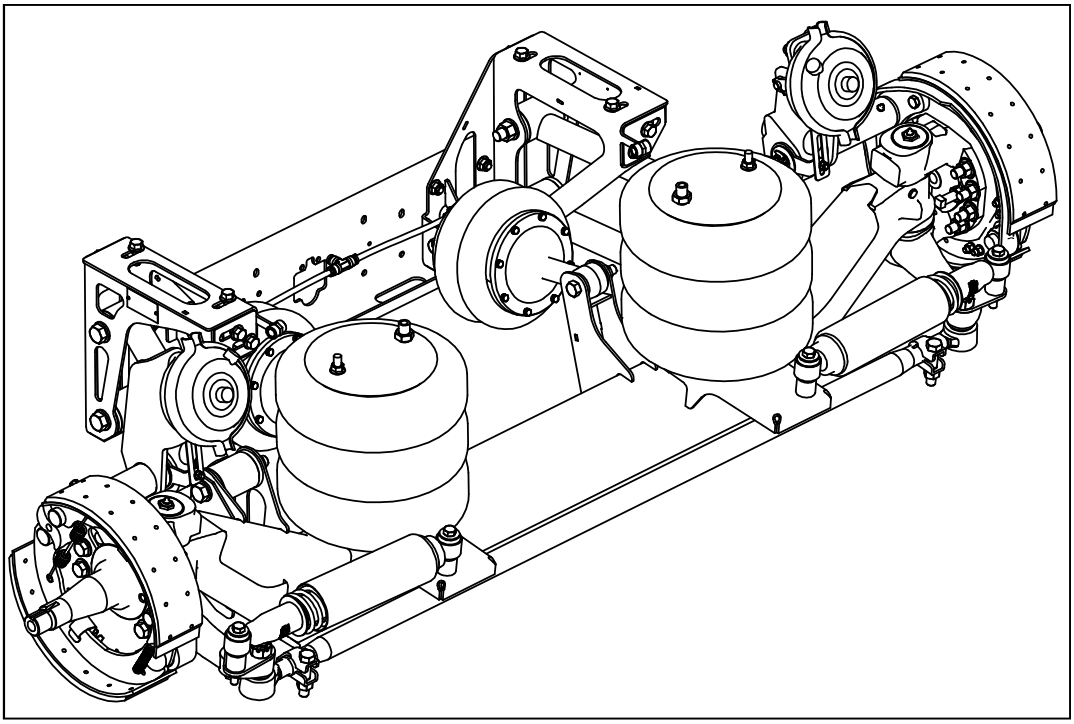
LIFTABLE
SUSPENSIONS

INSTALLATION INSTRUCTIONS
PARTS LIST

DURALIFT II



AVAILABLE IN 8K AND 13.2K CAPACITIES

Link Mfg. Ltd.
223 15th St. N.E.
Sioux Center, IA USA
51250-2120
www.linkmfg.com

QUESTIONS?
CALL CUSTOMER
SERVICE
1-800-222-6283

080730
80001918

1. INTRODUCTION

Thank you for choosing a Link Duralift II liftable suspension. We want to help you to get the best results from the suspension and to operate it safely. This manual contains information to introduce you to the Link Duralift II liftable suspension and to assist you with its installation and maintenance. The manual is intended solely for use with this product.

All information in this manual is based on the latest information available at the time of printing. Link Manufacturing reserves the right to change its products or manuals at any time without notice. Contact Link at (800) 222-6283 for information on recent changes to products.

Defective or damaged components should be returned to Link with a pre-arranged Returned Goods Authorization (RGA) number through the Customer Service Department. The damaged or defective component may then be replaced if in compliance with warranty conditions.

IMPORTANT: IT IS IMPORTANT THAT THE ENTIRE INSTALLATION INSTRUCTIONS BE READ THOROUGHLY BEFORE PROCEEDING WITH SUSPENSION INSTALLATION.

2. SAFETY SYMBOLS, TORQUE SYMBOL, and NOTES

	**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.**
⚠ WARNING	**WARNING indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.**
⚠ CAUTION	**CAUTION indicates a potentially hazardous situation which, if not avoided, could result in minor or moderate injury.**
CAUTION	**CAUTION used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.**
	**The torque symbol alerts you to tighten fasteners to a specified torque value.**
NOTE:	**A Note provides information or suggestions that help you correctly perform a task.**

3. SAFE WORKING PRACTICES:

3.1 ⚠ CAUTION
When handling parts, wear appropriate gloves, eyeglasses, ear protection, and other safety equipment.

3.2 ⚠ CAUTION
Practice safe lifting procedures. Consider size, shape, and weight of assemblies. Obtain help or the assistance of a crane when lifting heavy assemblies. Make certain the path of travel is clear.

4. INSTALLATION GUIDELINES

4.1 In order for this suspension to operate properly, it must operate in the parameters specified by Link.

4.2 The installer must verify the vehicle is configured properly for the lift axle(s) being added.

4.3 It is the responsibility of the installer to determine the location of the suspension in order to obtain proper load distribution.

4.4 Suspension Identification: Each assembly has an identification tag located on the hanger of the suspension on the drivers side of the vehicle. The plate includes the Link part number for the axle and the wheel end kit, and the suspension serial number.

4.5 No alterations of any Link suspension component is permitted without proper authorization from qualified Link personnel.

4.6 No welding of any suspension components is permitted except when specified by Link.

4.7 CAUTION The vehicle manufacturer should be consulted before any modifications are made to the frame of the vehicle. Cutting or altering the frame in certain areas may affect the manufacturer's warranty.

4.8 ⚠ WARNING
It is the responsibility of the installer to ensure that compliance with FMVSS 121 is maintained by the braking system.

4.9 ⚠ WARNING

Proper tightening of fasteners is important to the performance and safety of the suspension. Follow all torque specifications throughout the instructions.

5. PRE-INSTALLATION CHECKLIST

❑ Verify that the axle spacing to be used conforms to Federal and local bridge laws.

❑ Verify that the frame width matches the suspension specifications (33.50" to 35.00").

❑ Verify that adequate air supply exists to support braking requirements for the lift axle being installed.

❑ Verify clearance between the drive shaft and the liftable suspension, with the axle lifted and lowered.

❑ Verify tire clearance in all directions, with the axle lifted and lowered.

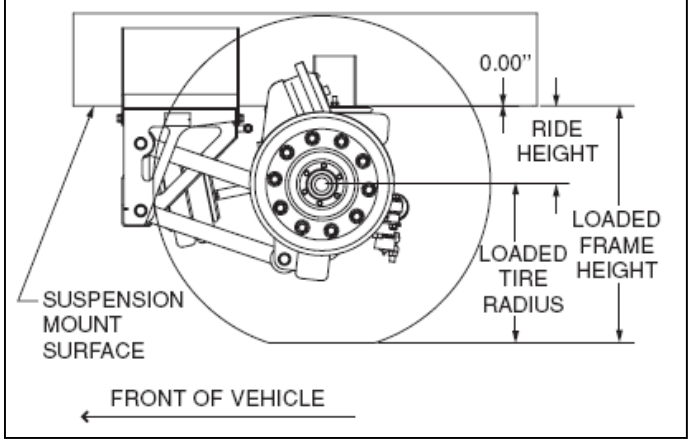
❑ Verify air spring clearance in all directions, with the axle lifted and lowered.

❑ Verify suspension clearance with truck components, with the axle lifted and lowered.

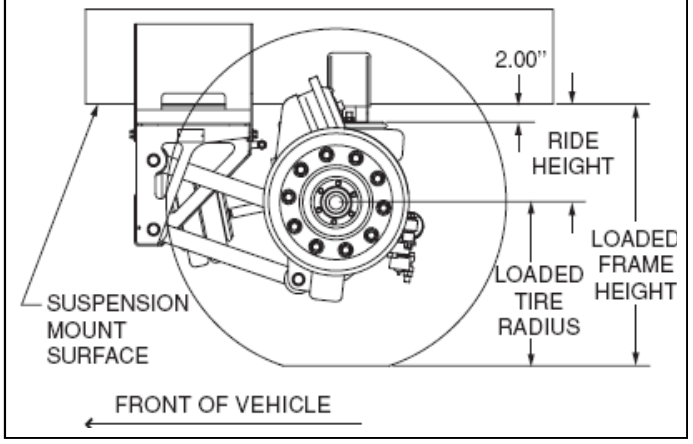
6. FRAME BRACKET KITS:

There are 4 frame bracket kits available to allow for a wide range of ride heights. The ride heights vary for the 8K suspension vs. the 13.2K suspension. See charts on Pages 4 and 5 for details.

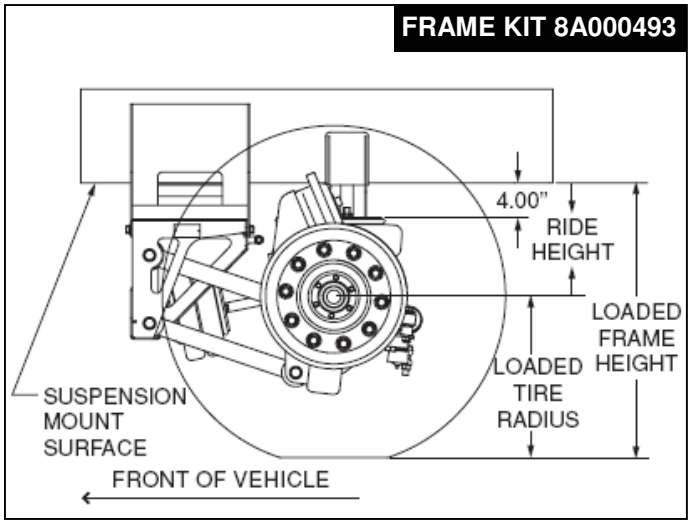
FRAME KIT 8A000491



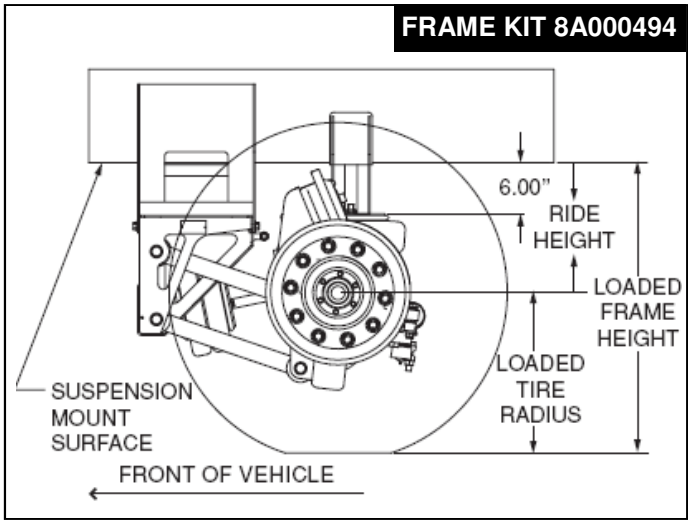
FRAME KIT 8A000492



FRAME KIT 8A000493



FRAME KIT 8A000494



7. RIDE HEIGHT AND FRAME ACCOMMODATIONS FOR *8K SUSPENSION (8A000711)*

7.1 CAUTION In order for the suspension to function properly, the “ride height” of the suspension must be within the range specified by Link Mfg. See the charts below for more information on available lift.

7.2 Four ride heights exist for this suspension; 11.00" to 13.50", 13.00" to 15.50", 15.00" to 17.50", and 17.00" to 19.50".

7.3 To determine the appropriate Frame Mount Kit and chart, use the formula below.

Loaded Frame Height - Loaded Tire Radius = Ride Height

7.4 With the correct chart, the amount of lift can be found by intersecting the Loaded Tire Radius with the Loaded Frame Height.
NOTE: When measuring frame to ground clearance, be sure to measure with vehicle loaded, at intended suspension location and on level ground.

DURALIFT II LIFT CHART	**8K** RIDE HEIGHT 11.00" - 13.50" (FRAME MOUNT KIT 8A000491)											
LOADED FRAME HEIGHT	25.0	25.5	26.0	26.5	27.0	27.5	28.0	28.5	29.0	29.5	30.0	30.5
TIRE RADIUS												
14 (LOADED)	7.0	7.5	8.0	8.5	9.0	9.5						
15 (LOADED)			7.0	7.5	8.0	8.5	9.0	9.5				
16 (LOADED)					7.0	7.5	8.0	8.5	9.0	9.5		
17 (LOADED)							7.0	7.5	8.0	8.5	9.0	9.5

DURALIFT II LIFT CHART	**8K** RIDE HEIGHT 13.00" - 15.50" (FRAME MOUNT KIT 8A000492)											
LOADED FRAME HEIGHT	27.0	27.5	28.0	28.5	29.0	29.5	30.0	30.5	31.0	31.5	32.0	32.5
TIRE RADIUS												
14 (LOADED)	7.0	7.5	8.0	8.5	9.0	9.5						
15 (LOADED)			7.0	7.5	8.0	8.5	9.0	9.5				
16 (LOADED)					7.0	7.5	8.0	8.5	9.0	9.5		
17 (LOADED)							7.0	7.5	8.0	8.5	9.0	9.5

DURALIFT II LIFT CHART	**8K** RIDE HEIGHT 15.00" - 17.50" (FRAME MOUNT KIT 8A000493)											
LOADED FRAME HEIGHT	29.0	29.5	30.0	30.5	31.0	31.5	32.0	32.5	33.0	33.5	34.0	34.5
TIRE RADIUS												
14 (LOADED)	7.0	7.5	8.0	8.5	9.0	9.5						
15 (LOADED)			7.0	7.5	8.0	8.5	9.0	9.5				
16 (LOADED)					7.0	7.5	8.0	8.5	9.0	9.5		
17 (LOADED)							7.0	7.5	8.0	8.5	9.0	9.5

DURALIFT II LIFT CHART	**8K** RIDE HEIGHT 17.00" - 19.50" (FRAME MOUNT KIT 8A000494)											
LOADED FRAME HEIGHT	31.0	31.5	32.0	32.5	33.0	33.5	34.0	34.5	35.0	35.5	36.0	36.5
TIRE RADIUS												
14 (LOADED)	7.0	7.5	8.0	8.5	9.0	9.5						
15 (LOADED)			7.0	7.5	8.0	8.5	9.0	9.5				
16 (LOADED)					7.0	7.5	8.0	8.5	9.0	9.5		
17 (LOADED)							7.0	7.5	8.0	8.5	9.0	9.5

8. RIDE HEIGHT AND FRAME ACCOMMODATIONS FOR *13.2K SUSPENSION (8A000712)*

8.1 CAUTION In order for the suspension to function properly, the "ride height" of the suspension must be within the range specified by Link Mfg. See the charts below for more information on available lift.

8.2 Four ride heights exist for this suspension; 8.00" to 10.50", 10.00" to 12.50", 12.00" to 14.50" and 14.00" to 16.50".

8.3 To determine the appropriate Frame Mount Kit and chart, use the formula below.

Loaded Frame Height - Loaded Tire Radius = Ride Height

8.4 With the correct chart, the amount of lift can be found by intersecting the Loaded Tire Radius with the Loaded Frame Height.
NOTE: When measuring frame to ground clearance, be sure to measure with vehicle loaded, at intended suspension location and on level ground.

DURALIFT II LIFT CHART	**13.2K** RIDE HEIGHT 8.0" - 10.5" (FRAME MOUNT KIT 8A000491)																	
LOADED FRAME HEIGHT	23.0	23.5	24.0	24.5	25.0	25.5	26.0	26.5	27.0	27.5	28.0	28.5	29.0	29.5	30.0	30.5	31.0	31.5
TIRE RADIUS																		
15 (LOADED)	7.0	7.5	8.0	8.5	9.0	9.5												
16 (LOADED)			7.0	7.5	8.0	8.5	9.0	9.5										
17 (LOADED)					7.0	7.5	8.0	8.5	9.0	9.5								
18 (LOADED)							7.0	7.5	8.0	8.5	9.0	9.5						
19 (LOADED)									7.0	7.5	8.0	8.5	9.0	9.5				
20 (LOADED)											7.0	7.5	8.0	8.5	9.0	9.5		
21 (LOADED)													7.0	7.5	8.0	8.5	9.0	9.5

DURALIFT II LIFT CHART	**13.2K** RIDE HEIGHT 10.0" - 12.5" (FRAME MOUNT KIT 8A000492)																	
LOADED FRAME HEIGHT	25.0	25.5	26.0	26.5	27.0	27.5	28.0	28.5	29.0	29.5	30.0	30.5	31.0	31.5	32.0	32.5	33.0	33.5
TIRE RADIUS																		
15 (LOADED)	7.0	7.5	8.0	8.5	9.0	9.5												
16 (LOADED)			7.0	7.5	8.0	8.5	9.0	9.5										
17 (LOADED)					7.0	7.5	8.0	8.5	9.0	9.5								
18 (LOADED)							7.0	7.5	8.0	8.5	9.0	9.5						
19 (LOADED)									7.0	7.5	8.0	8.5	9.0	9.5				
20 (LOADED)											7.0	7.5	8.0	8.5	9.0	9.5		
21 (LOADED)													7.0	7.5	8.0	8.5	9.0	9.5

DURALIFT II LIFT CHART	**13.2K** RIDE HEIGHT 12.0" - 14.5" (FRAME MOUNT KIT 8A000493)																	
LOADED FRAME HEIGHT	27.0	27.5	28.0	28.5	29.0	29.5	30.0	30.5	31.0	31.5	32.0	32.5	33.0	33.5	34.0	34.5	35.0	35.5
TIRE RADIUS																		
15 (LOADED)	7.0	7.5	8.0	8.5	9.0	9.5												
16 (LOADED)			7.0	7.5	8.0	8.5	9.0	9.5										
17 (LOADED)					7.0	7.5	8.0	8.5	9.0	9.5								
18 (LOADED)							7.0	7.5	8.0	8.5	9.0	9.5						
19 (LOADED)									7.0	7.5	8.0	8.5	9.0	9.5				
20 (LOADED)											7.0	7.5	8.0	8.5	9.0	9.5		
21 (LOADED)													7.0	7.5	8.0	8.5	9.0	9.5

DURALIFT II LIFT CHART	**13.2K** RIDE HEIGHT 14.0" - 16.5" (FRAME MOUNT KIT 8A000494)																	
LOADED FRAME HEIGHT	29.0	29.5	30.0	30.5	31.0	31.5	32.0	32.5	33.0	33.5	34.0	34.5	35.0	35.5	36.0	36.5	37.0	37.5
TIRE RADIUS																		
15 (LOADED)	7.0	7.5	8.0	8.5	9.0	9.5												
16 (LOADED)			7.0	7.5	8.0	8.5	9.0	9.5										
17 (LOADED)					7.0	7.5	8.0	8.5	9.0	9.5								
18 (LOADED)							7.0	7.5	8.0	8.5	9.0	9.5						
19 (LOADED)									7.0	7.5	8.0	8.5	9.0	9.5				
20 (LOADED)											7.0	7.5	8.0	8.5	9.0	9.5		
21 (LOADED)													7.0	7.5	8.0	8.5	9.0	9.5

9. SUSPENSION LOCATION

9.1 Before determining the suspension location, thoroughly review the pre-installation checklist found in Section 5 of this manual. Be sure that the vehicle is located on a flat and level surface before measuring for suspension location. When this is complete, mark the suspension location and boundaries on the truck frame rails. (See **Fig. 1** & **Fig. 2** below for details).

9.2 Prior to suspension installation, any interference with existing frame bolts or brackets should be addressed. If any modification to the auxiliary suspension is needed, you should consult Link.

NOTE: Truck frame cross-members should be located at or near the front frame brackets.

10. SUSPENSION INSTALLATION

10.1 With suspension location determined, clamp the front and rear frame brackets to the truck frame rails.

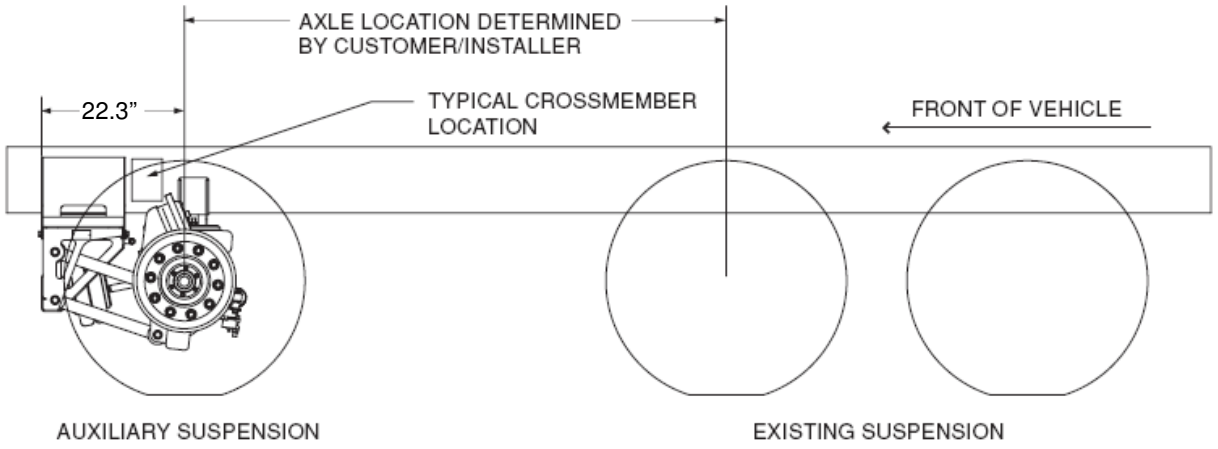
CAUTION The mounting surfaces of the auxiliary suspension must be tight against the sides and bottom of the truck frame rails.

10.2 Double check the suspension location and check for any interference concerns. Also, check that drilling will not interfere with any brake or fuel lines, wiring or other components that might be located on the inside of the frame.

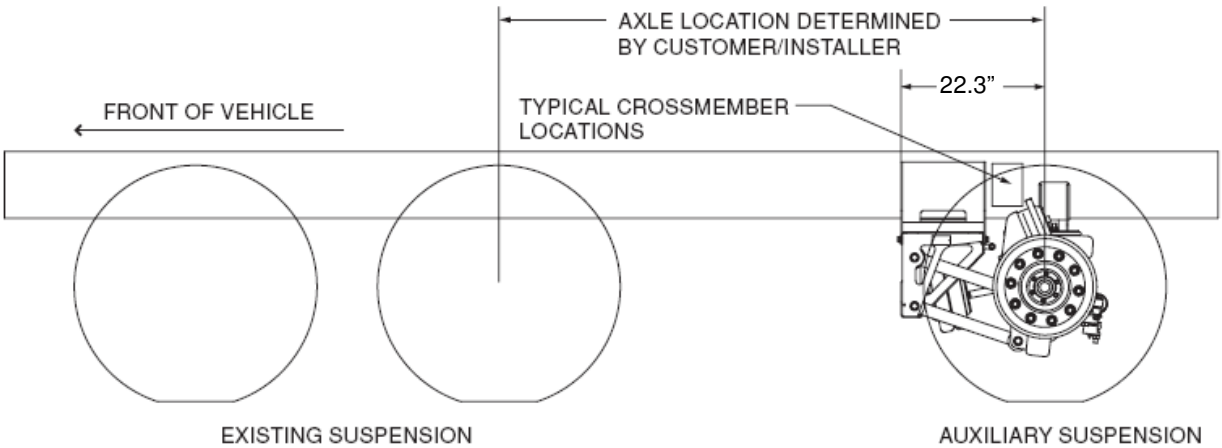
10.3 Once the frame brackets are clamped tightly to the outside and bottom surfaces of the truck frame, check all clearance issues and then center punch all mount holes. (See **Fig. 3** for recommended mount hole location.)

10.4 With mount holes marked, drill 21/32" diameter holes at hole locations.

PUSHER CONFIGURATION **FIG. 1**



TAG CONFIGURATION **FIG. 2**



10.5 Fasten frame brackets to the frame rail with SAE 5/8" UNC GRADE 8 HEX FLANGE BOLTS and 5/8" GRADE G PREVAILING TORQUE HEX FLANGE NUTS (not supplied, available with optional installation kit 800A0014).

TORQUE to 160-180 FT-LBS.

10.6 Assemble the suspension to the front frame brackets using the provided mounting hardware (See **Fig. 4** for fastener detail)

NOTE: Center the suspension on the truck with the frame width adjustment slots.

TORQUE to 90-120 FT-LBS.

10.7 Assemble the air springs to rear frame brackets using the 1/2" and 3/4" mounting hardware (See **Fig. 4** for fastener detail).

TORQUE the 1/2" nut to 20-30 FT-LBS.

TORQUE the 3/4" nut to 45-50 FT-LBS.

FIG. 3

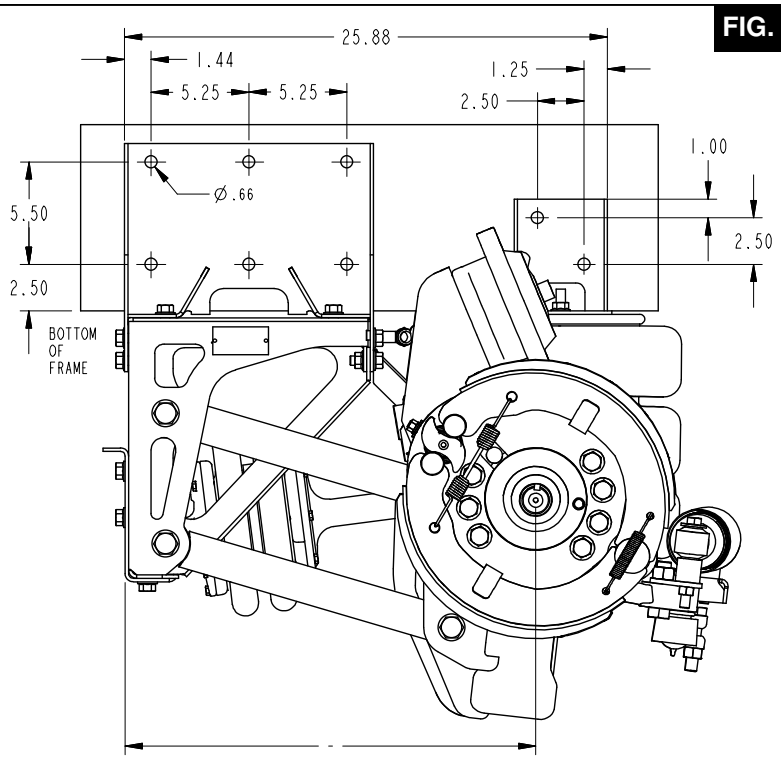
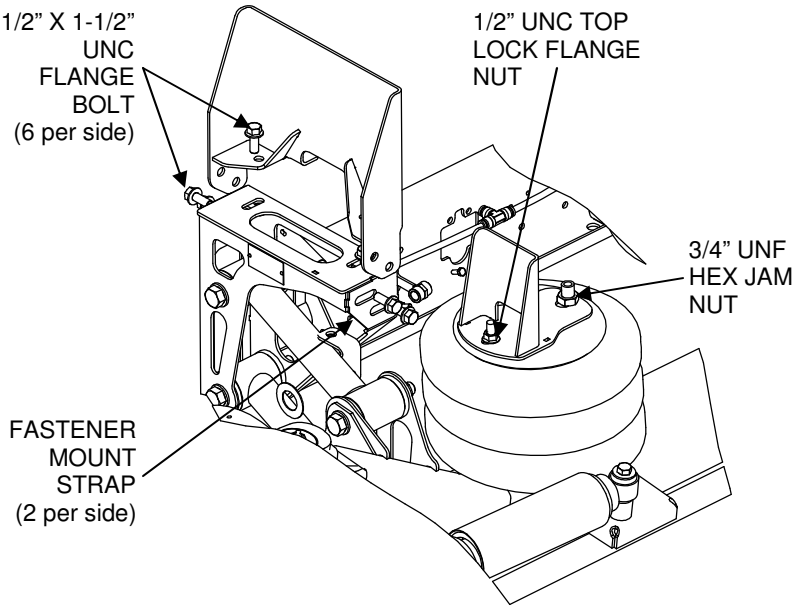


FIG. 4



11. SPECIAL PLUMBING INSTRUCTIONS

11.1 Connect the fitting in **Fig. 5** to the port on the lift axle control valve that lifts the suspension. See **Fig. 6** for details.

11.2 Connect the control box to the quick release valve used on the load springs.See **Fig. 6** for details.

Contact Link for available integrated air control options.

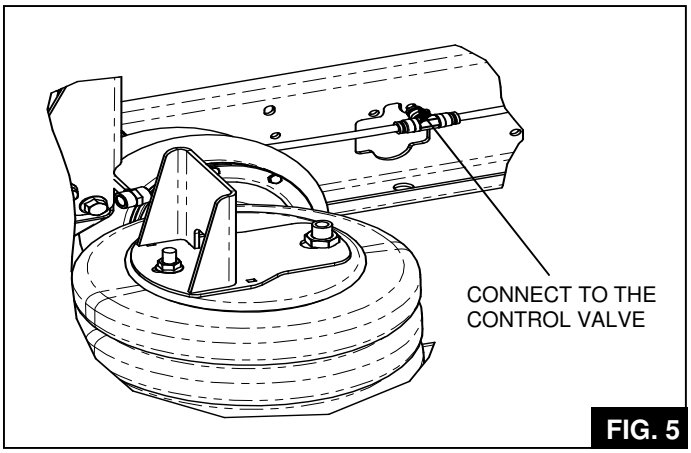


FIG. 5

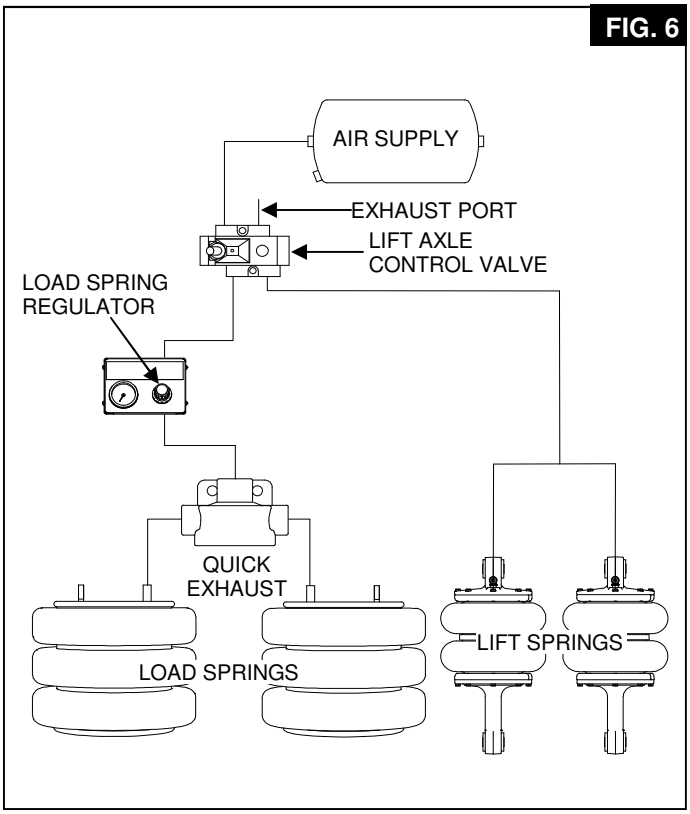


FIG. 6

12. FINAL ASSEMBLY AND INSPECTION CHECK-LIST

❑ Are both shipping straps and extra nuts removed? (see **Fig.7**)

❑ Are all fasteners installed and bolts tightened to proper torque specifications? **NOTE:** All fasteners torque specifications are given for dry fasteners with no additional lubrication required.

❑ Are all wheel lug nuts tightened to recommended torque specifications?

❑ Is air control installation complete and checked for leaks and proper operation?

❑ Has the suspension been raised and lowered, and inspected for any interference between the auxiliary suspension and any truck components?

❑ Are brakes and slack adjusters properly set, and the wheels free to rotate?

❑ Are wheel hubs sufficiently filled with the manufacturer's specified lubricant? (SAE 80W-90 Mineral based or SAE 75W-80 Synthetic Gear Lube)?

❑ Is the TOE-IN set properly (1/8 +/- 1/16 measured at the tire centers)?

❑ Verify the steering knuckles come into contact with the stop bolts before the tires interfere with any other truck components?

CAUTION: With the vehicle unloaded, the auxiliary axle's ride springs must be limited to a maximum of 20 psi to avoid improper weight distribution or component damage.

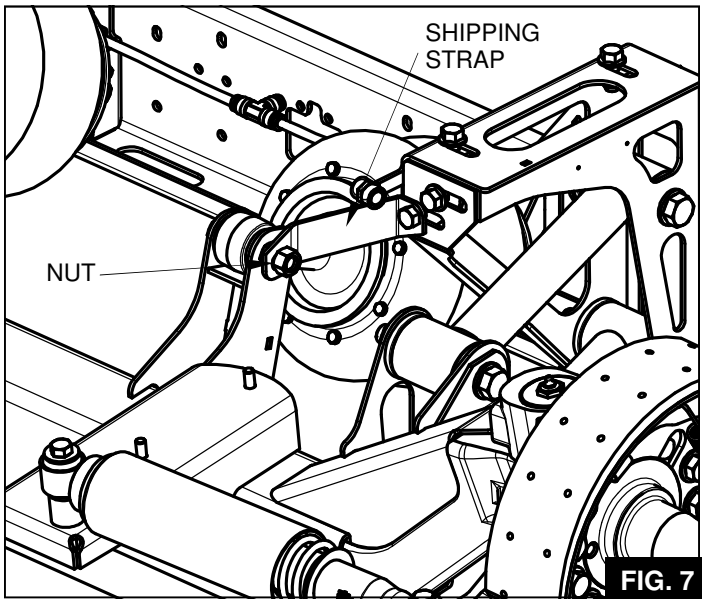


FIG. 7

Link Manufacturing, Ltd.
223 15th St. NE
Sioux Center, IA 51250
1-800-222-6283
www.linkmfg.com

DEALER / INSTALLER: Please remove this section and give to vehicle owner

Serial No:_____.
Part No: __ __ __ __ - __ __ __ __
Capacity: _____.
Date Installed: _____.

WARRANTY

Link warrants their suspension's fabricated structural components against failure under normal use for a period of three (3) years from date of installation by the original purchaser. Under this warranty Link will replace or repair any part that by it's inspection is determined to be defective. In addition, for a period not to exceed one (1) year,* Link will provide a labor allowance, using guidelines, which it determines to be adequate to properly replace or repair defective structural parts and/or components within constraints as noted below.

All parts and components thought to be defective must be returned with company authorization, freight prepaid, to Link. These returns must be accompanied by a complete written explanation of claimed defects and circumstances of failure, the serial number, and date of installation. Labor allowance must be authorized by Link prior to initiation of repairs.

*Purchased components and/or accessories other than the fabricated structure (axle and axle assemblies, air springs, wheel end equipment, brake and brake components, and air control parts) are warranted in accordance with warranty coverage provisions from date of installation.

LIMITATIONS

Link accepts no warranty responsibility for:
- Incidental or consequential damages or loss of time or profits resulting from product failure.
- Damage resulting from owner or operator abuse, misuse or neglect.
- Failure due to improper installation.
- Component parts manufactured by others for Link, beyond those companies' implied or expressed warranty.

This warranty is in lieu of any other warranty, obligation, or liability on the part of Link and no other person is authorized to make any representation or warranties beyond those expressed herein. All implied warranties of fitness and merchantability for any particular purpose are hereby excluded. There are no warranties of fitness which extend beyond the description on the face hereof. This warranty does not apply to failures resulting from improper installation, neglect, accident, misuse or operation beyond the rated capability of the model or the vehicle to which it is attached, nor to any parts which have been altered or repaired without the written consent of Link Manufacturing, Ltd. In no event shall Link be liable for indirect special, incidental or consequential damages of any nature. The foregoing is Link Manufacturing's only warranty, and all other warranties, whether expressed or implied, including, but not limited to, the implied warranties or merchantability or fitness for a particular purpose, are hereby disclaimed.

WARRANTY COVERAGE PROVISIONS

ITEM	MONTHS *(WHICHEVER COMES FIRST)*	MILEAGE	COVERAGE
MAJOR STRUCTURAL COMPONENTS	UP TO 12	UP TO 100,000	PARTS & LABOR ALLOWANCE
	12-36	100,000-300,000	PARTS ONLY
PIVOT BUSHING	UP TO 12	UP TO 100,000	PARTS & LABOR ALLOWANCE
	12-36	100,000-300,000	PARTS ONLY
AIR CONTROLS	UP TO 12	UP TO 100,000	PARTS & LABOR ALLOWANCE
AIR SPRINGS	UP TO 12	UP TO 100,000	PARTS & LABOR ALLOWANCE
	12-36	100,000-300,000	PARTS ONLY
LINK MANUFACTURED AXLE COMPONENTS	UP TO 12	UP TO 100,000	PARTS & LABOR ALLOWANCE
	12-36	100,000-300,000	PARTS ONLY
OTHER SUSPENSION AND BRAKE COMPONENTS	WARRANTY AS PROVIDED BY THE ORIGINAL EQUIPMENT MANUFACTURER		

TORQUE TABLE

SUSPENSION PIVOT FASTENERS	3/4 UNF	300-320 FT-LBS
FRAME MOUNT FASTENERS	5/8 UNC	160-180 FT-LBS
HANGER FASTENERS	1/2 UNC	90-120 FT-LBS
AIR SPRING NUT	3/4 UNC	40-50 FT-LBS
AIR SPRING NUT	1/2 UNC	20-30 FT-LBS
AIR SPRING BOLT	3/8 UNC	15-20 FT-LBS
LIFT ACTUATOR	5/8 UNF	150-190 FT-LBS

CROSS REFERENCE COMMON REPLACEMENT PARTS

ITEM	LINK	FIRESTONE	CONTITECH
LIFT AIR SPRINGS	1103-0511		FD 200-25
LOAD AIR SPRINGS	1103-0056	W01-358-7996	161524

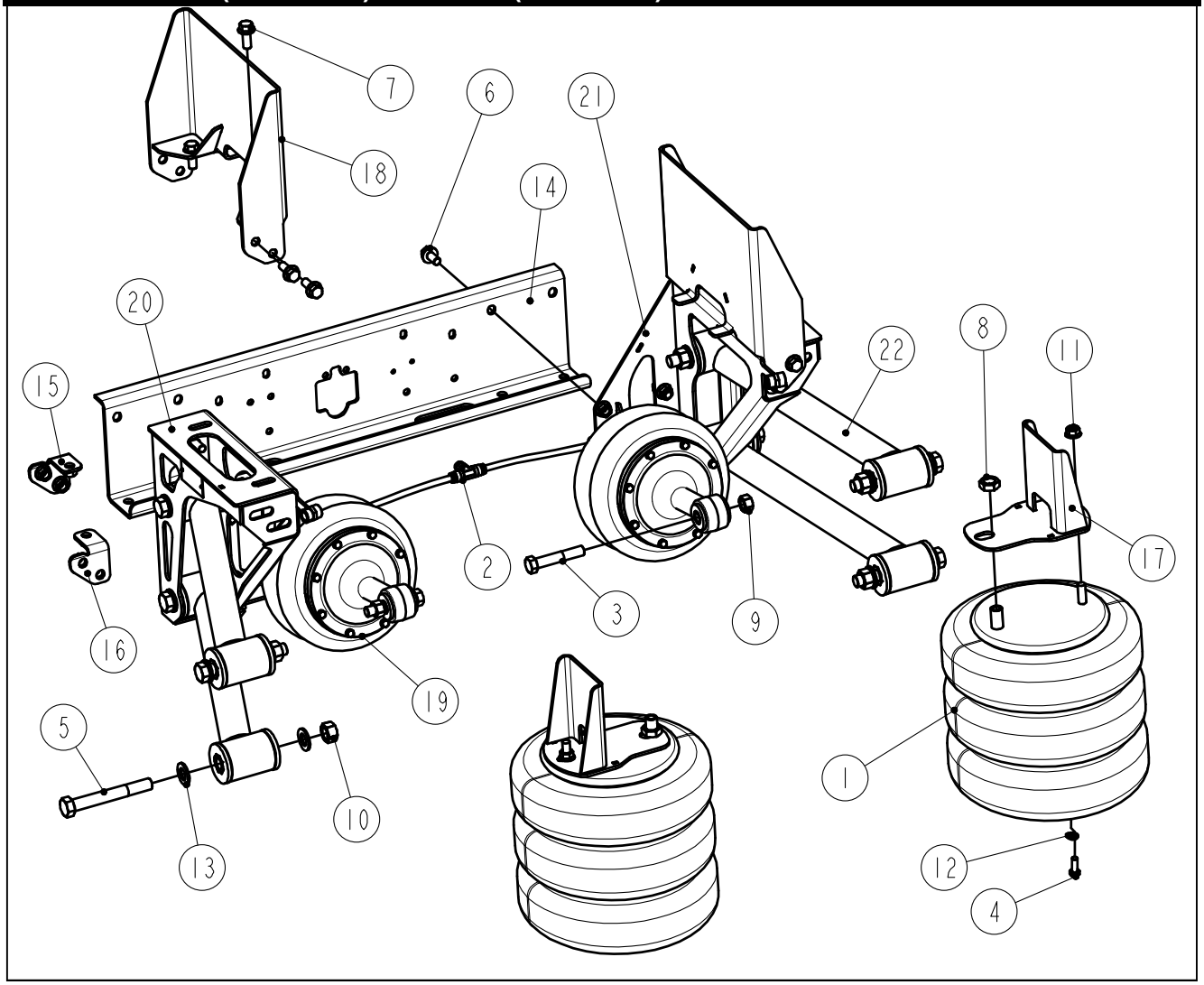
LINK SUSPENSION PREVENTATIVE MAINTENANCE

Every month or 1,000 miles	❑ Check wheel bearing oil level and inspect wheels for leaks (SAE 80W-90 Mineral Based Gear Lube). ❑ Check suspension for debris rubbing air springs. ❑ Check for worn steering stabilizer shocks.
Every three months or 2,500 miles	❑ Grease camshaft bushings (Multipurpose NLGI 2). ❑ Check for worn suspension bushings. ❑ Check for loose suspension fasteners (Tighten to values given on Torque Table). ❑ Check brake lining wear and replace any cracked, broken or oil soaked linings. ❑ Inspect brake drums for heat checks, grooves, hot spots, glazing, cracks and out of round and replace if necessary. ❑ Inspect wheel ends for excessive play.
Every twelve months or 10,000 miles	❑ Grease slack adjusters (Multipurpose NLGI 2). ❑ Replace wheel bearings lubricating oil (SAE 80W-90 Mineral Based or SAE 75W-80 Synthetic Gear Lube). ❑ Check brake chambers and slack adjusters for proper function and excessive wear. ❑ Inspect brake rollers, roller shafts, anchor pins and bushings for excessive wear and replace if necessary. ❑ Check shoes for bent shoe ribs, cracks in shoe table welds and elongated rivet holes and replace if necessary. ❑ Inspect suspension air controls for proper function and leaks.

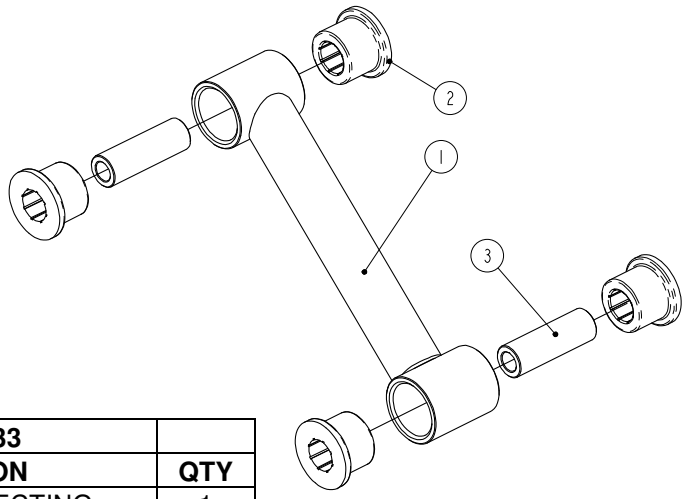
TROUBLESHOOTING GUIDE

TROUBLE	PROBABLE CAUSE	REMEDY
Axle will not stay up	Loose Air Fittings	Check and retighten.
	Damaged Air Lines	Check for excessive wear. Replace if worn or damaged.
	Damaged or Worn Air Springs	
Punctured Load Air Springs	Other Components too close to Air Spring	Check for clearance all around air spring under full load and deflated. Move anything coming in contact with air springs.
Loose Convolution Ribs	Under Extended Air Springs–Improper ride height	Check for proper ride height. A) Use smaller tires.
Air Spring Separation at End Plates	Over Extended Air Springs–Improper ride height	Check for proper ride height. A) Use bigger tires. B) Lower suspension.
Lift Air Spring Wear or Broken Bumper	Over Extended Load Springs–Crushes lift bag	Check for proper ride height. A) Use bigger tires B) Lower suspension. C) Install over-extension straps.

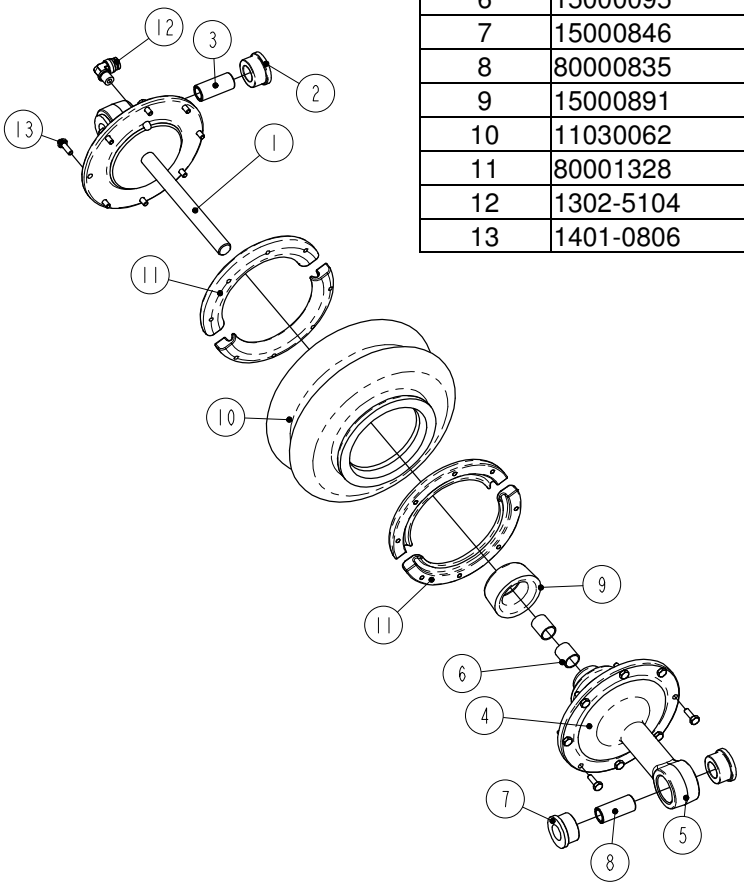
8K (8A000711) AND 13K (8A000712) DURALIFT II SELF-STEER



ITEM	PART NUMBER	DESCRIPTION	QTY
1	11030056	SPRING-AIR	2
2	1302-5061	TEE-UNION, 3/8 TUBE	1
3	1403-2028	5/8 X 3 1/2 UNF HEX CAP SCR (GR 5)	4
4	140B-1208	3/8 X 1 UNC HEX CAP SCR (GR 8) O&P	4
5	140D-2446	3/4 X 5 3/4 UNF HEX CAP SCR (GR 8) O&P	8
6	1411-1608	1/2 X 1 UNC FLANGE BOLT (GRADE 8)	8
7	1411-1610	1/2 X 1 1/4 UNC FLANGE BOLT (GRADE 8)	12
8	1475-2402	3/4 UNF HEX JAM NUT, O&P	2
9	1477-2006	5/8 UNF HEX TOP LOCK NUT (GR C) O&P	4
10	1477-2406	3/4 UNF HEX TOP LOCK NUT (GR C) O&P	8
11	1480-1604	1/2 UNC TOP LOCK FL NUT (GR G) O&P	10
12	1485-1200	3/8 LOCK WASHER	4
13	1488-2402	3/4 SAE HARDENED WASHER	16
14	80002109	CROSSMEMBER-DURALIFT2	1
15	800A0120	BRACKET-MOUNT, FASTENER	2
16	800A0121	BRACKET-MOUNT, FASTENER	2
17	SEE NOTE 1	BRACKET-MOUNT, AIRSPRING	2
18	SEE NOTE 1	BRACKET-MOUNT, FRAME	2
19	800A0258	ACTUATOR-SPRING, LIFT	2
20	810A0094	BRACKET-HANGER, SUSPENSION	1
21	810A0095	BRACKET-HANGER, SUSPENSION	1
22	820A0033	ARM-CONNECTING	4

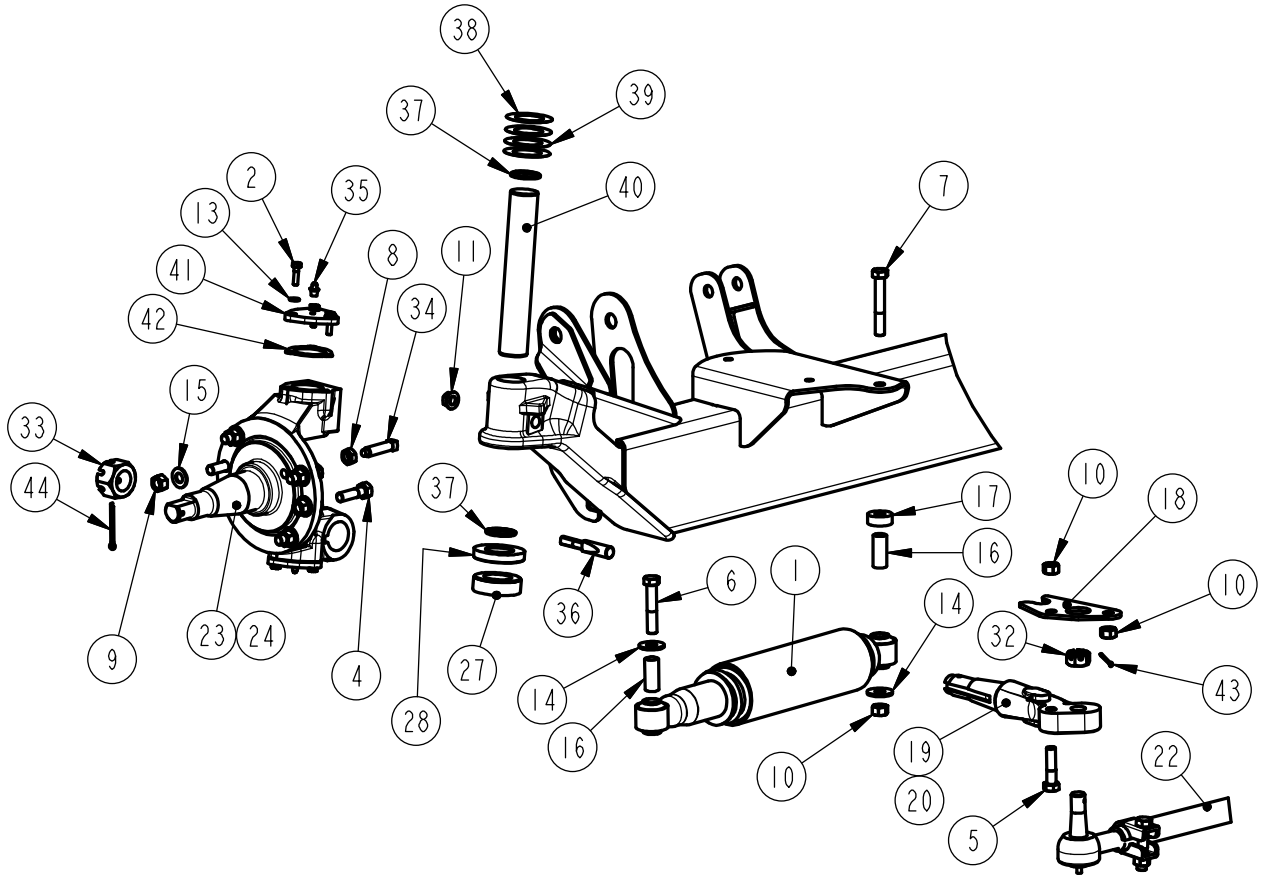


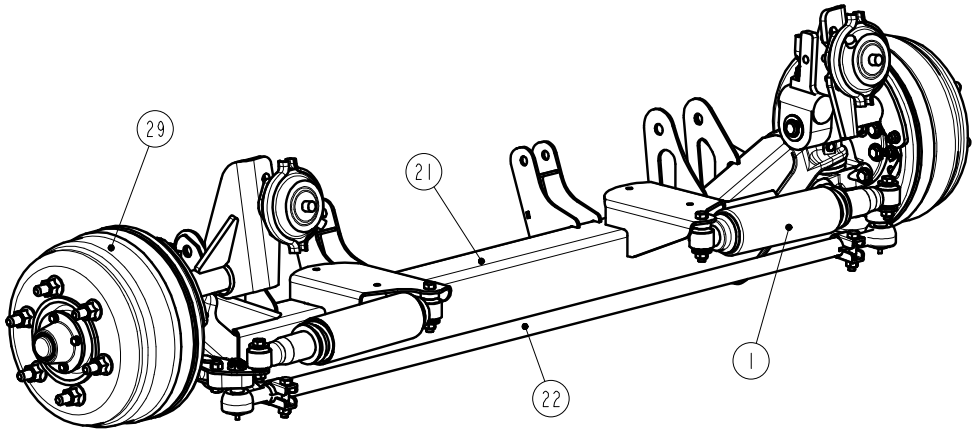
BILL OF MATERIALS FOR ASSEMBLY: 820A033			
ITEM	**PART NUMBER**	**DESCRIPTION**	**QTY**
1	820A0036	ARM-CONNECTING	1
2	15000890	BUSHING	4
3	80001210	TUBE-BUSHING	2

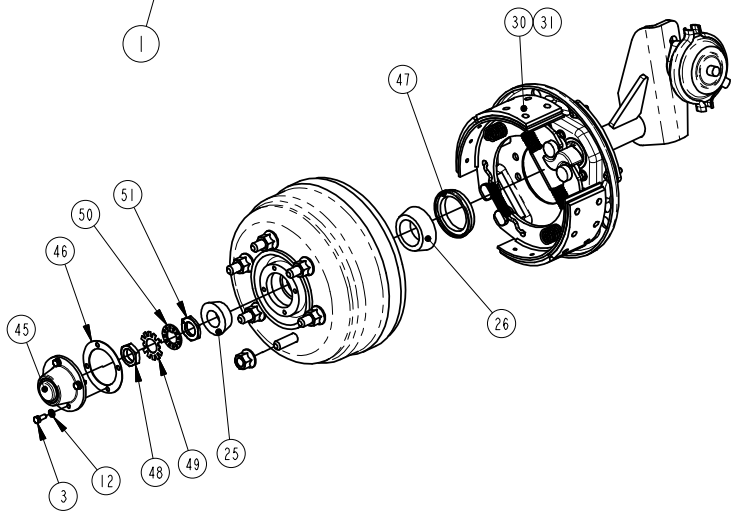


BILL OF MATERIALS FOR ASSEMBLY: 800A0258			
ITEM	**PART NUMBER**	**DESCRIPTION**	**QTY**
1	800A0259	CAP-CYL., AIR	1
2	15000846	BUSHING	2
3	80000835	TUBE-BUSHING	1
4	800A0260	PISTON-CYL., AIR	1
5	80001326	PISTON-CYL., AIR	1
6	15000095	BEARING-LINEAR	2
7	15000846	BUSHING	2
8	80000835	TUBE-BUSHING	1
9	15000891	STOP-BUMPER, CYL.	1
10	11030062	SPRING-AIR	1
11	80001328	RING-RETAINER, AIRSPRING	4
12	1302-5104	ELBOW-3/8 TB, 1/4 M-NPT	1
13	1401-0806	1/4 X 3/4 UNC HEX CAP SCR (GR 5)	16

8K DURALIFT II SELF-STEER AXLE ASSEMBLY (830A0303)







8K AIR PRESSURE AXLE LOAD CHART

(For reference only. Use scale to determine actual loads.)

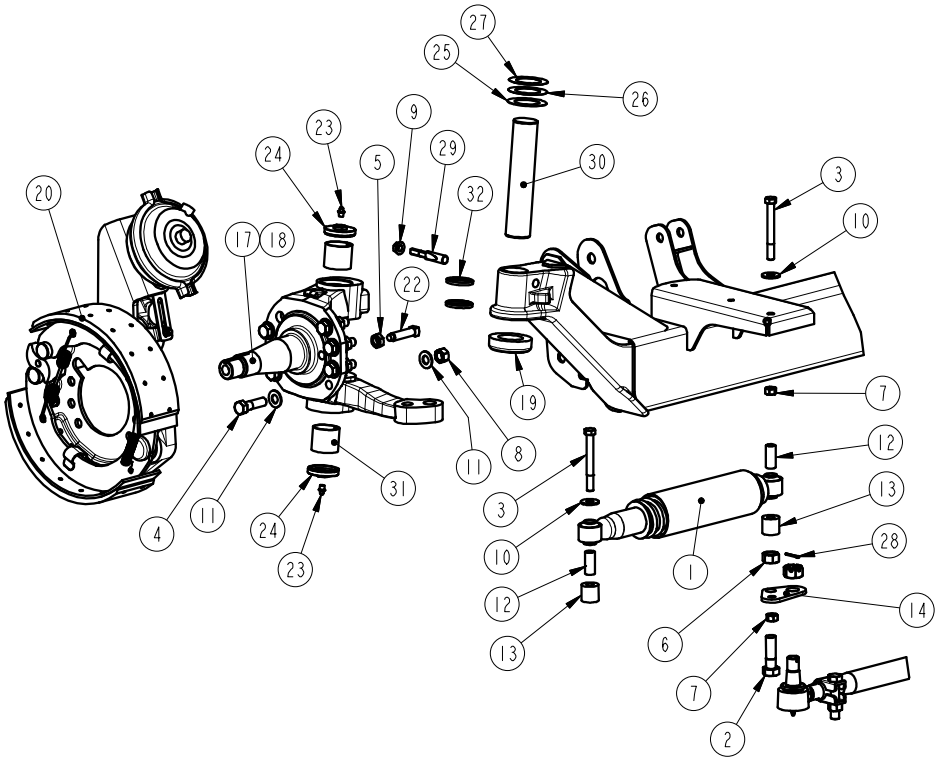
LOAD IN LBS AT GROUND	DURALIFT II PSI
4000	28
5000	37
6000	46
7000	55
8000	64

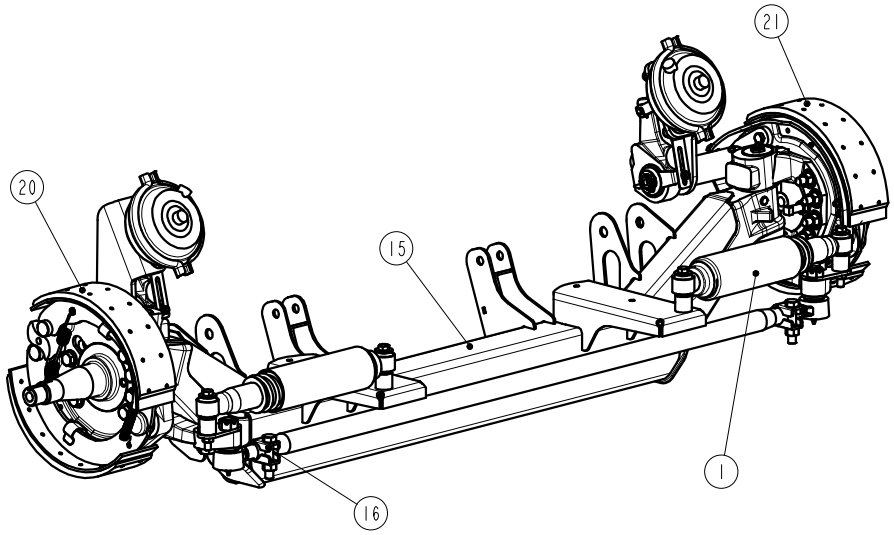
8K DURALIFT II SELF-STEER AXLE ASSEMBLY BILL OF MATERIAL (830A0303)

ITEM	PART NUMBER	DESCRIPTION	QTY
1	12100012	SHOCK ABSORBER, WIDE BODY	2
2	1401-0808	1/4 X 1 UNC HEX CAP SCR (GR 5)	12
3	1401-1006	5/16 X 3/4 UNC HEX CAP SCR (GR 5)	8
4	1402-1614	1/2 X 1 3/4 UNC HEX CAP SCR (GR 8)	12
5	140D-1616	1/2 X 2 UNF HEX CAP SCR (GR 8) O&P	2
6	140D-1622	1/2 X 2 3/4 UNF HEX CAP SCR (GR 8) O&P	2
7	140D-1626	1/2 X 3 1/4 UNF HEX CAP SCR (GR 8) O&P	2
8	1474-1600	1/2 UNC HEX JAM NUT	2
9	1476-1601	1/2 UNC HEX TOP LOCK NUT (GR C)	12
10	1477-1606	1/2 UNF HEX TOP LOCK NUT (GR C) O&P	6
11	1480-1404 *	7/16 UNC TOP LOCK FL NUT (GR G) O&P	2
12	1485-1004	5/16 LOCK WASHER OIL&PHOS	8
13	1487-0600	3/16 TYPE A PLAIN WASHER	12
14	1487-1600	1/2 TYPE A PLAIN WASHER	4
15	1488-1602	1/2 SAE HARDENED WASHER	24
16	80000009	BUSHING-SHOCK, ACETAL	4
17	83000079	SPACER-MOUNT, SHOCK	2
18	83000096	PLATE-MOUNT, SHOCK	2
19	83000097	ARM-STEERING, 8K	1
20	83000098	ARM-STEERING, 8K	1
21	830A0301	AXLE-FAB., 8K DURALIFT2	1
22	84001034	TIE ROD ASSEMBLY	1
23	84001233	ASSEMBLY-KNUCKLE, 8K (LEFT)	1
24	84001234	ASSEMBLY-KNUCKLE, 8K (RIGHT)	1
25	84001406	BEARING-ROLLER, CONE	2
26	84001407	BEARING-ROLLER, CONE	2
27	84001433 *	BEARING-THRUST	2
28	84001434 *	CAP-BEARING	2
29	84001508	HUB & DRUM-FN, 12.8X4	2
30	84001612A	BRAKE ASSY-L	1
31	84001613A	BRAKE ASSY-R	1
32	84001697	NUT-HEX, SLOTTED, .75	2
33	84001698	NUT-HEX, SLOTTED, 1.13	2
34	84001699	BOLT-STOP, STEERING	2
35	84001901	FITTING-GREASE	4
36	84001928 *	PIN-DRAW, LOCKING	2
37	84001987 *	SEAL-KNUCKLE	4
38	84001988 *	SHIM (.005)	4
39	84001989 *	SHIM (.010)	4
40	84001990 *	PIN-KING, 8K	2
41	84001991	CAP-KNUCKLE	4
42	84001992 *	GASKET-CAP, KING PIN	4
43	84001995	PIN-COTTER, .13 X 1.75	2
44	84001996	PIN-COTTER, .18 X 2.00	2
45	84002001	CAP, HUB	2
46	84002002	GASKET-CAP, HUB	2
47	84002003	SEAL-OIL	2
48	84002004	1.125 UNF HEX JAM NUT	2
49	84002005	WASHER-STAR	2
50	84002006	WASHER-LOCK	2
51	84002007	1.125 UHF HEX BEARING NUT	2

* Items included in Kingpin Kit 84001933

13.2K DURALIFT II SELF-STEER AXLE ASSEMBLY (830A0304)





13.2K AIR PRESSURE AXLE LOAD CHART
(For reference only. Use scale to determine actual loads.)

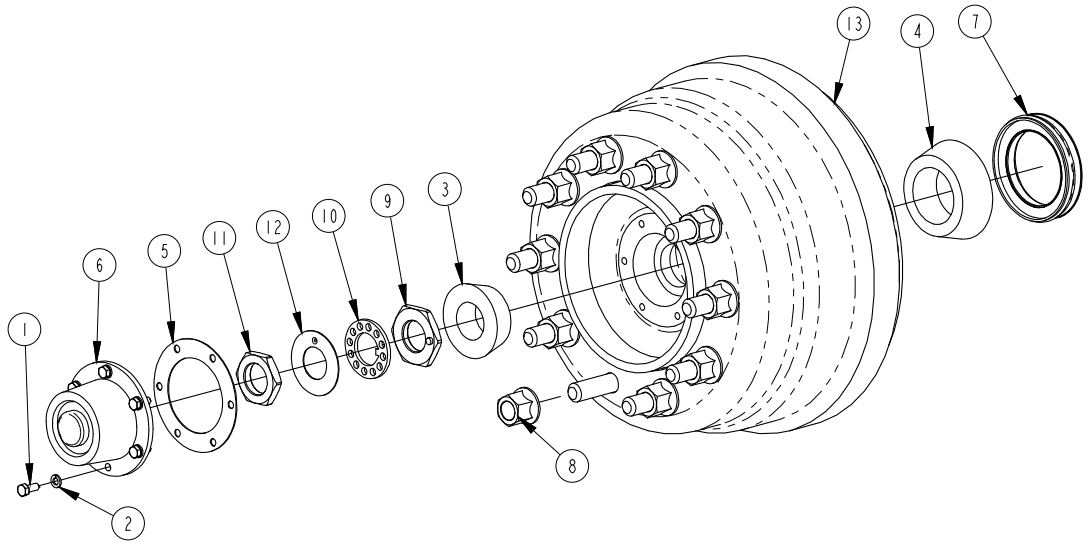
LOAD IN LBS AT GROUND	DURALIFT II PSI
4000	28
5000	37
6000	46
7000	55
8000	64
9000	73
10000	79
11000	87
12000	93
13000	98

ITEM	PART NUMBER	DESCRIPTION	QTY
1	12100012	SHOCK ABSORBER, WIDE BODY	2
2	140B-2420	3/4 X 2 1/2 UNC HEX CAP SCR (GR 8) O&P	2
3	140D-1636	1/2 X 4 1/2 UNF HEX CAP SCR (GR 8) O&P	4
4	140D-2018	5/8 X 2 1/4 UNF HEX CAP SCR (GR 8) O&P	14
5	1475-2000	5/8 UNF HEX JAM NUT	2
6	1476-2406	3/4 UNC HEX TOP LOCK NUT (GR C) O&P	2
7	1477-1606	1/2 UNF HEX TOP LOCK NUT (GR C) O&P	4
8	1477-2006	5/8 UNF HEX TOP LOCK NUT (GR C) O&P	14
9	1480-1404 *	7/16 UNC TOP LOCK FL NUT (GR G) O&P	2
10	1487-1600	1/2 TYPE A PLAIN WASHER	4
11	1488-2003	5/8 SAE PLAIN WASHER, OIL&PHOS	28
12	80000009	BUSHING-SHOCK, ACETAL	4
13	80001919	SPACER-MOUNT, SHOCK	4
14	83000078	TAB-MOUNT, SHOCK	2

13.2K DURALIFT II SELF-STEER AXLE ASSEMBLY BILL OF MATERIAL (830A0304)

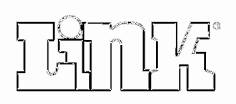
15	830A0302	AXLE-FAB., 13K DURALIFT 2	1
16	84001038	ASSEMBLY-ROD, TIE	1
17	84001241	INTEGRAL KNUCKLE	1
18	84001242	INTEGRAL KNUCKLE	1
19	84001435 *	BEARING-THRUST	2
20	84001607	ASSEMBLY-BRAKE, 15X 4L	1
21	84001608	ASSEMBLY-BRAKE, 15X 4R	1
22	84001731	BOLT-STOP, STEERING	2
23	84001901 *	FITTING-GREASE	4
24	84001902 *	CAP-KNUCKLE	4
25	84001903 *	SHIM (.030)	2
26	84001904 *	SHIM (.010)	2
27	84001905 *	SHIM (.005)	2
28	84001912	PIN, COTTER	2
29	84001928 *	PIN-DRAW, LOCKING	2
30	84002020 *	PIN-KING, DANA	2
31	84002021 *	BUSHING-KNUCKLE	4
321	84002022 *	SEAL-KNUCKLE	4

* Items included in Kingpin Kit 84001934



ITEM	PART NUMBER	DESCRIPTION	QTY
1	1401-1006	5/16 X 3/4 UNC HEX CAP SCR (GR 5)	6
2	1485-1000	5/16 LOCK WASHER	6
3	84001403	BEARING-ROLLER, CONE	1
4	84001404	BEARING-ROLLER, CONE	1
5	84001683	GASKET	1
6	84001684	CAP, HUB	1
7	84001687	SEAL-OIL	1
8	84001709	NUT-FLANGE, M22X1.5	10
9	84001721	NUT-INNER, JAM	1
10	84001722	WASHER-LOCK, SPINDLE	1
11	84001723	NUT-OUTER, JAM	1
12	84001724	WASHER-RETAINER	1
13	SEE NOTE 1	ASSEMBLY-HUB & DRUM, FN-15 X 4	1

Notes:
1. Multiple options exist—call for details.



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