INSTALLING THE ABS BRACKET
This kit is intended for field installation of weld-on ABS brackets on Hendrickson INTRAAX®, VANTRAAX® and ULTRAA-K® suspensions and TRLAXLE® Non-integrated Trailer Axles. This procedure applies to installing ABS brackets on HN and HP spindles for both LDA™ Large Diameter Axles and 5-inch axles.

NOTE: Only a properly trained and certified welder should perform the welding. Follow all applicable safety rules and regulations for welding, including but not limited to, wearing proper eye protection and other personal protective equipment, working in a well ventilated area and keeping all flammable and combustible materials out of the work area. Refer to L64 Welding Procedures general weld guidelines and specifications.

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

For general safety and precautionary statements, refer to Hendrickson literature number T12007, available at www.Hendrickson-intl.com/TrailerLit.

1. Remove tire / wheel assembly, brake and wheel-end components.

NOTE: For applicable wheel-end maintenance procedures, refer to available literature online at www.hendrickson-intl.com/TrailerLit.

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

3. To position the ABS bracket along the length of the axle, measure back (inboard) from the bearing shoulder to the face of the ABS bracket the distance indicated in Figure 1.
4. To position the ABS bracket around the outside diameter of the axle (Figure 2), align the center of the ABS bracket hole with the center of the slot in the brake spider or with the center of the hole in the torque plate.

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

5. Ensure the ABS bracket is flat against the axle and properly aligned. The ABS bracket must not be tilted or askew (Figure 3).

6. Temporarily clamp the bracket in place.

7. Verify the ABS bracket is in the proper location.

8. Insert an ABS sensor into the bracket to ensure adequate clearance with the brake spider and the hub.

9. Cover spindle area.

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

10. Verify ABS bracket location and sensor clearance, then weld the ABS bracket to the axle with a 1/4 inch (6.3 mm) fillet weld (Figure 4).

11. When cool, remove clamp.

12. Apply surface coat as needed.

For assistance in the United States and Canada, call Hendrickson Trailer Technical Services at 866-RIDEAIR (743-3247) or e-mail HTTS@Hendrickson-intl.com.