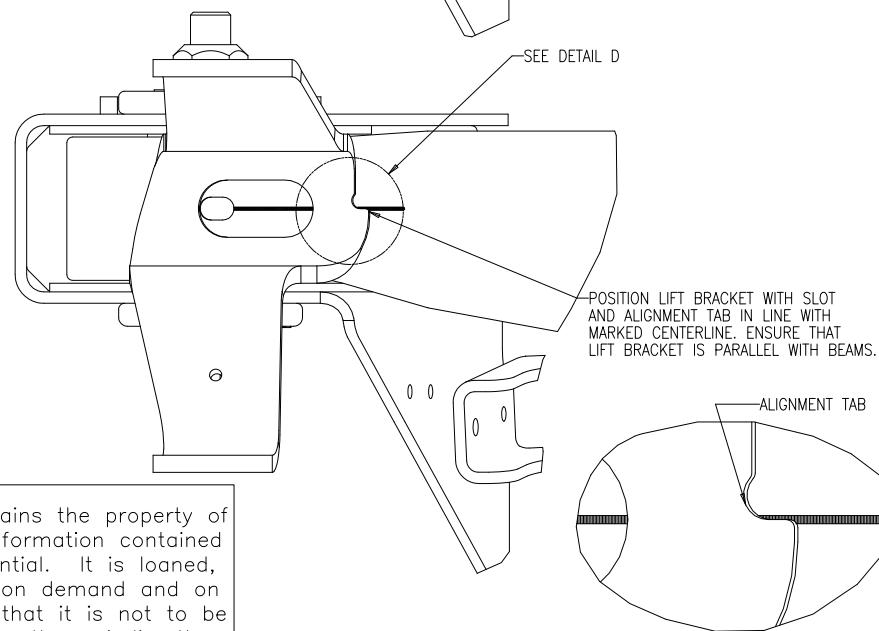
SEE PAGE 3 FOR FRONT BRACKET ASSEMBLY INSTRUCTIONS.

STEPS 1 & 2



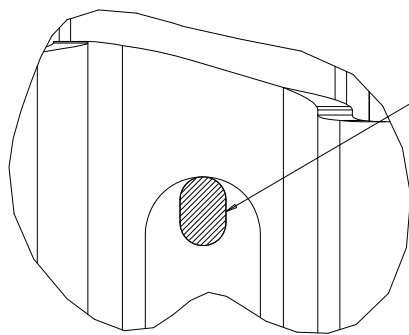
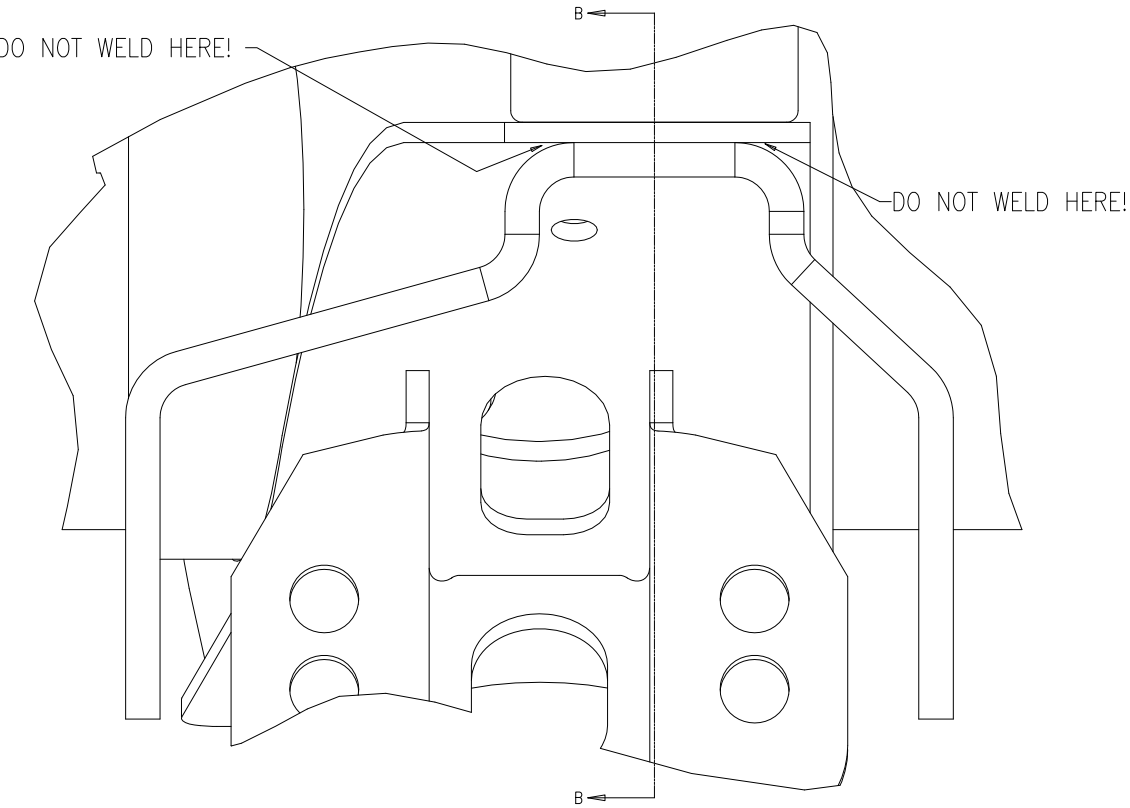
SCALE 1:4

STEP 3



DETAIL D
ALIGNMENT TAB
SCALE 3:2

DO NOT WELD HERE!



STEP 4

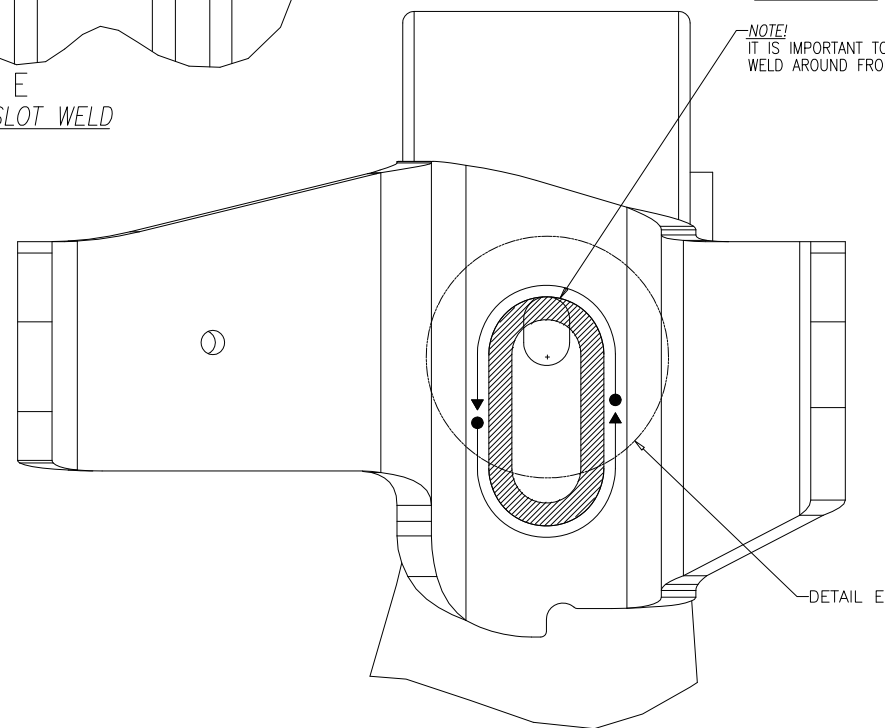
FILL SLOT COMPLETELY

DETAIL E
SMALL SLOT WELD
SCALE 1:1

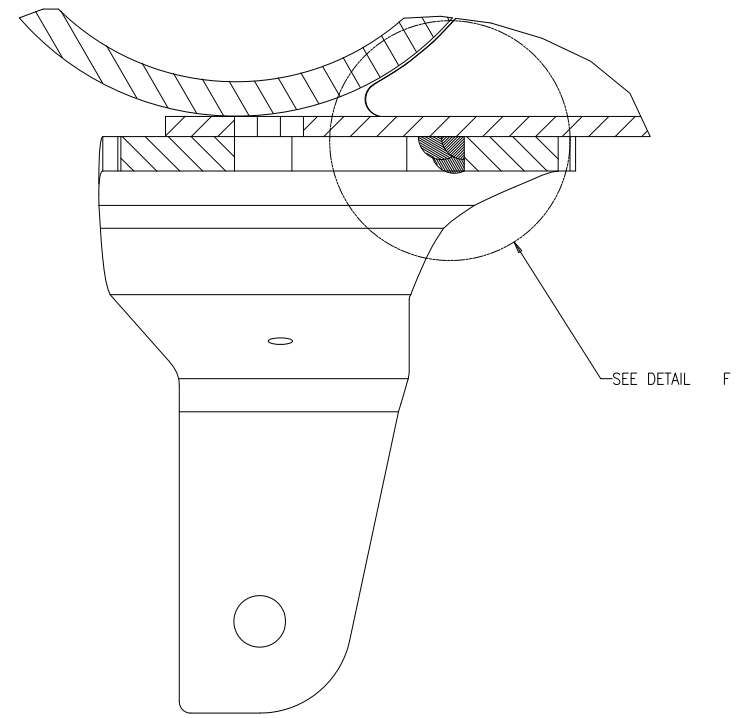
FRAME BRACKET, BRAKES, AND ASSOCIATED COMPONENTS NOT PICTURED FOR CLARITY.
SCALE 1:1

STEP 5

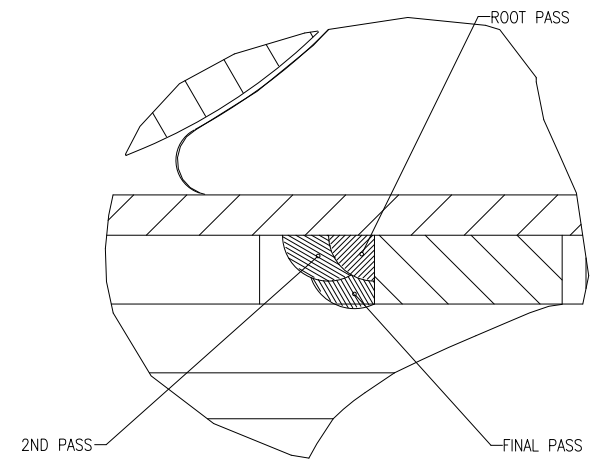
NOTE!
IT IS IMPORTANT TO ENSURE CONTINUOUS WELD AROUND FRONT OF SLOT.



DETAIL E



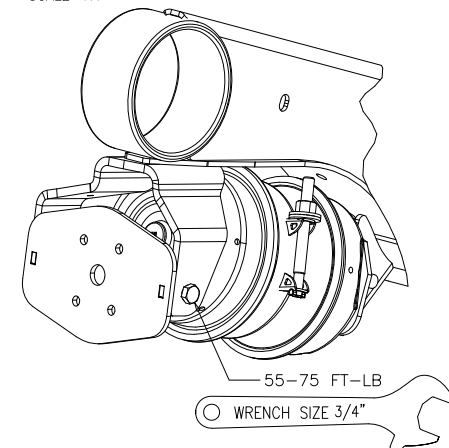
SECTION B-B



DETAIL F
TRIPLE-PASS WELD SEQUENCE
SCALE 2:1

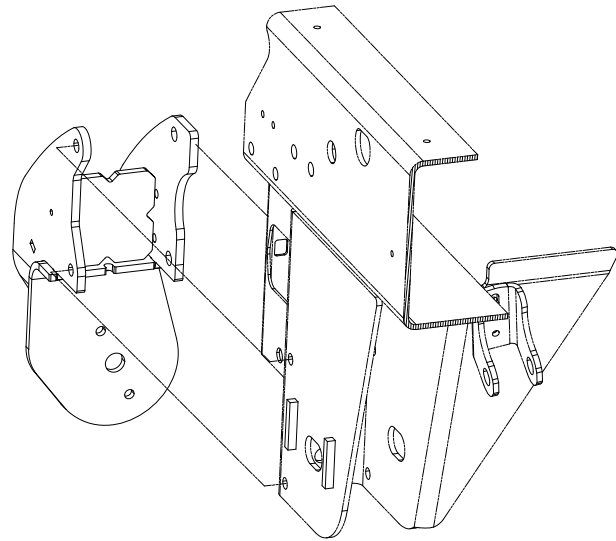
STEP 6

SCALE 1:1

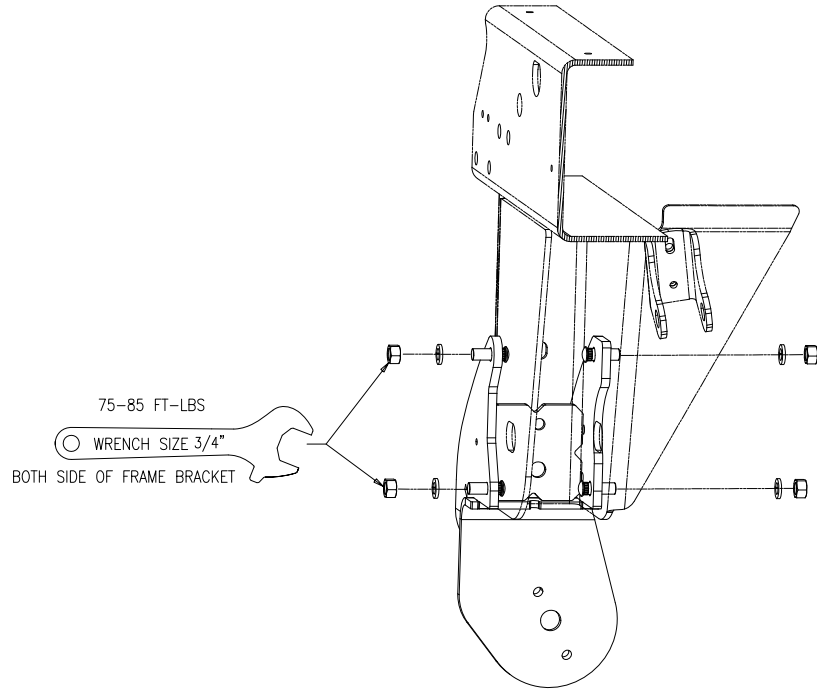


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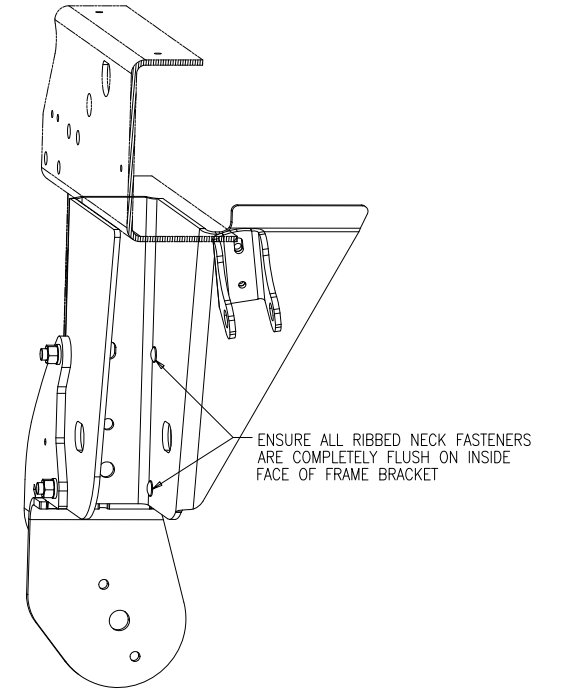
STEP 1



STEP 2



STEP 3



**FRONT BRACKET
ASSEMBLY PROCEDURE**

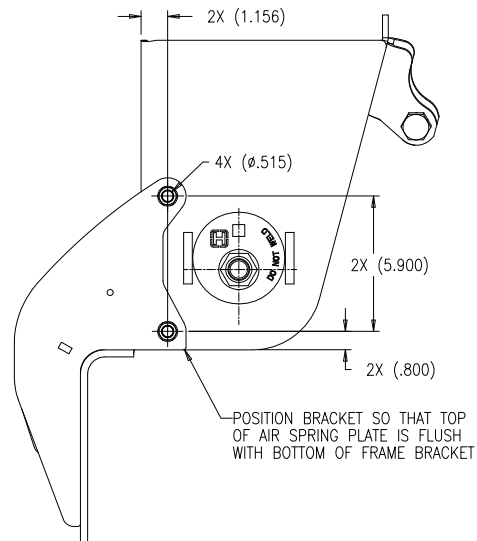
** FRONT BRACKET MUST BE IN PLACE BEFORE SEATING THE RIBBED-NECK BOLTS. BRACKET CANNOT BE INSTALLED IF BOLTS ARE INSTALLED PRIOR TO POSITIONING OF THE BRACKET.

1. **FITTING BRACKET INTO PLACE.**
SLIDE FRONT BRACKET INTO PLACE, MAKING SURE THAT ALL MOUNTING HOLES IN UBL BRACKET ALIGN WITH HOLES IN FRAME BRACKET.
2. **INSERTING SIDE MOUNTING BOLTS.**
HOLDING THE FRONT BRACKET IN PLACE, PUSH RIBBED NECK FASTENERS INTO MOUNTING HOLES FROM INSIDE OF FRAME BRACKET. INSERT AND TIGHTEN THE PROVIDED 1/2-13 STANDARD (NON-LOCKING) HEX NUT AND 1/2 LOCK WASHER ON EACH RIBBED-NECK FASTENER. AS THE NUT IS TIGHTENED, THE FASTENER WILL BE DRAWN INTO THE FRAME BRACKET MOUNTING HOLES. TIGHTEN THE NUT UNTIL THE HEAD OF THE FASTENER IS FLUSH WITH THE INSIDE OF THE HANGER. TORQUE TO SPECIFIED VALUE.
3. **ENSURE ALL RIBBED NECK FASTENERS ARE COMPLETELY FLUSH ON INSIDE FACE OF FRAME BRACKET.**
4. **AIR SPRING ASSEMBLY.** 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 TORQUES.

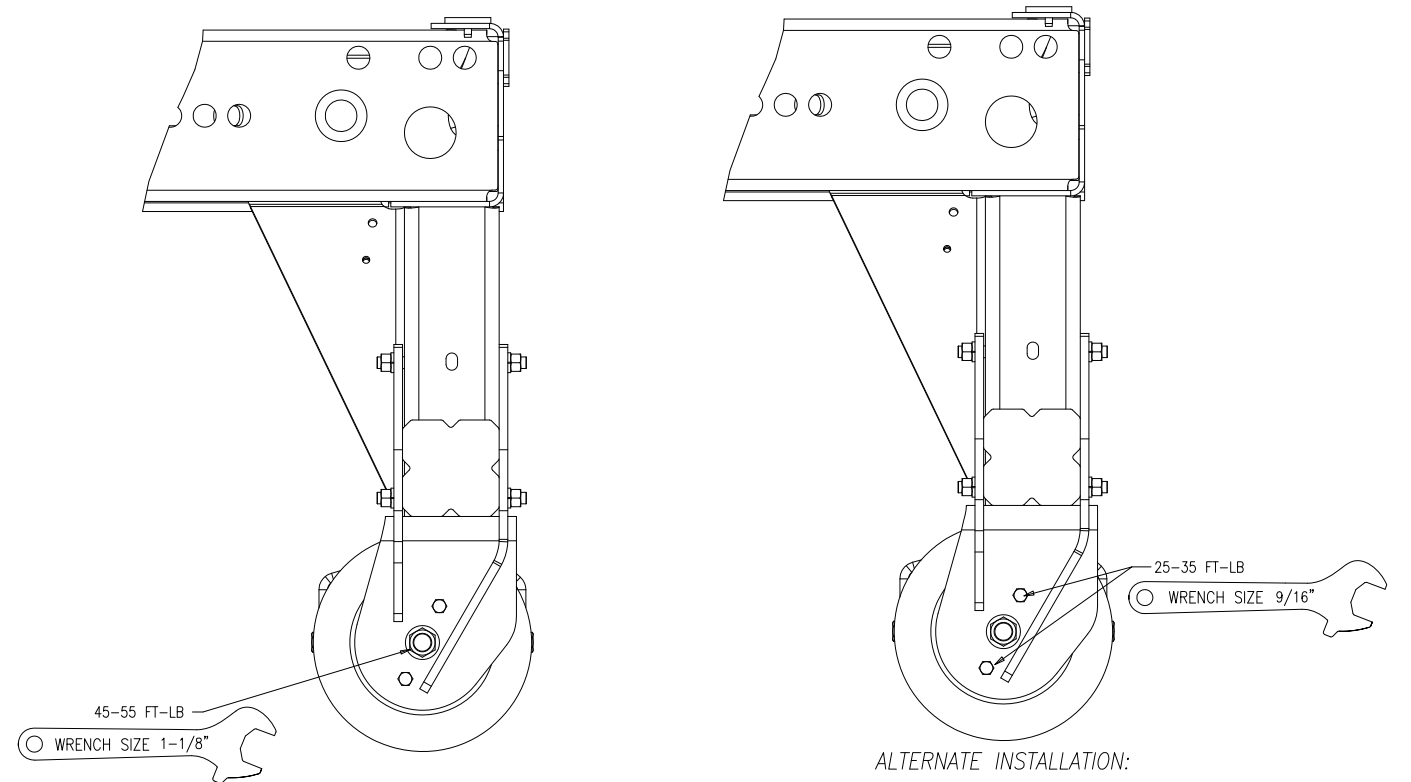
MODIFICATIONS NECESSARY IF FRAME BRACKETS ARE NOT EQUIPPED WITH MOUNTING HOLES

1. POSITION FRONT LIFT BRACKET ONTO SUSPENSION FRAME BRACKET.
2. OUTBOARD HOLES: USING TRANSFER PUNCH, CENTER PUNCH TO LOCATE CENTER OF FRONT LIFT BRACKET HOLES ONTO THE OUTBOARD SIDE OF THE SUSPENSION FRAME BRACKET.
3. DRILL PILOT HOLES, SIZE OPTIONAL.
4. DRILL FINISH HOLES USING 33/64" DRILL (.515" DIA.)
5. FINISH: IF FRAME BRACKETS HAVE BEEN GALVANIZED, SURFACE OF DRILLED HOLES WILL NEED TO BE SUITABLY RECOATED.

HOLE LOCATIONS



STEP 4



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