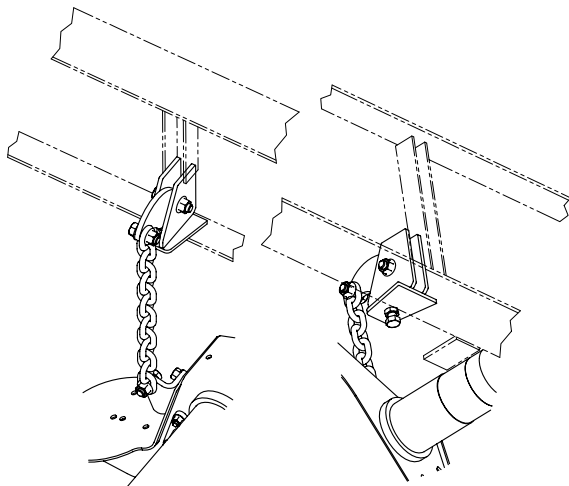


ITEM	DESCRIPTION	ARL
1-199	ARL KIT COMPONENTS	B-26594

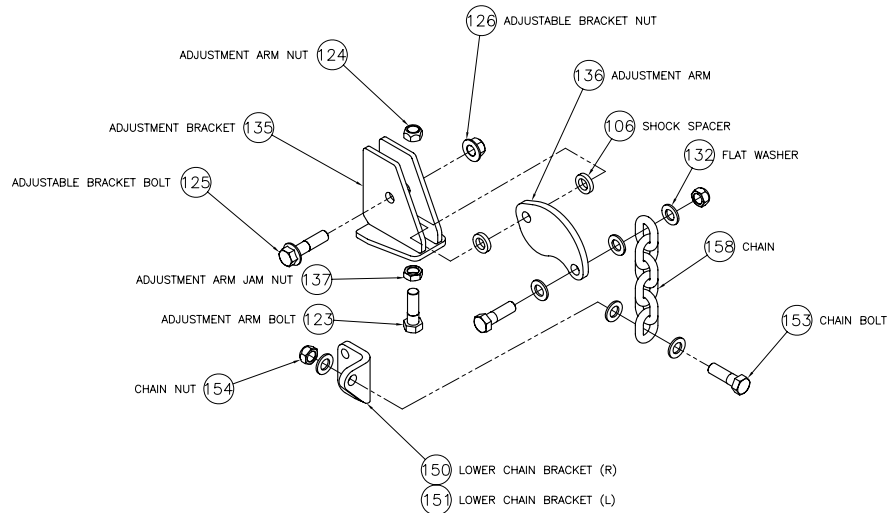


VIEW B

OPTION 1
REINFORCEMENT GUSSETS

VIEW C

OPTION 2
WEB STIFFENERS

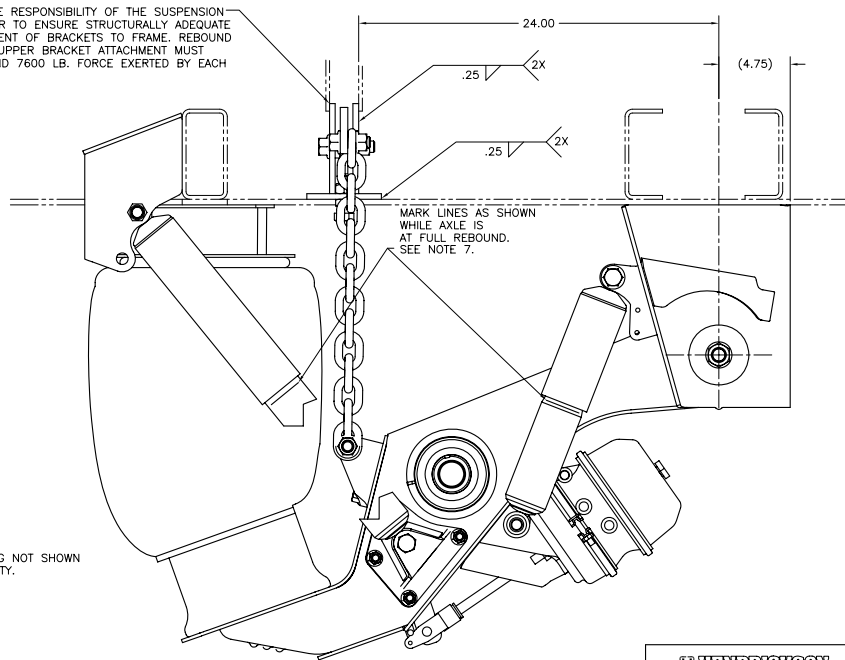


NOTES:
1. BALLOONED NUMBERS FOR HENDRICKSON INTERNAL USE ONLY.

ASSEMBLY PROCEDURE FOR REBOUND LIMITER:

1. RAISE REAR OF TRAILER AND SUPPORT SECURELY. TRAILER MUST BE HIGH ENOUGH FOR THE SUSPENSION TO BE AT FULL REBOUND WITHOUT TIRES TOUCHING GROUND.
2. POSITION UPPER BRACKET ASSEMBLIES ON FRAME RAILS TO INDICATED DIMENSION AND CLAMP INTO PLACE.
3. ATTACH LOWER BRACKETS TO TRAILING ARMS USING THE FOUR 5/8" FLANGE BOLTS AND NUTS.
4. VERIFY THAT THE CHAINS HAVE THE CORRECT NUMBER OF LINKS INDICATED FOR THE APPLICATION'S RIDE HEIGHT (SEE "CHAIN LENGTH" CHART). ATTACH CHAINS TO LOWER AND UPPER BRACKETS USING THE 3/4" BOLTS, NUTS, AND WASHERS AS SHOWN IN EXPLODED VIEW.
5. ROTATE THE ADJUSTMENT BOLT UNTIL THE SLACK IS TAKEN OUT OF THE CHAINS.
6. WELD THE UPPER BRACKETS TO THE FRAME AS SHOWN. BRACKETS MUST BE ADEQUATELY ATTACHED TO FRAME USING ONE OF TWO METHODS: WEB STIFFENER PLATES OR SUPPLEMENTARY GUSSETS. (SEE VIEW "B" AND "C").
7. ON REAR MOUNTED SHOCK ABSORBERS, MEASURE 3/8" OFFSET FROM THE BOTTOM EDGE OF THE SHOCK ABSORBER DUST TUBE AND MARK WITH A PAINT PEN OR FELT TIP MARKER. IF THE SUSPENSION IS NOT EQUIPPED WITH REAR SHOCKS, OFFSET 1/4" ON THE FRONT SHOCK AND MARK. (SEE FRONT VIEW).
8. ROTATING THE ADJUSTMENT BOLTS ON EACH SIDE, RAISE THE AXLE UNTIL THE BOTTOM EDGES OF THE SHOCK DUST TUBES ARE ALIGNED WITH THE MARKS.
9. TIGHTEN ALL FASTENERS, INCLUDING JAM NUT, TO SPECIFIED TORQUE. (SEE "TORQUE SPECIFICATION" CHART).

IT IS THE RESPONSIBILITY OF THE SUSPENSION INSTALLER TO ENSURE STRUCTURALLY ADEQUATE ATTACHMENT OF BRACKETS TO FRAME. REBOUND LIMITER UPPER BRACKET ATTACHMENT MUST WITHSTAND 7600 LB. FORCE EXERTED BY EACH CHAIN.

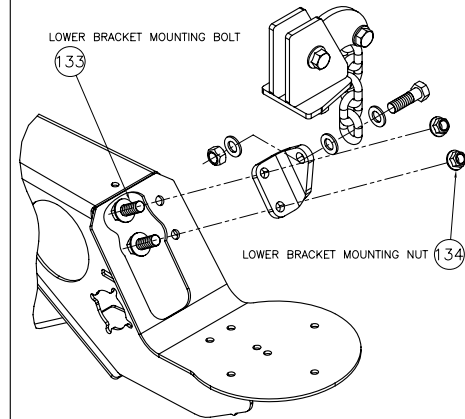


TORQUE SPECIFICATIONS		
DESCRIPTION	SIZE	TORQUE (FT-LB)
LOWER CHAIN BRACKET BOLTS	5/8-11	190-200
UPPER CHAIN BRACKET BOLTS	3/4-10	240-260
CHAIN ATTACHMENT BOLTS	3/4-10	240-260
JAM NUT	3/4-10	240-260

CHAIN LENGTH	RIDE HEIGHT	# OF LINKS
8	10	
9	10	
12	12	
14	14	
15	14	
16	14	
17	14	
19	16	

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REBOUND LIMITER EXPLODED VIEW



AIR SPRING NOT SHOWN FOR CLARITY.