

# **H** TECHNICAL PROCEDURE

## ULTIMAAX® Rear Suspension for Kenworth Vehicles

**SUBJECT:** Service Instructions

**LIT NO:** 17730-301

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### TABLE OF CONTENTS

<b>Section 1</b>	<b>Introduction</b> . . . . .	2	<b>Section 7</b>	<b>Alignment &amp; Adjustments</b>	
<b>Section 2</b>	<b>Product Description</b> . . . . .	2		Drive Axle Pinion Angle . . . . .	29
<b>Section 3</b>	<b>Important Safety Notice</b> . . . . .	4		Drive Axle Alignment . . . . .	29
<b>Section 4</b>	<b>Parts List</b> . . . . .	8		Axle Lateral Alignment . . . . .	31
<b>Section 5</b>	<b>Special Tools</b> . . . . .	12		Bar Pin Alignment . . . . .	31
<b>Section 6</b>	<b>Preventive Maintenance</b>		<b>Section 8</b>	<b>Component Replacement</b>	
	Hendrickson Recommended			Fasteners . . . . .	34
	Inspection Intervals . . . . .	14		Shock Absorber – ULTIMAAX 46K•52K . . . . .	34
	Component Inspection . . . . .	14		Shear Spring / Frame Hanger Assembly /	
	Center Bushing . . . . .	15		Saddle Assembly . . . . .	35
	Equalizing Beam End Connection . . . . .	16		Progressive Load Spring (PLS) . . . . .	40
	Bar Pin Style End Bushings –			Equalizing Beam . . . . .	41
	ULTIMAAX 46K•52K . . . . .	20		Equalizing Beam Center Bushing . . . . .	44
	Bar Pin Shims – ULTIMAAX 46K•52K . . . . .	20		Bar Pin Style End Bushings –	
	Beam End Axle Brackets . . . . .	20		ULTIMAAX 46K•52K . . . . .	47
	Frame Hanger Assembly . . . . .	21		Adapter Style End Bushing –	
	Shear Springs . . . . .	22		ULTIMAAX 60K•70K . . . . .	49
	Progressive Load Springs (PLS) . . . . .	23		Cross Tube . . . . .	52
	Saddle Connection . . . . .	24		Torque Rods . . . . .	54
	Cross Tube . . . . .	25		XTRB Torque Rod Bushings . . . . .	56
	Torque Rods . . . . .	26	<b>Section 9</b>	<b>Torque Specifications</b> . . . . .	58
	Shock Absorbers (if equipped) . . . . .	26	<b>Section 10</b>	<b>Troubleshooting Guide</b> . . . . .	62

## SECTION 1

# Introduction

This publication is intended to acquaint and assist maintenance personnel in the preventive maintenance, service, and repair of the ULTIMAAX® Rear Rubber Suspension System for applicable Kenworth Vehicles.

### NOTE

Use only Hendrickson Genuine parts for servicing this suspension system.

It is important to read and understand the entire Technical Procedure publication prior to performing any maintenance, service, or repair of this product. The information in this publication contains parts lists, safety information, product specifications, features, proper maintenance, service, and repair instructions for ULTIMAAX suspensions.

Hendrickson reserves the right to make changes and improvements to its products and publications at any time. Contact Hendrickson Tech Services for information on the latest version of this manual at 1-866-755-5968 (toll-free U.S. and Canada), 1-630-910-2800 (outside U.S. and Canada) or e-mail: techservices@hendrickson-intl.com.

**The latest revision of this publication is available online at [www.hendrickson-intl.com](http://www.hendrickson-intl.com).**

## SECTION 2

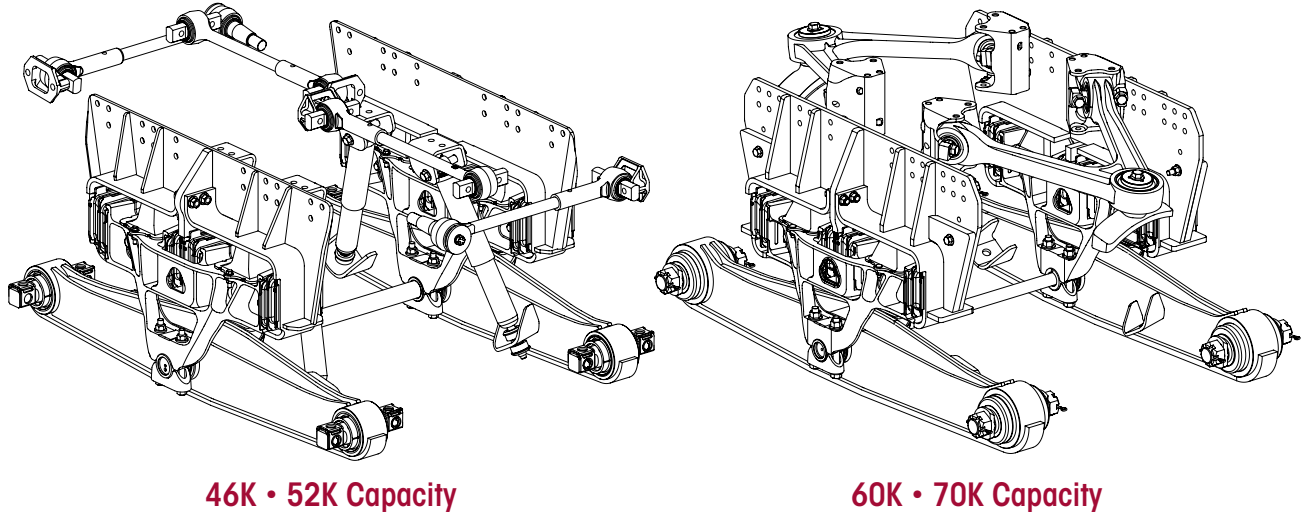
# Product Description

**ULTIMAAX** is an advanced severe-duty rear rubber suspension designed to balance outstanding durability, empty ride quality, loaded stability and mobility. Through its unique design, the system offers premium ride quality in both empty and loaded conditions, with increasing stability as the load increases. The ULTIMAAX system is capable of extremely high articulation for demanding job-site or off-highway conditions. When loaded, it delivers up to 17.5" of diagonal wheel articulation.

- **Equalizing beam** — Formed and robotically welded to provide a narrow profile for weight savings. Distributes load equally between axles to improve maneuverability, stability and handling. Increases ground clearance with flat bottom design. Lowers the center of gravity to increase stability.
- **Frame hangers** — Optimized design to balance durability and weight savings. Fabricated to offer flexibility with multiple truck configurations.
- **Premium rubber bushings** — Require no lubrication. Extend service life and reduce re-bush time with rugged bar pin axle connection. Improve articulation with high performance patent pending design.
- **Progressive load springs** — Designed to balance empty ride quality and loaded stability. Stiffness of progressive load spring increases as load increases, providing a unique balance of empty ride quality and loaded stability.
- **Rubber shear springs** — Primary springs in unloaded condition, providing superb ride quality. React to longitudinal loads during braking and accelerating for minimal displacement.
- **Saddle** — Triangular geometry provides structure and durability. Weight efficient design helps to increase payload, while offering a considerable weight savings versus competitive suspensions.
- **Torque rods** — **Longitudinal torque rods** are engineered to optimize resistance to axle wind-up during acceleration and braking. **Transverse torque rods** ensure maximum lateral axle control and straight line suspension stability. **V-rods** are engineered to evenly distribute higher capacity longitudinal and lateral loads into the chassis connections.



FIGURE 2-1



ULTIMAAX® SPECIFICATIONS

	46K	52K	60K	70K
<b>Suspension Rating</b>	46,000 lbs.	52,000 lbs.	60,000 lbs.	70,000 lbs.
<b>Suspension Weight<sup>1</sup></b>	1,179 lbs.	1,198 lbs.	1,407 lbs.	1,750 lbs.
<b>GVW Approval</b>	Contact Vehicle Manufacturer		Contact Vehicle Manufacturer	
<b>GCW Approval</b>	Contact Vehicle Manufacturer		Contact Vehicle Manufacturer	
<b>Site Travel Rating<sup>2</sup></b>	70,000 lbs.	75,000 lbs.	80,000 lbs.	90,000 lbs.
<b>Diagonal Articulation<sup>3</sup></b>	17.5 in.		17.5"	
<b>Lift Axles</b>	Approved		Approved	
<b>Ride Heights</b>	9.5 – 13 in.		9.5 – 13 in.	
<b>Axle Spacing<sup>4</sup></b>	52, 54, 56, 60 in.		56, 60 in.	

Hendrickson approves the use of ULTIMAAX in the following vocational truck applications: dump, concrete mixer, refuse, logging, crane / boom, platform and fire / rescue. All such applications must comply with applicable Hendrickson specifications and must also be approved by the respective vehicle manufacturer with the vehicle in its original, as-built configuration. Contact Hendrickson and the respective vehicle manufacturer for approval of additional applications.

1. Installed weight includes full suspensions with torque rods and without shocks.
2. Site travel rating – operators using vehicles equipped with liftable pusher or tag axles must not exceed published ratings. Ratings are limited to no more than five percent of vehicle operation at speed not to exceed five mph. Liftable pusher or tag axles should only be raised (or unloaded) to improve vehicle maneuverability in off-road use or when vehicle is empty. Site travel ratings are consistent with published axle manufacturer’s limitations. Axle and suspension site travel specifications must not be exceeded.
3. Suspension articulation may exceed vehicle’s capability and may be limited by vehicle manufacturer; vehicle manufacturer installed axle stops may restrict suspension’s articulation.
4. Contact Hendrickson for availability of additional beam lengths.

Actual product performance may vary depending upon vehicle configuration, operation, service and other factors.

U.S. and foreign patents granted and / or pending.

## SECTION 3

# Important Safety Notice

Proper maintenance, service and repair are important to the reliable operation of the suspension. The procedures recommended by Hendrickson and described in this technical publication are methods of performing such maintenance, service and repair.

This technical publication should be read carefully to help prevent personal injury and to assure that proper methods are used. Improper maintenance, service or repair may damage the vehicle, cause personal injury, render the vehicle unsafe in operation, or void the manufacturer's warranty.

Failure to follow the safety precautions in this manual can result in personal injury and/or property damage. Carefully read and understand all safety related information within this publication, on all decals and in all such materials provided by the vehicle manufacturer before conducting any maintenance, service or repair.

## ■ EXPLANATION OF SIGNAL WORDS

Hazard "Signal Words" (Danger • Warning • Caution) appear in various locations throughout this publication. Information accented by one of these signal words must be observed to help minimize the risk of personal injury to service personnel, or possibility of improper service methods which may damage the vehicle or render it unsafe.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

Additional Notes or Service Hints are utilized to emphasize areas of procedural importance and provide suggestions for ease of repair. The following definitions indicate the use of these signal words as they appear throughout the publication.

** DANGER**

INDICATES AN IMMINENTLY HAZARDOUS SITUATION, WHICH IF NOT AVOIDED, WILL RESULT IN SERIOUS INJURY OR DEATH.

** WARNING**

INDICATES A POTENTIAL HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, CAN RESULT IN SERIOUS INJURY OR DEATH.

** CAUTION**

INDICATES A POTENTIAL HAZARDOUS SITUATION WHICH, IF NOT AVOIDED, MAY RESULT IN MINOR OR MODERATE INJURY.

**NOTE**

An operating procedure, practice condition, etc. which is essential to emphasize.

**SERVICE HINT**

A helpful suggestion that will make the service being performed a little easier and/or faster.

Also note that particular service operations may require the use of special tools designed for specific purposes. These special tools can be found in the "Special Tools" Section of this publication.



The torque symbol alerts you to tighten the fasteners to a specific torque value. See Torque Specifications Section of this publication.



## ■ SAFETY PRECAUTIONS

### WARNING

#### FASTENERS

DISCARD USED FASTENERS. ALWAYS USE NEW FASTENERS TO COMPLETE A REPAIR. FAILURE TO DO SO COULD RESULT IN FAILURE OF THE PART, OR MATING COMPONENTS, ADVERSE VEHICLE HANDLING, PERSONAL INJURY, OR PROPERTY DAMAGE.

LOOSE OR OVER TORQUED FASTENERS CAN CAUSE COMPONENT DAMAGE, ADVERSE VEHICLE HANDLING, PROPERTY DAMAGE, OR SEVERE PERSONAL INJURY. MAINTAIN CORRECT TORQUE VALUE AT ALL TIMES. CHECK TORQUE VALUES ON A REGULAR BASIS AS SPECIFIED, USING A REGULARLY CALIBRATED TORQUE WRENCH. TORQUE VALUES SPECIFIED IN THIS TECHNICAL PUBLICATION ARE FOR HENDRICKSON SUPPLIED FASTENERS ONLY. IF NON-HENDRICKSON FASTENERS ARE USED, FOLLOW TORQUE SPECIFICATION LISTED IN THE VEHICLE MANUFACTURER'S SERVICE MANUAL.

### WARNING

#### TORCH/WELDING

DO NOT USE A CUTTING TORCH TO REMOVE ANY FASTENERS OR BUSHINGS. THE USE OF HEAT ON SUSPENSION COMPONENTS WILL ADVERSELY AFFECT THE STRENGTH OF THESE PARTS. A COMPONENT DAMAGED IN THIS MANNER CAN RESULT IN THE ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE.

EXERCISE EXTREME CARE WHEN HANDLING OR PERFORMING MAINTENANCE IN THE AREA OF THE EQUALIZING BEAM. DO NOT CONNECT ARC WELDING GROUND LINE TO THE EQUALIZING BEAM. DO NOT STRIKE AN ARC WITH THE ELECTRODE ON THE EQUALIZING BEAM AND AXLE. DO NOT USE HEAT NEAR THE EQUALIZING BEAM ASSEMBLY. DO NOT NICK OR GOUGE THE EQUALIZING BEAM. SUCH IMPROPER ACTIONS CAN DAMAGE THE EQUALIZING BEAM ASSEMBLY AND CAUSE ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE.

### WARNING

#### LOAD CAPACITY

ADHERE TO THE PUBLISHED CAPACITY RATINGS FOR THE SUSPENSION. ADD-ON AXLE ATTACHMENTS AND OTHER LOAD TRANSFERRING DEVICES CAN INCREASE THE SUSPENSION LOAD ABOVE ITS RATED AND APPROVED CAPACITIES, WHICH CAN RESULT IN COMPONENT DAMAGE AND ADVERSE VEHICLE HANDLING, POSSIBLY CAUSING PERSONAL INJURY OR PROPERTY DAMAGE.

### WARNING

#### MODIFYING COMPONENTS

DO NOT MODIFY OR REWORK PARTS WITHOUT AUTHORIZATION FROM HENDRICKSON. DO NOT USE SUBSTITUTE OR REPLACEMENT COMPONENTS NOT AUTHORIZED BY HENDRICKSON. USE OF MODIFIED, REWORKED, SUBSTITUTE OR REPLACEMENT PARTS NOT AUTHORIZED BY HENDRICKSON MAY NOT MEET HENDRICKSON'S SPECIFICATIONS, AND CAN RESULT IN FAILURE OF THE PART, ADVERSE VEHICLE HANDLING, AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE AND WILL VOID WARRANTY. USE ONLY HENDRICKSON AUTHORIZED REPLACEMENT PARTS.

### WARNING

#### PERSONAL PROTECTIVE EQUIPMENT

ALWAYS WEAR PROPER EYE PROTECTION AND OTHER REQUIRED PERSONAL PROTECTIVE EQUIPMENT TO HELP PREVENT PERSONAL INJURY WHEN PERFORMING VEHICLE MAINTENANCE, REPAIR OR SERVICE.

### CAUTION

#### PROCEDURES AND TOOLS

A TECHNICIAN USING A SERVICE PROCEDURE OR TOOL WHICH HAS NOT BEEN RECOMMENDED BY HENDRICKSON MUST FIRST SATISFY HIMSELF THAT NEITHER HIS SAFETY NOR THE VEHICLE'S SAFETY WILL BE JEOPARDIZED BY THE METHOD OR TOOL SELECTED. INDIVIDUALS DEVIATING IN ANY MANNER FROM THE INSTRUCTIONS PROVIDED WILL ASSUME ALL RISKS OF CONSEQUENTIAL PERSONAL INJURY OR DAMAGE TO EQUIPMENT INVOLVED.

**WARNING**

**SUPPORT THE VEHICLE PRIOR TO SERVICING**

PLACE THE VEHICLE ON A LEVEL FLOOR AND CHOCK THE WHEELS TO PREVENT THE VEHICLE FROM MOVING OR ROLLING. DO NOT WORK AROUND OR UNDER A RAISED VEHICLE SUPPORTED BY ONLY A FLOOR JACK OR OTHER LIFTING DEVICE. ALWAYS SUPPORT A RAISED VEHICLE WITH RIGID SAFETY STANDS. FAILURE TO DO SO CAN CAUSE SERIOUS PERSONAL INJURY OR DAMAGE TO EQUIPMENT.

**WARNING**

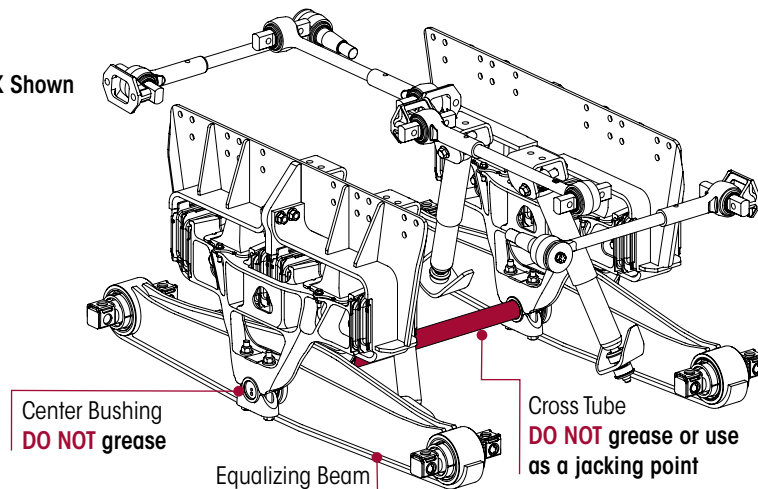
**IMPROPER JACKING METHOD**

IMPROPER JACKING METHODS CAN CAUSE STRUCTURAL DAMAGE WHICH CAN CAUSE ADVERSE VEHICLE HANDLING, PROPERTY DAMAGE OR SEVERE PERSONAL INJURY AND WILL VOID HENDRICKSON'S WARRANTY.

- DO NOT USE THE SUSPENSION CROSS TUBE AS A JACKING POINT, SEE FIGURE 3-1, REFER TO VEHICLE MANUFACTURER FOR PROPER JACKING INSTRUCTIONS.
- ACCEPTABLE LIFTING POINTS FOR A VEHICLE AT THE RATED LOAD INCLUDE BUT ARE NOT LIMITED TO: THE AXLE, EQUALIZING BEAM, AND THE VEHICLE FRAME RAIL. REFER TO THE VEHICLE MANUFACTURER FOR PROPER JACKING INSTRUCTIONS.

**FIGURE 3-1**

ULTIMAAX 52K Shown

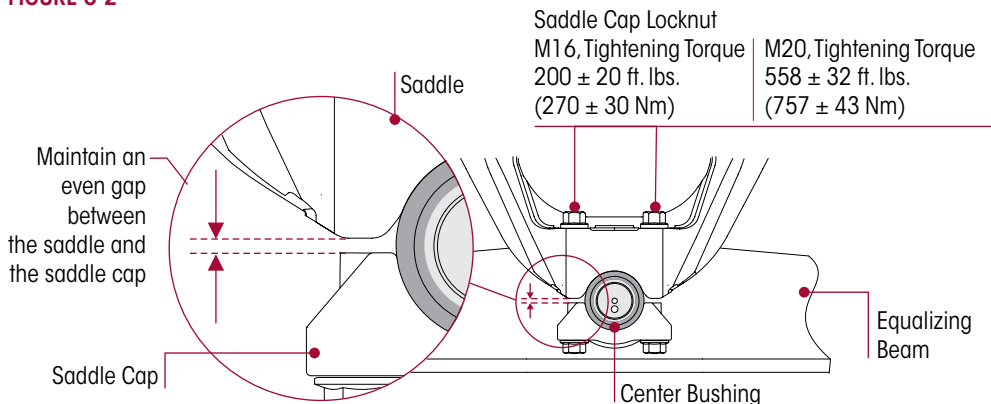


**CAUTION**

**SADDLE CONNECTION**

A SADDLE ASSEMBLY IS ATTACHED TO THE CENTER BUSHING OF EACH EQUALIZING BEAM WITH TWO (2) SADDLE CAPS. EACH SADDLE CAP USES TWO (2) BOLTS TO CLAMP THE CENTER BUSHING INNER METAL TO THE SADDLE. EACH SADDLE CAP MUST BE INSTALLED SO THAT THERE IS AN EVEN GAP BETWEEN THE SADDLE CAP AND THE BASE OF THE SADDLE LEGS AS SHOWN IN FIGURE 3-2. IF EACH SADDLE CAP IS NOT INSTALLED EVENLY, THE SADDLE LEGS COULD BECOME DEFORMED, RESULTING IN BENT BOLTS OR DAMAGED SADDLES.

**FIGURE 3-2**





 **WARNING**

**TORQUE ROD ASSEMBLY**

THE ULTIMAAX SUSPENSION INCORPORATES LONGITUDINAL, TRANSVERSE TORQUE RODS AND V-RODS FOR VEHICLE STABILITY. IF THESE COMPONENTS ARE DISCONNECTED OR ARE NON-FUNCTIONAL THE VEHICLE SHOULD NOT BE OPERATED. FAILURE TO DO SO CAN RESULT IN ADVERSE VEHICLE HANDLING AND POSSIBLE TIRE CONTACT WITH THE FRAME OR THE SUSPENSION.

 **WARNING**

**PARTS CLEANING**

SOLVENT CLEANERS CAN BE FLAMMABLE, POISONOUS, AND CAUSE BURNS. TO HELP AVOID SERIOUS PERSONAL INJURY, CAREFULLY FOLLOW THE MANUFACTURER'S PRODUCT INSTRUCTIONS AND GUIDELINES AND THE FOLLOWING PROCEDURES:

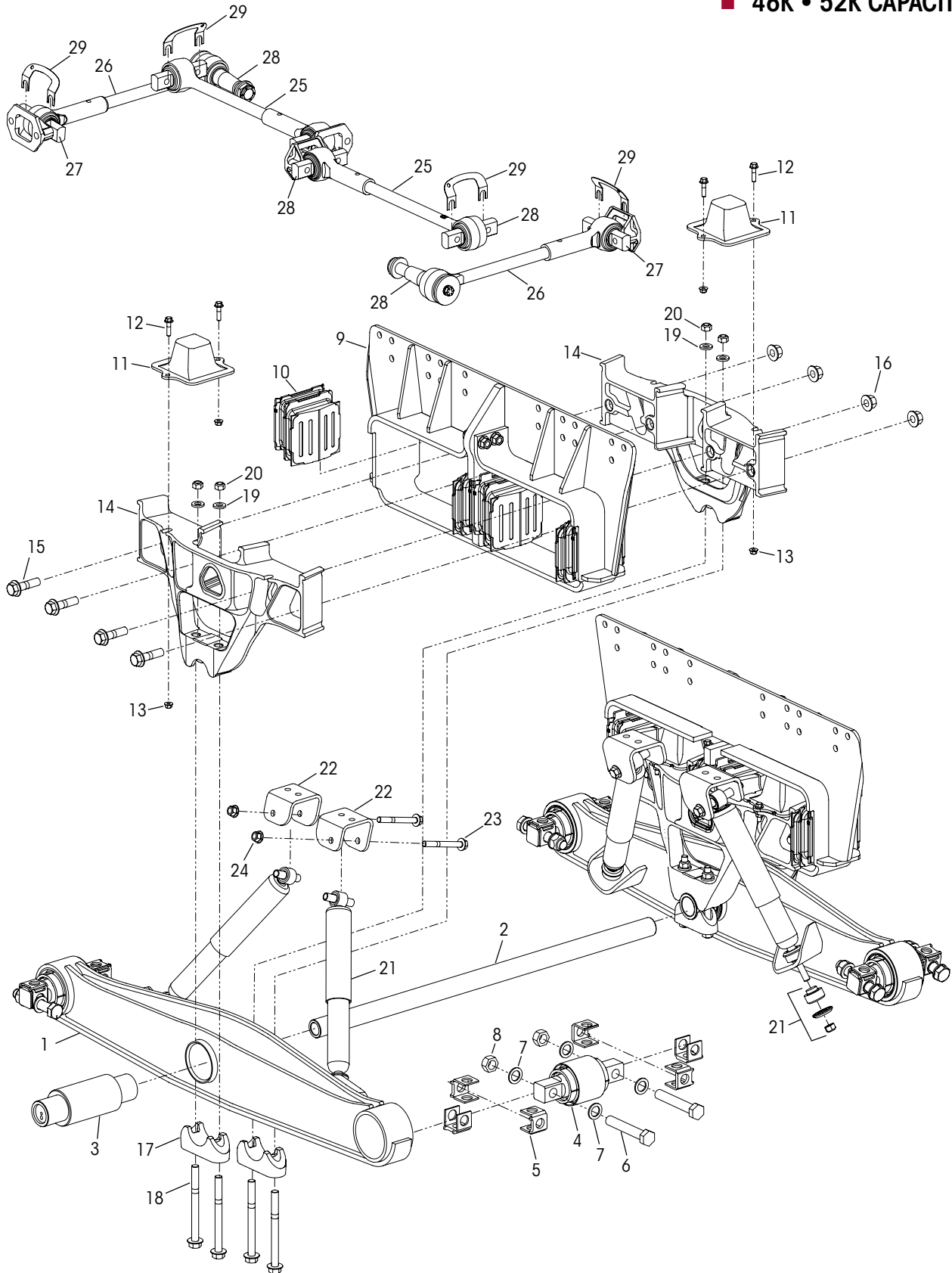
1. WEAR PROPER EYE PROTECTION.
2. WEAR CLOTHING THAT PROTECTS YOUR SKIN.
3. WORK IN A WELL-VENTILATED AREA.
4. DO NOT USE GASOLINE OR SOLVENTS THAT CONTAIN GASOLINE. GASOLINE CAN EXPLODE.
5. HOT SOLUTION TANKS OR ALKALINE SOLUTIONS MUST BE USED CORRECTLY. FOLLOW THE MANUFACTURER'S RECOMMENDED INSTRUCTIONS AND GUIDELINES CAREFULLY TO HELP PREVENT PERSONAL ACCIDENT OR INJURY.

DO NOT USE HOT SOLUTION TANKS OR WATER AND ALKALINE SOLUTIONS TO CLEAN GROUND OR POLISHED PARTS. DOING SO WILL CAUSE DAMAGE TO THE PARTS AND VOID WARRANTY.



# SECTION 4 Parts List

■ 46K • 52K CAPACITY







KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.	KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
1		Equalizing Beam Assembly with Shock Bracket Includes Key Nos. 3-5a	2		60961-751	<b>Progressive Load Spring Service Kit, One Side</b> Includes Key Nos. 11-13	
	78489-540	54" Beam Length		11		*Progressive Load Spring	4
	78489-560	56" Beam Length			34013-196	<b>Progressive Load Spring Fasteners Service Kit, One Side</b> , Includes Key Nos. 12-13	
	60961-759	<b>Cross Tube Service Kit</b> , Includes Key No. 2 and Weldable Loose Plug (Not Shown)		12		*M10 x 1.5 x 40 mm 6G Flange Bolt	8
2	44642-008	Cross Tube - 1140 mm	1	13		*M10 x 1.5 Flange Lock Nut	8
	60961-755	<b>Equalizing Beam Bushings Service Kit, One Beam</b> , Includes Key No. 3-4, 6-8, 18-20		14	70886-000	Saddle Assembly	4
3	69538-000L	Center Bushing	2		34013-197	<b>Saddle Only Fasteners Service Kit, One Side</b> , Includes Key Nos. 15-16	
	60961-752	<b>End Bushing Service Kit, One Wheel End</b> , Includes Key Nos. 4-8		15		*M20 x 1.5 x 75 mm Flange Bolt	8
4		*Bar Pin End Bushing Assembly, Includes Key No. 5a		16		*M20 x 1.5 Flange Nut	8
5		Bar Pin Shim	8	17	77205-001	Saddle Cap, <i>Replaces 77374-001</i>	4
a	50130-000	0.19" / 0.19" Standard			60961-768	<b>Saddle Cap Fasteners Service Kit, One Side</b> , Includes Key Nos. 18-20	
b	50131-000	0.25" / 0.12" Optional		18		*M16 x 2 x 6G x 180 mm Flange Bolt	8
c	57026-000	0.375" Optional flat shim		19		*M16 Flat Washer	8
		<b>End Bushing Fasteners Service Kit</b> , Includes Key Nos. 6-8		20		*M16 x 2 x 6H Nut	8
	56659-001	Tandem		21	60680-015L	Shock Absorber	4
	56659-005	One Beam		22	78630-001	Upper Shock Bracket <i>Replaces 78630-002 (If equipped)</i>	2
	34013-104	One Wheel End			60961-818	<b>Upper Shock Fasteners Service Kit, One Beam</b> , Includes Key Nos. 23-24	
6		*1"-8 UNC x 6" Bolt	8	23		*M16 x 2 x 140 mm Flange Bolt	4
7		*1" Hardened Washer	16	24		*M16 x 2 Flange Nut	4
8		*1"-8 UNC Locknut	8	25		ULTRA ROD® PLUS™ Longitudinal Torque Rod, Straddle/Straddle Includes Key No. 27	2
9		Frame Hanger, 34" Width, 11" Ride Height	2		92000-610S	Front	
	70912-204	7" Axle Hanger Drop			92000-660S	Rear	
	70912-205	7¾" Axle Hanger Drop		26	92350-605S	**ULTRA ROD PLUS Transverse Torque Rod Straddle/Taper Includes Key Nos. 27-28	2
	60961-749	<b>Shear and Progressive Load Spring Service Kit, One Side</b> , Includes Key Nos. 10-13, 15-16, 18-20, 30		27	66649-002L	XTRB Straddle Bushing	6
	60961-750	<b>Shear Spring Service Kit, One Side</b> Includes Key Nos. 10, 15-16, 18-20, 30		28	66649-004L	XTRB Taper Bushing	2
10		*Shear Spring	8	29	49689-000L	Torque Rod Shim	As Req.
				30	70867-001	P-80 Lubricant - 10 ml (Not Shown)	As Req.

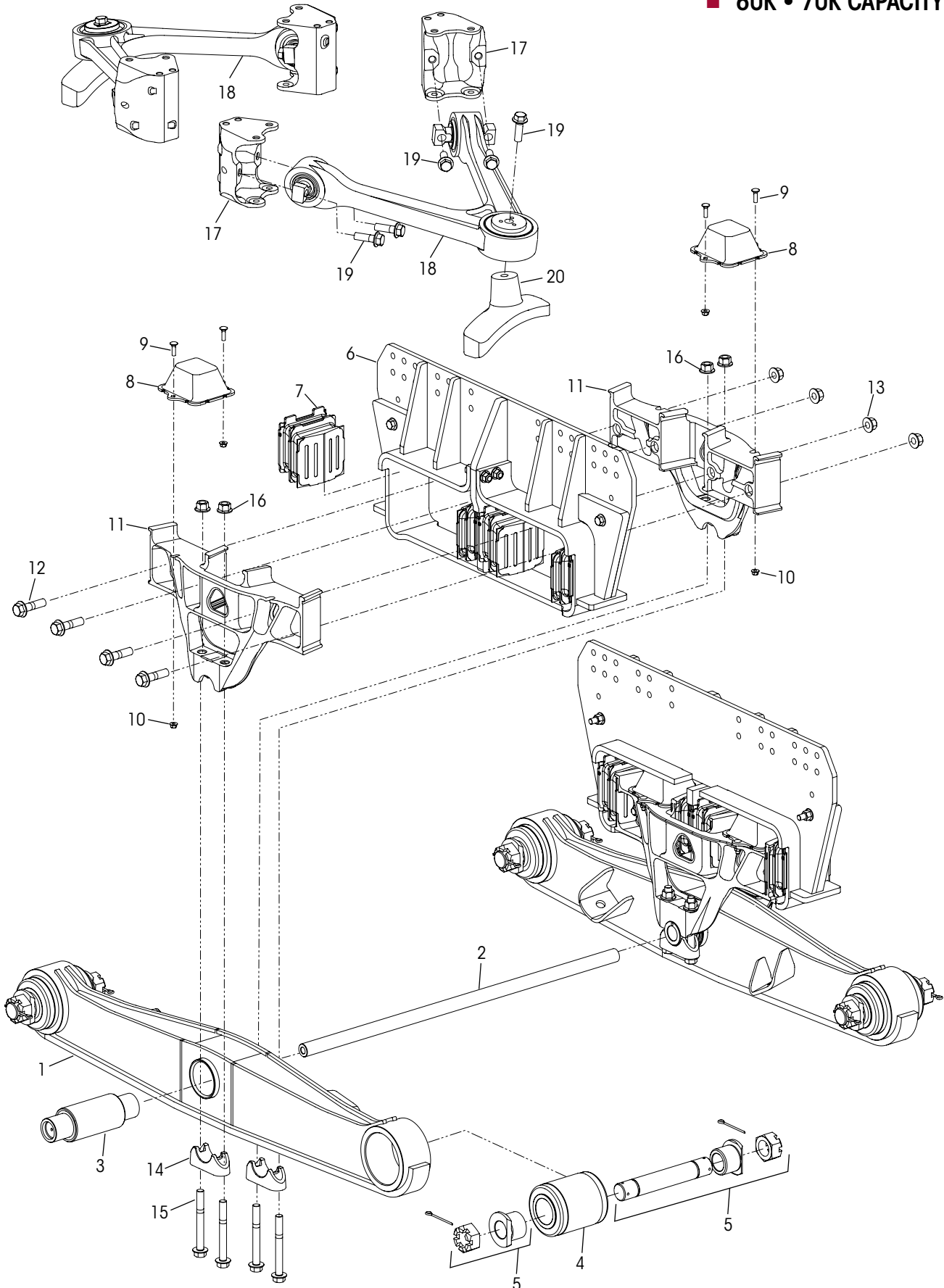
**NOTES:** \* Item included in kit/assembly only, part not sold separately.

\*\* Transverse torque rods are mandatory for the ULTIMAAX 46K and 52K rear suspension regardless of axle spacing.

**Hendrickson Lit. No. 48422-592** – ULTIMAAX Gauge Card can be used to measure in unloaded condition (1) the height of the progressive load spring (PLS) and (2) the length of cut/split of the shear spring and PLS. Gauge card can be obtained on-line at [www.hendrickson-intl.com/Litform](http://www.hendrickson-intl.com/Litform)



■ 60K • 70K CAPACITY





KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.	KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
1		Equalizing Beam Assembly, Includes Key Nos. 3-4	2	6		Frame Hanger	2
	78634-560	60K, 56" Beam Length			80821-003	60K, 6" Bushing	
	78634-600	60K, 60" Beam Length			80821-002	70K, 6" Bushing	
	80192-560	70K, 56" Beam Length, 6" Bushing			80821-001	70K, 7" Bushing	
	80291-560	70K, 56" Beam Length, 7" Bushing			60961-876	<b>Shear and Progressive Load Spring Service Kit, One Side</b> , Includes Key Nos. 7-8, 9-10, 12-13, 15-16, 21	
	80192-600	70K, 60" Beam Length, 6" Bushing			60961-877	<b>Shear Spring Service Kit, One Side</b> Includes Key Nos. 7, 12-13, 15-16, 21	
	80291-600	70K, 60" Beam Length, 7" Bushing			7	*Shear Spring	8
		<b>Cross Tube Service Kit</b> , Includes Weldable Loose End Plug (Not Shown)			60961-822	<b>Progressive Load Spring Service Kit, One Side</b> Includes Key Nos. 8-10	
	60961-759	60K, Includes Key No. 2a			8	*Progressive Load Spring	4
	60961-875	70K, Includes Key No. 2b & Circlip (Not Shown)			60961-812	<b>Progressive Load Spring Fasteners Service Kit, One Side</b> , Includes Key Nos. 9-10	
2		Cross Tube, 1140 mm	1		9	*M10 x 1.5 x 35 mm 6G Flange Bolt	8
a	44642-008	60K			10	*M10 x 1.5 Flange Locknut	8
b	78962-001	70K			11	80964-001 Saddle Assembly	4
		<b>Equalizing Beam Bushings Service Kit, One Beam</b>			34013-197	<b>Saddle Only Fasteners Service Kit, One Side</b> , Includes Key Nos. 12-13	
	34013-290	60K, 6" Bushing, Includes Key No. 3a-5a, 15-16			12	*M20 x 1.5 x 75 mm Flange Bolt	8
	34013-291	70K, 6" Bushing, Includes Key No. 3b, 4a-5a, 15-16			13	*M20 x 1.5 Flange Nut	8
	34013-292	70K, 7" Bushing, Includes Key No. 3b-5b, 15-16			14	80965-001 Saddle Cap	4
3		Center Bushing Assembly, includes End Plug	2		60961-879	<b>Saddle Cap Fasteners Service Kit, One Side</b> , Includes Key Nos. 15-16	
a	69538-000L	60K			15	*M20 x 1.5 x 175 mm Flange Bolt	8
b	80539-001	70K, includes Circlip (Not Shown)			16	*M20 x 1.5 Flange Locknut	8
		<b>End Bushing and Adapter Service Kits,</b>			17	78561-001 Corner Bracket	4
		• <b>Tandem</b>			18	76847-000 **V-rod Assembly	2
	60872-010	60K-70K, 6" Bushing, Includes Key No. 4a-5a			19	68754-065 M20 x 2.5 x 65 mm Flange Bolt	10
	60872-011	70K, 7" Bushing, Includes Key No. 4b-5b			20	Axle Apex Bracket, <i>see Table below</i>	2
		• <b>One Wheel End</b>			21	70867-001 P-80 Lubricant - 10 ml (Not Shown)	As Req.
	34013-052	60K-70K, 6" Bushing, Includes Key No. 4a-5a					
	34013-110	70K, 7" Bushing, Includes Key No. 4b-5b					
4		End Bushing	4				
a	10363-000L	60K-70K, 6" Bushing					
b	10364-000L	70K, 7" Bushing					
5		End Bushing Adapter Assembly	4				
a	21140-007	60K-70K, 6" Bushing					
b	21140-004L	70K, 7" Bushing					

**NOTES:** \* Item included in kit/assembly only, part not sold separately.

\*\* V-rods are mandatory for the ULTIMAAX 60K and 70K rear suspension regardless of axle spacing.

**Hendrickson Lit. No. 48422-598** – ULTIMAAX Gauge Card can be used to measure in unloaded condition (1) the height of the progressive load spring (PLS) and (2) the length of cut/split of the shear spring and PLS. Gauge card can be obtained on-line at [www.hendrickson-intl.com/Litform](http://www.hendrickson-intl.com/Litform)

KEY NO. 20		AXLE APEX BRACKET									
80784-XXX – RT70 Axle			80786-XXX – D70 Axle			80913-XXX – RT58 Axle			91005-XXX – D60 Axle		
Pinion Angle	Front Drive	Rear Drive	Pinion Angle	Front Drive	Rear Drive	Pinion Angle	Front Drive	Rear Drive	Pinion Angle	Front Drive	Rear Drive
0	80784-005	80784-105	0	80786-005	80786-105	0	80913-005	80913-105	0	91005-005	91005-105
1	80784-001	80784-101	1	80786-001	80786-101	1	80913-001	80913-101	1	91005-001	91005-101
2	80784-002	80784-102	2	80786-002	80786-102	2	80913-002	80913-102	2	91005-002	91005-102
2.5	80784-025	80784-125	2.5	80786-025	80786-125	2.5	80913-025	80913-125	2.5	91005-025	91005-125
3	80784-003	80784-103	3	80786-003	80786-103	3	80913-003	80913-103	3	91005-003	91005-103
4	80784-004	80784-104	4	80786-004	80786-104	4	80913-004	80913-104	4	91005-004	91005-104
								80913-106	11		91005-106
								80913-107	10.25		91005-107
								80913-108	9.5		91005-108
								80913-109	9		91005-109
								80913-110	8.75		91005-110
								80913-111	7.75		91005-111

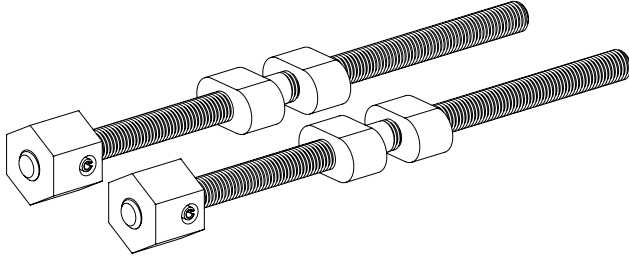


## SECTION 5 Special Tools

### SADDLE ASSEMBLY TOOLS

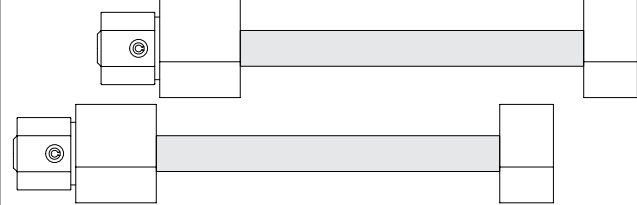
#### DISASSEMBLY TOOL

Hendrickson Part No. 66086-113L



#### ASSEMBLY TOOL

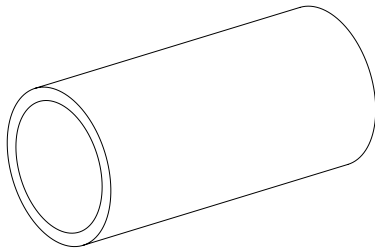
Hendrickson Part No. 66086-108L



### CENTER BUSHING TOOLS

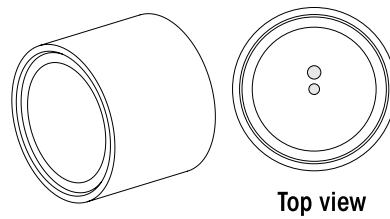
#### RECEIVING TOOL

Hendrickson Part No. 66086-112



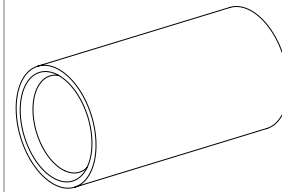
#### INSTALLATION TOOL

Hendrickson Part No. 66086-107



#### REMOVAL TOOL

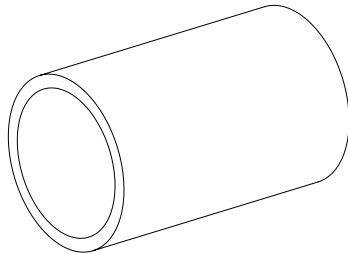
Hendrickson Part No. 66086-110



### BAR PIN STYLE END BUSHING TOOLS – 46K • 52K

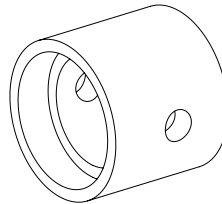
#### RECEIVING TOOL

Hendrickson Part No. 66086-111



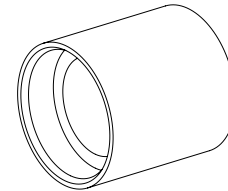
#### INSTALLATION TOOL

Hendrickson Part No. 66086-106



#### REMOVAL TOOL

Hendrickson Part No. 66086-109



### ADAPTER STYLE END BUSHING TOOLS – 60K • 70K

End Bushing  
Removal / Replacement Adapter  
OTC Part Number 208350



Clamp  
OTC Part Number 208349



Center Bushing  
Removal / Replacement Adapter  
OTC Part Number 28541  
Not Needed for this publication



**Hendrickson Part No. 66086-101**

**OTC Part No. 1763**

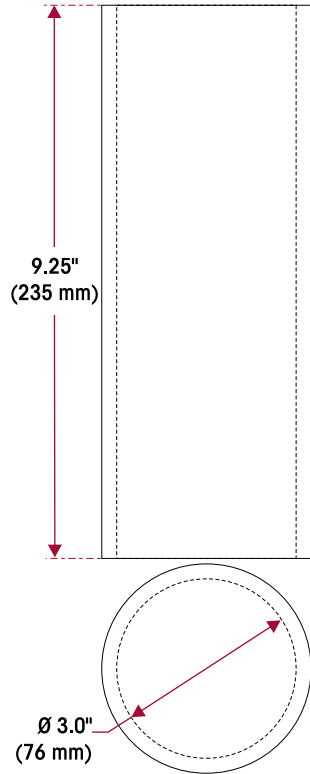
Visit [otctools.com](http://otctools.com)



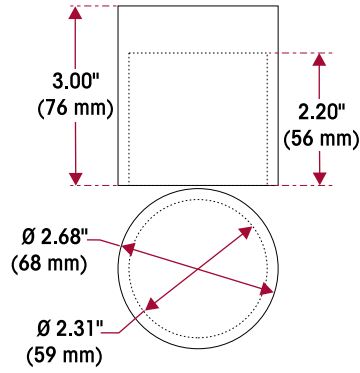
### TORQUE ROD BUSHING TOOLS

These shop made tools are made from cold rolled steel or equivalent. The drawings are for reference only, Hendrickson does not supply these tools.

#### RECEIVING TOOL



#### INSTALLATION / REMOVAL TOOL





## SECTION 6 Preventive Maintenance

Following appropriate inspection procedures is important to help ensure the proper maintenance and operation of the suspension system and component parts. Hendrickson recommends the ULTIMAAX severe-duty rear suspension be inspected at pre-delivery, the first in-service inspection and regular preventive maintenance intervals. Off-highway and severe service operating conditions may require more frequent inspections than on-highway service operation. Inspection must include the following items and other components referenced in this section.

**NOTE** Torque values shown in this publication apply only if Hendrickson supplied fasteners are used. If non-Hendrickson fasteners are used, follow the torque specification listed in the vehicle manufacturer’s service manual.

HENDRICKSON RECOMMENDED INSPECTION INTERVALS	PRE-DELIVERY INSPECTION	FIRST IN-SERVICE INSPECTION	PREVENTIVE MAINTENANCE
Inspect progressive load spring (PLS)	<b>Within the first 500 miles (500 km)</b>	<b>Within the first 1,500 miles (2,500 km) or 100 Hours</b>	<b>Every 3 Months / 600 Hours</b>
Visually Inspect proper assembly and function. Check for all of the following and replace components as necessary: <ul style="list-style-type: none"> <li>• Signs of unusual movement, loose or missing components</li> <li>• Signs of abrasive or adverse contact with other components (example: brake lines, wheel wells, frame hangers, etc.)</li> <li>• Damaged, or cracked parts</li> <li>• Proper suspension function, alignment</li> </ul>			<b>Every 6 Months / 1200 Hours or 25,000 miles / 40,000 km</b>
Inspect torque rods (Longitudinal, Transverse and V-rods) and equalizing beam end connections			<b>Every 12 Months / 2400 Hours</b>
Inspect fasteners for proper torque as recommended in the Torque Specification Section of this publication with special attention to the following suspension connections: <ul style="list-style-type: none"> <li>• Equalizing beam end connection</li> <li>• Saddle cap connection</li> <li>• Frame hanger to frame rail connection</li> <li>• Center bushing</li> </ul>			
Verify the alignment of axles are within the vehicle manufacturer’s tolerances.			

### COMPONENT INSPECTION

Following appropriate inspection procedures is important to help ensure the proper maintenance and operation of the ULTIMAAX severe-duty rear suspension system and component parts. Look for and replace worn, damaged, bent or cracked parts.

- **Cross tube** — Clean the cross tube and inspect it for cracks or excessive wear 8" to 10" from each end where it enters into the equalizing beam center bushings. Use a straight edge to check the straightness of the cross tube. If there is a doubt as to fracture, wear or straightness, replacement is necessary.

- **Equalizing beam assembly** — Check the overall condition of the equalizing beam for dents, dings, or other damage. Check the beam end connections for tearing or extreme bulging. Check for any metal-to-metal contact in the bushed joints. Refer to Equalizing Beam End Connection Inspection in this section.
- **Fasteners** — Look for any loose, missing or damaged fasteners on the entire suspension. Make sure all fasteners are tightened to a torque value within the specified torque range. See recommended torque specifications for Hendrickson supplied fasteners in Torque Specification Section of this publication. For fasteners not supplied by Hendrickson, see vehicle manufacturer. Use a calibrated torque wrench to check torque in the tightening direction. As soon as the fastener starts to move, record the torque. Correct the torque as necessary.

**NOTE** Hendrickson recommends the use of Grade 8 bolts, hardened washers, and Grade C locknuts. Hardened washers are not necessary when flange head fasteners are used.

**NOTE** Torque values shown in this publication apply only if Hendrickson supplied fasteners are used. If non-Hendrickson fasteners are used, follow the torque specification listed in the vehicle manufacturer's service manual.

- **Saddle cap fasteners** — Inspect the locknuts for proper torque to prevent wear of the beam center bushing into the saddle. See Torque Specification Section of this publication for recommended torque requirements.
- **Shock absorbers** — Look for any signs of dents or leakage. Misting is not considered a leak. See Shock Absorber Inspection in this section.
- **Torque rods (transverse/longitudinal/V-rods)** — The torque rods must be connected and in good working condition when operating the vehicle.
- **Wear and damage** — Inspect all parts of the suspension for wear and damage. Look for bent or cracked parts.

See vehicle manufacturer's applicable publications for other preventive maintenance requirements.

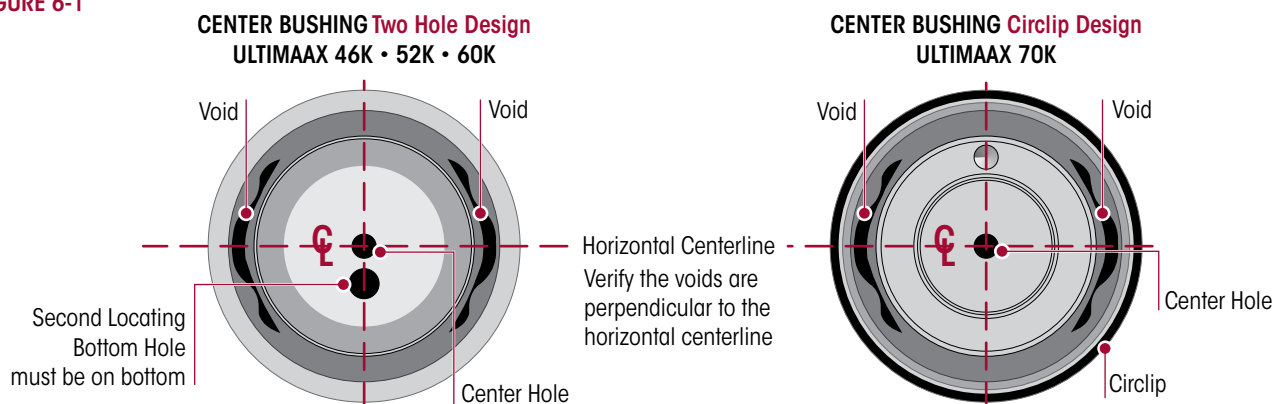
## CENTER BUSHING

### VISUAL INSPECTION

An inspection of the center bushing is necessary **when a vehicle is in the shop for major repair work** and at regular preventive maintenance intervals.

**NOTE** ULTIMAAX center bushing is designed with voids at front and rear, see Figure 6-1. These voids are not an indication of wear.

**FIGURE 6-1**





1. Visually inspect the center bushing for signs of movement or excessive wear such as frayed, bulging or distorted rubber in the center bushing.
2. Replacement is necessary if:
  - Any metal to metal contact is visible.
  - Any signs that the bushing inner metal is not centered in the bushing.
  - Any equalizing beam to saddle contact.

### EQUALIZING BEAM END CONNECTION

An inspection of the beam end connections are necessary **when a vehicle is in the shop for major repair work** and at regular preventive maintenance intervals. Periodic visual inspection by the driver and service personnel is also recommended.

- **Bar Pin Style ULTIMAAX 46K•52K**, see Figure 6-2

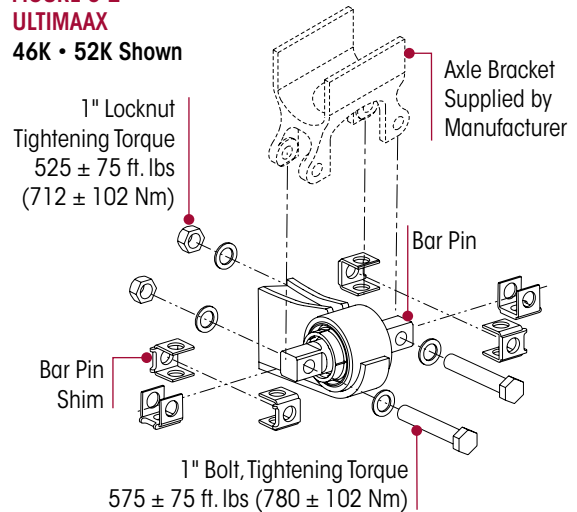
**NOTE**

The equalizing beam end connection requires that the fasteners are tightened to torque specifications, see Figure 6-2, to maintain the clamp load of the axle bracket legs to the bar pin. All bushing motion is accommodated by rubber deflection.

**VISUAL INSPECTION**

1. Chock the wheels.
2. Visually inspect suspension components for signs of movement or excessive wear.
  - Inspect alignment shims in equalizing beam end for looseness. Lightly tap on the alignment shims to see if they can be moved. If movement is detected, tighten fasteners to the proper torque value, see Figure 6-2.
  - Inspect the equalizing beam end connection for signs of excessive wear or looseness.

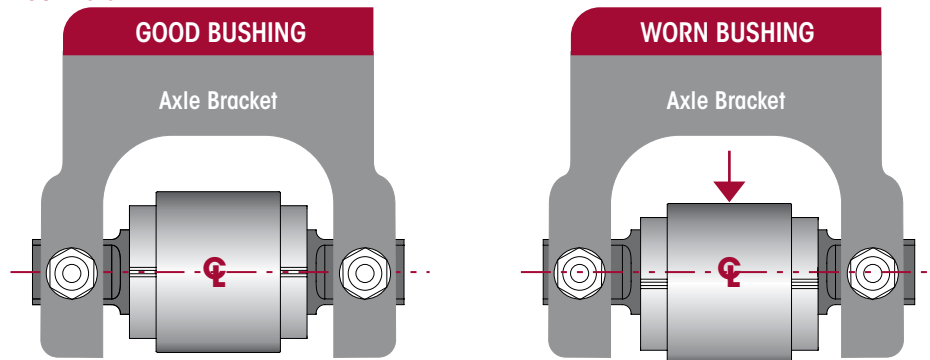
**FIGURE 6-2  
ULTIMAAX  
46K • 52K Shown**



**SERVICE HINT**

An equalizing beam end connection that is visibly cleaner than the other connections may indicate a loose connection.

**FIGURE 6-3**



A **GOOD** bushing will result in the equalizing beam end hub appearing to be **centered** with the centerline of the end bushing in the axle bracket

A **WORN** bushing will result in the equalizing beam end hub appearing to be **5/8" (15 mm) offset/below** the centerline of the end bushing in the axle bracket



- Look for worn, frayed or distorted rubber in the bar pin beam end bushing, see Figure 6-3.
- Look for the equalizing beam to be lower in the beam hanger, see Figure 6-3.
- If the bar pin beam end bushing is visually offset a floor jack test should be performed, refer to Jack Test in this section.

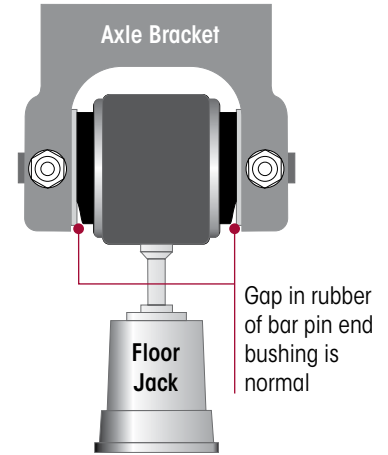
### JACK TEST

1. Place a jack under each beam end as shown. Raise the jack to check for movement in the connection or rubber components, see Figure 6-4.

### NOTE

The gap at each side of the visible rubber on the lower part of the end bushing is normal, see Figure 6-4, and is not an indication to replace the bushing. Because all rubber end bushings are in compression, with the load bearing on the top side, the lower side of the rubber is slightly relieved, allowing the rubber to move inward, and a gap appears.

**FIGURE 6-4**



### PHYSICAL INSPECTION

### WARNING

IF BAR PIN MOVEMENT OR LOOSENESS IS NOTED IN ANY OF THE EQUALIZING BEAM END HUBS, DO NOT OPERATE THE VEHICLE. REPLACE THE RUBBER END BUSHINGS AND ALL CONNECTING PARTS IF NECESSARY. THE ABOVE CONDITION CAN RESULT IN COSTLY REPAIR, DOWNTIME, POSSIBLE SEPARATION OF COMPONENTS, ADVERSE VEHICLE HANDLING, PROPERTY DAMAGE, OR PERSONAL INJURY.

### SERVICE HINT

An equalizing beam end connection that is visibly cleaner than the other connections may indicate a loose connection.

2. If bar pin end bushing movement or looseness is detected in the equalizing beam end hub, replace the end bushings and all connecting parts. Refer to the Component Replacement Section of this publication.
3. Check and record torque values, as received, for each 1" bar pin fastener, see Figure 6-2. Ensure all fasteners are tightened to:
  - At the **locknut** to 525 ± 75 foot pounds torque, or
  - At the **bolt head** to 575 ± 75 foot pounds
4. Recheck equalizing beam end connections for signs of looseness.
  - Inspect alignment shims in equalizing beam end for looseness. Lightly tap on the alignment shims to see if they can be moved. If movement is detected, tighten fasteners to the proper torque value, see Figure 6-2.
  - Inspect equalizing beam end connection for signs of excessive wear or looseness.
5. If bar pin looseness is still detected in any of the equalizing beam end hub, **DO NOT** operate the vehicle. One or more components will require replacement, see Component Replacement Section of this publication.

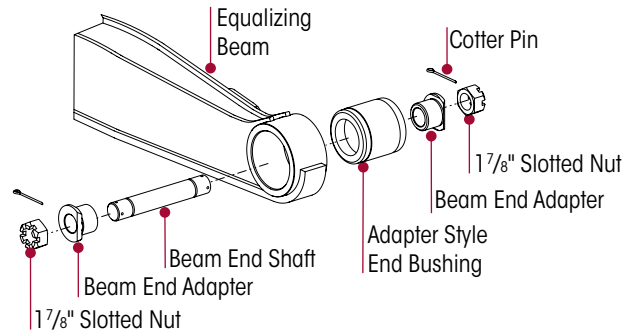


■ **Adapter Style ULTIMAAX 60K•70K**, see Figure 6-5

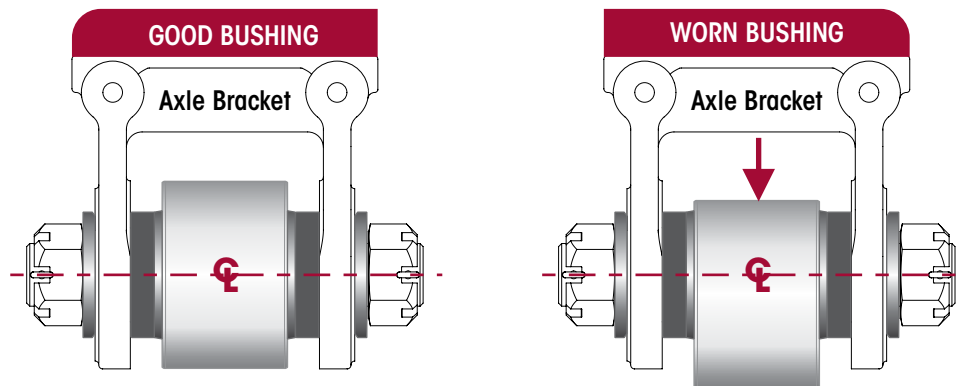
**FIGURE 6-5**  
ULTIMAAX 60K • 70K Shown

**VISUAL INSPECTION**

1. Chock the wheels.
2. Visually inspect suspension components for signs of movement or excessive wear.
  - Inspect equalizing beam end connection for signs of excessive wear or looseness.
  - Look for worn, frayed or distorted rubber in the beam, see Figure 6-6.
  - Look for the equalizing beam to be lower in the axle bracket, see Figure 6-6.
  - If the adapter style end bushing is visually offset, a floor jack test should be performed, refer to Jack Test in this section.



**FIGURE 6-6**

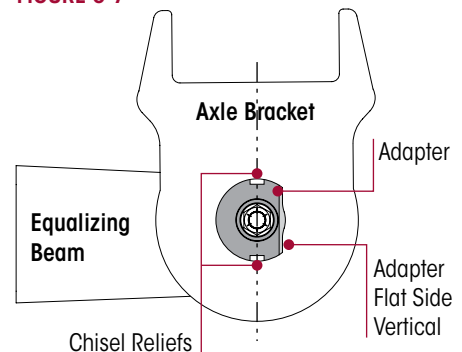


A **GOOD** bushing will result in the equalizing beam end hub appearing to be **centered** with the centerline of the end bushing in the axle bracket

A **WORN** bushing will result in the equalizing beam end hub appearing to be  $\frac{5}{8}$ " (15 mm) **offset/below** the centerline of the end bushing in the axle bracket

3. The beam end adapter style connections have the flange of the adapter cut off for assembly clearance with the axle housing bowl.
  - The flat must be positioned vertically as shown in Figure 6-7. If the flat of the adapter position is incorrect, removal of the fasteners will be necessary to correct position, refer to the Adapter Style End Bushings in the Component Replacement Section.

**FIGURE 6-7**





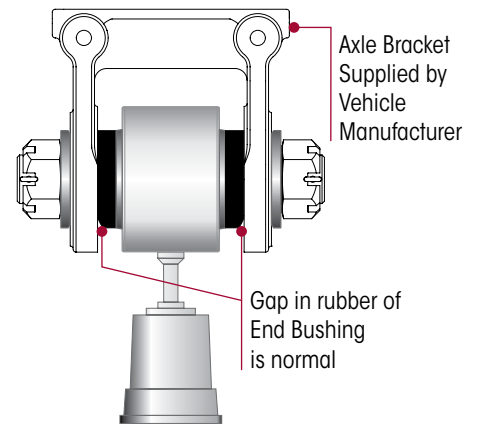
**JACK TEST**

1. Place a jack under each beam end as shown. Raise the jack to check for movement in the connection or rubber components, see Figure 6-8.

**NOTE**

The gap at each side of the visible rubber on the lower part of the bar pin end bushing is normal, see Figure 6-8, and is not an indication to replace the bushing. Because all rubber end bushings are in compression, with the load bearing on the top side, the lower side of the rubber is slightly relieved, allowing the rubber to move inward, and a gap appears.

**FIGURE 6-8**



**PHYSICAL INSPECTION**

**WARNING**

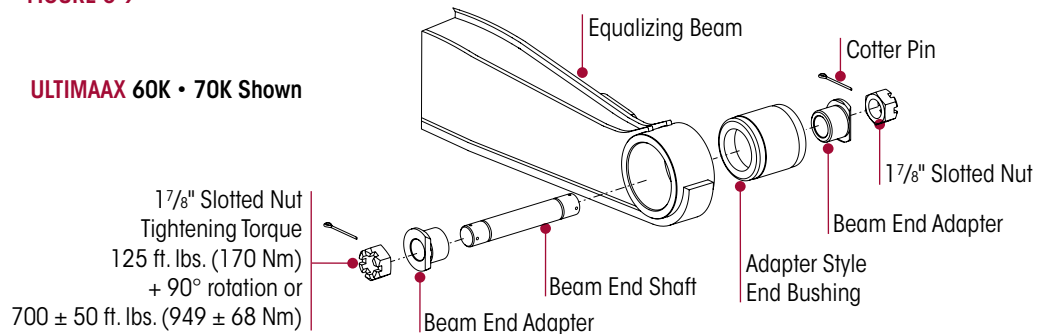
IF BUSHING MOVEMENT OR LOOSENESS IS NOTED IN THE EQUALIZING BEAM END HUB, DO NOT OPERATE THE VEHICLE. REPLACE THE RUBBER END BUSHINGS AND ALL CONNECTING PARTS. THE ABOVE CONDITION CAN RESULT IN COSTLY REPAIR, DOWNTIME, POSSIBLE SEPARATION OF COMPONENTS, ADVERSE VEHICLE HANDLING, PROPERTY DAMAGE, OR PERSONAL INJURY.

**SERVICE HINT**

An equalizing beam end connection that is visibly cleaner than the other connections may indicate a loose connection.

2. If bushing movement or looseness is detected in the equalizing beam end hub, **DO NOT** operate vehicle. Replace the equalizing beam end bushings and all connecting parts. Refer to the Component Replacement Section of this publication.
3. Check and record torque values, see Figure 6-9. Correct torque values as required making sure all fasteners are tightened to 125 foot pounds + 90° rotation or 700 ± 50 foot pounds torque.

**FIGURE 6-9**



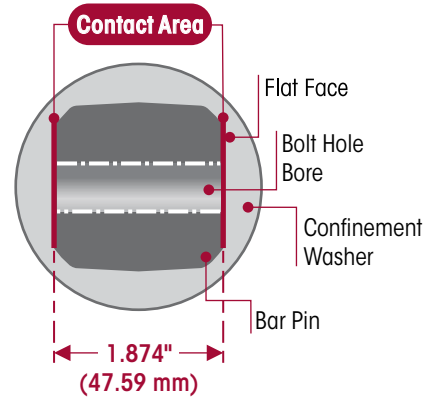
### BAR PIN STYLE END BUSHINGS – ULTIMAAX 46K•52K

#### VISUAL INSPECTION

An indication that the end bushing requires replacement is when one or more of the following conditions apply:

- If the contact area, see Figure 6-10 (the flat face area where bar pin contacts the axle bracket) reveal signs of excessive wear. Replace if bar pin thickness measures less than 1 7/8" (47.59 mm).
- If bar pin bolt holes bores reveal signs of elongation or wear, see Figure 6-10.

**FIGURE 6-10**  
Shim Type Bar Pin End Bushing



If bar pin measurement is **less than 1.874" (47.59 mm)**, replacement is required.

### BAR PIN SHIMS – ULTIMAAX 46K•52K

An indication that the bar pin shims require replacement is when one or more of the following conditions apply:

- Visual inspection of contact area on the shim reveals signs of excessive wear.
- The thickness of any single leg on the shim, is less than the measurement shown in Figure 6-11, replacement of bar pin shim is required.

**FIGURE 6-11**

Part Number	Original Thickness of Shim Leg	Minimum Thickness Required	Part Number
50130-000	3/16" (4.8 mm)	0.123" (3.1 mm)	50131-000
50131-000	1/4" (6.4 mm)	0.186" (4.7 mm)	50130-000
57026-000	3/8" (9.5 mm)	0.248" (6.3 mm)	50131-000
		3/8" (9.5 mm)	57026-000

### BEAM END AXLE BRACKETS

**NOTE**

The axle brackets are furnished and welded into position by the vehicle manufacturer or axle manufacturer.

#### VISUAL INSPECTION

When inspecting the equalizing beam end connection also inspect the axle brackets for damage or cracks, see Figures 6-12, 6-13 and 6-14. Any axle bracket that is found damaged or cracked must be repaired or replaced.

Consult the axle and/or vehicle manufacturer for additional inspections, component repair and replacement instructions.

#### PHYSICAL INSPECTION

■ **Bar Pin Style – ULTIMAAX 46K•52K**

- a. Inspect the axle brackets for damage or cracks in the locations shown in Figures 6-12 and 6-13. Any axle bracket that is found damaged or cracked must be repaired or replaced.

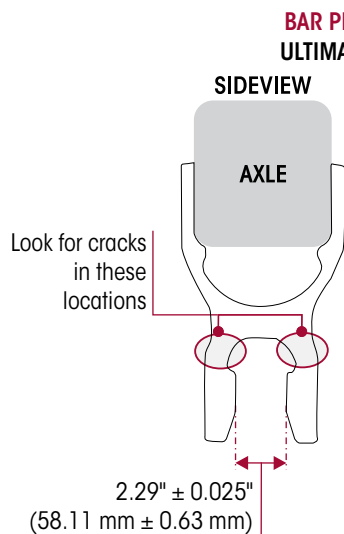
- b. Measure the distance between the axle bracket legs for correct width, refer to Figures 6-12 and 6-13 for measurement location and dimensions. An axle bracket outside of the measurement range must be repaired or replaced.
- c. Consult the vehicle manufacturer for inspection, component repair and replacement instructions.

■ **Adapter Style – ULTIMAAX 60K•70K**

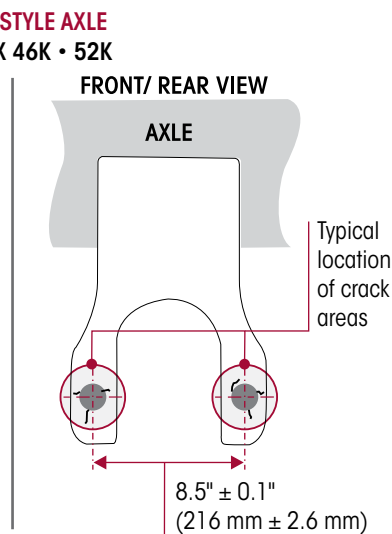
- a. Inspect the 2½" (64 mm) diameter holes in each of the axle bracket legs, Figure 6-14.
- b. Remove any burrs or material left there by the old adapters.
- c. Use a new adapter style bushing as a gauge for fit, being sure it enters the holes from the outside of each bracket leg.
- d. Measure the distance between the axle bracket legs for correct width, refer to Figure 6-14 for measurement location and dimensions.

The dimension between the inside surfaces of the axle bracket legs is 6.015" ± 0.005" (152.7 mm ± 0.1 mm), see Figure 6-14.

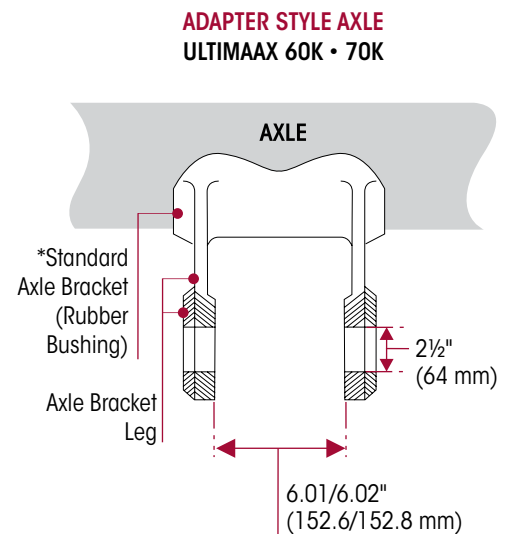
**FIGURE 6-12**



**FIGURE 6-13**



**FIGURE 6-14**



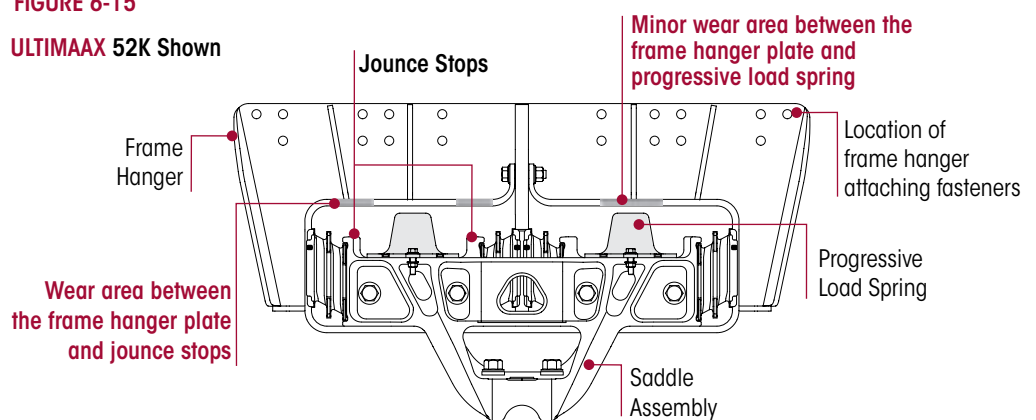
**NOTE:** Typical axle brackets shown

**FRAME HANGER ASSEMBLY**

The following points are for guidance and intended to assist personnel in determining when frame hanger assembly maintenance is necessary.

**FIGURE 6-15**

**ULTIMAAX 52K Shown**



### INSPECTION

- Inspect the frame hanger for any damage, cracks or signs of adverse or abrasive contact with other components. Some minor wear will be evident where the progressive load spring contacts the frame hanger assembly, see Figure 6-15. If more than half the thickness of the frame hanger plate is damaged or cracked, replace the frame hanger assembly.
- Look for wear in the frame hanger cavity due to contact with the jounce stop, see Figure 6-15. If more than half the thickness of the frame hanger plate is worn or damaged, replace the frame hanger.
- Inspect the frame hanger attaching fasteners and frame hanger assembly for signs of looseness or movement. Re-tighten any loose fasteners to specified torque. Components damaged by loose fasteners must be replaced.

### SHEAR SPRINGS

#### INSPECTION

Inspection of the shear spring should always be conducted with the vehicle in the **UNLOADED** condition.

- Bent or burred edges on the rate plates extending beyond the rubber are acceptable provided the rubber can freely expand during vehicle operation, see Figure 6-16.
- Creases formed by folding of the rubber surface under load are acceptable. These appear as stripes on the surface, polished by wear or covered with tacky (sticky) rubber, see Figure 6-17.

FIGURE 6-16

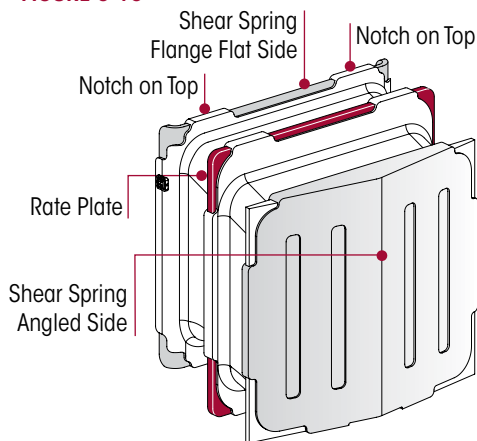
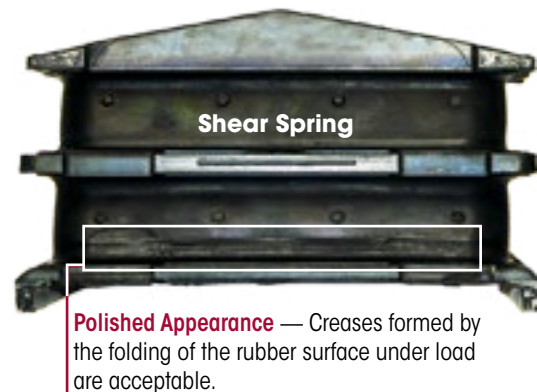


FIGURE 6-17



- Bonding separation of the rubber from any of the bonded rate plate surfaces to a maximum depth of approximately 2" (50 mm) is acceptable, see Figure 6-18. If the bonding separation depth is 2" (50 mm) or more, the shear springs require replacement.
- A certain amount of gradual breakup of the rubber surface is acceptable. Use a feeler gauge to measure cuts or splits in the rubber. If the measurement is over a depth of 2" (50 mm), then the shear springs require replacement, see Figures 6-19 and 6-20.

FIGURE 6-18

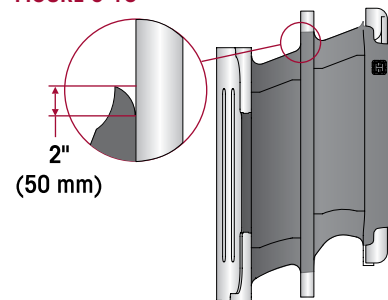




FIGURE 6-19

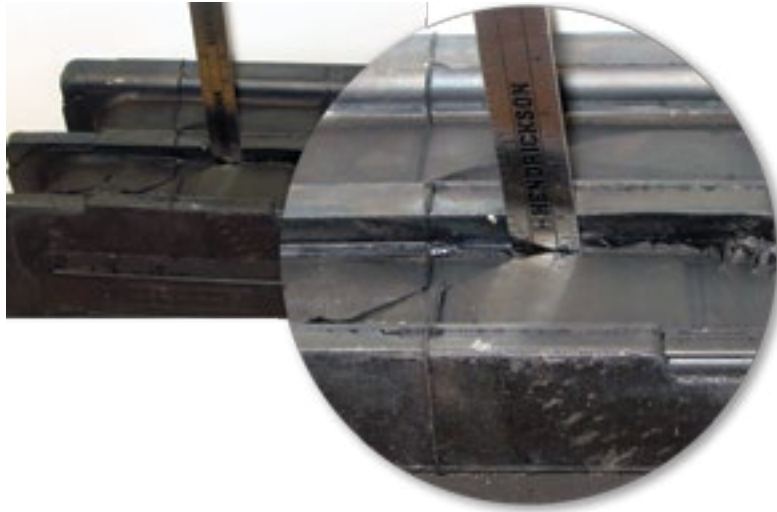


FIGURE 6-20



### PROGRESSIVE LOAD SPRINGS (PLS)

**NOTE**

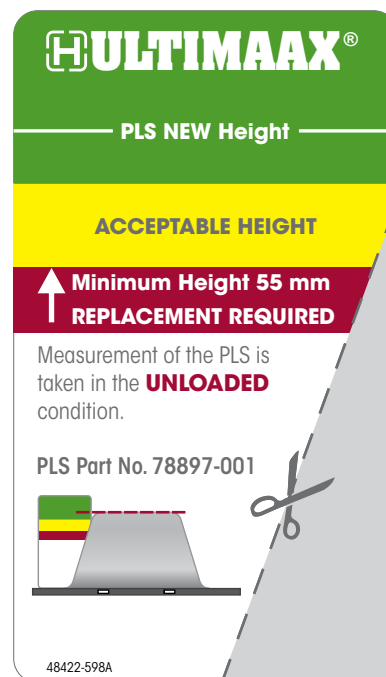
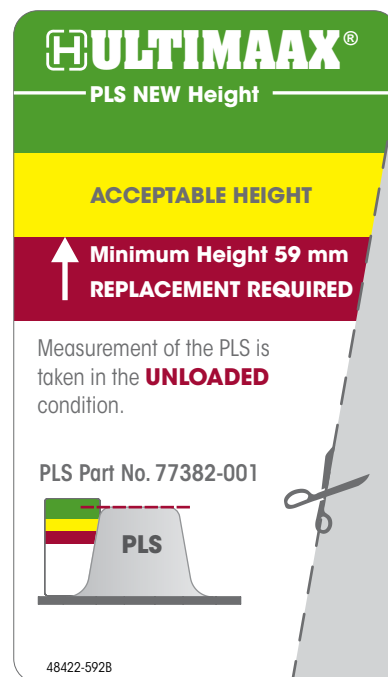
The Hendrickson ULTIMAAX suspension progressive load springs must be replaced in pairs (left side pairs or right side pairs or rear position pairs or front position pairs), even if only one PLS shows unacceptable conditions. Replacement of only one (1) PLS can cause uneven wear, and higher premature wear for the one replaced.

Visually inspect the progressive load springs at regular preventive maintenance intervals. The following points are for guidance and intended to assist personnel in determining when progressive load spring component requires replacement, refer to the Component Replacement Section of this publication.

**SERVICE HINT**

Use **Hendrickson gauge card (Lit. No. 48422-592 for 48K•52K)** or **(Lit. No. 48422-598 for 60K•70K)** in unloaded condition to help determine the height, length of cut or split and depth of separation of the ULTIMAAX progressive load spring (PLS), see Figure 6-21. These gauge cards are available on-line at [www.hendrickson-intl.com/Litform](http://www.hendrickson-intl.com/Litform)

FIGURE 6-21

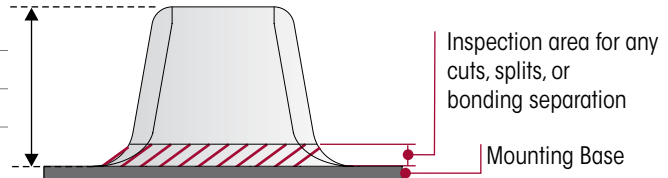


Always inspect the progressive load spring with the vehicle in the **UNLOADED** condition.

- The height of a **new** PLS is:  
**48K•52K** – 3½" (78 mm) • **60K•70K** – 2⅞" (73 mm)
- The PLS requires replacement if the height is below, see Figure 6-22:  
**48K•52K** – 2⅝" (59 mm) • **60K•70K** – 2¾" (55 mm)

**FIGURE 6-22**

Progressive Load Spring (PLS) Height in Unloaded Condition		
	NEW	MINIMUM
46K • 52K	3.1" (78 mm)	2.3" (59 mm)
60K • 70K	2.9" (73 mm)	2.2" (55 mm)



**FIGURE 6-23**

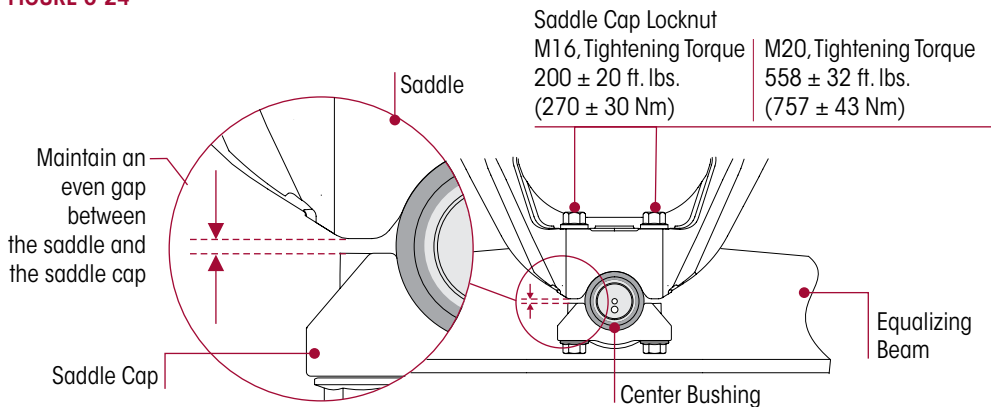
- A bent or cracked mounting base requires PLS replacement.
- If any cuts or splits in the rubber of over 2" (50 mm) in length and an average depth of ½" (13 mm), the effected PLS requires replacement. A certain amount of gradual breakup of the rubber surface is normal. The most likely areas for potential cuts, splits, or wear are shown in Figure 6-22 as "//////".
- If any bonding separation depth of the rubber from the PLS mounting base plate surface (see Figure 6-22) is more than ½" (13 mm), the effected PLS requires replacement.
- Creases formed by folding of the rubber surface under load are acceptable. These appear as stripes on the surface, polished by wear or covered with tacky rubber, see Figure 6-23.



**Polished Appearance** —  
 Creases formed by the folding of the rubber surface under load are acceptable.

## SADDLE CONNECTION

**FIGURE 6-24**



Visually inspect for any signs of movement or looseness and ensure:

- Each saddle is centered on each equalizing beam center bushing.
- The center bushing inner metal is full seated to the saddle.



- Saddle cap locknuts are tightened to proper torque as specified in the Torque Specifications Section of this publication.

**Saddle cap fasteners** — While tightening the saddle cap fasteners maintain an even gap between the saddle and saddle cap, see Figure 6-24.

**NOTE**

Tightening the saddle cap fasteners properly will help prevent wear of mating components.

**CROSS TUBE**

The ULTIMAAX cross tube connects the two (2) equalizing beams through the equalizing beam's center bushings, see Figure 6-25. The cross tube has clearance to float side-to-side in the center bushings.

The length of the cross tube will allow side-to-side movement of approximately 2½" (60 mm). For this reason, the cross tube **may appear polished** or missing paint at each end where it enters into the center bushings. This is normal. Also, the cross tube will rattle in straight position which is acceptable.

**WARNING**

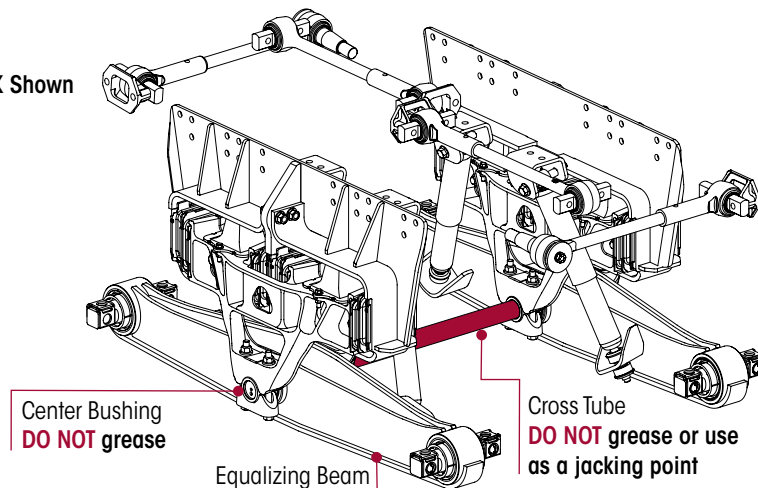
IMPROPER JACKING METHODS CAN CAUSE STRUCTURAL DAMAGE WHICH CAN CAUSE ADVERSE VEHICLE HANDLING, PROPERTY DAMAGE OR SEVERE PERSONAL INJURY AND WILL VOID HENDRICKSON'S WARRANTY.

- DO NOT USE THE SUSPENSION CROSS TUBE AS A JACKING POINT, REFER TO VEHICLE MANUFACTURER FOR PROPER JACKING INSTRUCTIONS.
- ACCEPTABLE LIFTING POINTS FOR A VEHICLE AT THE RATED LOAD INCLUDE BUT ARE NOT LIMITED TO: THE AXLE, EQUALIZING BEAM, AND THE VEHICLE FRAME RAIL. REFER TO THE VEHICLE MANUFACTURER FOR PROPER JACKING INSTRUCTIONS.

**DO NOT** grease or lubricate the cross tube or the center bushing and **DO NOT** use the cross tube as a jacking point, see Figure 6-25.

**FIGURE 6-25**

**ULTIMAAX 52K Shown**


**VISUAL INSPECTION**
**NOTE**

A bent cross tube may cause misalignment of the axles, which may cause abnormal tire wear.

- Visually inspect the overall condition of the cross tube for dents, dings, or bent condition, replace as necessary.
- Use a straight edge to inspect the straightness of the cross tube, replace as necessary

## TORQUE RODS

### WARNING

THE ULTIMAAX SUSPENSION INCORPORATES TORQUE RODS FOR VEHICLE STABILITY. IF THESE COMPONENTS ARE DISCONNECTED OR ARE NON-FUNCTIONAL THE VEHICLE SHOULD NOT BE OPERATED. FAILURE TO DO SO CAN RESULT IN ADVERSE VEHICLE HANDLING AND POSSIBLE TIRE CONTACT WITH THE FRAME OR THE SUSPENSION.

### VISUAL INSPECTION

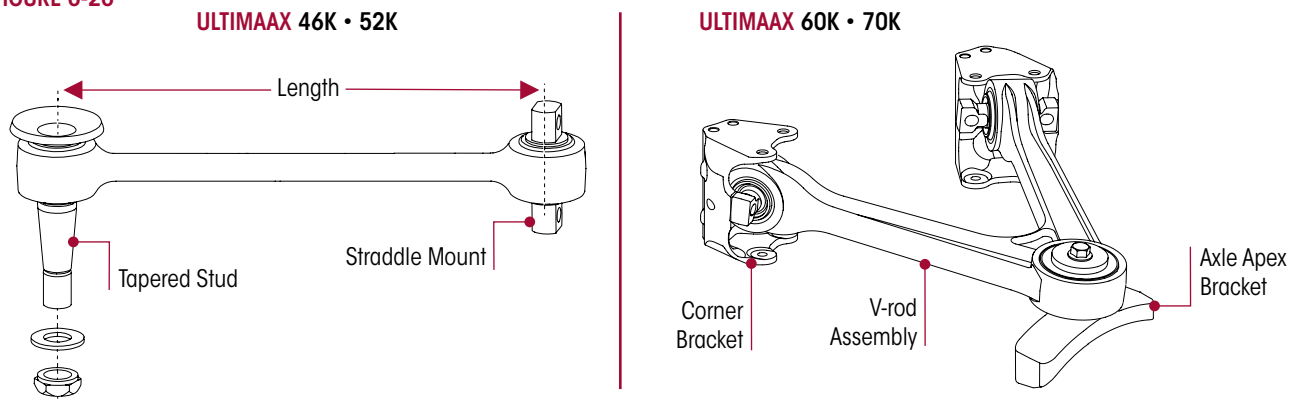
All transverse, longitudinal or V-rod (as applicable) need to be inspected during preventive maintenance and service for looseness.

**Visually inspect (1) torque rod bushings** for any torn or shredded rubber material interfaces or elongated oval shapes and **(2) torque rods** for any metal to metal contact, bent, cracked or broken components. The torque rod and / or the torque rod bushings will require replacement if any of these conditions are encountered.

**Torque rod looseness** inspection is necessary. With the vehicle shut down, a lever check can be made with a long pry bar (36") placed under each torque rod end and pressure applied.

**Torque rod length** is determined by the original vehicle manufacturer (see Figure 6-26). The mounting bracket at the axle housing end of the torque rods are furnished and welded into position on the axle housings by the axle or vehicle manufacturer,

FIGURE 6-26



### NOTE

Hendrickson Suspension recommends Grade 8 bolts, hardened flat washer and Grade C locknuts be used for all straddle mount torque rod attachments.

- It is important that the **tightening torque** of the locknuts be checked during preventive maintenance and service. Follow the tightening torque specifications and all applicable preventive maintenance, service and safety instructions issued by the respective vehicle and suspension manufacturers.

## SHOCK ABSORBERS (if equipped)

### NOTE

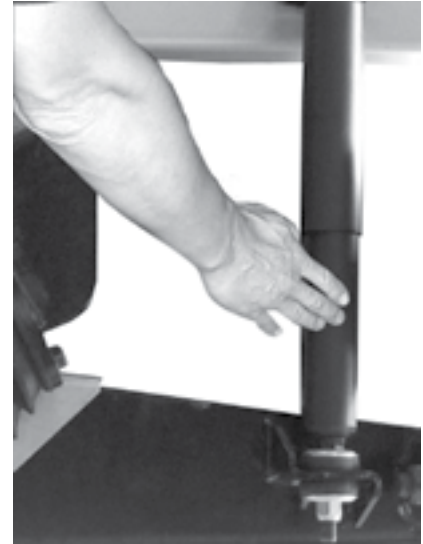
It is not necessary to replace shock absorbers in pairs if only one shock absorber requires replacement.

Hendrickson offers a long service life, premium shock absorber for use on ULTIMAAX suspensions. If shock absorber replacement is necessary, Hendrickson recommends that original Hendrickson shock absorbers be replaced with identical Hendrickson Genuine parts for servicing. Failure to do so will affect the suspension performance, durability, and will void the warranty.

Inspection of the shock absorber can be performed by doing a heat test, and a visual inspection. For instructions on shock absorber replacement see the Component Replacement Section of this publication.

**WARNING****HEAT TEST**

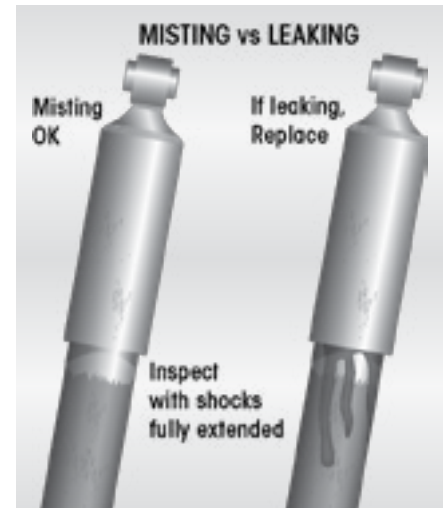
1. Drive the vehicle at moderate speeds on rough road for minimum of fifteen minutes.
2. Use an infrared thermometer to check the temperature of the shock absorber. This can also be performed by carefully touching the shock body below the dust cover. Touch the frame to get an ambient reference, see Figure 6-27. A warm shock absorber is acceptable, a cold shock absorber should be replaced.
3. To inspect for an internal failure, remove and shake the suspected shock. Listen for the sound of metal parts rattling inside. Rattling of metal parts can indicate that the shock has an internal failure.

**FIGURE 6-27****VISUAL INSPECTION**

Look for any of the potential problems shown in Figure 6-28 when doing a visual inspection. Inspect the shock absorbers fully extended. Replace as necessary.

**FIGURE 6-28****SHOCK ABSORBER VISUAL INSPECTION - UNACCEPTABLE CONDITIONS****LEAKING VS. MISTING VISUAL INSPECTION**

The inspection must not be conducted after driving in wet weather or a vehicle wash. Shocks need to be free from water. Many shocks are often misdiagnosed as failures. Misting is the process whereby very small amounts of shock fluid evaporate at a high operating temperature through the upper seal of the shock, see Figure 6-29. When the "mist" reaches the cooler outside air, it condenses and forms a film on the outside of the shock body. Misting is perfectly normal and necessary function of the shock. The fluid, which evaporates through the seal area helps to lubricate and prolong the life of the seal.

**FIGURE 6-29**



A shock that is truly leaking and needs to be replaced will show signs of fluid leaking in streams from the upper seal. These streams can easily be seen when the shock is fully extended, underneath the main body (dust cover) of the shock. Look for these potential problems when doing a visual inspection. Inspect the shock absorbers fully extended. Replace as necessary.

---

**NOTE**

The ULTIMAAX suspension is equipped with a premium seal on the shock, however this seal will allow for misting to appear on the shock body (misting is not a leak and is considered acceptable).

If the shock is damaged, install new shock absorber and replace as detailed in the Component Replacement Section of this publication.

## SECTION 7

# Alignment & Adjustments

### AXLE ALIGNMENT

- **The primary control for axle alignment** is the location of the frame hanger assemblies on the frame rail as installed by the vehicle manufacturer, and the location of the axle brackets on the axles as installed by the axle or vehicle manufacturer.
- **Axle centering and pinion angles** for (1) ULTIMAAX 46K • 52K are controlled by the longitudinal and transverse torque rods, and (2) ULTIMAAX 60K • 70K are controlled by the V-rods. All such torque rods are not adjustable.
- **Ride height** is controlled by the design of the suspension frame hanger. No adjustment is possible.

### DRIVE AXLE PINION ANGLE

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**NOTE**

Drive axle pinion angle for vehicles equipped with V-rods is non-adjustable.

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Drive axle pinion angles are established by the vehicle manufacturer. If pinion angle adjustment is required, check for proper angles with the vehicle manufacturer. Pinion angle is set by the longitudinal torque rod length.

**FIGURE 7-1**

#### TO CHECK THE PINION ANGLE

1. Use a work bay with a level floor.
2. Relax the suspension by slowly moving the vehicle back and forth several times in a straight line without using the brakes. This will slacken or loosen the suspension as the vehicle is positioned. End with all wheels positioned straight ahead. Roll to a stop without the brakes being applied. **DO NOT** set the parking brake.
3. Chock the front wheels of the vehicle.
4. Place a digital protractor on the axle housing as shown in Figure 7-1.
5. Check to see if the pinion angle is correct per the vehicle manufacturer's specified range.
6. If necessary, add/remove shims at the longitudinal torque rod connections as required to achieve the proper pinion angle.
7. When the pinion angle is correct tighten all fasteners to the proper torque specifications per the vehicle manufacturer and recheck the pinion angles.
8. Remove wheel chocks.



### DRIVE AXLE ALIGNMENT

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**NOTE**

Drive axle alignment with suspensions equipped with **adapter style equalizing beam** end connections **ARE NOT** adjustable.

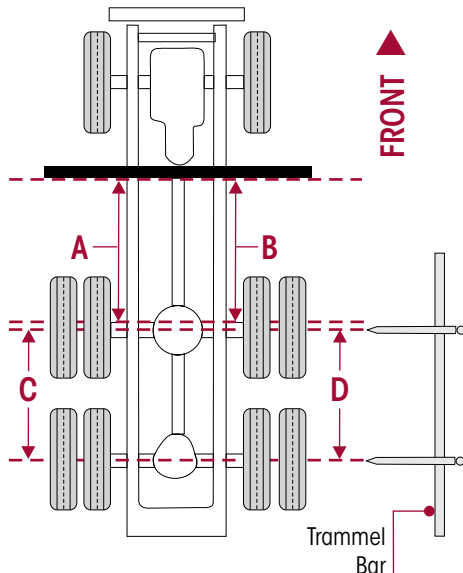
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Computerized alignment equipment is the preferred method of measuring alignment. To calculate the shim thickness required, the target offset must be converted to thrust angle, see alignment equipment manufacturer for procedures. If, however, computerized axle alignment equipment is not available refer to the following Inspection in this section.

Proper alignment is essential for maximum ride quality, performance, and tire service life. The following recommended alignment procedure as described below, should be performed if excessive or irregular tire wear is observed.

**NOTE**

Proper vehicle alignment can only be achieved when all axles are aligned to the vehicle's centerline and the steering axle's caster, camber and toe-in settings are within specifications.

**FIGURE 7-2****INSPECTION**

1. Use a work bay with a level, flat surface.
2. Relax the suspension by slowly moving the vehicle back and forth several times in a straight line. This will slacken or loosen the suspension as the vehicle is positioned. End with all wheels positioned straight ahead.
3. **DO NOT** set the parking brake. Chock the front wheels of the vehicle.
4. Verify the vehicle system air is at full operating pressure.
5. Verify all suspension components are in good condition. Repair or replace any worn or damaged suspension components before proceeding with the alignment process.
6. Ensure all drive axle tires are at the same size.
7. Securely clamp a six-foot piece of **STRAIGHT** bar stock or angle iron across the lower frame flange as shown in Figure 7-2. Select a location for the bar stock or angle iron as far forward of the drive axle as possible where components will not interfere.
8. Accurately square the bar stock or angle iron to the frame using a carpenter's square.
9. Using a measuring tape, measure from the straight edge to the forward face of the front drive axle arms on both sides of the vehicle as shown in Figure 7-2, dimensions **A** and **B**.
10. Calculate the difference between measurements **A** and **B**.
  - a. If the **front** drive axle is within vehicle manufacturer's specifications, proceed to check the rear drive axle (Step 11).
  - b. If alignment of the **front** drive axle **IS NOT** within the vehicle manufacturer's specifications, then the alignment of this axle **MUST** be corrected **BEFORE** measuring the rear drive axle alignment (Step 11).
  - c. If the suspension is equipped with bar pin end bushings, correct the alignment of this axle by following the bar pin alignment instructions in this section.

**NOTE**

Since the remaining drive axle will be aligned relative to the front drive axle, it is essential that the front drive axle is aligned within the vehicle manufacturer's specifications prior to the alignment of the remaining drive axle.

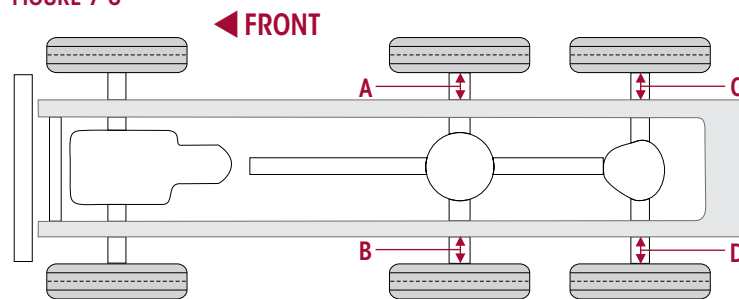
11. Using a trammel bar, measure the distance from the spindle center of the **front** drive axle to the spindle center of the rear drive axle on both sides of the vehicle; see Figure 7-2, **C** and **D**.
12. Calculate the difference between measurements **C** and **D**.
  - a. If the measurements are within the vehicle manufacturer's specifications, then the **rear** drive axle alignment is acceptable.
  - b. If alignment of the **rear** drive axle **IS NOT** within the vehicle manufacturer's specifications, then the alignment of this axle **MUST** be corrected.
  - c. If the suspension is equipped with bar pin end bushings, correct the alignment of this axle by following the Bar Pin with Shims Alignment instructions in this section.
13. Recheck measurements to confirm adjustments. Repeat Steps 10 through 12 until the correct alignment is achieved.
14. After all drive axles are aligned, check the pinion angle of each drive, refer to the Axle Pinon Angle in this section.

## AXLE LATERAL ALIGNMENT

**NOTE**

Axle lateral alignment for vehicles equipped with V-rods is non-adjustable.

1. Use a work bay with a level floor.
2. Drive the vehicle slowly, straight ahead. Try to slacken or loosen the suspension as the vehicle is positioned. End with all wheels positioned straight ahead. Try to roll to a stop without the brakes being used. **DO NOT** set the parking brake.
3. Chock the front wheels of the vehicle.
4. Measure from the outside of the frame rail to the rim flange of the inner tire. Record the measurement **A** and **B**, see Figure 7-3.
5. Measure the same distance on the opposite side of the same axle. Record the measurement **C** and **D**, see Figure 7-3.

**FIGURE 7-3**


6. Verify the axle lateral alignment is within the vehicle manufacturer's specifications. Adding or removing shims that are located between the transverse torque rod and the frame rail will normally correct the axle lateral alignment.
  - A general rule of thumb is to use a torque rod shim with a thickness that is half of the difference between the two measurements.

**EXAMPLE**

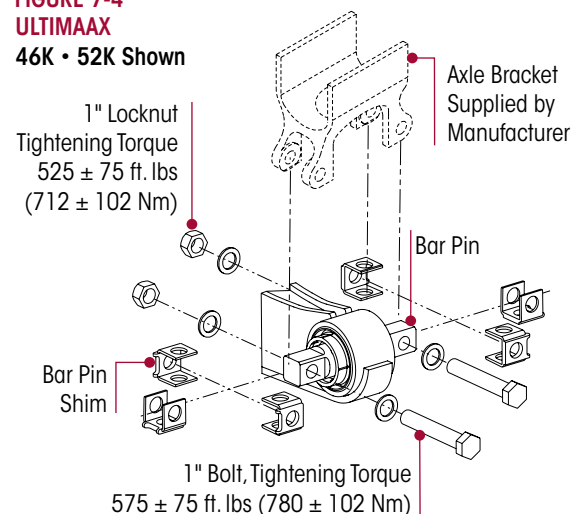
If the axle lateral alignment is out of specification by  $\frac{1}{4}$ " (6 mm), remove or install a  $\frac{1}{8}$ " (3 mm) torque rod shim between the transverse torque rod and frame rail as needed. Refer to Longitudinal and Transverse Torque Rod Section in Preventive Maintenance Section of this publication.

**NOTE**

Hendrickson recommends the use of Grade 8 bolts and Grade C locknuts. Washers are not necessary when flanged fasteners are used.

## BAR PIN ALIGNMENT

The alignment feature consists of specially designed, tightly tolerance steel shims which fill the  $\frac{3}{8}$ " (9.5 mm) total gap between the bushing's bar pin and the axle bracket legs. The gap must be filled by placing the shims on the bushing assembly in one of the positions shown in Figure 7-4. Hendrickson has three shim designs options for alignment, part number 50130-000 (provided), 50131-000 and 57026-000, see Figure 7-7.

**FIGURE 7-4  
ULTIMAAX  
46K • 52K Shown**




**WARNING**

A BAR PIN SHIM MUST BE INSTALLED AT EACH BOLT LOCATION. THE SAME PART NUMBER SHIM IN THE SAME ORIENTATION MUST BE USED AT BOTH BOLT LOCATIONS ON ANY ONE END BUSHING. DO NOT INSTALL OR STACK MORE THAN ONE SHIM AT EACH BOLT LOCATION. USE GENUINE HENDRICKSON BAR PIN SHIMS, DO NOT USE STANDARD WASHERS. FAILURE TO FOLLOW THESE WARNINGS MAY RESULT IN IMPROPER VEHICLE ALIGNMENT, FRACTURE OF THE AXLE BRACKET OR BAR PIN WHICH COULD RESULT IN THE ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE.

**ALIGNMENT ADJUSTMENT**

If alignment of the drive axles is required, as determined by an alignment inspection procedure, the following steps will need to be performed.

1. Determine direction of axle thrust angle. Figure 7-5 illustrates the forward drive axle with a thrust angle to the left (-negative thrust).

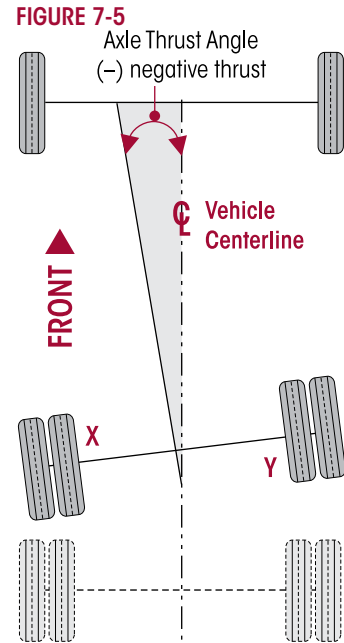
**SERVICE HINT**

Axle movement is in the same direction as the increased shim thickness, see Figure 7-6.

2. To determine where to adjust shim thickness use measurement **A** and **B** for front drive axle or **C** and **D** for rear drive axle, see Figure 7-2.

**SERVICE HINT**

Axle adjustment will be on the side of the bar pin where shim thickness is increased. For example, to correct the axle thrust angle illustrated in Figure 7-5, shim thickness will need to be increased at the front of the bar pin (Location X) and/or the rear of the bar pin (Location Y).



**NOTE**

Computerized alignment equipment is the preferred method of measuring alignment. To calculate the shim thickness required the target offset must be converted to thrust angle, see alignment equipment manufacturer for procedures.

3. Chock the wheels of the front axles to prevent vehicle movement during service.
4. Raise the frame of the vehicle to remove the load from the suspension. Support the frame at this height.
5. Support the equalizing beam and remove the fasteners from the end bushing where the bar pin alignment shim adjustment is being made.
6. Adjust shim thickness to move the axle in the desired direction, see Figure 7-6.

**WARNING**

EACH EQUALIZING BEAM END BUSHING HAS ONE (1) INBOARD AND ONE (1) OUTBOARD ALIGNMENT SHIM, FOR A TOTAL OF FOUR SETS OF TWO ALIGNMENT SHIMS PER SUSPENSION. EACH SET OF ALIGNMENT SHIMS FOR A PARTICULAR BEAM END BUSHING MUST BE INSTALLED IN THE SAME ORIENTATION. SHIM ORIENTATION MAY DIFFER FOR EACH BEAM END BUSHING, SEE FIGURE 7-4. FAILURE TO FOLLOW THESE WARNINGS MAY RESULT IN THE FRACTURE OF EITHER THE AXLE BRACKET OR BAR PIN WHICH COULD RESULT IN THE ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE.

**WARNING**

THE BAR PIN ALIGNMENT SHIM (PART NO. 50130-000) MUST BE INSTALLED WITH THE FOLDED EDGE FACING AWAY FROM THE BUSHING, SEE FIGURE 7-7. FAILURE TO DO SO MAY RESULT IN SHIM DAMAGE, IMPROPER ALIGNMENT, DAMAGE OR FRACTURE OF THE AXLE BRACKET OR BAR PIN WHICH COULD RESULT IN THE ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE.

7. Install new end bushing fasteners and tighten to:
  - At the **locknut** to 525 ± 75 foot pounds torque, or
  - At the **bolt head** to 575 ± 75 foot pounds torque





FIGURE 7-6

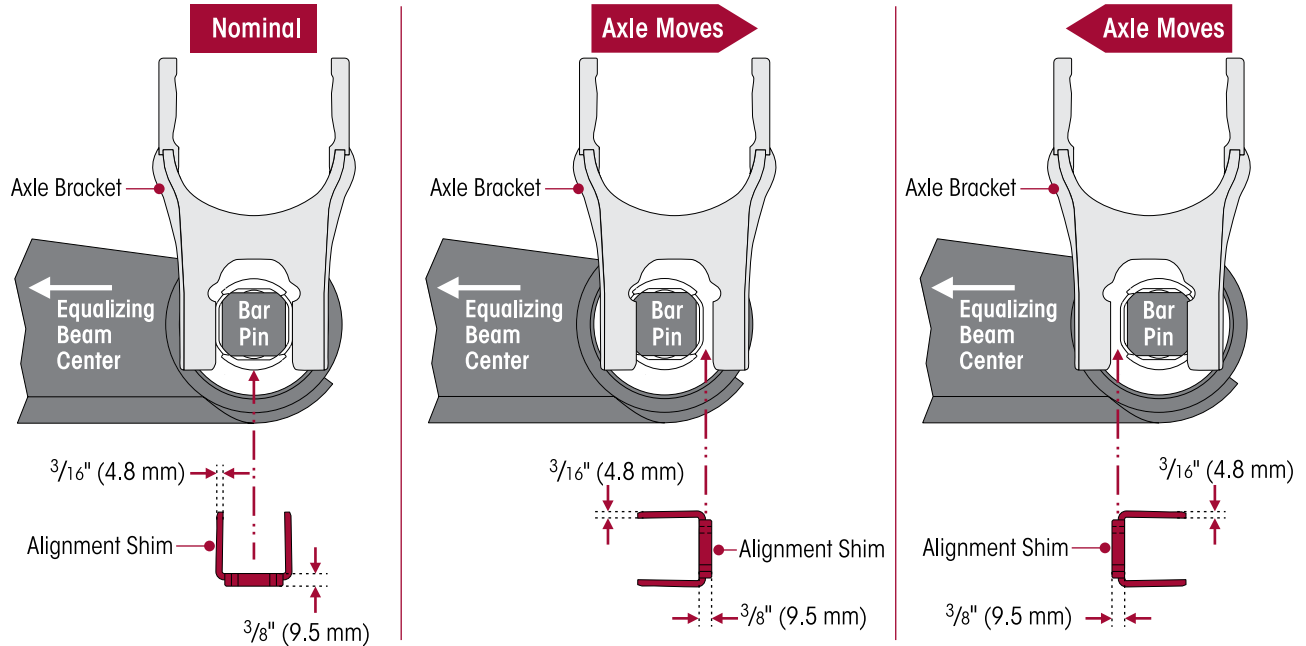
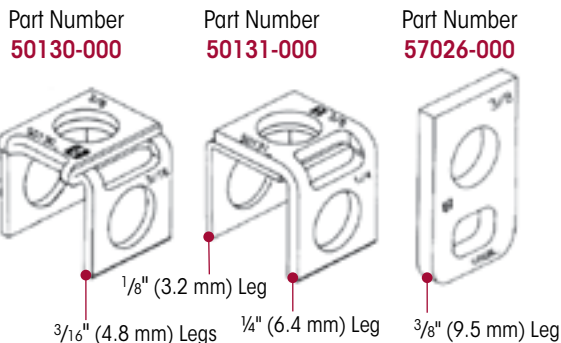


FIGURE 7-7

### BAR PIN ALIGNMENT SHIMS

The following service notes will help when performing Hendrickson equalizing beam bar pin alignment

- The standard alignment shims supplied with each suspension (P/N 50130-000) have two  $\frac{3}{16}$ " (4.8 mm) legs and a  $\frac{3}{8}$ " (9.5 mm) back. Rotating the shim pairs 90° will change the axle alignment in  $\pm \frac{3}{16}$ " (4.8 mm) increments.
- If a finer adjustment is required use alignment shim (P/N 50131-000). This alignment shim has one  $\frac{1}{8}$ " (3.2 mm) leg, one  $\frac{1}{4}$ " (6.4 mm) leg, and a  $\frac{3}{8}$ " (9.5 mm) back. A total of  $\frac{3}{4}$ " (19 mm) adjustment is achievable to the axle. A  $\frac{3}{8}$ " (9.5 mm) flat shim is also available (P/N 57026-000).
- $\frac{1}{16}$ " (1.5 mm) shim thickness increases thrust angle by 0.10°.
- To accomplish a thrust angle adjustment rotate the alignment shims on the bar pin of the end bushing. Axle movement will be in the direction of the shim thickness increase.
- Axle thrust angle may be adjusted at either wheel end on an axle. If insufficient adjustment is available at one wheel end, the opposing wheel end will also need to be adjusted, but in the opposite direction.



**NOTE:** Folded edge in 50130-000 shim must be positioned away from the bushing

**Example:** The alignment equipment shows the front drive axle to have a 0.40° thrust angle to the left. This will require a  $\frac{1}{4}$ " (6.4 mm) shim thickness increase to the front side of the left front equalizing beam end bushing. If there is less than  $\frac{1}{4}$ " (6.4 mm) of adjustment available at this location then some of the adjustment will have to be made at the rear of the right front end bushing. In this case a  $\frac{1}{8}$ " (3.2 mm) shim thickness increase at the front side of the left front bar pin **AND** a  $\frac{1}{8}$ " (3.2 mm) shim thickness increase at the rear side of the right front bar pin will correct the 0.40° thrust angle.

8. Remove support and lower the vehicle.
9. Verify the axles' alignments are within the vehicle manufactures tolerance.
10. Set brakes and remove wheel chocks.

## SECTION 8

# Component Replacement

### FASTENERS

When servicing an ULTIMAAX suspension, Hendrickson recommends replacing all removed fasteners with new genuine Hendrickson fasteners. Maintain correct torque values at all times. Check torque values as specified, see Hendrickson's Torque Specifications Section of this publication. If non-Hendrickson fasteners are used follow torque specifications listed in the vehicle manufacturer's service manual.

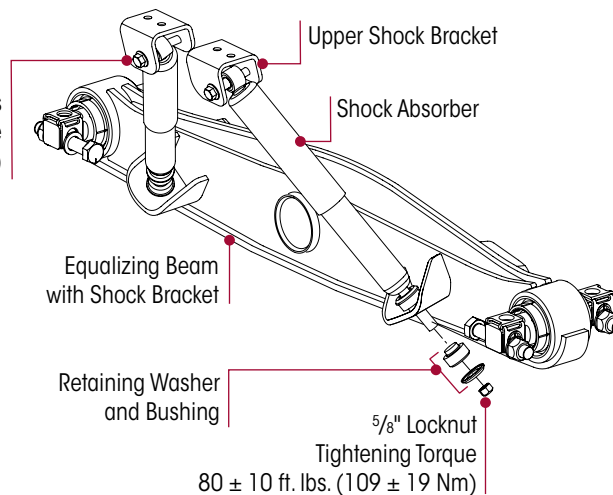
**NOTE** Torque values shown in this publication apply only if Hendrickson supplied fasteners are used. If non Hendrickson fasteners are used, follow the torque specification listed in the vehicle manufacturer's service manual.

### SHOCK ABSORBER – ULTIMAAX 46K•52K

**NOTE** It is not necessary to replace shock absorbers in pairs if one shock absorber requires replacement.

**FIGURE 8-1**  
**ULTIMAAX 46K • 52K Shown**

M16 Upper Shock Bracket Fasteners  
Tightening Torque  
170 ± 20 ft. lbs. (231 ± 27 Nm)





5/8" Locknut  
Tightening Torque  
80 ± 10 ft. lbs. (109 ± 19 Nm)

### DISASSEMBLY

1. Chock the front wheels of the vehicle.
2. Remove the lower shock absorber nylon locknut, retainer washer and rubber bushing from the shock absorber stud, see Figure 8-1.
3. Remove the upper shock fasteners from the upper shock bracket, see Figure 8-1.
4. Remove shock absorber.

### ASSEMBLY

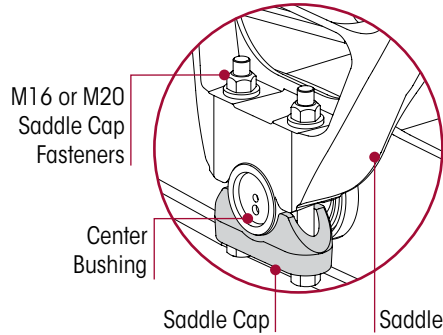
1. Mount the shock absorber in the upper shock bracket and install fasteners, tighten to  170 ± 20 foot pounds torque, see Figure 8-1.
2. Locate the shock absorber stud in the lower shock bracket and install the rubber bushing, retainer washer and nylon locknut. Tighten to  80 ± 10 foot pounds torque, see Figure 8-1.
3. Remove the wheel chocks.

## SHEAR SPRING / FRAME HANGER ASSEMBLY / SADDLE ASSEMBLY

**You will need:**

- **Saddle Disassembly Tool** Part No. 66086-113L and **Saddle Assembly Tool** Part No. 66086-108L, refer to the Special Tools Section of this publication.

**FIGURE 8-2**

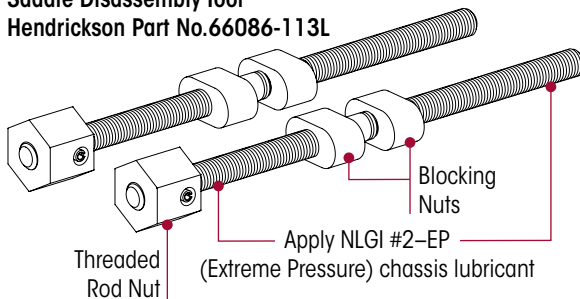


### DISASSEMBLY

1. Chock the front wheels of the vehicle.
2. Raise and support the drive axles on safety stands.
3. Remove the drive tires from the side of the vehicle being serviced.
4. Remove and discard the M16 or M20 saddle cap fasteners that attach the saddle assembly to the center bushing, see Figure 8-2.
5. Raise the vehicle's frame just enough to create a ½" (13 mm) gap between the saddle assembly and center bushing. Support the vehicle's frame at this height on safety stands.
6. Remove the progressive load springs M10 fasteners and discard, see Figure 8-4.
7. Remove the progressive load springs.
8. Apply NLGI #2-EP (Extreme Pressure) chassis lubricant to the threaded rod of the Saddle Disassembly Tool Part No. 66086-113L, see Figure 8-3.

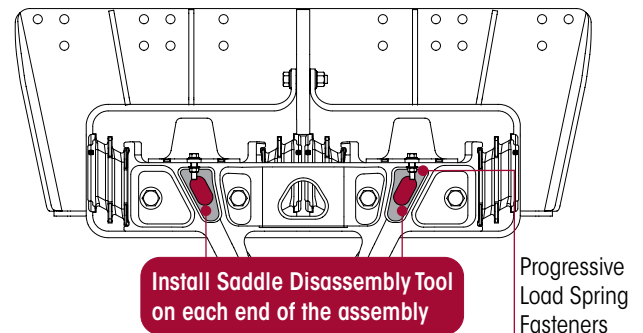
**FIGURE 8-3**

**Saddle Disassembly Tool**  
Hendrickson Part No. 66086-113L



**FIGURE 8-4**

**ULTIMAAX 52K Shown**

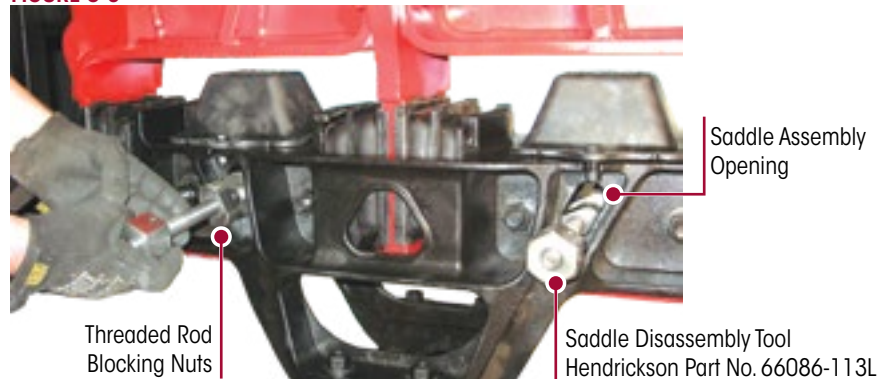


**NOTE**

The threaded rod spacer and spacer nut are designed and orientated to fit into the saddle assembly openings, see Figure 8-5.

9. Install both Saddle Disassembly Tool on each end of one saddle assembly, rotate the threaded rod blocking nuts until each are oriented properly into the saddle assembly openings, see Figures 8-4 and 8-5.

**FIGURE 8-5**



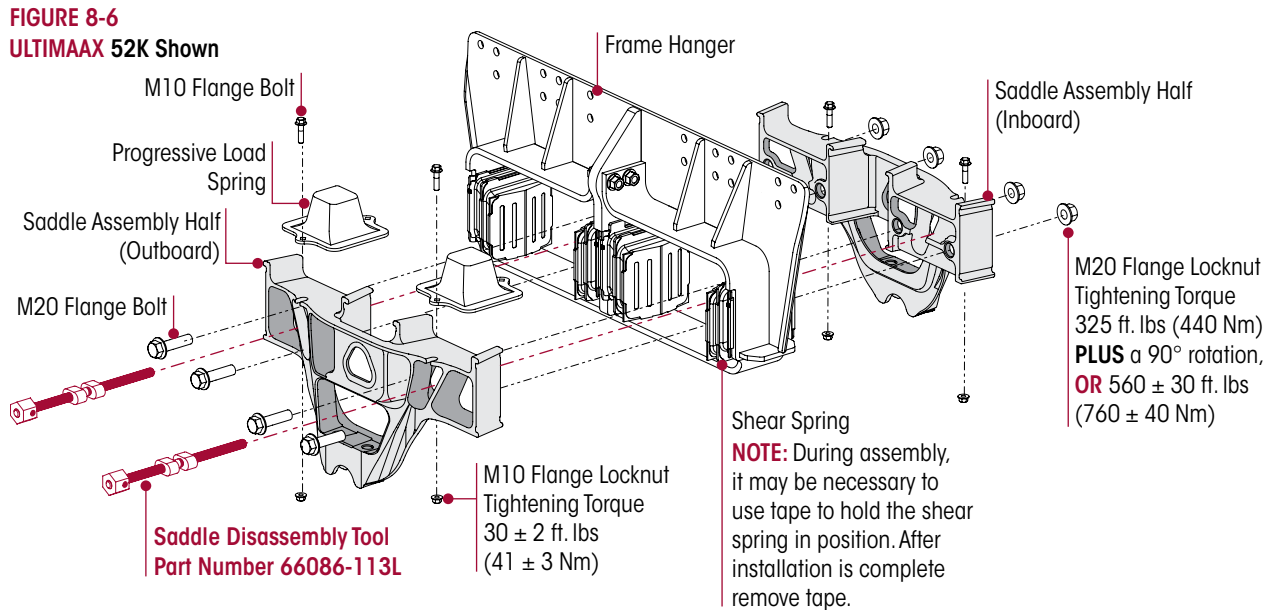
**SERVICE HINT** Use ratchet strap attached to each saddle half and the frame or vehicle body to secure the saddle halves during removal.

10. Snug the Saddle Disassembly Tool.

**NOTE** The shear springs in each frame hanger are compressed when installed.

11. Remove and discard the M20 saddle fasteners, see Figure 8-6.

12. To separate the two saddle halves, evenly rotate the threaded rod nut to tighten the Saddle Disassembly Tool, see Figure 8-6.



13. Remove the saddle halves and / or shear springs for replacement.

**CAUTION**

EACH FRAME HANGER ASSEMBLY WEIGHS APPROXIMATELY 165-252 POUNDS (75-114 KILOGRAMS), USE APPROPRIATE LIFTING DEVICES TO REMOVE OR INSTALL THE FRAME HANGER ASSEMBLY. FAILURE TO DO SO CAN RESULT IN DAMAGE TO THE VEHICLE OR PERSONAL INJURY.

14. If replacing the frame hanger, remove the frame fasteners per the vehicle manufacturer's instructions. Remove frame hanger.

**ASSEMBLY**

1. If installing a new frame hanger continue to Step 2. If installing or servicing shear springs or saddle assembly, proceed to Step 3.

**CAUTION**

EACH FRAME HANGER ASSEMBLY WEIGHS APPROXIMATELY 165-252 POUNDS (75-114 KILOGRAMS), USE APPROPRIATE LIFTING DEVICES TO REMOVE OR INSTALL THE FRAME HANGER ASSEMBLY. FAILURE TO DO SO CAN RESULT IN DAMAGE TO THE VEHICLE OR PERSONAL INJURY.

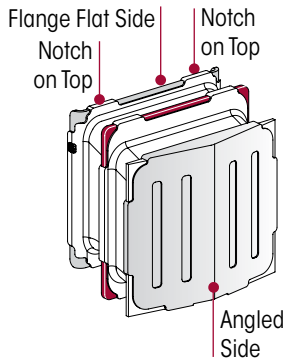
2. Position the frame hanger assembly against the frame rail. Install fastener's per the vehicle manufacturer's instructions and specifications.

**SERVICE HINT** During assembly, it may be necessary to use tape to hold the shear springs in position. After installation is complete remove tape.

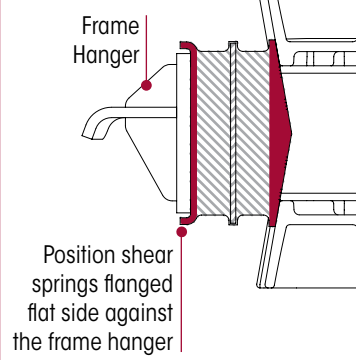
3. Position the shear springs with the flanged flat side against the frame hanger with the shear spring angled downward, see Figure 8-7.

**FIGURE 8-7**  
**ULTIMAAX 52K Shown**

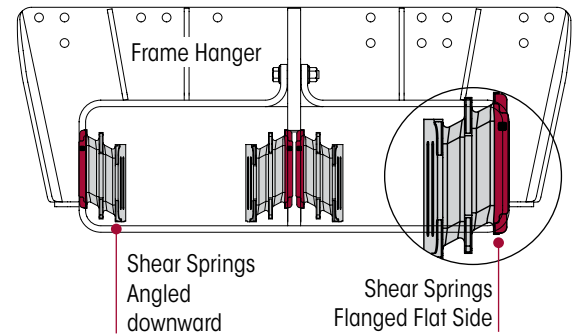
**SHEAR SPRING**



**TOP VIEW**



**SIDE VIEW**



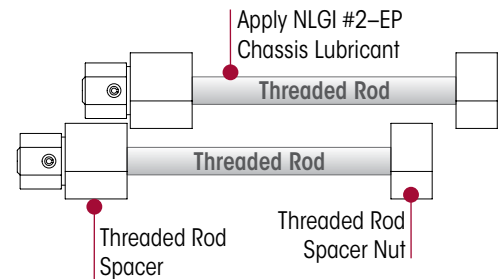
4. Apply NLGI #2-EP (Extreme Pressure) chassis lubricant to the threaded rod of the Saddle Assembly Tool Part No. 66086-108L, see Figure 8-8.

**NOTE**

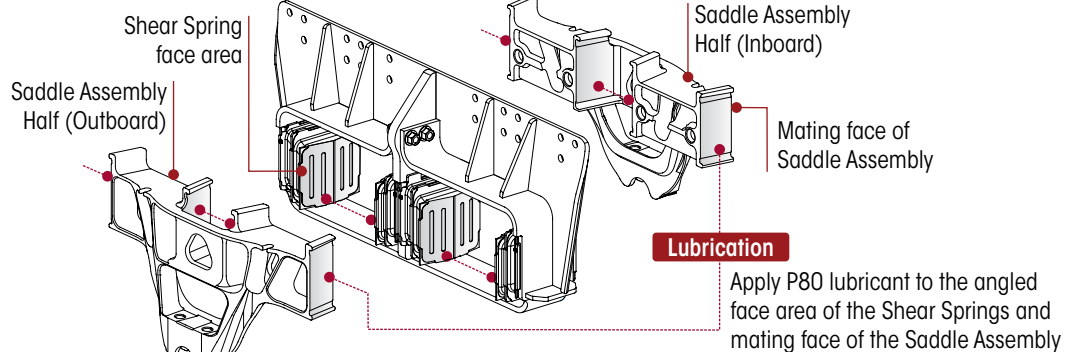
The threaded rod spacer and spacer nut are designed and orientated to fit into the saddle assembly openings.

5. Apply P-80 lubricant to the shear spring's angled face and to the mating face of the saddle halves, see Figure 8-9.

**FIGURE 8-8**  
**Saddle Assembly Tool**  
**Hendrickson Part No. 66086-108L**



**FIGURE 8-9**  
**ULTIMAAX 52K Shown**



6. On each side of the saddle assemblies, rotate the threaded rod spacers and spacer nuts of the saddle assembly tool until each are oriented properly into the saddle assembly openings, see Figure 8-10.

**SERVICE HINT**

Use a mechanism to attach to the frame to aid in holding the saddle up while performing procedure (such as a strap or rope) attached to each saddle half and the frame or the vehicle body to secure the saddle halves during installation or have an additional person assist to align the saddle halves properly.

7. Position the inner saddle half into the frame hanger along with the shear springs, outer saddle half, see Figure 8-11.
8. Bring both saddle halves together with the Saddle Assembly Tool. Evenly tightening the Saddle Assembly Tool until both saddle halves are seated against each other.

FIGURE 8-10

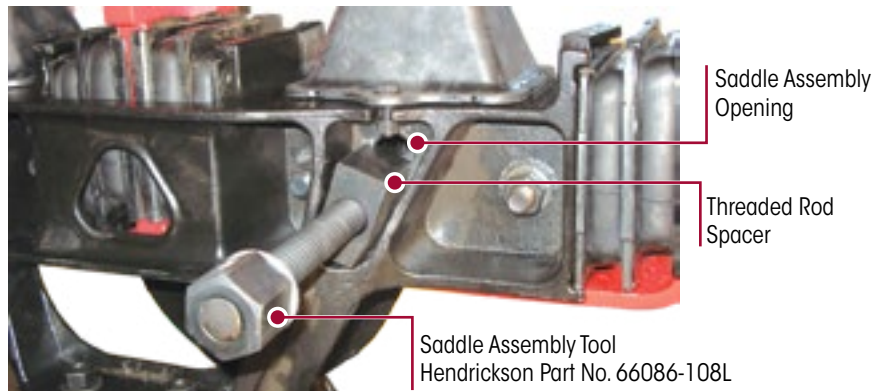
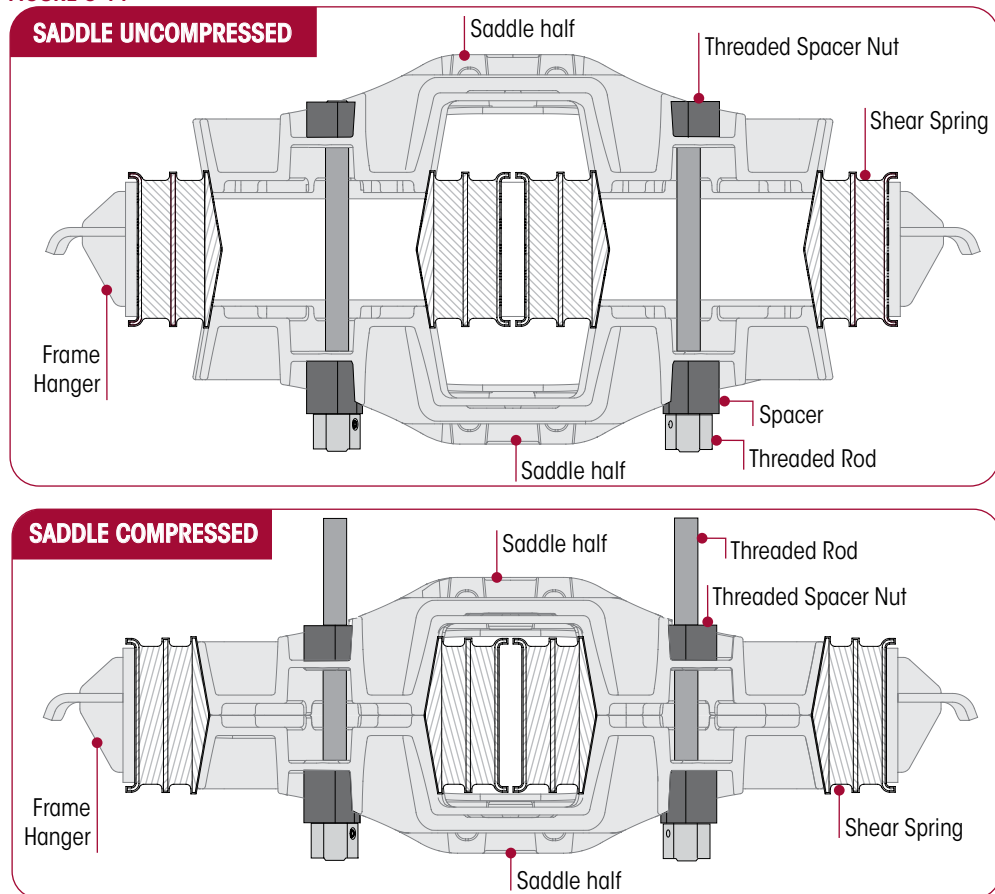
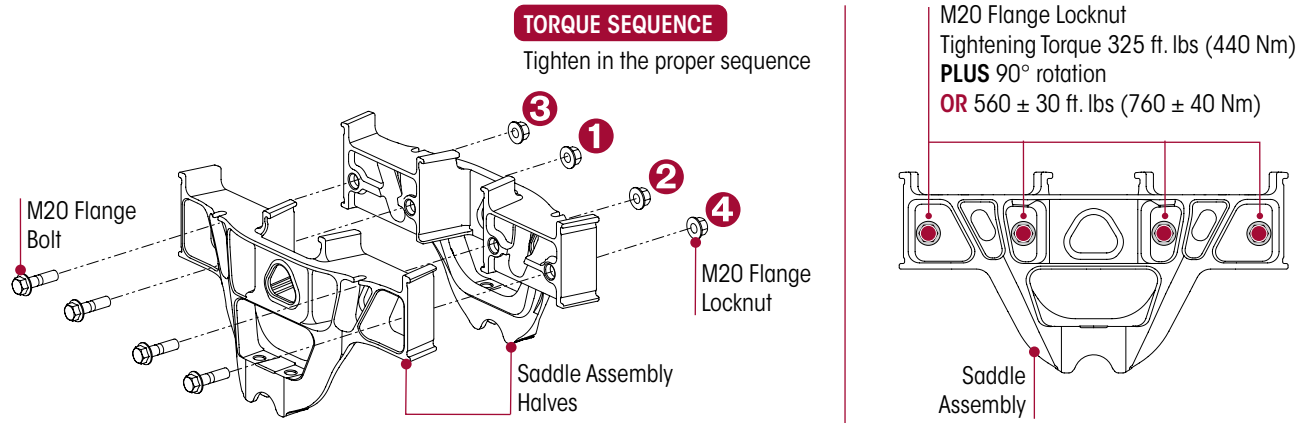
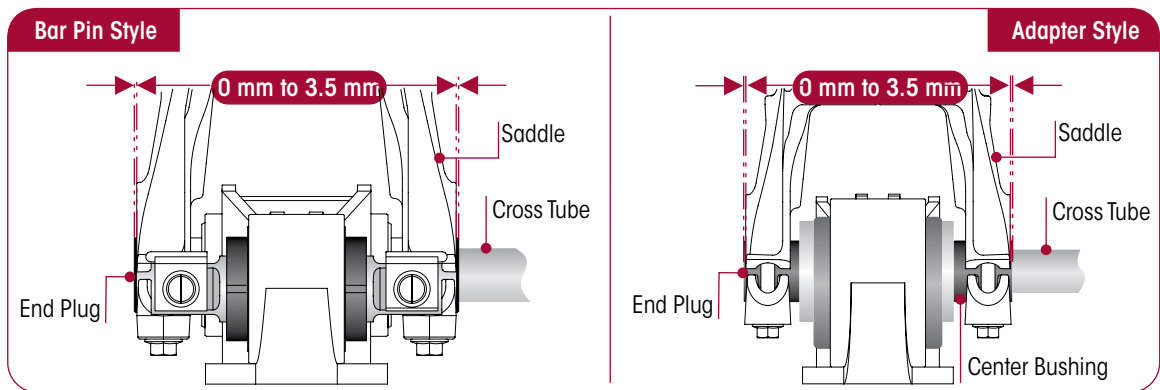


FIGURE 8-11



9. Install the new M20 saddle fasteners. Tighten in the proper sequence shown in Figure 8-12 to 325 foot pounds plus a 90° rotation, or 560 ± 30 foot pounds torque.
10. Remove temporary tape from the shear springs if used during assembly.
11. Remove the Saddle Assembly Tool.
12. Install the progressive load springs.
13. Install the progressive load spring M10 fasteners. Tighten to 30 ± 2 foot pounds torque.
14. Remove the frame supports.
15. Lower the frame of the vehicle while engaging and centering the saddles on the equalizing beam's center bushings, see Figure 8-13.

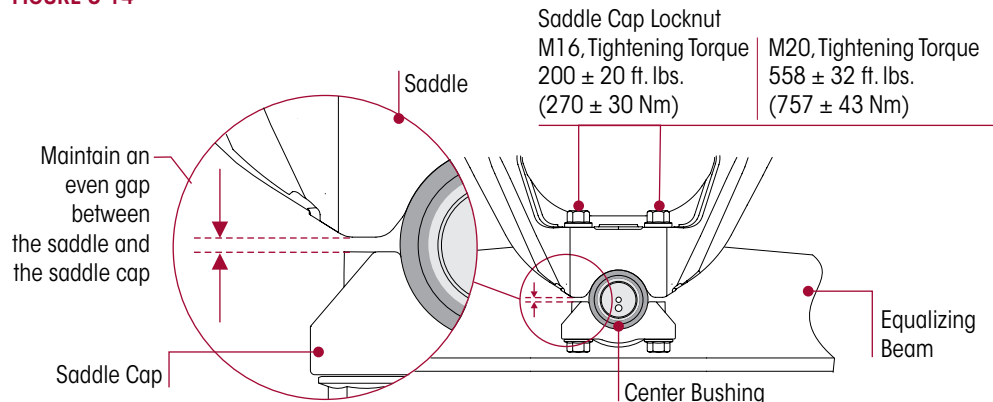
**FIGURE 8-12**

**FIGURE 8-13**

**CAUTION**

A SADDLE ASSEMBLY IS ATTACHED TO THE CENTER BUSHING OF EACH EQUALIZING BEAM WITH TWO (2) SADDLE CAPS. EACH SADDLE CAP USES TWO (2) BOLTS TO CLAMP THE CENTER BUSHING INNER METAL TO THE SADDLE. EACH SADDLE CAP MUST BE INSTALLED SO THAT THERE IS AN EVEN GAP BETWEEN THE SADDLE CAP AND THE BASE OF THE SADDLE LEGS AS SHOWN IN FIGURE 8-14. IF EACH SADDLE CAP IS NOT INSTALLED EVENLY, THE SADDLE LEGS COULD BECOME DEFORMED, RESULTING IN BENT BOLTS OR DAMAGED SADDLES.

**NOTE**

Tightening the saddle cap fasteners properly will help prevent wear of mating components, such as the beam center bushing, saddle, and saddle cap.

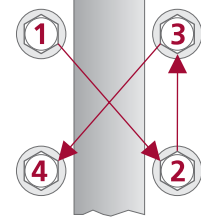
16. While tightening the saddle cap fasteners, maintain an even gap between the saddle and saddle cap, see Figure 8-14.

**FIGURE 8-14**


17. Install the saddle cap fasteners and tighten evenly in several steps in proper sequence to achieve uniform bolt tension, see Figure 8-15:

- **46K • 52K Capacity** –  $200 \pm 20$  foot pounds torque
- **60K • 70K Capacity** –  $558 \pm 32$  foot pounds torque

FIGURE 8-15



18. Install the tires.

19. Remove supports from the axles and lower the vehicle onto the ground.

20. Remove the wheel chocks.

## PROGRESSIVE LOAD SPRING (PLS)

### NOTE

The Hendrickson ULTIMAAX suspension progressive load springs must be replaced in pairs (left side pairs or right side pairs or rear position pairs or front position pairs), even if only one PLS shows unacceptable conditions. Replacement of only one PLS can cause uneven wear, and higher premature wear for the one replaced.

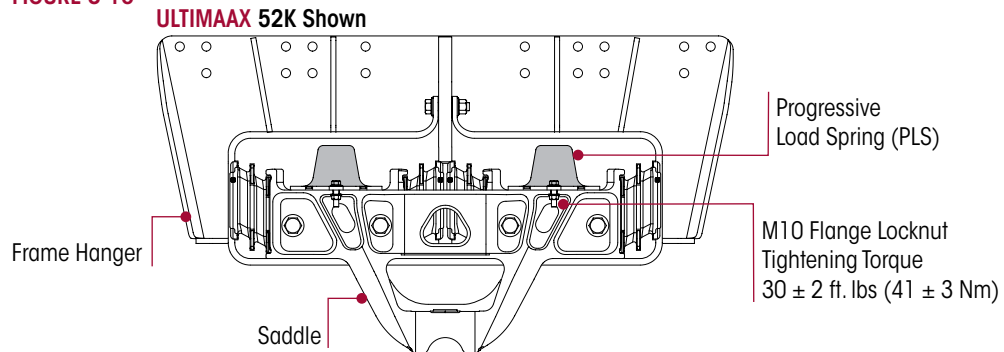
### DISASSEMBLY

1. Chock the front wheels of the vehicle.
2. Raise the vehicle's frame until the saddle assembly contacts the bottom of the frame hanger assembly. Support the vehicle's frame at this height with safety stands.
3. Remove and discard the M10 fasteners that attach the progressive load springs to the saddle assembly.
4. Remove the progressive load springs from the frame hanger assembly.

### ASSEMBLY

1. Install the progressive load springs into the frame hanger assembly.
2. Install four M10 flange bolts that attach the PLS to the saddle assembly. The flange bolts **must** be installed with the locknuts facing downward as shown in Figure 8-16.
3. Tighten the PLS fasteners to  $30 \pm 2$  foot pounds torque.
4. Remove the frame safety stands and lower the vehicle.
5. Remove the wheel chocks.

FIGURE 8-16



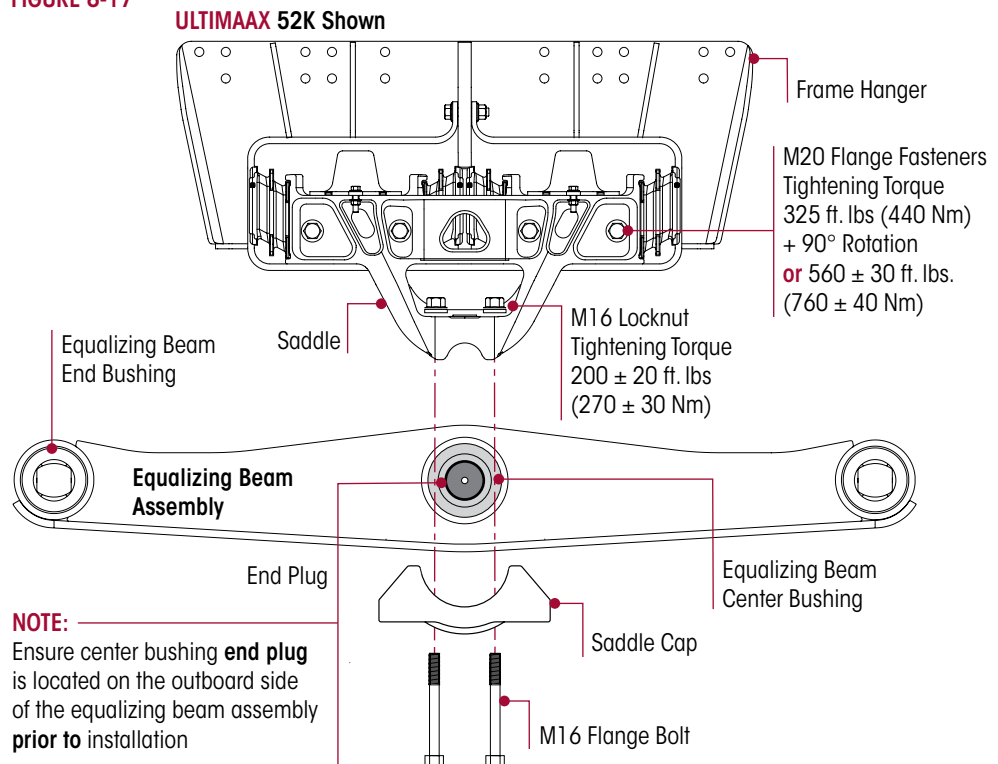


## EQUALIZING BEAM

### DISASSEMBLY

1. Chock the wheels of the steer axle.
2. Raise and support the drive axles with safety stands.
3. Remove the tires.
4. Support the pinion angle of the drive axles to prevent axle movement during service.
5. Remove the saddle cap bolts from both inboard and outboard side of each equalizing beam.
6. Remove the saddle caps, see Figure 8-17.

**FIGURE 8-17**



7. Raise the vehicle's frame just enough to create a ½" (13 mm) gap between the saddles and the center bushings. Support the vehicle's frame at this height with safety stands.

### **WARNING**

THE WEIGHT OF THE EQUALIZING BEAM ASSEMBLY IS APPROXIMATELY 290 TO 315 POUNDS (131 TO 141 KILOGRAMS). PRIOR TO REMOVING THE END BUSHING BOLTS FROM THE EQUALIZING BEAM, SUPPORT THE END OF THE EQUALIZING BEAM TO PREVENT IT FROM DROPPING. CARE SHOULD BE TAKEN AT REMOVAL AND INSTALLATION TO PREVENT PERSONAL INJURY OR DAMAGE TO COMPONENTS.

8. Support both equalizing beams under the center bushing with floor jacks.
9. **Adapter Style End Bushing** – Proceed to Step 11.

### NOTE

Prior to disassembly of the equalizing beam bar pin fasteners, note the orientation of the bar pin alignment shims, see Figure 8-18. It is required that the bar pin alignment shims are installed in the same orientation and location as removed to preserve the existing vehicle alignment. Improper vehicle alignment can increase tire wear.

10. **Bar Pin Style End Bushing** – Note the orientation and location of the bar pin shims, see Figure 8-18.
11. Remove and discard end bushing fasteners.

### SERVICE HINT

The center bushing will allow the cross tube and the equalizing beam to angle downward once the equalizing beam end fasteners are removed.



12. Slowly lower the floor jacks and remove the equalizing beams from the axle brackets.

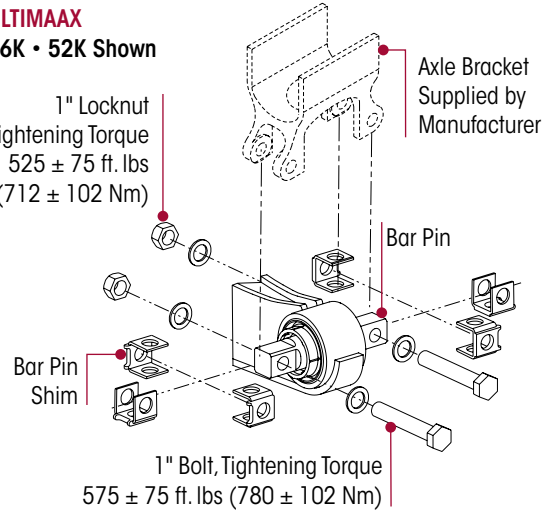
**WARNING**

PRIOR TO REMOVING BOTH EQUALIZING BEAMS, SUPPORT THE PINION OF EACH DRIVE AXLE. FAILURE TO DO SO CAN RESULT IN PERSONAL INJURY OR ALLOW THE AXLES TO SHIFT MAKING REASSEMBLY MORE DIFFICULT.

13. Slide the equalizing beams off the cross tube and out from under the vehicle.
14. Remove the floor jacks from under the equalizing beams.

**FIGURE 8-18**  
**ULTIMAAX**  
**46K • 52K Shown**

1" Locknut  
Tightening Torque  
525 ± 75 ft. lbs  
(712 ± 102 Nm)



**ASSEMBLY**

1. Position the equalizing beams under the axles with floor jacks.

**SERVICE HINT**

Ensure the equalizing beam's center bushing end plug is located on the outboard side of the equalizing beam, see Figure 8-17.

2. Install the cross tube into the center bushings of both equalizing beams.

**SERVICE HINT**

Increasing or decreasing the pinion angle may help align the axle bracket and the equalizing beam end bushings.

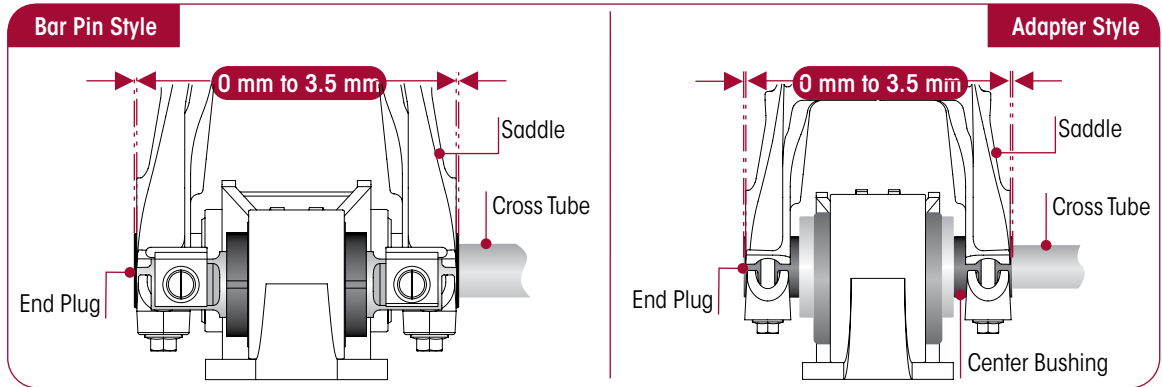
**WARNING**

THE WEIGHT OF THE EQUALIZING BEAM ASSEMBLY IS APPROXIMATELY 290 TO 315 POUNDS (131 TO 141 KILOGRAMS). CARE SHOULD BE TAKEN AT REMOVAL AND INSTALLATION TO PREVENT PERSONAL INJURY OR DAMAGE TO COMPONENTS.

3. Using the floor jacks, slowly raise both equalizing beams and cross tube as an assembly into the axle brackets. Ensure each equalizing beam end bushing correctly engages its respective axle bracket.
4. **Adapter Style End Bushing 60K • 70K** – Proceed to Step 6.
5. **Bar Pin Style End Bushing 46K • 52K**– Install bar pin shims in the same orientation and location as noted prior to disassembly, see Figure 8-18.
6. Install new equalizing beam end fasteners into both beams. Tighten the equalizing beam end fasteners to:
  - **Adapter Style End Bushing** – 125 + 90° rotation or 700 ± 50 foot pounds torque.
  - **Bar Pin Style End Bushing** –
    - at the **locknuts** 525 ± 75 foot pounds or
    - at the **bolt head** 575 ± 75 foot pounds torque
7. Remove the frame supports.
8. Lower the frame of the vehicle while engaging and centering the saddles on the equalizing beam's center bushings, see Figure 8-19.



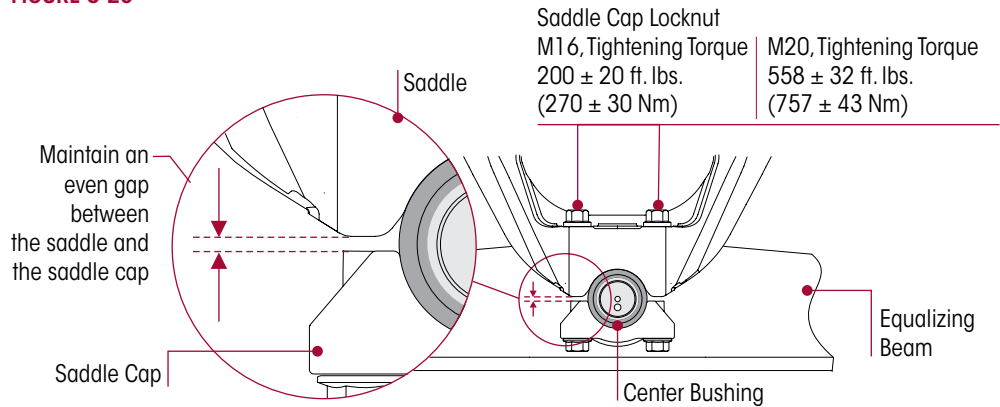
FIGURE 8-19



**CAUTION**

A SADDLE ASSEMBLY IS ATTACHED TO THE CENTER BUSHING OF EACH EQUALIZING BEAM WITH TWO (2) SADDLE CAPS. EACH SADDLE CAP USES TWO (2) BOLTS TO CLAMP THE CENTER BUSHING INNER METAL TO THE SADDLE. EACH SADDLE CAP MUST BE INSTALLED SO THAT THERE IS AN EVEN GAP BETWEEN THE SADDLE CAP AND THE BASE OF THE SADDLE LEGS AS SHOWN IN FIGURE 8-20. IF EACH SADDLE CAP IS NOT INSTALLED EVENLY, THE SADDLE LEGS COULD BECOME DEFORMED, RESULTING IN BENT BOLTS OR DAMAGED SADDLES.

FIGURE 8-20

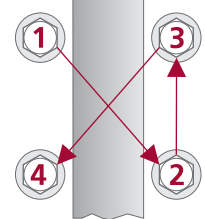


**NOTE**

Tightening the saddle cap fasteners properly will help prevent wear of mating components, such as the beam center bushing, saddle, and saddle cap.

9. While tightening the saddle cap fasteners at the bolt head, maintain an even gap between the saddle and saddle cap, see Figure 8-20.
10. Install the saddle cap fasteners and tighten evenly in several steps and proper sequence to achieve uniform bolt tension, see Figure 8-21:
  - **46K • 52K Capacity** – 200 ± 20 foot pounds torque
  - **60K • 70K Capacity** – 558 ± 32 foot pounds torque
11. Install the tires.
12. Remove supports from the axles and lower the vehicle onto the ground.
13. Remove the wheel chocks.

FIGURE 8-21



## EQUALIZING BEAM CENTER BUSHING

### You will need

- Vertical shop press with a capacity of at least 100 Tons (90 metric tones).
- Center bushing tools – Receiving Tool Part No. 66086-112, Installation Tool Part No. 66086-107 and Removal Tool Part No. 66086-110, see Special Tools Section of this publication.

FIGURE 8-22

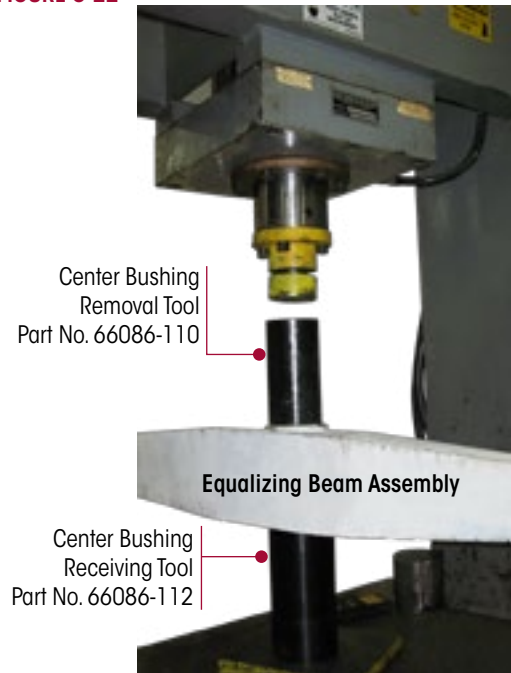
### DISASSEMBLY

1. Remove the equalizing beam assembly from the vehicle. Follow the equalizing beam disassembly procedure in this section.

### WARNING

DO NOT USE A CUTTING TORCH TO REMOVE ANY FASTENERS OR BUSHINGS. THE USE OF HEAT ON SUSPENSION COMPONENTS WILL ADVERSELY AFFECT THE STRENGTH OF THESE PARTS. A COMPONENT DAMAGED IN THIS MANNER CAN RESULT IN THE ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE.

2. Place the equalizing beam assembly in a shop press with the center hub firmly supported on the receiving tool or on the press, see Figure 8-22.
3. Install the center bushing removal tool, ensure it is centered on the center bushing.
4. Push directly on center bushing removal tool until the center bushing is pressed out of the equalizing beam bore, see Figure 8-22.
5. Inspect the beam bore.



### INSPECTION

After removing the center bushing, thoroughly inspect the beam bore. If damaged, replace with a new equalizing beam. **DO NOT** attempt to re-bush or use an equalizing beam that has been damaged.

### WARNING

FAILURE TO REPLACE AN EQUALIZING BEAM THAT HAS BEEN DAMAGED FROM BUSHING REMOVAL CAN RESULT IN THE FAILURE OF THAT BEAM, LEADING TO ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE.

When installing new center bushings the following steps will minimize the chance of damaging a new bushing:

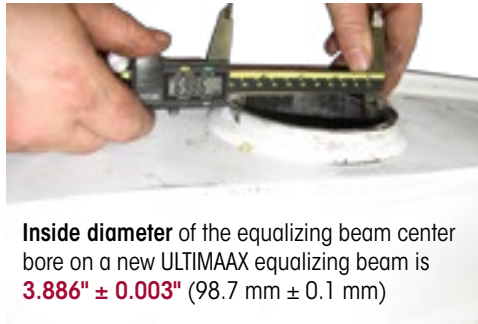
1. Clean the bore of the equalizing beam with emery cloth or ball hone, removing any nicks or metal buildup from bushing removal.
2. Measure the inside diameter of the equalizing beam center bore. The specification for the **inside diameter** of the equalizing beam center bore on a new ULTIMAAX equalizing beam is  $3.886" \pm 0.003"$  ( $98.7 \text{ mm} \pm 0.1 \text{ mm}$ ), calculate the mean of any two measurements  $90^\circ$  apart in the same plane, see Figure 8-23. If the mean is **NOT** within the specified range, replacement of the equalizing beam is required.

### NOTE

Always use the bushing outer metal for pressing operations. Pressing on the bushings inner metal may damage the bushing and require bushing replacement.

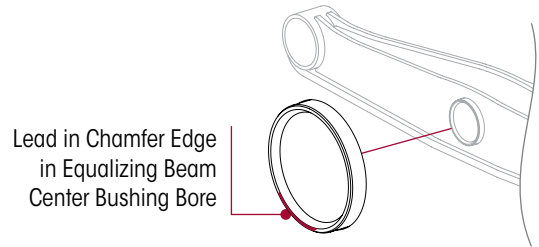


FIGURE 8-23



Inside diameter of the equalizing beam center bore on a new ULTIMAAX equalizing beam is **3.886" ± 0.003"** (98.7 mm ± 0.1 mm)

FIGURE 8-24



Lead in Chamfer Edge in Equalizing Beam Center Bushing Bore

FIGURE 8-25



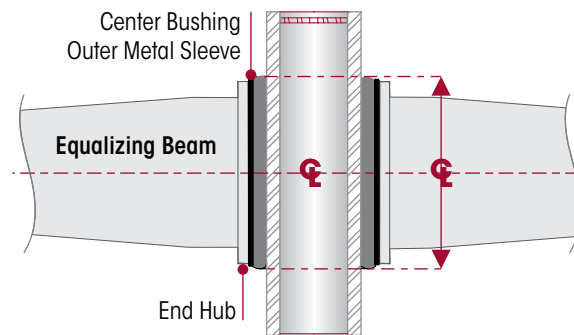
**ASSEMBLY**

1. The equalizing beam bore may have a more substantial lead in chamfer at one end of the bore than the other, see Figure 8-24. Take advantage of the larger chamfer by pressing in the new bushing from this end.
2. Place the equalizing beam in a shop press on the receiving tool or press. Support the beam squarely at the center bore area to avoid distortion of the beam bore or bending of the beam.
3. Lubricate the equalizing beam bore and the equalizing beam center bushing outer metal sleeve with an NLGI#2 – EP (Extreme Pressure) grease, see Figure 8-25.

**NOTE**

The center bushing must be square with the equalizing beam hub before pressing the center bushing into the beam. Center bushings pressed in at an angle will damage the center bushing and the equalizing beam, see Figure 8-26.

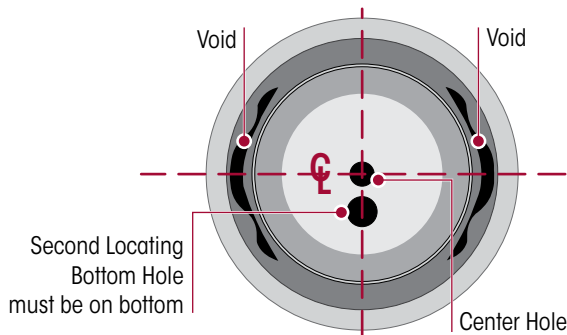
FIGURE 8-26



Press the center bushing until the center bushing **outer metal sleeve** is centered in the equalizing **beam end hub**.

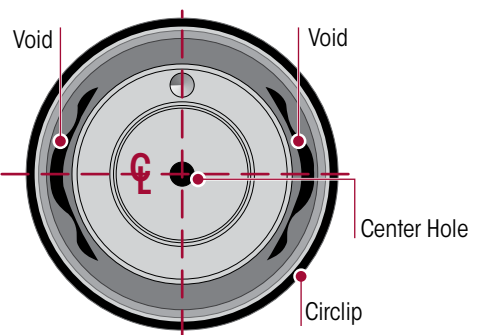
FIGURE 8-27

**CENTER BUSHING Two Hole Design**  
ULTIMAAX 46K • 52K • 60K



**CENTER BUSHING Circlip Design**  
ULTIMAAX 70K

Horizontal Centerline  
Verify the voids are perpendicular to the horizontal centerline



**CAUTION**

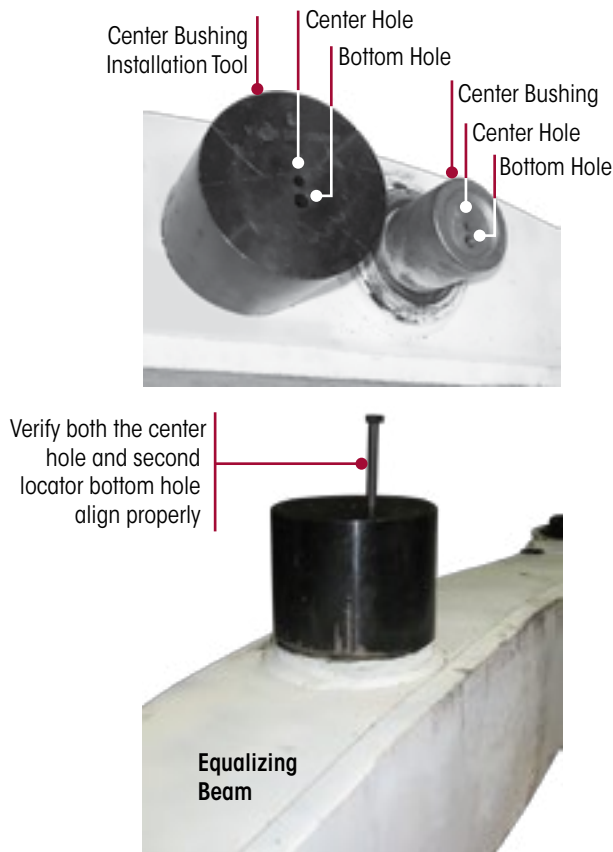
ALWAYS USE THE CENTER BUSHING OUTER METAL FOR PRESSING OPERATIONS. PRESSING ON THE CENTER BUSHING'S INNER METAL WILL CAUSE DAMAGE TO THE CENTER BUSHING AND REQUIRE CENTER BUSHING REPLACEMENT.

**NOTE**

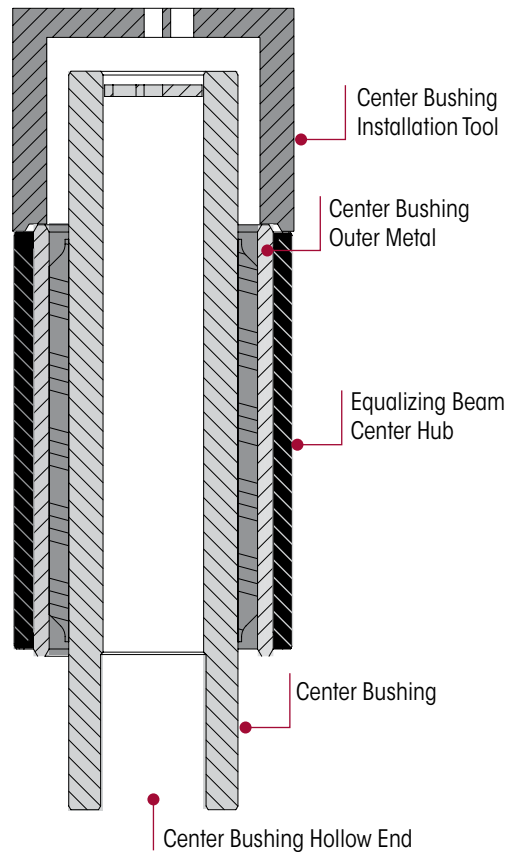
The ULTIMAAX center bushing has voids that must be positioned horizontally front and back, see Figure 8-27.

4. Install the center bushing installation tool, Part no. 66086-107, making sure the voids are positioned horizontally front and back and press in the new center bushing until the outer metal sleeve is centered in the equalizing beam bore, see Figures 8-26 through 8-29.
5. Wipe off excess grease from around the installed center bushing.
6. Install the equalizing beam assembly to the vehicle. Follow the equalizing beam installation procedure in this section.

**FIGURE 8-28**



**FIGURE 8-29**



## BAR PIN STYLE END BUSHINGS – ULTIMAAX 46K•52K

### You will need:

- A shop press with a capacity of at least 100 tons
- End bushing service kit, refer to the Parts List Section of this publication.
- End bushing tools – Receiving Tool Part No. 66086-111, Installation Tool Part No. 66086-106 and Removal Tool Part No. 66086-109, see Special Tools Section of this publication.

### DISASSEMBLY

#### WARNING

WHEN REMOVING AND INSTALLING BUSHINGS IN THE EQUALIZING BEAMS, FOLLOW THE PROCEDURES OUTLINED IN THIS PUBLICATION. DO NOT USE A CUTTING TORCH TO REMOVE THE BUSHING OUTER METALS PRESSED IN THE BEAM BORES OR FASTENERS. WELDING, TORCHING OR ATTACHING MATERIAL TO THE EQUALIZING BEAM MUST NEVER BE PERFORMED. THE USE OF HEAT CAN ADVERSELY AFFECT THE STRENGTH OF THE EQUALIZING BEAMS AND CAN CAUSE DAMAGE TO THE EQUALIZING BEAM ASSEMBLY, ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE.

#### WARNING

DISCARD USED FASTENERS. ALWAYS USE NEW FASTENERS TO COMPLETE A REPAIR. FAILURE TO DO SO COULD RESULT IN FAILURE OF THE PART OR MATING PARTS, ADVERSE VEHICLE HANDLING, PERSONAL INJURY, OR PROPERTY DAMAGE.

#### NOTE

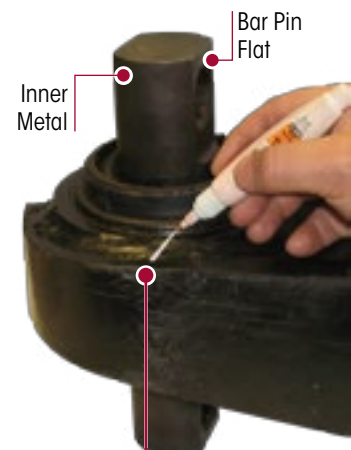
Hendrickson recommends the use of Grade 8 bolts, hardened washers, and Class C locknuts. Hardened washers are not necessary when flange head fasteners are used.

#### NOTE

Whenever an equalizing beam is removed for repair or inspection of the equalizing beam end connection reveals movement, measure the distance between the axle bracket legs for correct width. Refer to Axle Bracket in Preventive Maintenance Section of this publication for measurement location and dimensions. An axle bracket outside of the measurement range must be repaired or replaced. Consult the vehicle manufacturer for inspection, component repair and replacement instructions.

1. Remove equalizing beam assembly from vehicle as detailed in the equalizing beam disassembly instructions in this section.
2. Place the equalizing beam in the shop press with the beam end hub squarely supported on the receiving tool (Part No. 66086-111) or press bed.
3. Prior to removal, mark the orientation of the bar pin flats on the equalizing beam with a paint stick, see Figure 8-30.
4. Support the beam end hub with it centered on the receiving tool. Be sure the equalizing beam is squarely supported on the press bed for safety.
5. Press on the end bushing inner metal, see Figure 8-30, of the end bushing until the inner metal is flush with the top of the equalizing beam end hub. This will move the bushing rubber away from the outer metal of the bushing so the removal tool (Part No. 66086-109) can be installed.
6. Center the bushing removal tool directly on the bushing's outer metal and press the bushing out of the equalizing beam end hub.

**FIGURE 8-30**



Mark the location of the bar pin flats with a paint stick on the equalizing beam end hub



**INSPECTION**

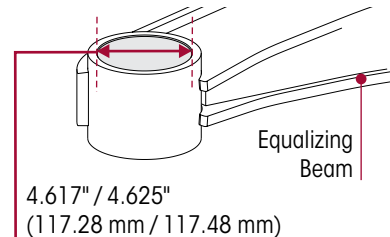
After removing the bar pin end bushings, thoroughly inspect the beam bores. If the equalizing beam is damaged from end bushing removal, replacement of the equalizing beam is required, replace with a new equalizing beam. **DO NOT** attempt re-bush or use an equalizing beam that has been damaged.

**WARNING**

FAILURE TO REPLACE AN EQUALIZING BEAM THAT HAS BEEN DAMAGED FROM BUSHING REMOVAL CAN RESULT IN THE FAILURE OF THAT BEAM, ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE.

1. Clean the bores of the equalizing beams with emery cloth or ball hone, removing any nicks or metal buildup from bushing removal.
2. Measure the equalizing beam end hub bore inner diameter. The Hendrickson specification for the equalizing beam end hub bore diameter is 4.621" ± 0.004" (117.38 mm ± 0.10 mm), and is taken as the mean of any two readings 90° apart in the same plane, see Figure 8-31. If it is **NOT** within the specified range, replacement is required.

**FIGURE 8-31**  
Equalizing Beam  
End Hub Bore Diameter



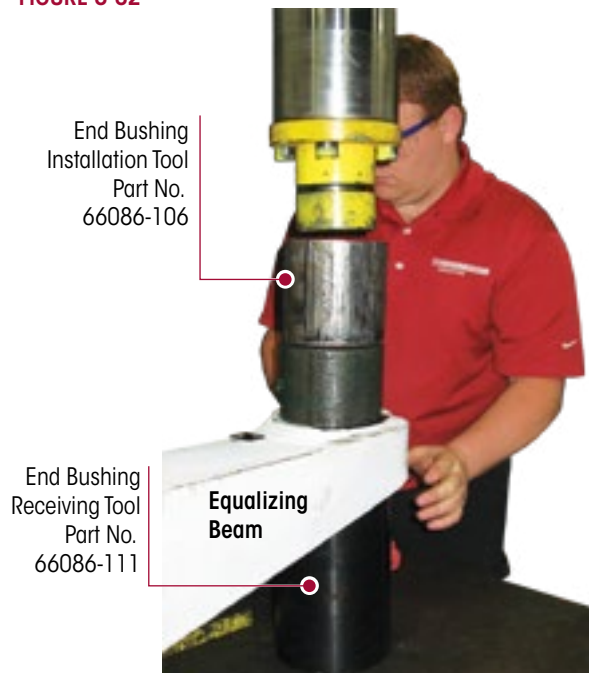
**ASSEMBLY**

**NOTE**

Always use the bushing outer metal for pressing operations. Pressing on the bushings inner metal may damage the bushing and require bushing replacement.

1. The equalizing beam bore may have a more substantial lead in chamfer at one end of the bore than the other. Take advantage of the larger chamfer by pressing in the new end bushing from this end.
2. Lubricate the equalizing beam end hub inside bore and the bar pin end bushing outer sleeve with a NLGI #2 – EP (Extreme Pressure) grease.
3. Place the equalizing beam in a shop press with the end hub, squarely supported on the receiving tool, see Figure 8-32.
4. Position and align the end bushing to the mark made before removal as shown in Figure 8-30.

**FIGURE 8-32**



**NOTE**

The end bushing must be square with the equalizing beam end hub before pressing the end bushing into the beam. End bushings pressed in at an angle will damage the end bushing and the equalizing beam.

**CAUTION**

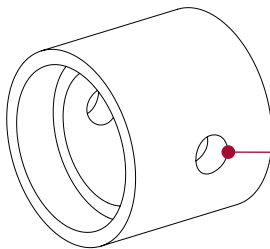
CARE MUST BE TAKEN DURING THE INSTALLATION OF THE BUSHING. DO NOT PUSH ON THE INNER METAL OF THE BUSHING, DOING SO WILL CAUSE DAMAGE TO THE BUSHING AND VOID WARRANTY.

**NOTE**

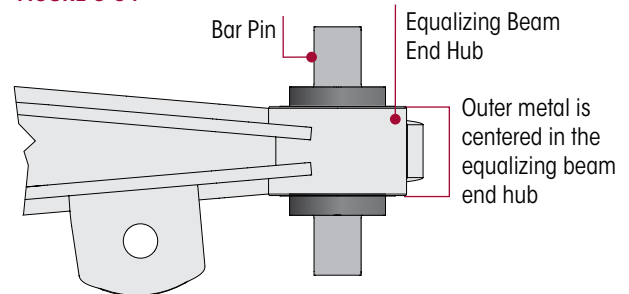
Always use the bushing outer metal for pressing operations. Pressing on the bushings inner metal may damage the bushing and require bushing replacement.



5. Place the end bushing installation tool on the end hub.
6. The through hole in the tool can help align the bar pin flats due to lack of visibility. Place a bolt with enough length to go through the tool and the bar pin hole, see Figure 8-33.
7. With the tools align, press in the end bushing, see Figure 8-32.
8. The end bushing must be centered within the hub of the equalizing beam, see Figure 8-34.
9. Install the equalizing beam assembly into vehicle as detailed in equalizing beam assembly in this section.

**FIGURE 8-33**

**66086-106  
End Bushing Installation Tool**

Through hole can be used to help align the bar pin flats due to lack of visibility. Place a bolt through the tool and bar pin hole.

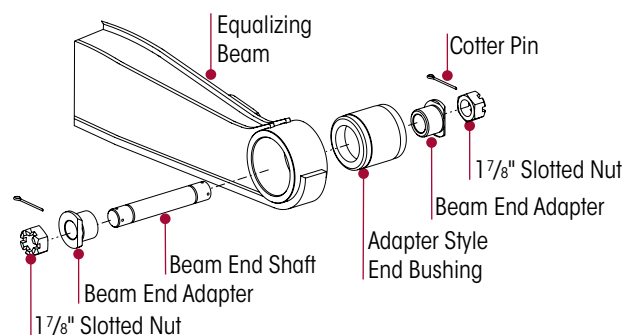
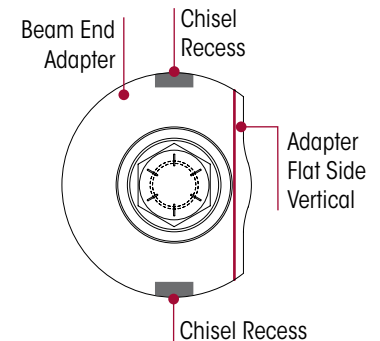
**FIGURE 8-34**

**ADAPTER STYLE END BUSHING – ULTIMAAX 60K•70K**
**FIGURE 8-35**
**You will need:**

- A shop press with a capacity of at least 100 tons
- Air hammer / chisel / Bent chisel, see Figure 8-35
- Hendrickson Part No. 66086-101 (OTC Part No. 1763), see Special Tools Section of this publication


**DISASSEMBLY**
**NOTE**

It is recommended that a penetrating oil be applied to all beam end connections.

1. Remove the cotter pins, slotted nuts and end bushing adapter tube, see Figure 8-36.
2. The beam end adapters have two chisel recesses located in their flanges as shown in Figure 8-37.
3. Locate the recess for the chisel, rotate the adapter if necessary. Place the air hammer/chisel in the recess.
4. If the adapter does not turn, use a hammer to rap the outside of the axle bracket legs around the adapter area and repeat with the air hammer chisel.

**FIGURE 8-36  
ULTIMAAX 60K • 70K Shown**

**FIGURE 8-37**


5. Support the end of the equalizing beam as it may drop when the other adapter is removed.
6. Remove remaining adapters.
7. When the adapter has enough clearance between the axle bracket and the adapter flange, use a bent chisel as shown in Figure 8-35 to wedge and force the adapter out.

**WARNING**

THE ADAPTER REMOVAL PROCESS CAN CAUSE DAMAGE. REUSE OF DAMAGED OR WORN ADAPTERS COULD RESULT IN A COMPONENT FAILURE LEADING TO ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY.

**NOTE**

Due to the process necessary to remove the adapters, the adapter can be subjected to damage. **DO NOT** reuse worn or damaged adapters. Replace as necessary.

8. Remove the equalizing beam assembly from vehicle as detailed in the Equalizing Beam Disassembly instructions in this section.
9. Position the equalizing beam in the shop press and align the End Bushing Removal / Replacement Adapter with the tapered end facing the bushing to be removed, see Figure 8-38.

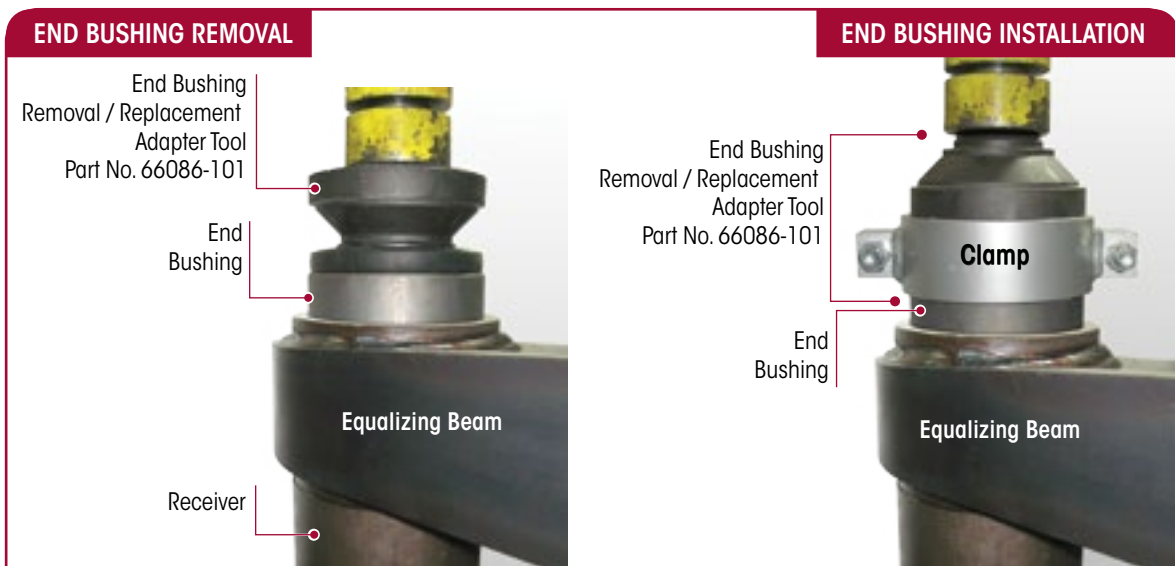
**WARNING**

CHECK TO INSURE PROPER ALIGNMENT OF TOOLING ADAPTERS WITH EQUALIZING BEAM COMPONENTS BEFORE APPLYING FULL HYDRAULIC PRESSURE WITH A SHOP PRESS.

10. Apply hydraulic force and push out the old bushing.

FIGURE 8-38

FIGURE 8-39

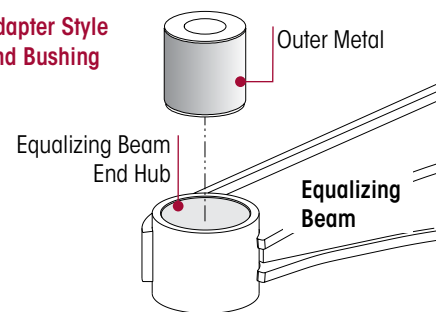


**ASSEMBLY**

1. Clean the end bushing bore with a cylinder ball hone or emery paper. Clean any debris.
2. Lubricate the equalizing beam bore and the equalizing beam center bushing outer metal sleeve with an NLGI#2 – EP (Extreme Pressure) grease, see Figure 8-40.
3. Position the end bushing removal / replacement adapter, with the tapered end facing away from the new bushing, onto the clamp, see Figure 8-39.
4. Wrench tighten the clamp onto the bushing and the adapter as shown in Figure 8-39.

FIGURE 8-40

**Adapter Style End Bushing**



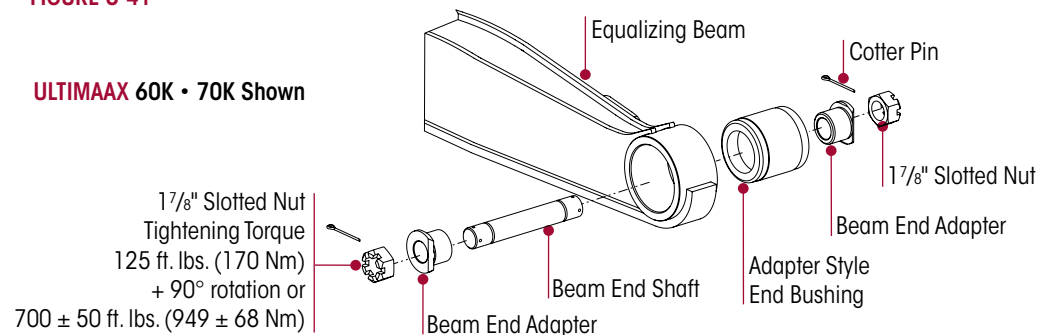
**NOTE**

Lubricate the inside diameter of **END HUB** and the end bushing **OUTER METAL** with NLGI#2-EP (Extreme Pressure) lithium base grease

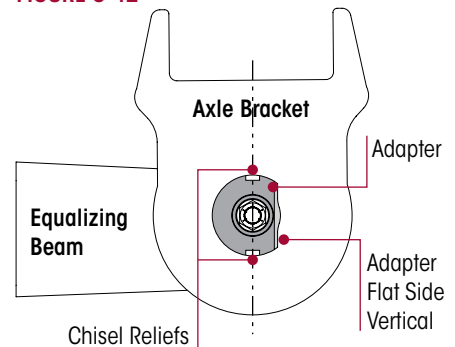
**WARNING**

ENSURE PROPER ALIGNMENT OF TOOLING ADAPTERS WITH EQUALIZING BEAM COMPONENTS BEFORE APPLYING FULL HYDRAULIC PRESSURE WITH A SHOP PRESS.

5. Apply hydraulic force and press the new bushing into place. The bushing will be completely seated when the clamp makes contact with the beam face.
6. Install one adapter through the axle bracket leg at the wheel side, into the beam end bushing, see Figure 8-41.
7. Install the other adapter through the axle bracket leg at the axle side, taking advantage of the cut-off flange on the adapter to clear the axle.

**FIGURE 8-41**


8. Insert adapter connections, see Figure 8-42.
9. Rotate the adapters so the adapter cut off flats are vertical as shown in Figure 8-42.

**FIGURE 8-42**

**NOTE**

Axes must be in operational position before fasteners are tightened to prevent pre-loading of the rubber bushing.

10. Assemble one slotted nut to the shaft and install the cotter pin. Place a suitable wrench on the nut and ensure the wrench is locked in place (braced) to prevent movement. Tighten using one of the following torque procedure.

**TORQUE PROCEDURE**
**WARNING**

IF THE RECOMMENDED TORQUE VALUE IS NOT PROPERLY MAINTAINED, THE METAL SURFACES OF THE AXLE BRACKET LEGS, HOLES, ADAPTERS AND RUBBER BUSHING INNER METALS CAN EXPERIENCE EXCESSIVE WEAR AND/OR FAILURE. THIS CAN CAUSE SEPARATION OF COMPONENTS AND ADVERSE VEHICLE HANDLING, PROPERTY DAMAGE OR PERSONAL INJURY.

A simple torque wrench will not be sufficient to obtain the proper torque requirement. The proper torque requirement can be obtained with the use of a torque multiplier. If one is not available the use of a slug wrench is recommended.

**METHOD A: TORQUE MULTIPLIER**
**You will need:**

- Torque Multiplier
  - a. Assemble the opposite nut and use a torque wrench with multiplier.
  - b. Tighten the nut to torque multiplier value 700 ± 50 Foot Pounds torque, see Table 1.

**CAUTION**

DO NOT BACK OFF NUT TO INSTALL COTTER PIN, DOING SO MAY REDUCE THE TIGHTENING TORQUE BELOW THE REQUIRED SPECIFICATION.

- c. Install cotter pin. The nut may be advanced to the next nut slot. **DO NOT** back off nut.

**METHOD B: SLUG WRENCH**

**You will need:**

- Two slug wrenches (see Figure 8-43), 4 pound hammer
  - a. Assemble the opposite nut and using a torque wrench, tighten the nut to the initial torque value shown in Table 1.

FIGURE 8-43

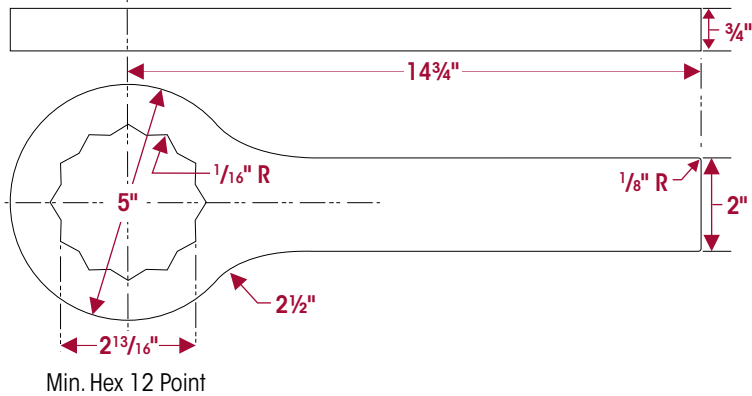
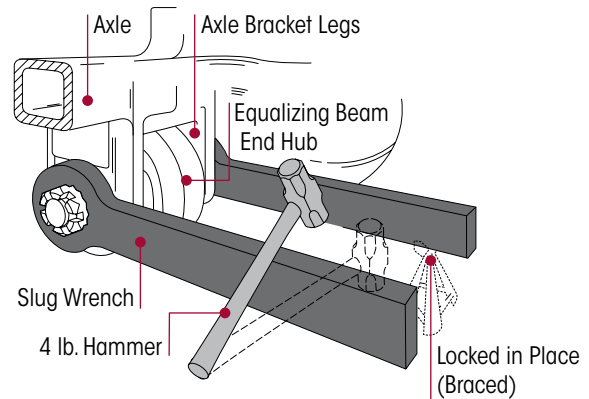


TABLE 1			
TORQUE SPECIFICATIONS			
SLUG WRENCH METHOD			TORQUE MULTIPLIER
125 Foot Pounds	<p>90 DEGREES</p>	1/4 or 90° turn on castle nut	700 ± 50 Foot Pounds

- b. Remove torque wrench and replace with the Slug Wrench. Using a four pound hammer, tighten the assembly by hitting the slug wrench near the handle as shown in Figure 8-44 until the nut has been turned to the degrees specified in Table 1.

FIGURE 8-44



**CAUTION**

DO NOT BACK OFF NUT TO INSTALL COTTER PIN, DOING SO MAY REDUCE THE TIGHTENING TORQUE BELOW THE REQUIRED SPECIFICATION.

**CAUTION**

REPEATED HAMMERING BEYOND THE DEGREE SPECIFIED CAN CAUSE COMPONENT DAMAGE.

**WARNING**

INSUFFICIENT TIGHTENING TORQUES CAN CAUSE PREMATURE WEAR AND DAMAGE TO THE AXLE BRACKET LEGS, HOLES AND/OR BEAM END CONNECTION COMPONENTS, THIS CAN FURTHER CAUSE FAILURE AND SEPARATION OF COMPONENTS, AND RESULT IN ADVERSE VEHICLE HANDLING, SEVERE PERSONAL INJURY OR DEATH. MAINTAIN PROPER TIGHTENING TORQUES AT ALL TIMES.

- c. Install cotter pin. The nut may be advanced to the next nut slot, **DO NOT** back off nut.

**CROSS TUBE**

A cross tube seldom requires replacement, usually only when it has been bent, possibly due to hitting an object. A bent cross tube may cause misalignment of the axles, and must be replaced immediately to eliminate abnormal tire wear.

**METHOD A: EQUALIZING BEAM REMOVAL**

Follow the steps in the Equalizing Beam Component Replacement procedure in this section. Within the procedure, after removal of the equalizing beams when the equalizing beams are separated, remove and replace cross tube.

**METHOD B: CENTER BUSHING END PLUG REMOVAL**
**You will need:**

- Cross Tube Service Kit 60961-759 for 46K•52K•60K or 60961-875 for 70K, (see Parts Lists Section of this publication)
- Cutting Torch
- Welding Equipment and Hole Saw (needed for 46K•52K•60K)

**DISASSEMBLY**

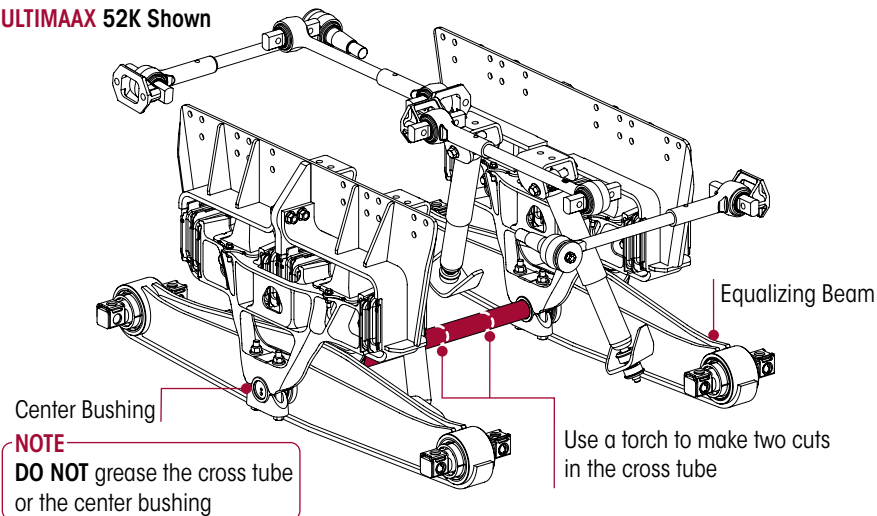
1. Use a work bay with a level surface.
2. Chock the front steer axle wheels.

**CAUTION**

FOLLOW THE SAFETY GUIDELINES FOR OPERATING THE TORCH. USE CAUTION AS PARTS MAY BE HOT.

3. Use a cutting torch to make two cuts in the cross tube, see Figure 8-45.

**FIGURE 8-45**  
**ULTIMAAX 52K Shown**



4. Remove the cut section of the cross tube and slide the remaining sections out of the center bushings and discard.
5. Remove only one center bushing end plug from the suspension:
  - **46K • 52K • 60K** – Use a 2" (50.8 mm) hole saw, see Figure 8-46
  - **70K** – Remove circlip, see Figure 8-47

**ASSEMBLY**

1. Clean the open end of the center bushing bore to approximately 1" (25.4 mm) depth of weld and debris.
2. From the open center bushing slide the new cross tube into both center bushings.
3. It may be necessary to use a floor jack under one or both equalizing beams to align the cross tube.
4. Once the new cross tube has been inserted,
  - **46K • 52K • 60K** – Position the end plug ¼" (6.6 mm) recessed in the center bushings and tack weld, see Figure 8-46. Check end plug position, final weld shall be a ¼" (6.6 mm) fillet.
  - **70K** – install new end plug and circlip, see Figure 8-47

FIGURE 8-46

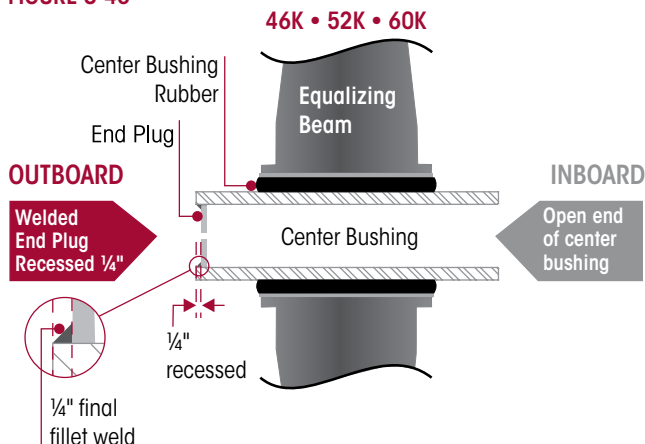
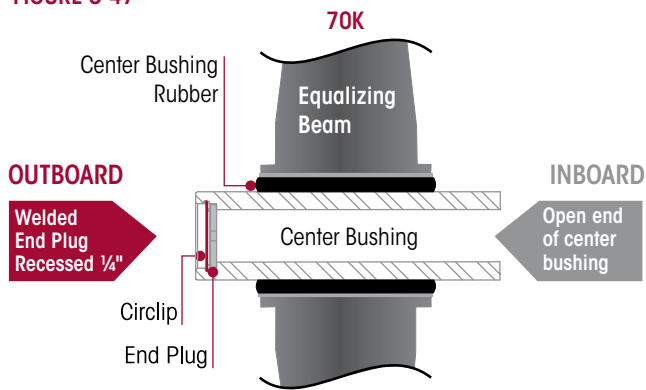


FIGURE 8-47



## TORQUE RODS

### WARNING

THE ULTIMAAX SUSPENSION INCORPORATES TORQUE RODS FOR VEHICLE STABILITY. IF THESE COMPONENTS ARE DISCONNECTED OR ARE NON-FUNCTIONAL THE VEHICLE SHOULD NOT BE OPERATED. FAILURE TO DO SO CAN RESULT IN ADVERSE VEHICLE HANDLING AND POSSIBLE TIRE CONTACT WITH THE FRAME OR THE SUSPENSION.

### ■ V-RODS

#### DISASSEMBLY

1. Chock the front wheels of the vehicle.
2. Remove and discard the V-rod mounting fasteners.
3. Remove the V-rod.
4. Inspect the mounting surface for any wear or damage. Repair or replace as necessary.

#### ASSEMBLY

1. Install the V-rod.
2. Install the new mounting fasteners that were removed.

#### NOTE

Hendrickson recommends the use of Grade 8 bolts and Grade C locknuts. If flange head bolts and locknuts are not used then hardened structural washers must be used under bolt heads and locknuts.

3. Prior to tightening, ensure that the vehicle is at the proper ride height. Tighten all fasteners to the required torque specification. Refer to vehicle manufacturer for specifications.
4. Remove wheel chocks.

### ■ LONGITUDINAL TORQUE RODS

#### DISASSEMBLY

1. Chock the front wheels of the vehicle.

#### SERVICE HINT

To remove all the load from the longitudinal torque rod, raise or lower the pinion as needed. This will ease the removal of the longitudinal torque rod.

2. Support the pinion on the axle being serviced.

#### NOTE

Prior to disassembly of the longitudinal torque rod, note the quantity and orientation of the longitudinal torque rod shims. It is required that the longitudinal torque rod shims are installed in the same orientation and location as removed to preserve the existing alignment.



3. Remove the torque rod mounting fasteners and shims (if equipped).
4. Remove the fasteners that connect the longitudinal torque rod to the cross member and axle brackets.
5. Remove longitudinal torque rod.

**ASSEMBLY**

1. Install longitudinal torque rod.
2. Install the fasteners and any shims that were removed to the cross member and axle brackets.

**NOTE**

Hendrickson recommends the use of Grade 8 bolts and Grade C locknuts. If flange head bolts and locknuts are not used then hardened structural washers must be used under bolt heads and locknuts.

3. Tighten all fasteners to vehicle manufacturer's torque specifications.
4. Verify proper pinion angle, and correct with drop in shims between the torque rod bar pin and the cross member or axle bracket depending on the direction of adjustment needed. Contact the vehicle manufacturer for proper pinion angle specifications.
5. Remove wheel chocks.

■ **TRANSVERSE TORQUE RODS**

**DISASSEMBLY**

1. Chock the front wheels of the vehicle.

**SERVICE HINT**

Note the quantity and location of shims removed to maintain the lateral alignment of the axle during assembly. See Alignment & Adjustments Section of this publication.

2. Remove the torque rod mounting fasteners.
3. Remove the transverse torque rod.
4. Inspect the mounting surfaces for any wear or damage. Repair or replace as necessary.

**ASSEMBLY**

1. Install the transverse torque rod.
2. Install the mounting fasteners and any shims that were removed.

**NOTE**

Hendrickson recommends the using Grade 8 bolts and Grade C locknuts for all torque rod attachments.

3. Prior to tightening, ensure that the vehicle is at the proper ride height. Tighten all fasteners to the required torque specification. Refer to original equipment manufacturer for specifications.
4. Check the lateral alignment. If not within vehicle manufacturer's specified range, a lateral alignment is necessary. See Lateral Alignment in the Alignment & Adjustments Section of this publication.
5. Remove the wheel chocks.

## XTRB TORQUE ROD BUSHINGS

### You Will Need:

- A vertical press with a capacity of at least 10 tons
- Shop made receiving tool and installation / removal tool, refer to the Special Tools Section of this publication for more information.

### BUSHING REMOVAL

1. Remove torque rods as detailed in Torque Rod Disassembly instructions in this section.

### WARNING

DO NOT USE HEAT OR USE A CUTTING TORCH TO REMOVE THE BUSHINGS FROM THE TORQUE ROD. THE USE OF HEAT WILL ADVERSELY AFFECT THE STRENGTH OF THE TORQUE ROD, HEAT CAN CHANGE THE MATERIAL PROPERTIES. A COMPONENT DAMAGED IN THIS MANNER CAN RESULT IN THE ADVERSE VEHICLE HANDLING AND POSSIBLE PERSONAL INJURY OR PROPERTY DAMAGE.

2. **Straddle Mount Bar Pin Bushing** (see Figure 8-48) —When servicing a straddle mount bar pin bushing assembly, mark the clocking position of the straddle mount bar pin flats with a paint stick on the torque rod end hub prior to disassembly, see Figure 8-49. This marking will serve as a guide when installing the new bushing so the original clocking position can be retained.
3. **Taper Pin Bushing** (see Figure 8-48) — Remove the fastener and the concave washer from the taper pin bushing.
4. Support the torque rod end hub and centered on the receiving tool (for a tapered bushing, have the tapered stud pointing down). Ensure the torque rod is squarely supported on the press bed for safety.
5. Install the removal tool, see Figure 8-50.
6. Press directly on the removal tool until the bushing clears the torque rod end hub, see Figure 8-51.

FIGURE 8-48



FIGURE 8-49

Mark the clocking position of the bar pin flats with a paint stick on the torque rod end hub

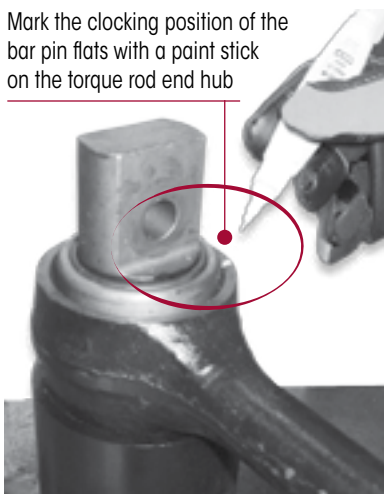
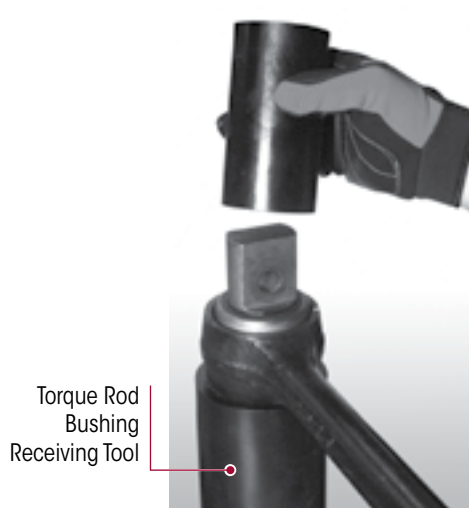
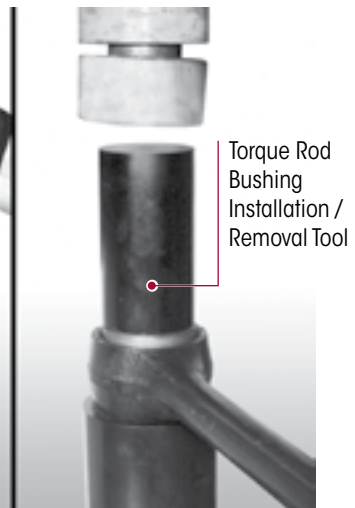


FIGURE 8-50



Torque Rod Bushing Receiving Tool

FIGURE 8-51



Torque Rod Bushing Installation / Removal Tool



**BUSHING INSTALLATION**

1. Clean and inspect the inner diameter of the torque rod end hubs, see Figure 8-52.

**SERVICE HINT**

**DO NOT** use a paraffinic oil, or soap base lubricant. Such lubricants can cause adverse reactions with the bushing, causing premature failure.

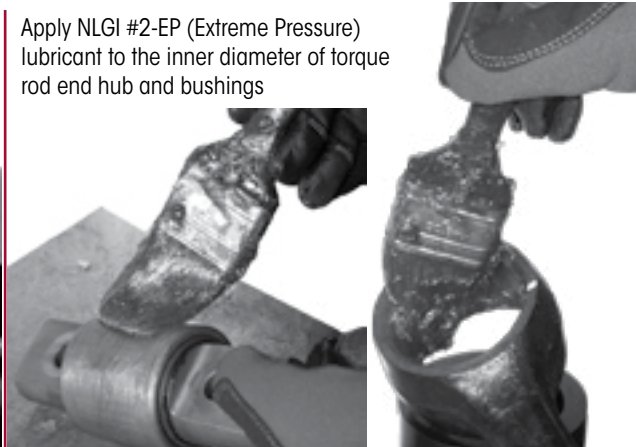
2. Lubricate the inner diameter of the torque rod end hubs and the outer metal of new bushings with NLGI #2 EP grease, see Figure 8-53.

**FIGURE 8-52**

Inspect and clean the inner diameter of torque rod end hubs

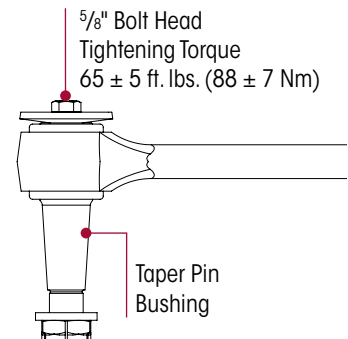

**FIGURE 8-53**

Apply NLGI #2-EP (Extreme Pressure) lubricant to the inner diameter of torque rod end hub and bushings



3. Support the torque rod end hub centered on the receiving tool. Ensure the torque rod is squarely supported on the press bed for safety.
4. **Straddle Mount** — Place the straddle mount bushing in the end hub and re-align the bar pin bushings to the mark made prior to removal as shown in Figure 8-49.

5. **Taper Pin** — Place the taper pin bushing in the end hub with the taper pointing down. Tighten  $\frac{5}{8}$ " bolt head to  $65 \pm 5$  ( $88 \pm 7$ ) torque, see Figure 8-54.
6. Using the shop made tool, place the installation tool on the bushing and press in, see Figure 8-51.
7. Ensure the bushing is centered within the hub of the torque rod.
8. Wipe off the excess lubricant.
9. Replace torque rod assembly as detailed in the Transverse or Longitudinal Torque Rod Component Replacement Section in this publication.

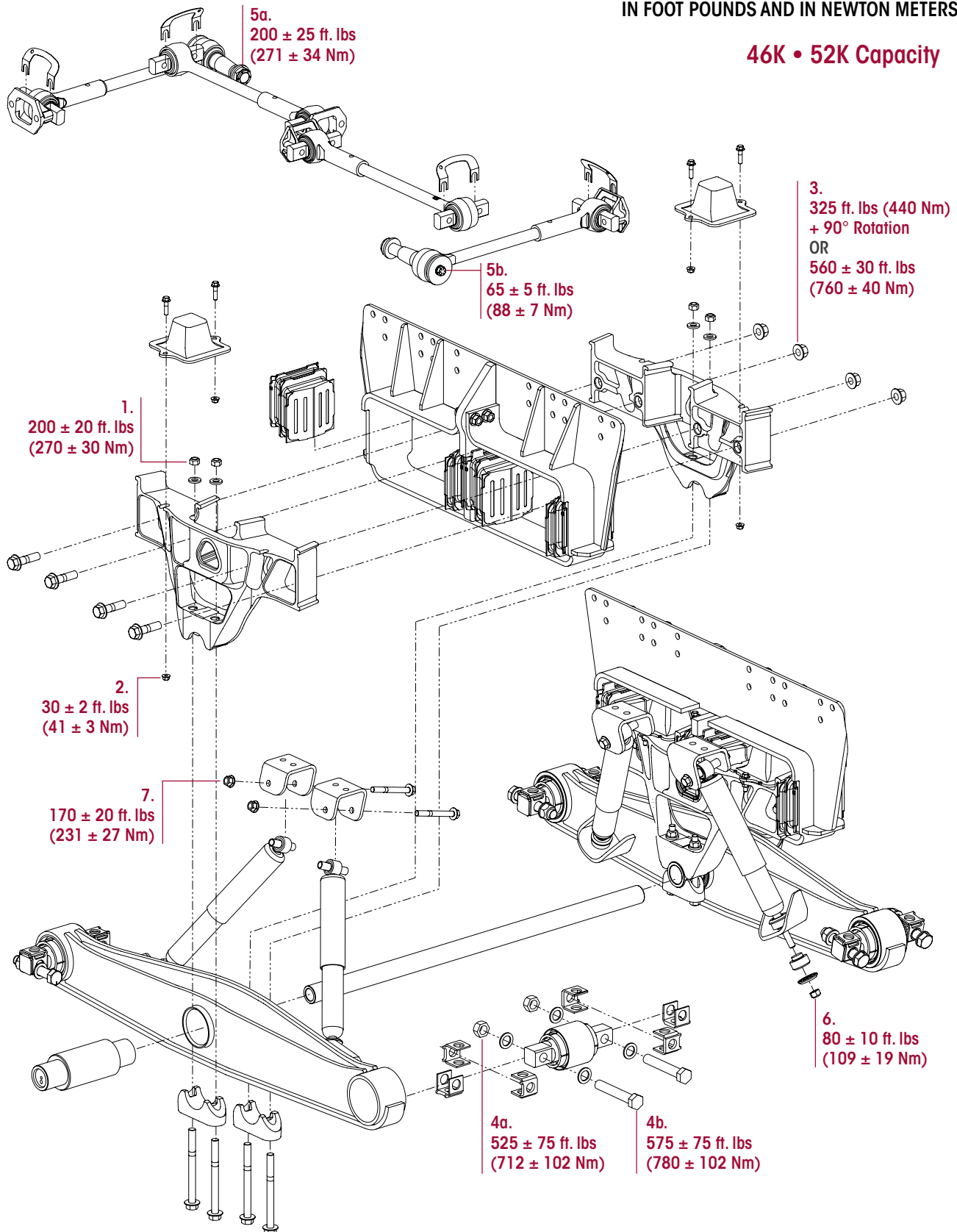
**FIGURE 8-54**




# SECTION 9 Torque Specifications

HENDRICKSON RECOMMENDED TORQUE VALUES PROVIDED  
IN FOOT POUNDS AND IN NEWTON METERS

**46K • 52K Capacity**





## ULTIMAAX 46K • 52K for Kenworth Vehicles

## HENDRICKSON RECOMMENDED TORQUE SPECIFICATIONS

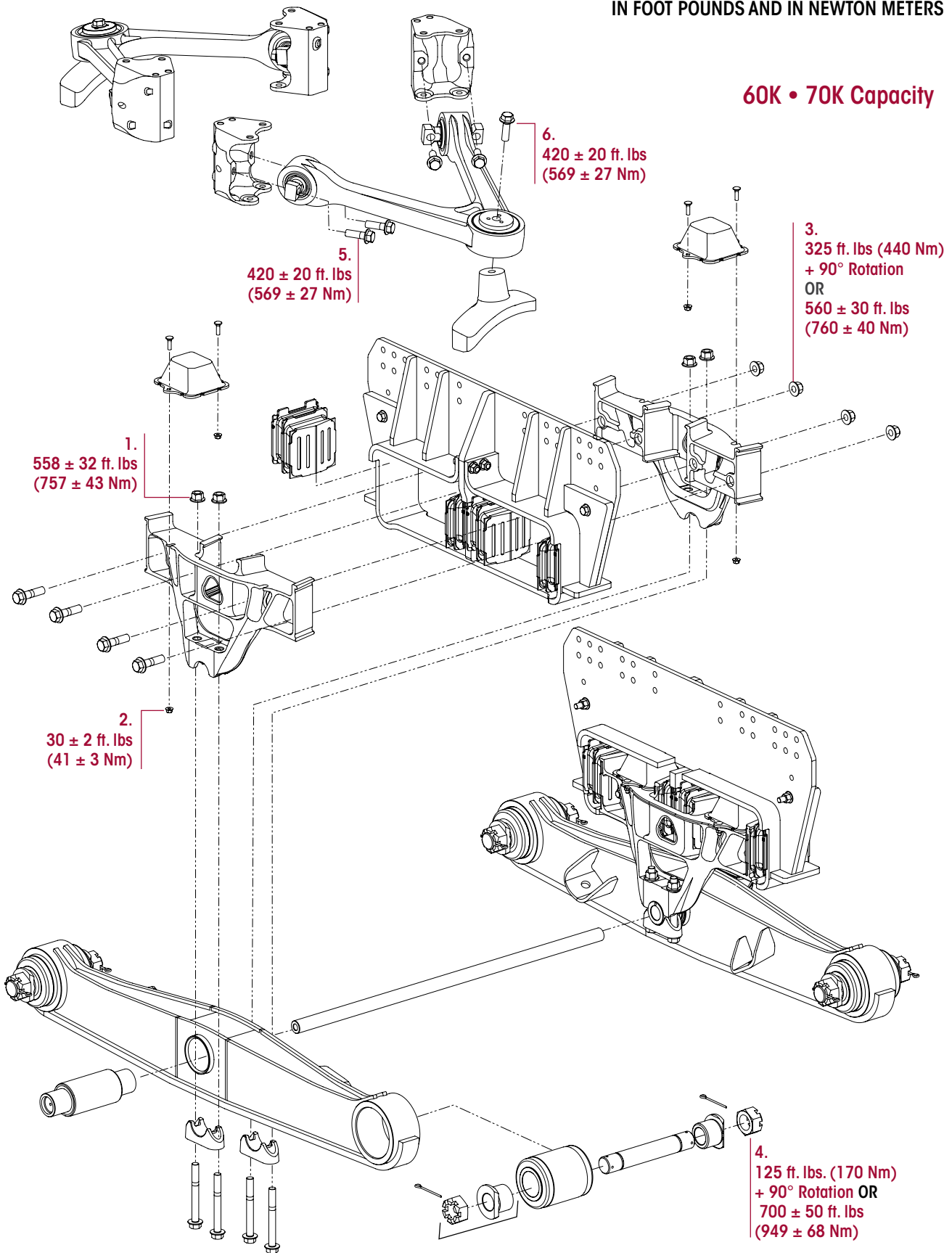
NO.	COMPONENT	FASTENER		TORQUE VALUE		
		*QUANTITY	SIZE	FOOT POUNDS	NM	
1	Saddle Assembly to Center Bushing Locknut	8	M16	200 ± 20	270 ± 30	
2	Saddle Assembly to Progressive Load Spring Flange Locknut	8	M10	30 ± 2	41 ± 3	
3	Saddle Assembly Halves Flange Locknuts	8	M20	325 + 90° rotation or 560 ± 30	440 + 90° rotation or 760 ± 40	
4a	Bar Pin End Bushing					
		at the Locknut	8	1"-8 UNC	525 ± 75	712 ± 102
4b		at the Bolt Head	8	1"-8 UNC	575 ± 75	780 ± 102
5a	Transverse Torque Rod to Axle					
		at the Locknut	2	1½"-12 UNF	200 ± 25	271 ± 34
5b		at the Bolt Head	2	5⁄8"-11 UNC	65 ± 5	88 ± 7

**NOTE:** \* Quantities shown are per suspension.

\*\* Torque values shown in this publication apply only if Hendrickson supplied fasteners are used. If non Hendrickson fasteners are used, follow the torque specification listed in the vehicle manufacturer's service manual.

HENDRICKSON RECOMMENDED TORQUE VALUES PROVIDED  
IN FOOT POUNDS AND IN NEWTON METERS

60K • 70K Capacity





## ULTIMAAX 60K • 70K for Kenworth Vehicles

## HENDRICKSON RECOMMENDED TORQUE SPECIFICATIONS

NO.	COMPONENT	FASTENER		TORQUE VALUE	
		*QUANTITY	SIZE	FOOT POUNDS	NM
1	Saddle Assembly to Center Bushing Locknut	8	M20	558 ± 32	757 ± 43
2	Saddle Assembly to Progressive Load Spring Flange Locknut	8	M10	30 ± 2	41 ± 3
3	Saddle Assembly Halves Flange Locknuts	8	M20	325 + 90° rotation or 560 ± 30	440 + 90° rotation or 760 ± 40
4	Adapter Style End Bushing	8	1 7/8"	125 + 90° rotation or 700 ± 50	170 + 90° rotation or 949 ± 68
5	V-rod to Corner Bracket	8	M20	420 ± 20	569 ± 27
6	V-rod to Axle Apex Bracket	2	M20	420 ± 20	569 ± 27
<p><b>NOTE:</b> * Quantities shown are per suspension.  ** Torque values shown in this publication apply only if Hendrickson supplied fasteners are used. If non Hendrickson fasteners are used, follow the torque specification listed in the vehicle manufacturer's service manual.</p>					



# SECTION 10 Troubleshooting Guide

## ULTIMAAX for Kenworth Vehicles

TROUBLESHOOTING GUIDE		
CONDITION	POSSIBLE CAUSE	CORRECTION
Suspension has harsh or bumpy ride	Damaged shock absorber	Replace shock absorbers
	Damaged progressive load spring	Replace progressive load springs, must be replaced in pairs
	Damaged shear spring	Replace shear spring
	Vehicle overloaded	Redistribute or reduce load to correct weight
Vehicle leans	Damaged progressive load spring	Replace progressive load springs, must be replaced in pairs
	Damaged shear spring	Replace shear spring
	Bent cross tube	Replace cross tube
	Weight bias	Redistribute load to correct weight bias
Irregular tire wear	Incorrect axle alignment	Axle alignment is permanently set at the time of vehicle manufacture. Contact vehicle manufacturer.
	Bent cross tube	Replace cross tube
	Damaged, bent, cracked suspension component	Replace damaged component
Loose or missing suspension fasteners	Suspension is overloaded	Reduce and/or redistribute load to correct weight
		Replace and/or properly tighten fasteners to the proper torque specification
	Improper torque or over torque	Increase inspection interval of fasteners
		Replace and/or properly tighten fasteners to the proper torque specification
Frame hanger cracked	Suspension is overloaded	Replace frame hanger assembly
		Reduce and/or redistribute load to correct weight
	Loose or missing suspension fasteners	Replace frame hanger assembly
		Increase inspection interval of fasteners
		Replace fasteners and/or properly tighten fasteners to the proper torque specification
Damaged frame hanger assembly	Replace frame hanger assembly	
Saddle leg to equalizing beam contact	Damaged, bent, worn, or cracked suspension component(s)	Replace damaged component
	Cross tube bent or missing	Replace cross tube
	Loose or worn saddle hex bolts	Replace saddle hex bolts, inspect mating components
	Saddles not center on equalizing beam	Center saddles on the equalizing beam
	Saddles not center on center bushing	Replace center bushing



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