



Installation Exchange Instructions and Guidelines

Dexter Torsion Arm Recall

EP1756

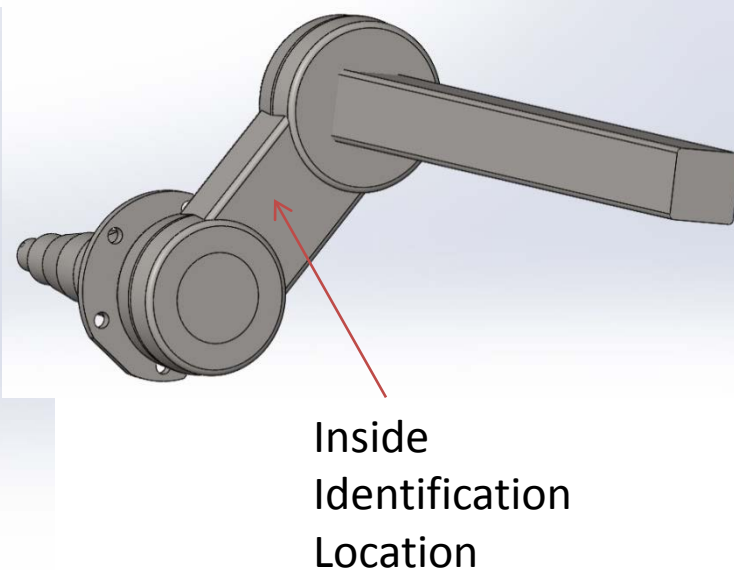
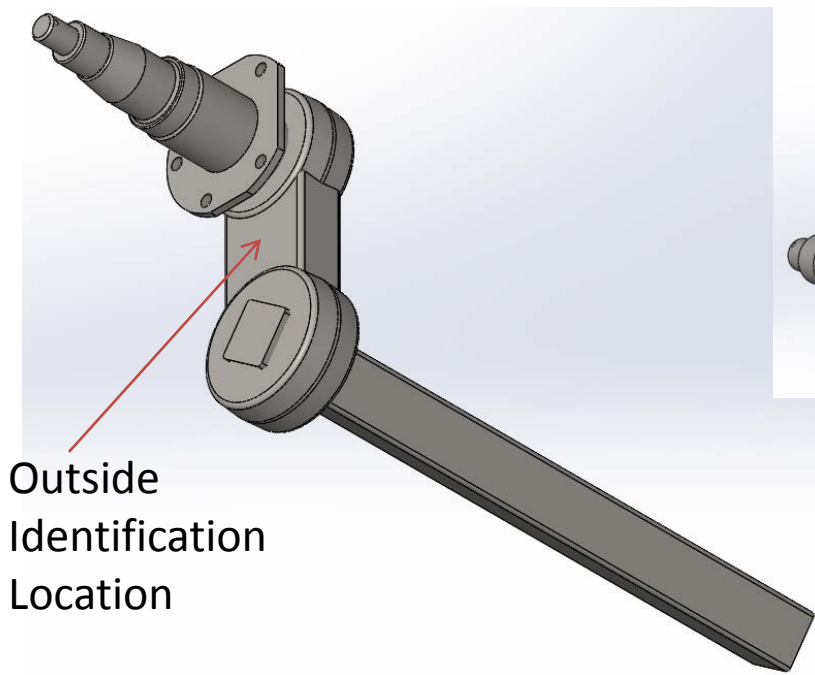
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Dexter Torsion Arm Recall

Identification

Look on the inside & outside of the torsion arm for the following identification marks to know if your trailer is part of the torsion arm recall.



Dexter Torsion Arm Recall Identification

Non-Recalled Torsion Arms:

Have the following three identification mark combinations:

- 1) HT followed by two numbers stamped on the inside or outside of the torsion arm and a manufacturing number (sequence of 4 characters), blank or empty stamp on the other side.
- 2) TA followed by two numbers stamped on the inside or outside of the torsion arm and a manufacturing number (sequence of 4 characters), blank or empty stamp on the other side.
- 3) 60 or 35 stamped on the inside or outside of the torsion arm and a manufacturing number (sequence of 4 characters), blank or empty stamp on the other side.



If you have the non-recalled Torsion Arms, no further actions required.

Dexter Torsion Arm Recall Identification

Recalled Torsion Arms:

Have the following two identification mark combinations:

- 1) PY stamped on the inside or outside of the torsion arm and a blank or empty stamp on the other side.
- 2) Blank or empty stamped on the inside or outside of the torsion arm and a blank or empty stamp on the other side.



If you have the recalled Torsion Arms please proceed with removal & replacement installation instructions.

Cautionary Statements



Wear appropriate personal safety protection when performing recall removal & replacement installations.



For safety reasons it is recommended that the **Boat is Removed from Trailer** prior to performing any recall removal & replacement installations.

Axle Identification

- EZ Loader has 4 axle configurations. Identify yours and proceed.

- **1) Non-Brake Axle**

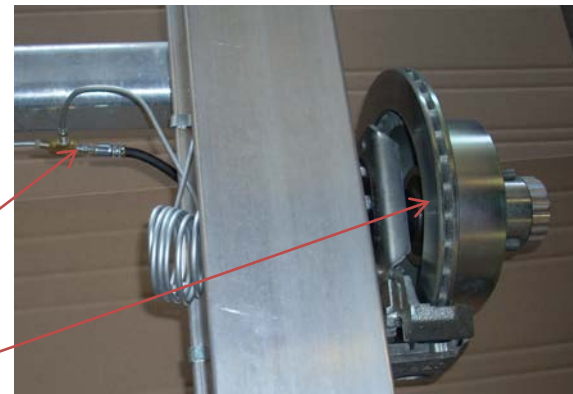
- No brake line on axle.
- No caliper or backing plate.



- **2) Hydraulic Disc Brake Axle**

- Metal and/or flex brake line on axle.
- Has caliper and rotor visible from back of tire.

Brake Line
Caliper
and Rotor



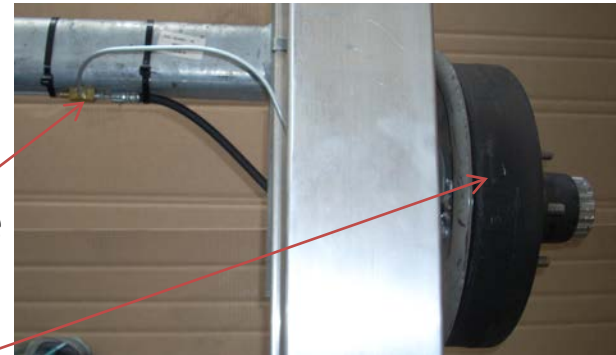
Axle Identification

- **3) Hydraulic Drum Brake Axle**

- Metal and/or flex brake line on axle.
- Has drum and backing plate visible from back of tire.

Brake Line

Drum and
Backing Plate

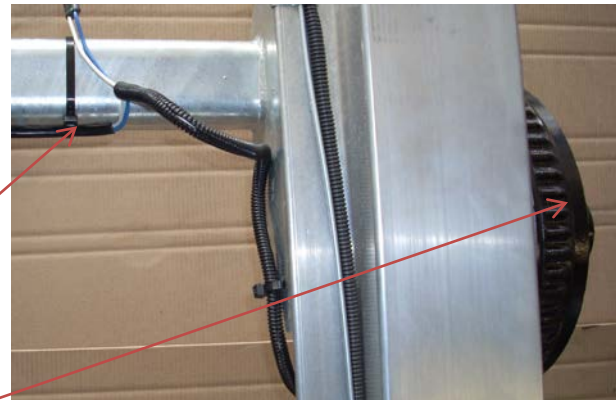


- **4) Electric Drum Brake Axle**

- Wire brake line on axle.
- Has drum and backing plate visible from back of tire.

Wire
Brake Line

Drum and
Backing Plate



EXCHANGE PROCEDURE

NO BRAKE AXLE

Dexter Torsion Arm Recall

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Exchange Procedure

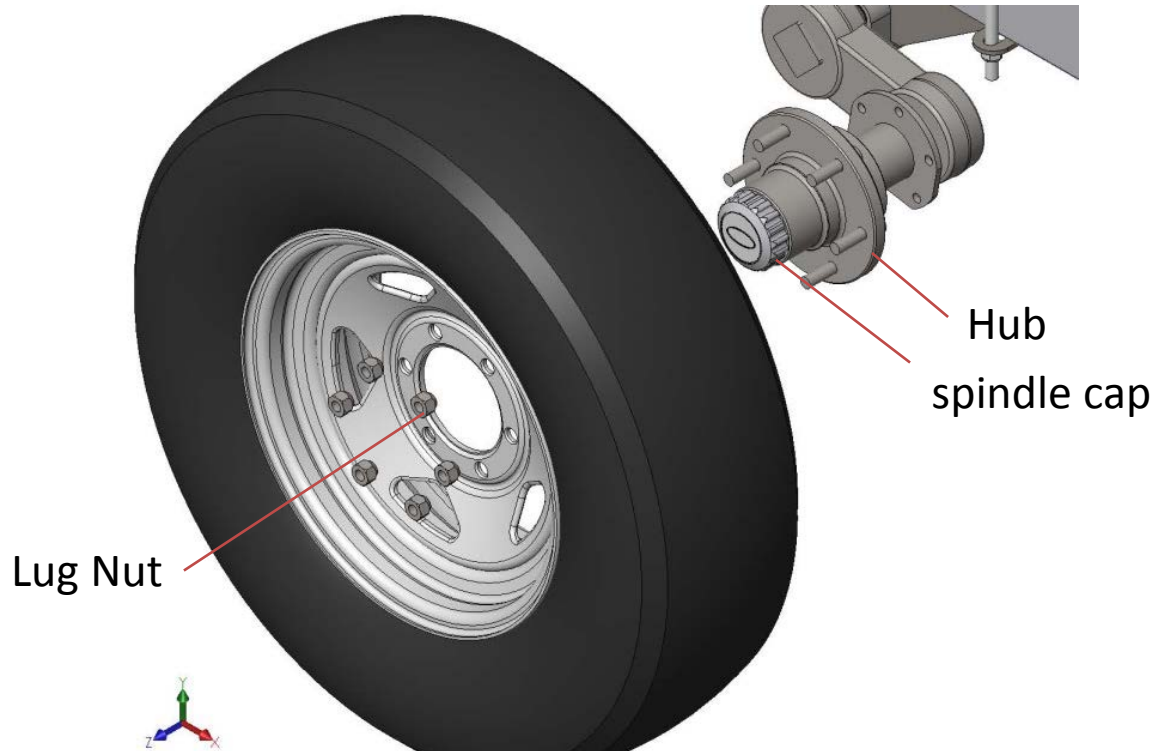
No Brake Axle

- Loosen lug nuts. Do not remove the lug nuts at this point, simply loosen them to about 50% pressure.
- Use a jack to lift the trailer off the ground. Place the jack under the axle, close to the frame to lift the trailer.
- Place jack stand under frame just behind chassis mounting on both sides. Larger trailers and trailers with boats on, will require more jack stands equally placed under the frame as need for weight and stability.

Exchange Procedure

No Brake Axle

- Remove the lug nuts and pull the tire off the trailer. Make sure to pull the tire straight toward yourself to remove it from the hub, keeping clear of the spindle cap. Repeat the process on the other side.

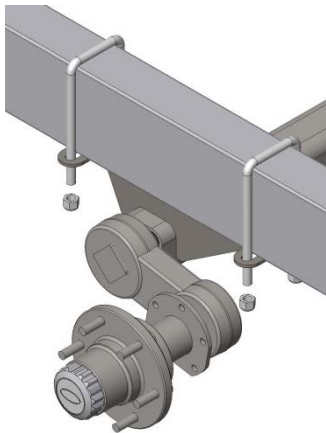


Exchange Procedure

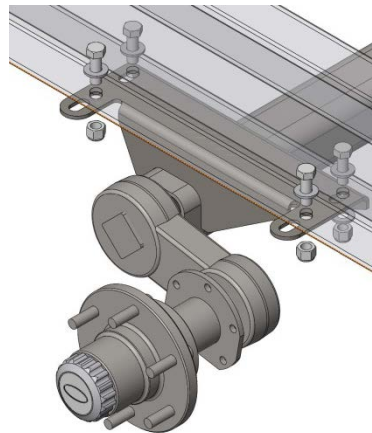
No Brake Axle

- Place the jack in the middle of the axle. Lift jack until it makes contact with the axle.
- EZ Loader has 3 mounting configurations. Identify yours and proceed.

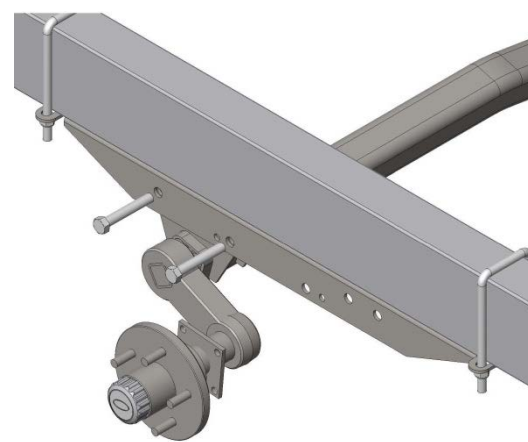
U-Bolt to Frame



Bolt to Frame



Bolt to Axle Hanger

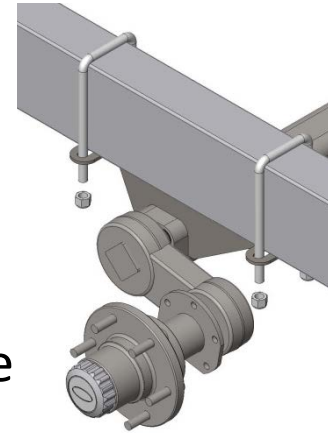


Exchange Procedure

No Brake Axle

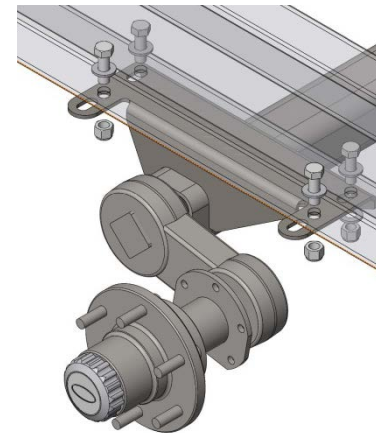
1) U-Bolt to Frame

- Take note, mark the u-bolt location.
- Remove four ½" locknut
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.



2) Bolt to Frame

- Remove four ½" bolts, washers & locknuts.
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.

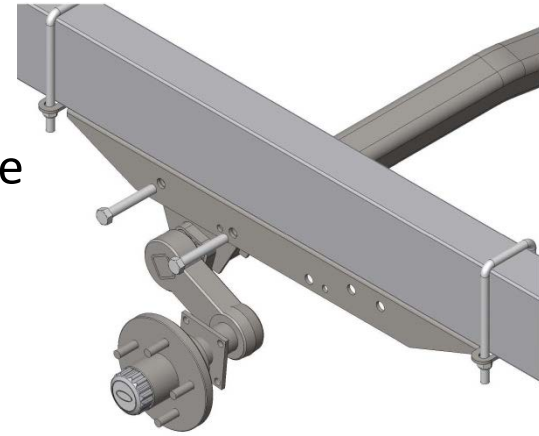


Exchange Procedure

No Brake Axle

3) Bolt to Axle Hanger

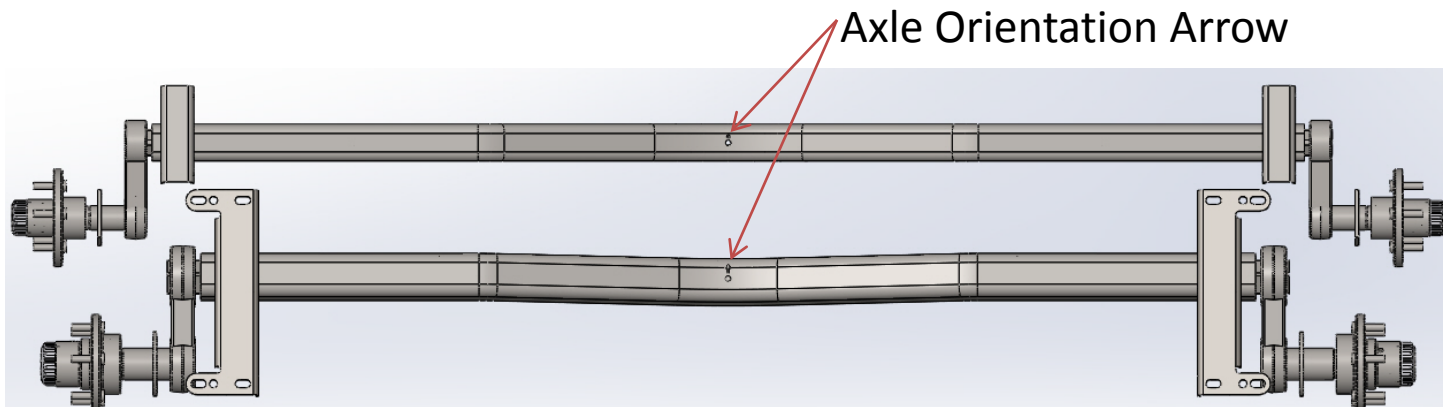
- Take note, mark if needed, the two 9/16" bolt location in the axle hanger. The new axle will mount in the same location.
- Remove two 9/16" locknuts and bolts.
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.



Exchange Procedure

No Brake Axle

- Slide the recalled axle out from under trailer.
- Slide the new axle under the trailer with axle orientation arrow pointing forward



- Center axle under the trailer frame.
- Place the jack in the middle of the axle.

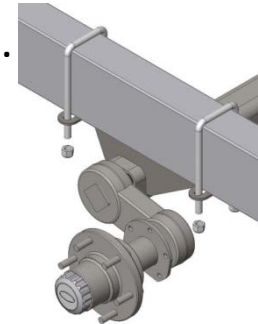
Exchange Procedure

No Brake Axle

- Identify your 1 of 3 mounting configurations and proceed.

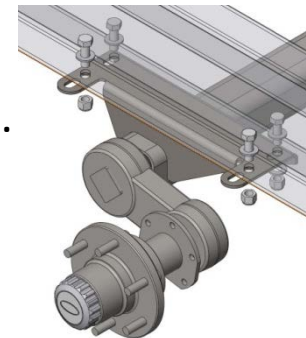
- **U-Bolt to Frame**

- Lift the axle, until the axle makes contact with the frame.
- Replace all removed frame mounting hardware on both sides at the marked location of the old axle mounting.
- Tighten all fasteners.



- **Bolt to Frame**

- Lift the axle, until the axle makes contact with the frame.
- Replace all removed frame mounting hardware on both sides.
- Tighten all fasteners.

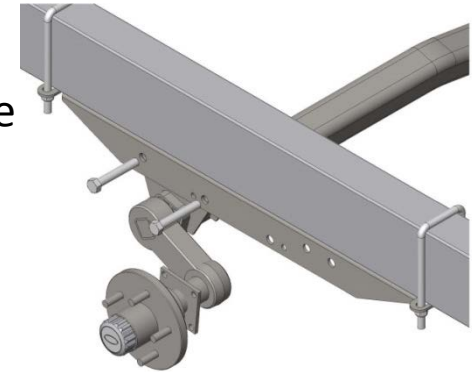


Exchange Procedure

No Brake Axle

- **Bolt to Axle Hanger**

- Replace the mounting bolts in the same hole locations used in the old axle mounting)
- Lift the axle, until the forward axle mounting hole aligns with the forward mounting hanger hole.
- Replace 9/16" bolt and locknut. Do not tighten.
- Repeat the process on the other side.
- Remove jack.
- With one hand, swing the axle to the rear until the back mounting hole aligns with the back hanger hole.
- Replace 9/16" bolt and locknut. Do not tighten.
- Repeat the process on the other side.
- Tighten all fasteners.



Exchange Procedure

No Brake Axle

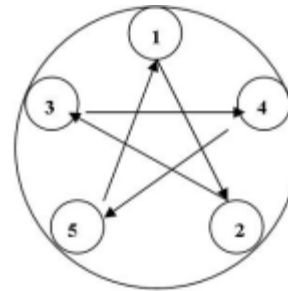
Now that the axle and chassis mounting hardware are securely tightened

- Replace the tire. Make sure to keep clear of the spindle cap.
- Tighten on the lug nuts about 50% pressure.
- Repeat the process on the other side.
- If there is more than one recalled axle on this trailer, identify the other axle and/or axles configurations and follow the exchange procedure instructions for that axle and/or axles.

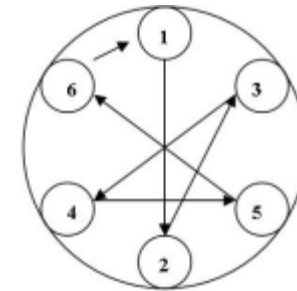
Exchange Procedure

No Brake Axle

- Place the jack under the trailer frame and lift the trailer up just enough to remove jack stands and return trailer to ground on both sides.
- Torque lug nuts to 80 lbs./ft. using a crisscross pattern as shown in diagram
- Exchange procedure complete.



Five-Bolt



Six-Bolt

EXCHANGE PROCEDURE HYDRAULIC DISC BRAKE AXLE

Dexter Torsion Arm Recall

EP1756



Exchange Procedure

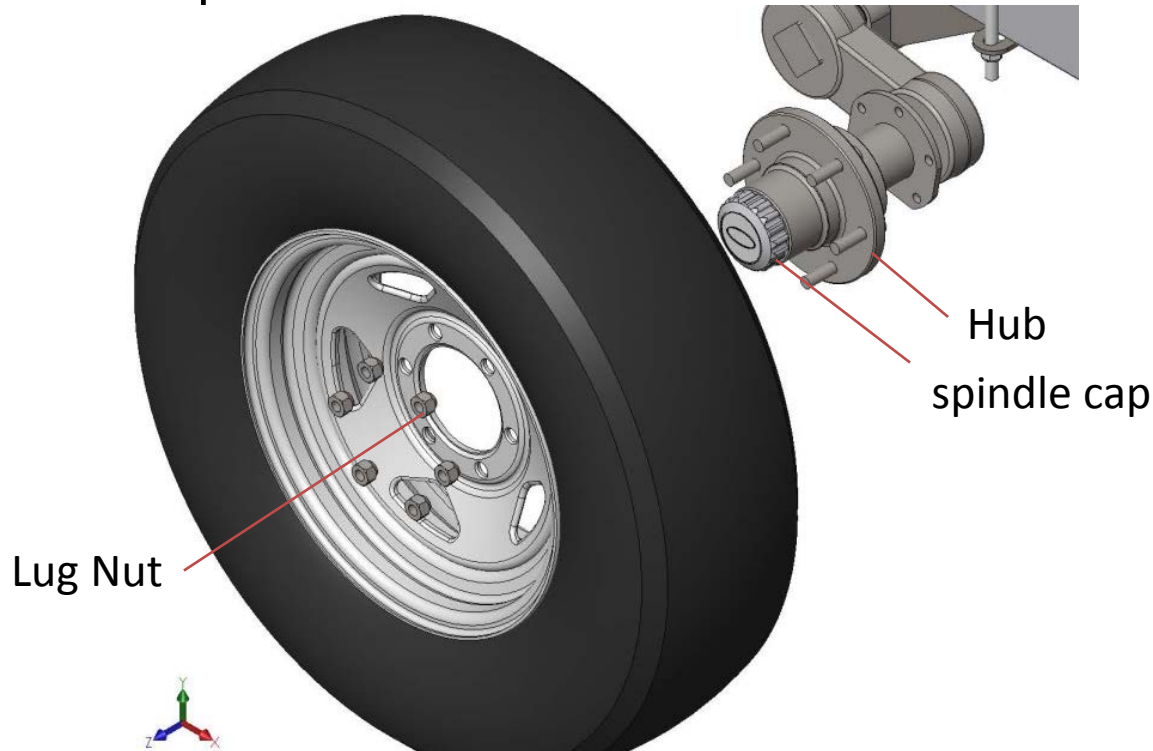
Hydraulic Disc Brake Axle

- Loosen lug nuts. Do not remove the lug nuts at this point, simply loosen them to about 50% pressure.
- Use a jack to lift the trailer off the ground. Place the jack under the axle, close to the frame to lift the trailer.
- Place jack stand under frame just behind chassis mounting on both sides. Larger trailers and trailers with boats on, will require more jack stands equally placed under the frame as need for weight and stability.

Exchange Procedure

Hydraulic Disc Brake Axle

- Remove the lug nuts and pull the tire off the trailer. Make sure to pull the tire straight toward yourself to remove it from the hub, keeping clear of the spindle cap.
- Repeat the process on the other side.



Exchange Procedure

Hydraulic Disc Brake Axle

- Take note of the zip tie location and tightness.
- Using cutting pliers, cut all the axle brake line zip ties.



- Lightly pull the brake line free of the axle. Do not bend or force the brake line.

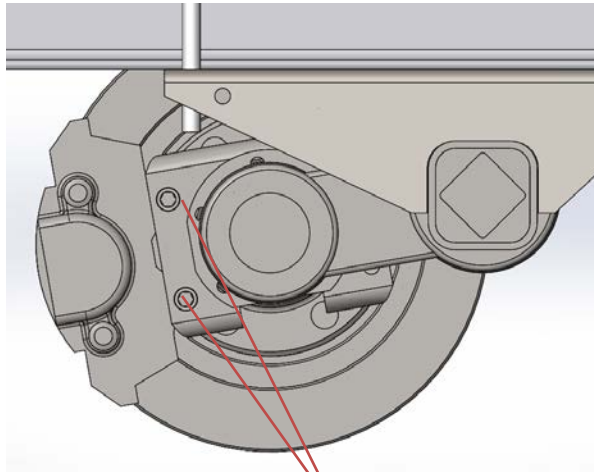


Exchange Procedure

Hydraulic Disc Brake Axle

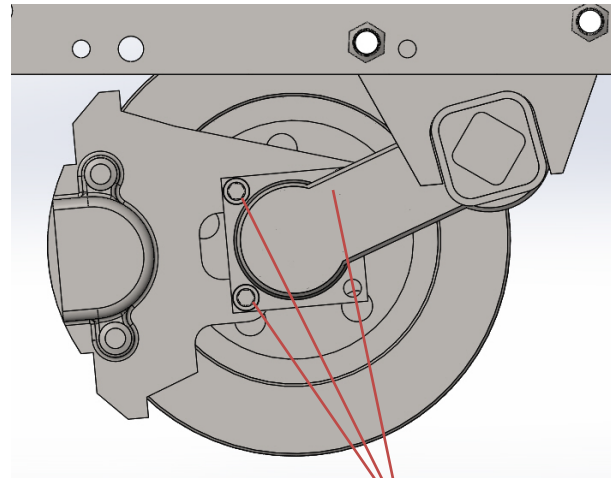
- EZ Loader has 2 disc brake caliper mounting configurations. Identify yours and proceed.

1) Caliper Mounting Plate



2 Bolt Mounting

2) Brake Flange Mounting



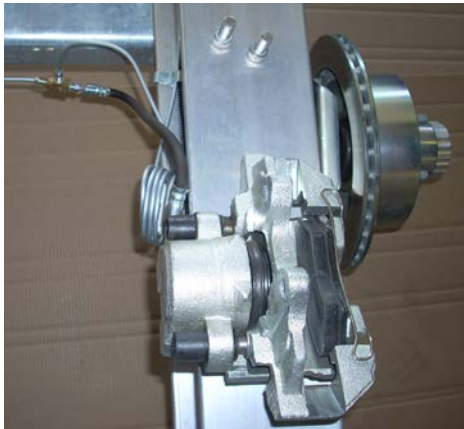
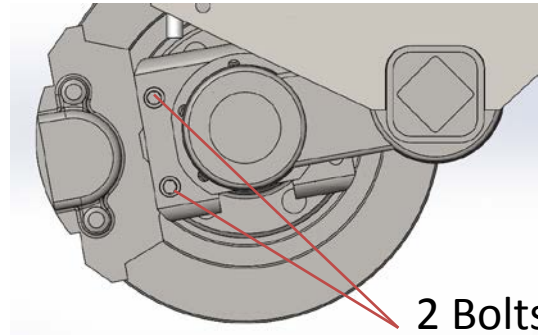
3 Bolt Mounting

Exchange Procedure

Hydraulic Disc Brake Axle

1) Caliper Mounting Plate

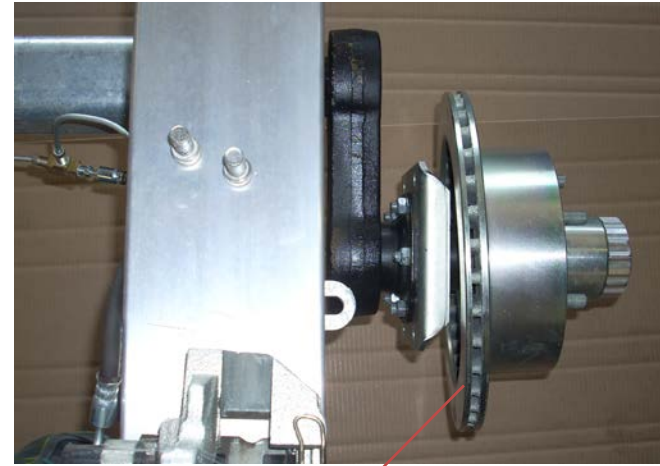
- Remove the two brake caliper mounting bolts.
- Place caliper on the trailer frame. Do not over bend or force the brake line.
- Lightly secure the caliper to the frame, to prevent dropping.



Exchange Procedure

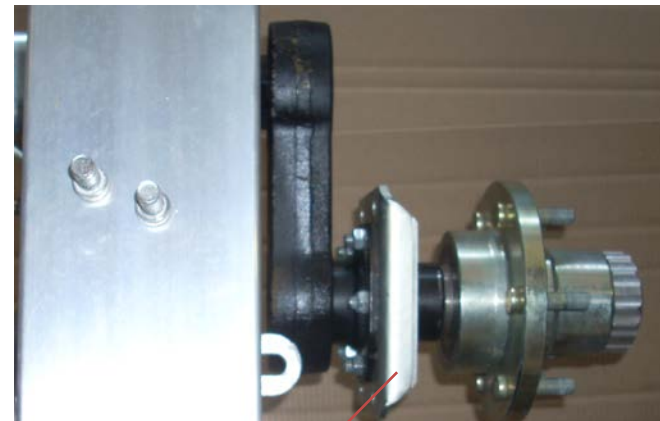
Hydraulic Disc Brake Axle

- Remove brake rotor. Make sure to pull the rotor straight toward yourself to remove it from the hub, keeping clear of the spindle cap and lug bolt treads.



Brake Rotor

- Remove the five bolts from the caliper mounting bracket.
- Remove the caliper mounting bracket.
- Repeat the process on the other side.



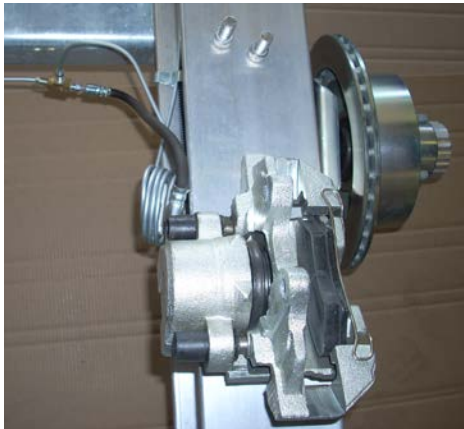
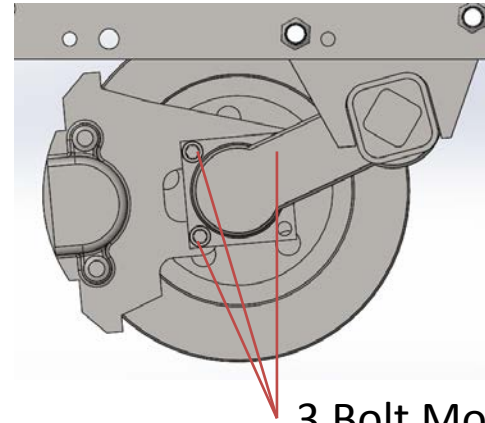
Caliper Mounting Bracket

Exchange Procedure

Hydraulic Disc Brake Axle

2) Brake Flange Mounting

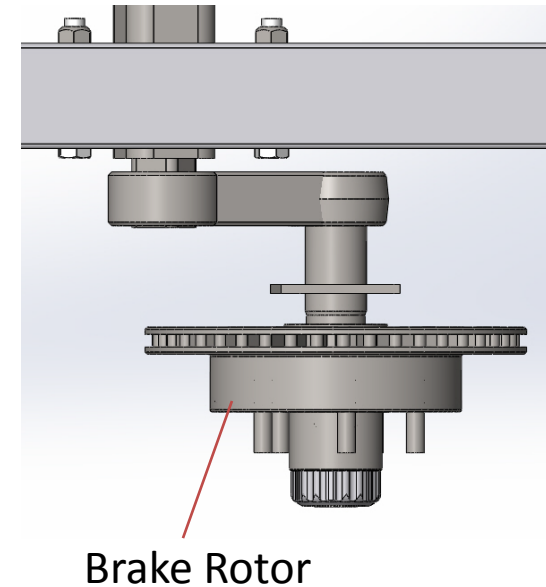
- Remove the three brake caliper mounting bolts. A jointed allen wrench socket will be required.
- Place caliper on the trailer frame.
- Do not over bend or force the brake line.
- Lightly secure the caliper to the frame, to prevent dropping.



Exchange Procedure

Hydraulic Disc Brake Axle

- Remove brake rotor. Make sure to pull the rotor straight toward yourself to remove it from the hub, keeping clear of the spindle cap and lug bolt threads.
- Repeat the process on the other side.

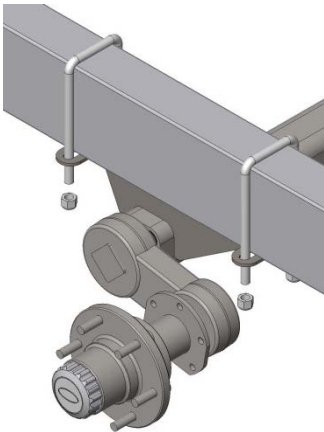


Exchange Procedure

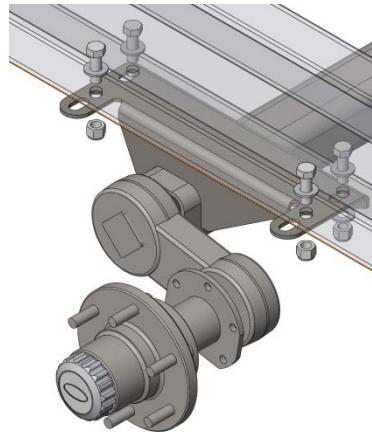
Hydraulic Disc Brake Axle

- Place the jack in the middle of the axle. Lift jack until it makes contact with the axle.
- EZ Loader has 3 axle mounting configurations. Identify yours and proceed.

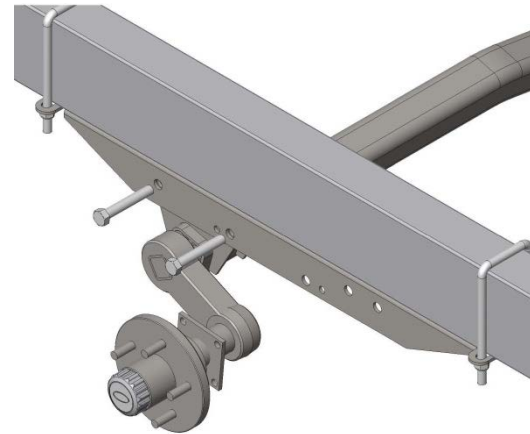
U-Bolt to Frame



Bolt to Frame



Bolt to Axle Hanger

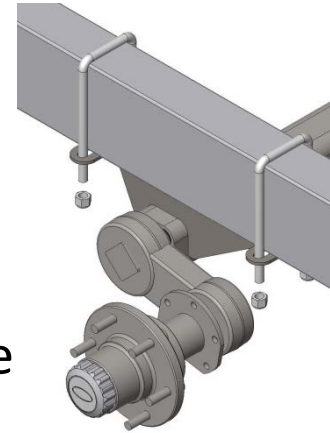


Exchange Procedure

Hydraulic Disc Brake Axle

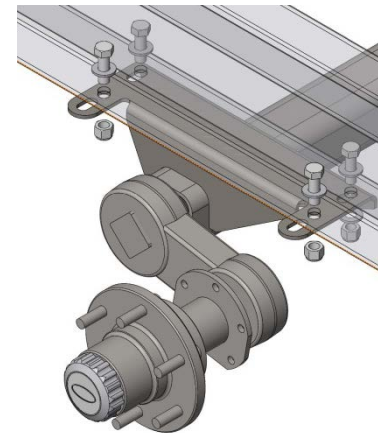
1) U-Bolt to Frame

- Take note, mark the u-bolt location.
- Remove four ½" locknut
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.



2) Bolt to Frame

- Remove four ½" bolts, washers & locknuts.
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.

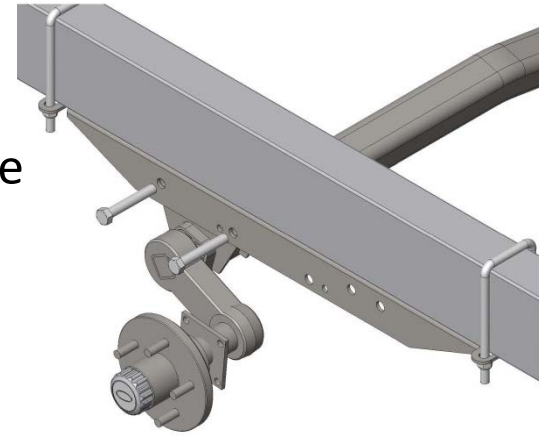


Exchange Procedure

Hydraulic Disc Brake Axle

3) Bolt to Axle Hanger

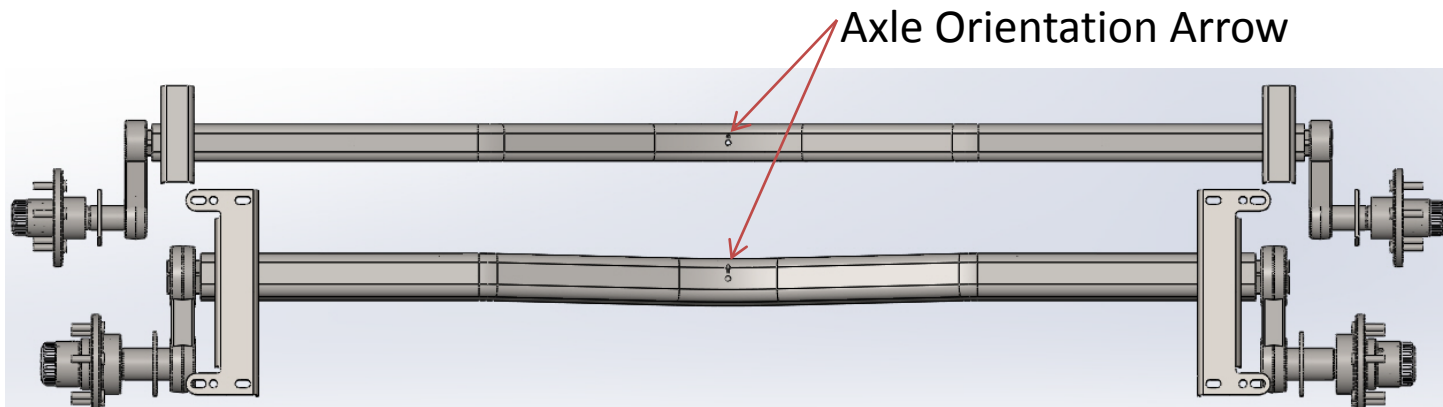
- Take note, mark if needed, the two 9/16" bolt location in the axle hanger. The new axle will mount in the same location.
- Remove two 9/16" locknuts and bolts.
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.



Exchange Procedure

Hydraulic Disc Brake Axle

- Slide the recalled axle out from under trailer.
- Slide the new axle under the trailer with axle orientation arrow pointing forward



- Center axle under the trailer frame.
- Place the jack in the middle of the axle.

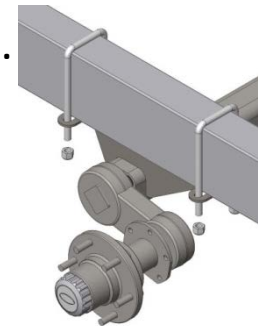
Exchange Procedure

Hydraulic Disc Brake Axle

- Identify your 1 of 3 axle mounting configurations and proceed.

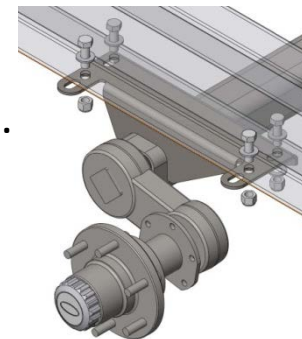
- **U-Bolt to Frame**

- Lift the axle, until the axle makes contact with the frame.
- Replace all removed frame mounting hardware on both sides at the marked location of the old axle mounting.
- Tighten all fasteners.



- **Bolt to Frame**

- Lift the axle, until the axle makes contact with the frame.
- Replace all removed frame mounting hardware on both sides.
- Tighten all fasteners.

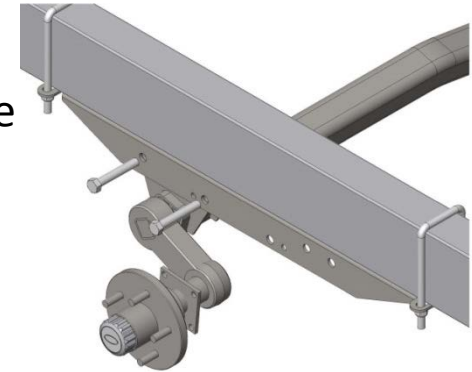


Exchange Procedure

Hydraulic Disc Brake Axle

- **Bolt to Axle Hanger**

- Replace the mounting bolts in the same hole locations used in the old axle mounting)
- Lift the axle, until the forward axle mounting hole aligns with the forward mounting hanger hole.
- Replace 9/16" bolt and locknut. Do not tighten.
- Repeat the process on the other side.
- Remove jack.
- With one hand, swing the axle to the rear until the back mounting hole aligns with the back hanger hole.
- Replace 9/16" bolt and locknut. Do not tighten.
- Repeat the process on the other side.
- Tighten all fasteners.



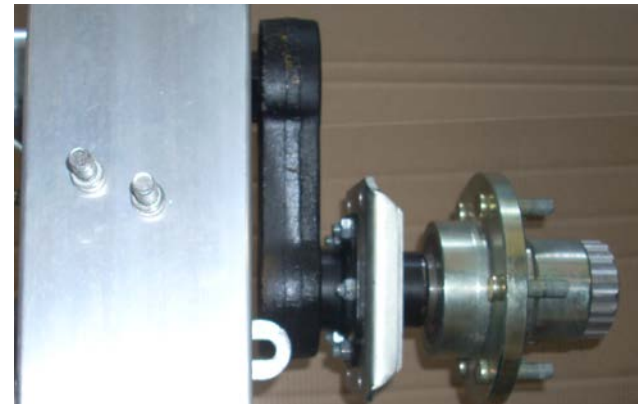
Exchange Procedure

Hydraulic Disc Brake Axle

- Identify your 1 of 2 disc brake caliper mounting configurations and proceed.

- **1) Caliper Mounting Plate**

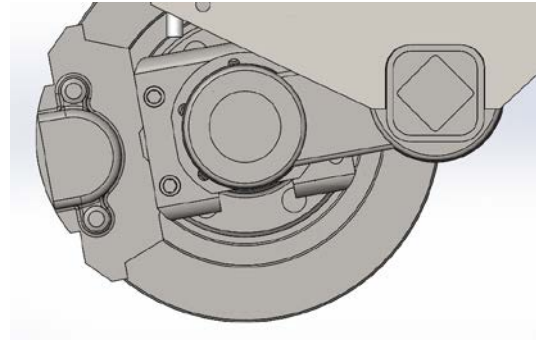
- Replace and tighten the caliper mounting bracket with the 5 bolts as shown. Torque to 35 lbs./ft.
- Replace the brake rotor. Make sure to keep clear of the spindle cap and lug bolt threads.



Exchange Procedure

Hydraulic Disc Brake Axle

- Unsecure the Caliper from the frame.
- When replacing the caliper and the two bolts, apply a small amount of Blue Lock-Tight to the threads and/or replace with new manufacture bolts. Torque to 55 lbs./ft.
- Do not bend or force the brake line.
- Tighten the bolts.
- Repeat the process on the other side.

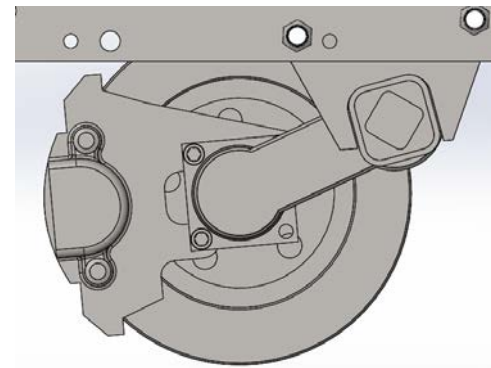
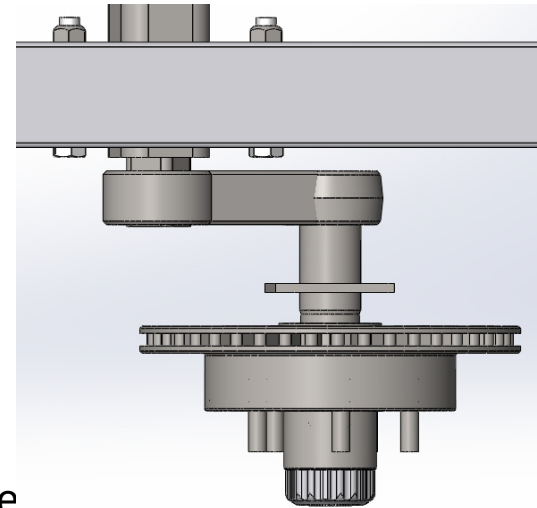


Exchange Procedure

Hydraulic Disc Brake Axle

- **2) Brake Flange Mounting**

- Replace the brake rotor. Make sure to keep clear of the spindle cap and lug bolt threads.
- Unsecure the Caliper from the frame.
- When replacing the caliper and the three bolts, apply a small amount of Blue Lock-Tight to the threads and/or replace with new manufacture bolts. Torque to 55 lbs./ft.
- Do not bend or force the brake line.
- Tighten the bolts.
- Repeat the process on the other side.



Exchange Procedure

Hydraulic Disc Brake Axle

- Lightly push the brake line back to the axle.
- Install the new zip ties in the old location
- Secure the brake lines tightly back to the axle.



Exchange Procedure

Hydraulic Disc Brake Axle

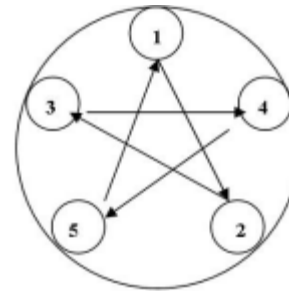
Now that the axle and chassis mounting hardware are securely tightened

- Replace the tire. Make sure to keep clear of the spindle cap.
- Tighten on the lug nuts about 50% pressure.
- Repeat the process on the other side.
- If there is more than one recalled axle on this trailer, identify the other axle and/or axles configurations and follow the exchange procedure instructions for that axle and/or axles.

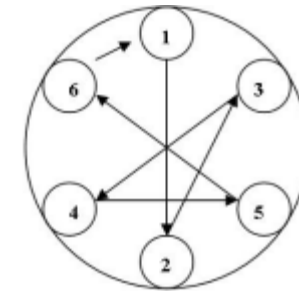
Exchange Procedure

Hydraulic Disc Brake Axle

- Place the jack under the trailer frame and lift the trailer up just enough to remove jack stands and return trailer to ground on both sides.
- Torque lug nuts to 80 lbs./ft. using a crisscross pattern as shown in diagram
- Exchange procedure complete.



Five-Bolt



Six-Bolt

EXCHANGE PROCEDURE HYDRAULIC DRUM BRAKE AXLE

Dexter Torsion Arm Recall

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Exchange Procedure

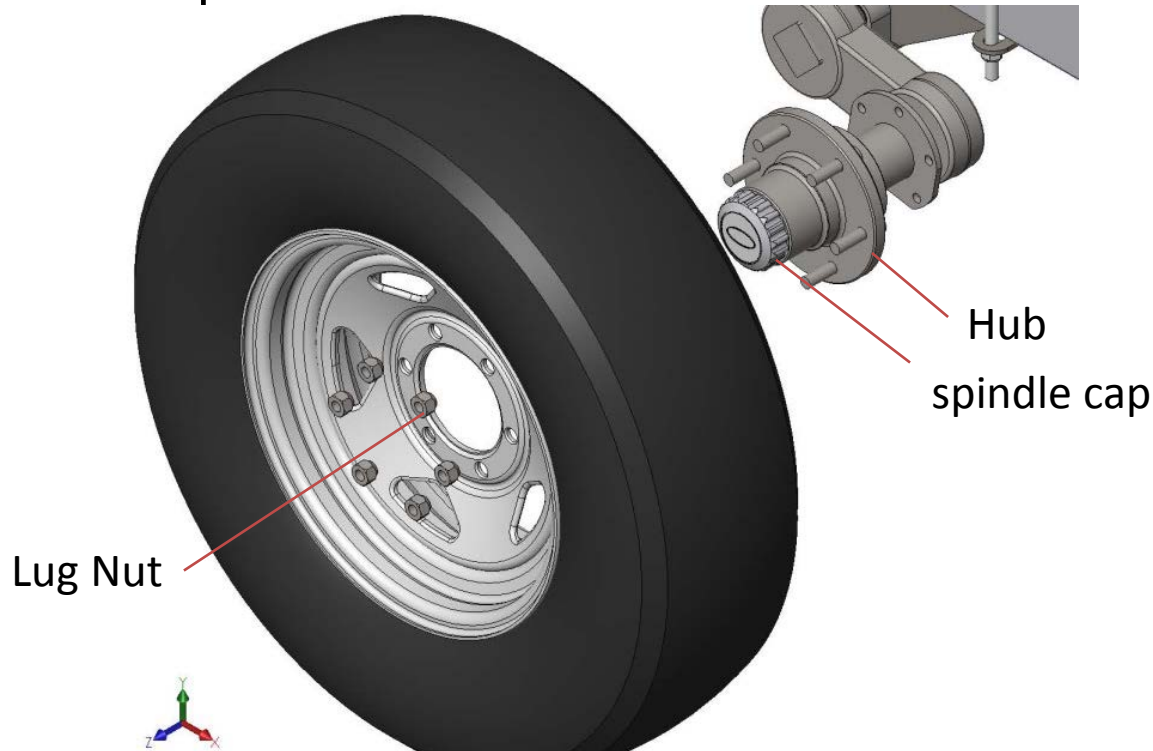
Hydraulic Drum Brake Axle

- Loosen lug nuts. Do not remove the lug nuts at this point, simply loosen them to about 50% pressure.
- Use a jack to lift the trailer off the ground. Place the jack under the axle, close to the frame to lift the trailer.
- Place jack stand under frame just behind chassis mounting on both sides. Larger trailers and trailers with boats on, will require more jack stands equally placed under the frame as need for weight and stability.

Exchange Procedure

Hydraulic Drum Brake Axle

- Remove the lug nuts and pull the tire off the trailer. Make sure to pull the tire straight toward yourself to remove it from the hub, keeping clear of the spindle cap.
- Repeat the process on the other side.



Exchange Procedure

Hydraulic Drum Brake Axle

- Take note of the zip tie location and tightness.
- Using cutting pliers, cut all the axle brake line zip ties.



- Lightly pull the brake line free of the axle. Do not bend or force the brake line.



Exchange Procedure

Hydraulic Drum Brake Axle

- Have clean rags available to capture brake fluid and keep the brake fittings clean.
- Using a brake line wrench, disconnect the brake line fitting from the drum backing plate as shown.
- Wrap the brake fitting with a rag.
- Do not over bend or force the brake line.
- Repeat the process on the other side.

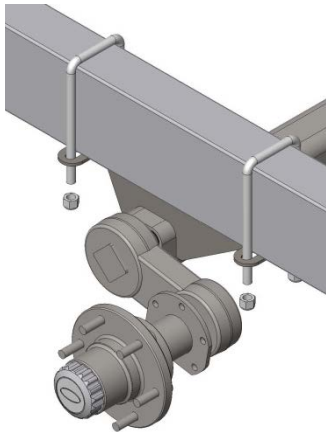


Exchange Procedure

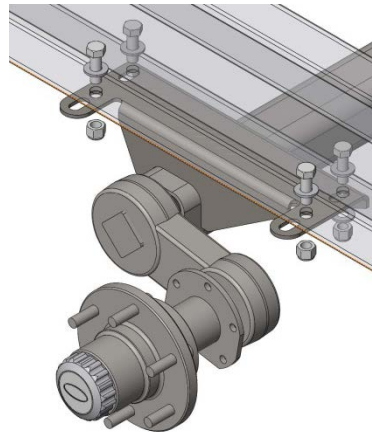
Hydraulic Drum Brake Axle

- Place the jack in the middle of the axle. Lift jack until it makes contact with the axle.
- EZ Loader has 3 axle mounting configurations. Identify yours and proceed.

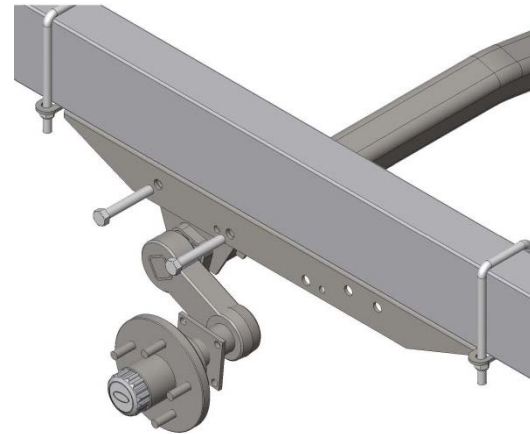
U-Bolt to Frame



Bolt to Frame



Bolt to Axle Hanger

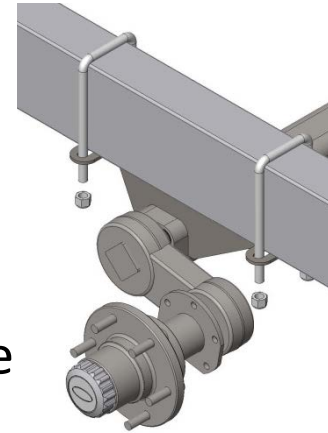


Exchange Procedure

Hydraulic Drum Brake Axle

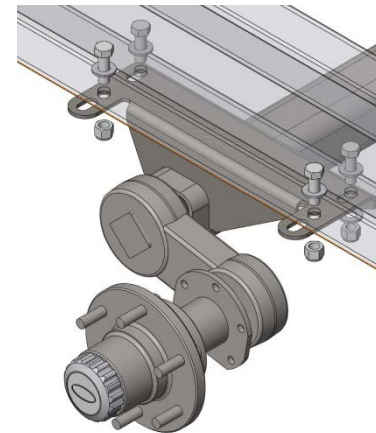
1) U-Bolt to Frame

- Take note, mark the u-bolt location.
- Remove four ½" locknut
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.



2) Bolt to Frame

- Remove four ½" bolts, washers & locknuts.
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.

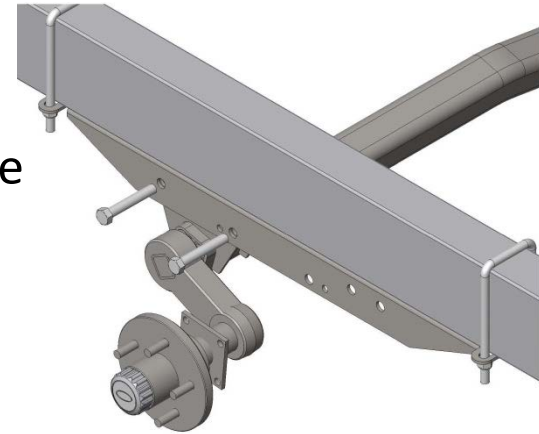


Exchange Procedure

Hydraulic Drum Brake Axle

3) Bolt to Axle Hanger

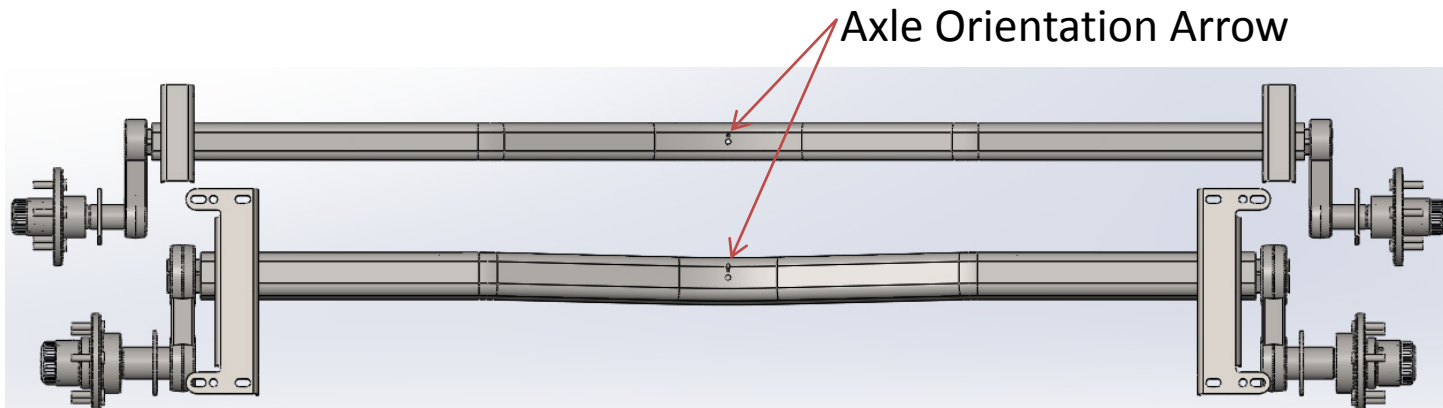
- Take note, mark if needed, the two 9/16" bolt location in the axle hanger. The new axle will mount in the same location.
- Remove two 9/16" locknuts and bolts.
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.



Exchange Procedure

Hydraulic Drum Brake Axle

- Slide the recalled axle out from under trailer.
- Slide the new axle under the trailer with axle orientation arrow pointing forward



- Center axle under the trailer frame.
- Place the jack in the middle of the axle.

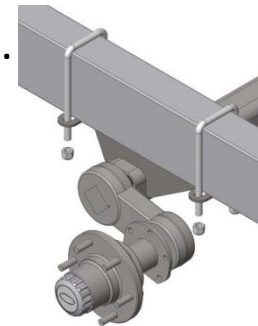
Exchange Procedure

Hydraulic Drum Brake Axle

- Identify your 1 of 3 axle mounting configurations and proceed.

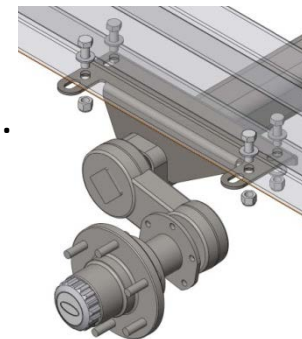
- **U-Bolt to Frame**

- Lift the axle, until the axle makes contact with the frame.
- Replace all removed frame mounting hardware on both sides at the marked location of the old axle mounting.
- Tighten all fasteners.



- **Bolt to Frame**

- Lift the axle, until the axle makes contact with the frame.
- Replace all removed frame mounting hardware on both sides.
- Tighten all fasteners.

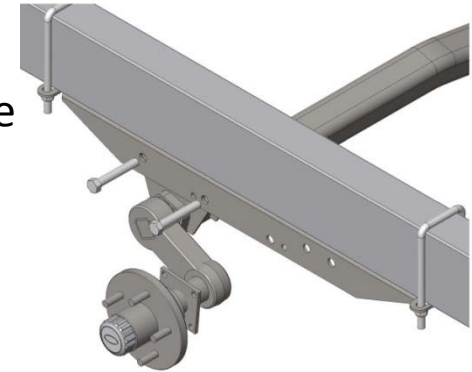


Exchange Procedure

Hydraulic Drum Brake Axle

- **Bolt to Axle Hanger**

- Replace the mounting bolts in the same hole locations used in the old axle mounting)
- Lift the axle, until the forward axle mounting hole aligns with the forward mounting hanger hole.
- Replace 9/16" bolt and locknut. Do not tighten.
- Repeat the process on the other side.
- Remove jack.
- With one hand, swing the axle to the rear until the back mounting hole aligns with the back hanger hole.
- Replace 9/16" bolt and locknut. Do not tighten.
- Repeat the process on the other side.
- Tighten all fasteners.



Exchange Procedure

Hydraulic Drum Brake Axle

- Unwrap the brake fitting from the rag.
 - Using a brake line wrench, connect the brake line fitting to the drum backing plate as shown.
 - Do not over bend or force the brake line.
 - Repeat the process on the other side.
-
- Lightly push the brake line back to the axle.
 - Install the new zip ties in the old location
 - Secure the brake lines tightly back to the axle.
 - If there is more than one recalled axle on this trailer, identify the other axle and/or axles configurations and follow the exchange procedure instructions for that axle and/or axles.



Exchange Procedure

Hydraulic Drum Brake Axle

- Fully read the following 2 pages about brake bleeding before proceeding with the bleeding process.

Bleed Screw Fitting with Rubber Cap
Wheel Cylinder



Exchange Procedure

Hydraulic Drum Brake Axle

MANUAL BLEEDING OF THE BRAKE SYSTEM

CAUTION

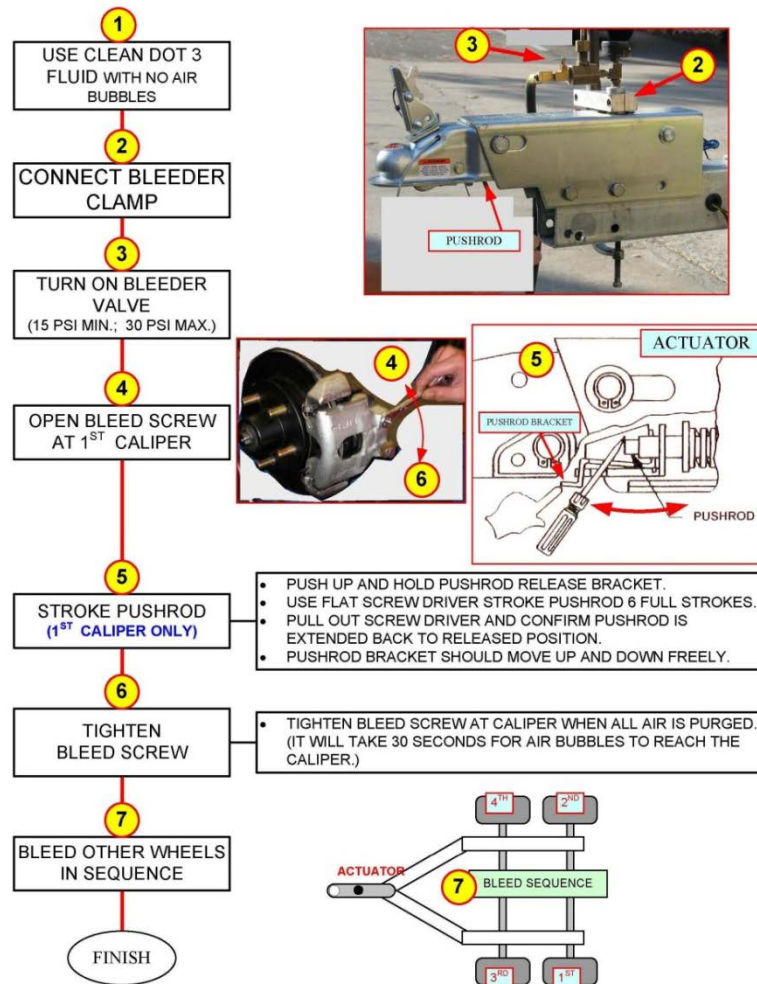
If you are not skilled in performing the following procedures, have a qualified service shop perform the job.

Check that all hydraulic fittings are secure. Read and understand all instructions before starting. Two people are required for manual bleeding.

- Remove the master cylinder reservoir plug and fill the reservoir with brake fluid. Use either DOT 3 or DOT 4 automotive brake fluid. Follow instructions on brake fluid container. Avoid shaking brake fluid container and pour fluid slowly to minimize air entrapment. Let fluid in reservoir stand until completely free of air bubbles.
- IMPORTANT:** Before bleeding brake lines, bleed the actuator master cylinder. Insert a screw driver through hole in bottom of inner member and use short strokes to pry on pushrod (while holding safety release bracket up) until no air bubbles are seen coming from small orifice hole in the bottom of the master cylinder reservoir.
- Start bleeding procedure on the brake furthest from master cylinder.
- At the brake assembly, connect a transparent bleeder hose to bleed screw fitting on wheel cylinder and submerge free end into a container partially filled with brake fluid. Do not reuse this fluid.
- The first person strokes the pushrod slowly while holding safety release bracket up. The second person opens the bleed screw fitting. He then closes the bleed screw fitting **BEFORE** the first person **SLOWLY** releases the pushrod. Repeat this procedure until the fluid expelled from the bleeder hose is free of air bubbles. Remember to always tighten the bleeder screw before releasing pushrod. During this procedure, the master cylinder reservoir fluid level must be maintained at no less than 1/2 full.
- Repeat steps 4 and 5 for the other brake and the brakes on the front axle, if equipped with tandem brake axles.
- If installation is tandem axle with brakes on both axles, repeat bleeding procedure on rear axle brakes for the second time to assure purging of all air in system.
- As a final check after bleeding is completed, stroke pushrod and check to be sure brake system is pressurized by attempting to rotate a tire.
- Push up on the safety release bracket to ensure that pushrod is in released position.
- After bleeding has been completed, re-check fluid level in master cylinder. Fill the master cylinder reservoir to indicator on reservoir plug. Do not overfill.

UFP Buddy BLENDED PROCEDURE

Work Instruction FRED WANG 3/31/09



Exchange Procedure

Hydraulic Drum Brake Axle

CAUTION

IMPORTANT: DO NOT USE BRAKE FLUID DRAINED FROM BRAKE SYSTEM TO REFILL MASTER CYLINDER RESERVOIR AS SUCH FLUIDS CONTAIN CONTAMINANTS FROM SYSTEM WHICH MAY RESULT IN BRAKE FAILURE OR COSTLY REPAIRS.

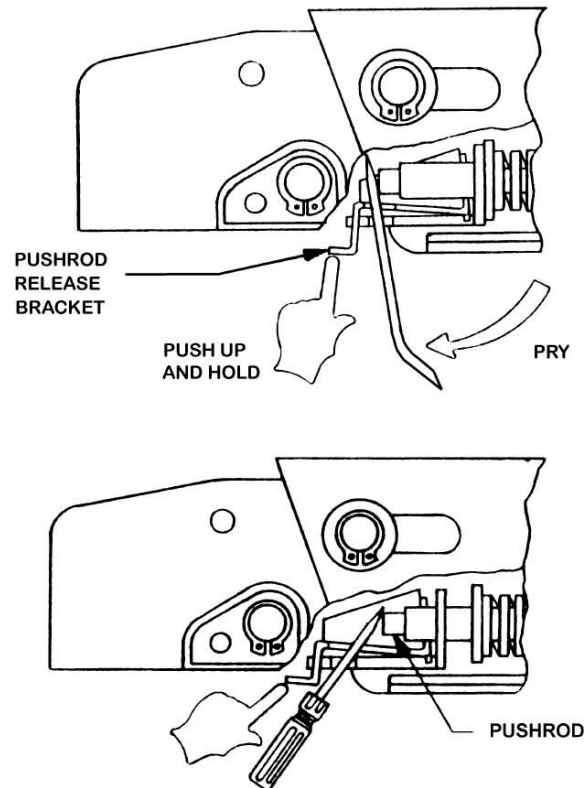


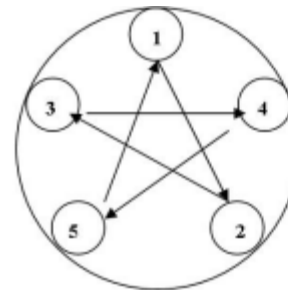
FIGURE 16 STROKING PUSHROD TO BLEED BRAKES

Exchange Procedure

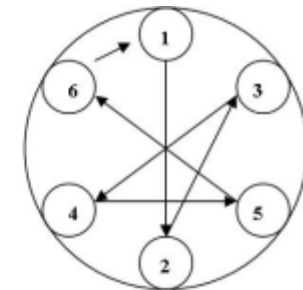
Hydraulic Drum Brake Axle

Now that the axle and chassis mounting hardware are securely tightened

- Replace the tire. Make sure to keep clear of the spindle cap.
- Tighten on the lug nuts about 50% pressure.
- Repeat the process on the other side.
- Place the jack under the trailer frame and lift the trailer up just enough to remove jack stands and return trailer to ground on both sides.
- Torque lug nuts to 80 lbs./ft. using a crisscross pattern as shown in diagram
- Exchange procedure complete.



Five-Bolt



Six-Bolt

EXCHANGE PROCEDURE ELECTRIC DRUM BRAKE AXLE

Dexter Torsion Arm Recall

EP1756



Exchange Procedure

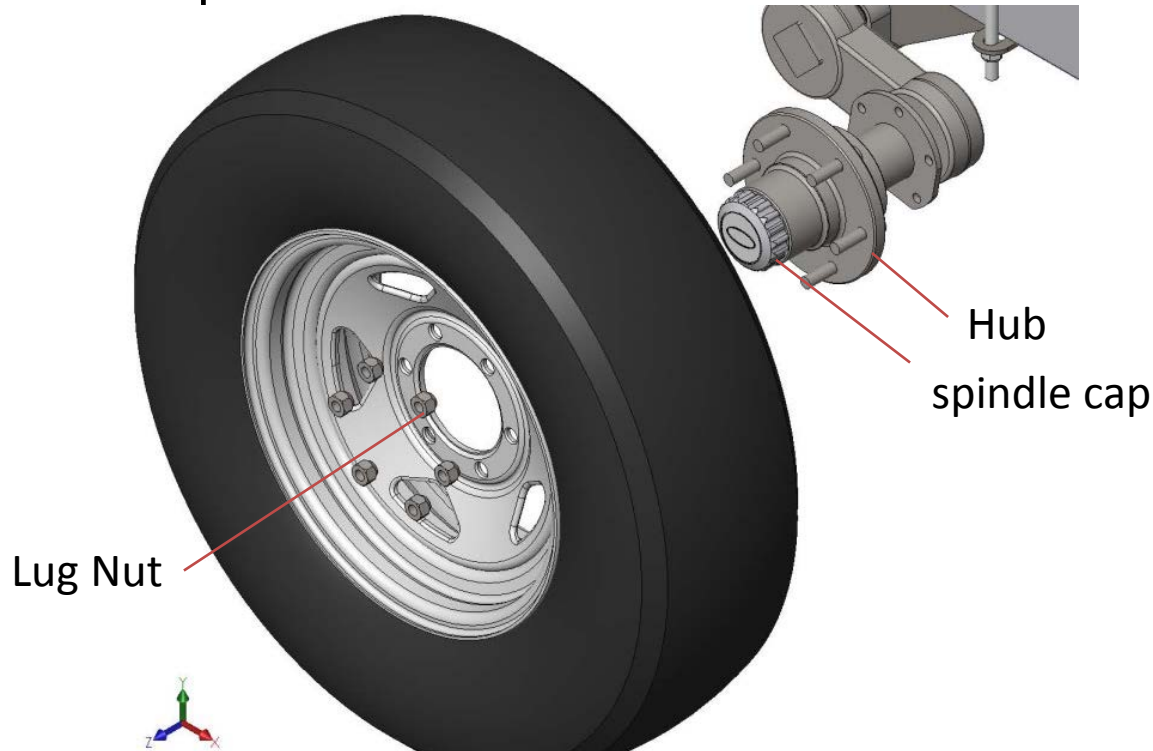
Electric Drum Brake Axle

- Loosen lug nuts. Do not remove the lug nuts at this point, simply loosen them to about 50% pressure.
- Use a jack to lift the trailer off the ground. Place the jack under the axle, close to the frame to lift the trailer.
- Place jack stand under frame just behind chassis mounting on both sides. Larger trailers and trailers with boats on, will require more jack stands equally placed under the frame as need for weight and stability.

Exchange Procedure

Electric Drum Brake Axle

- Remove the lug nuts and pull the tire off the trailer. Make sure to pull the tire straight toward yourself to remove it from the hub, keeping clear of the spindle cap.
- Repeat the process on the other side.



Exchange Procedure

Electric Drum Brake Axle

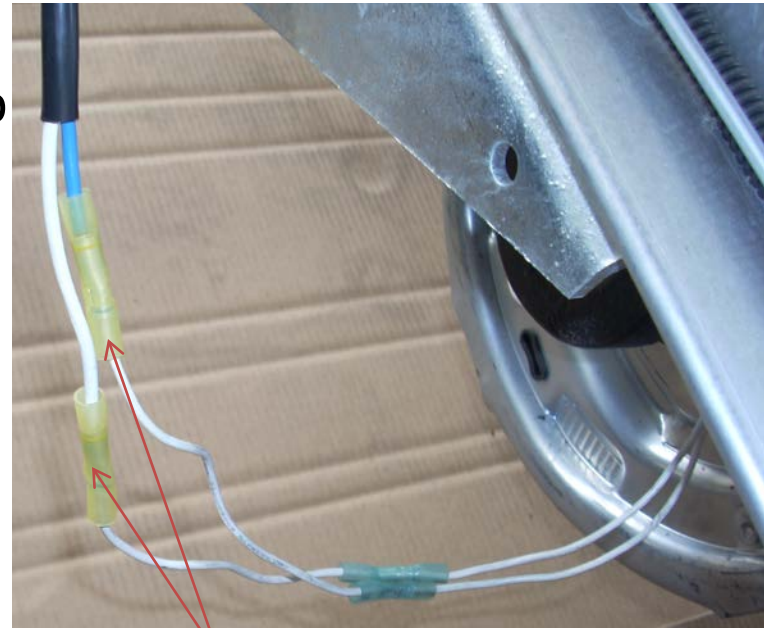
- Take note of the zip tie location and tightness.
- Using cutting pliers, cut the electric brake lines free of the axle.



Exchange Procedure

Electric Drum Brake Axle

- Remove wire loom from the backing plate, exposing the crimp and seal heat shrink butt connectors as shown.
- Cut and remove the yellow crimp and seal heat shrink butt connectors.
- Repeat the process on the other side.
- Now that the brake lines are fully disconnected place the brake lines out of the way.



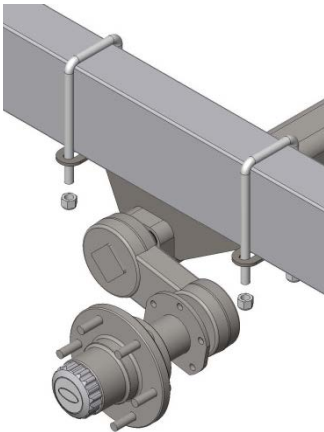
Yellow Crimp and Seal Heat Shrink Butt Connectors.

Exchange Procedure

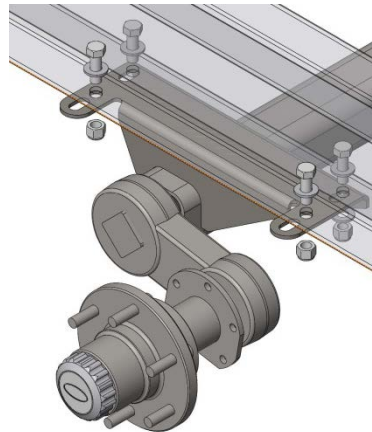
Electric Drum Brake Axle

- Place the jack in the middle of the axle. Lift jack until it makes contact with the axle.
- EZ Loader has 3 axle mounting configurations. Identify yours and proceed.

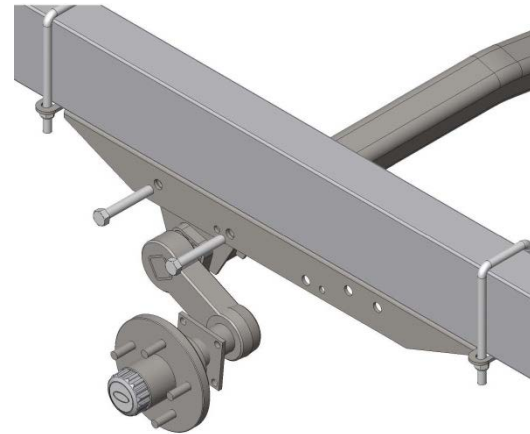
U-Bolt to Frame



Bolt to Frame



Bolt to Axle Hanger

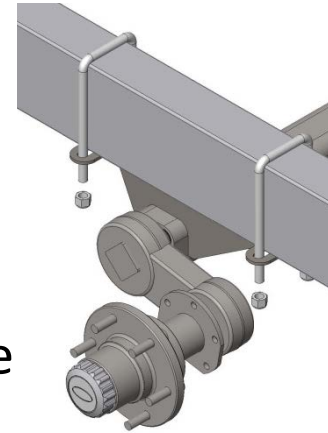


Exchange Procedure

Electric Drum Brake Axle

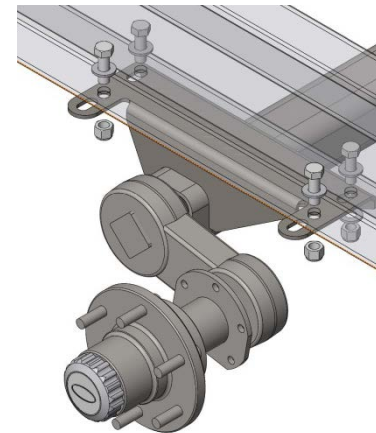
1) U-Bolt to Frame

- Take note, mark the u-bolt location.
- Remove four ½" locknut
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.



2) Bolt to Frame

- Remove four ½" bolts, washers & locknuts.
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.

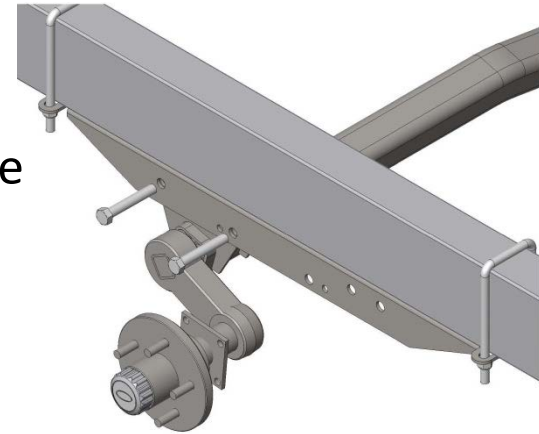


Exchange Procedure

Electric Drum Brake Axle

3) Bolt to Axle Hanger

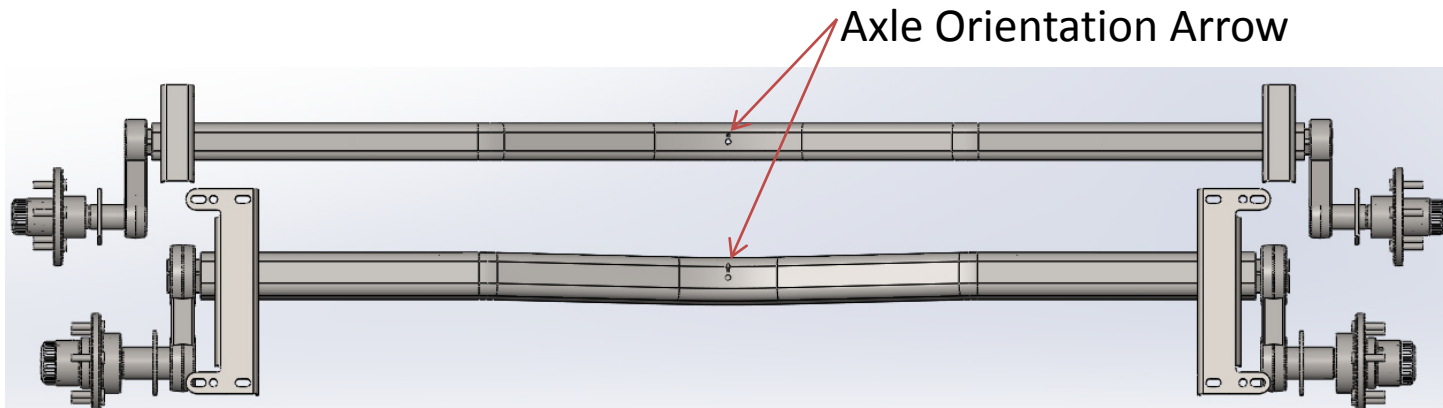
- Take note, mark if needed, the two 9/16" bolt location in the axle hanger. The new axle will mount in the same location.
- Remove two 9/16" locknuts and bolts.
- Repeat the process on the other side.
- Axle will be free, slowly, lower the axle to the ground with jack.



Exchange Procedure

Electric Drum Brake Axle

- Slide the recalled axle out from under trailer.
- Slide the new axle under the trailer with axle orientation arrow pointing forward



- Center axle under the trailer frame.
- Place the jack in the middle of the axle.

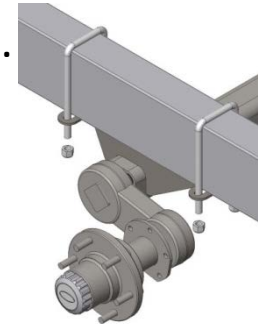
Exchange Procedure

Electric Drum Brake Axle

- Identify your 1 of 3 axle mounting configurations and proceed.

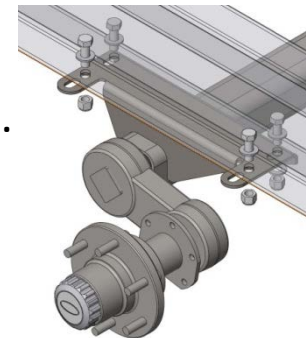
- **U-Bolt to Frame**

- Lift the axle, until the axle makes contact with the frame.
- Replace all removed frame mounting hardware on both sides at the marked location of the old axle mounting.
- Tighten all fasteners.



- **Bolt to Frame**

- Lift the axle, until the axle makes contact with the frame.
- Replace all removed frame mounting hardware on both sides.
- Tighten all fasteners.

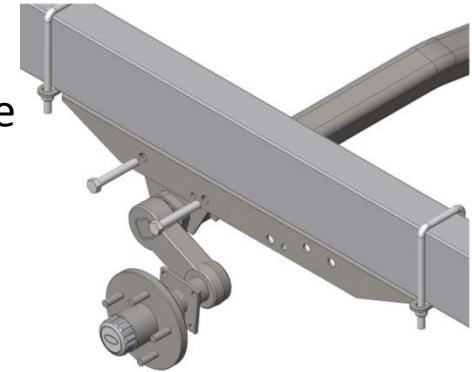


Exchange Procedure

Electric Drum Brake Axle

- **Bolt to Axle Hanger**

- Replace the mounting bolts in the same hole locations used in the old axle mounting)
- Lift the axle, until the forward axle mounting hole aligns with the forward mounting hanger hole.
- Replace 9/16" bolt and locknut. Do not tighten.
- Repeat the process on the other side.
- Remove jack.
- With one hand, swing the axle to the rear until the back mounting hole aligns with the back hanger hole.
- Replace 9/16" bolt and locknut. Do not tighten.
- Repeat the process on the other side.
- Tighten all fasteners.



Exchange Procedure

Electric Drum Brake Axle

- Strip a minimum of a ¼” of insulation from the four cut wires using the appropriate wire gauge setting.
- Insert one of the four wires into the end of a new yellow crimp and seal heat shrink butt connector.
- Use the yellow crimp die setting, crimp the crimp and seal heat shrink butt connector.



Exchange Procedure

Electric Drum Brake Axle

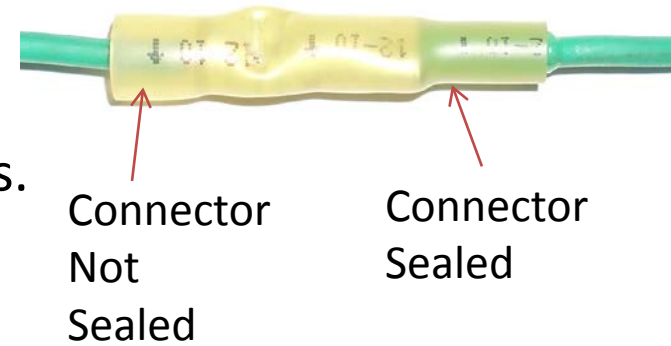
- Test your crimp by lightly tugging on the wires. If the wire pulls free, cut the wire and repeat the process.
- Repeat the connection process on the other wires
- The connectors should look like this when reconnected.



Exchange Procedure

Electric Drum Brake Axle

- Heat the connector with a heat gun from the center out until the tubing is fully shrunk and sealed on the wires. Keep the heat moving to prevent burning of the wire insulation.



Exchange Procedure

Electric Drum Brake Axle

- Reinstall the wire loom.
 - Apply black electrical tape around the wire next to the backing plate.
 - Slide wire loom over the tape, allowing the tape to slip into the slit in the wire loom
 - Fully wrap the wire loom with tape to secure.
 - Apply tape at regular intervals as required to secure.
- Repeat the process on the other side.



Exchange Procedure

Electric Drum Brake Axle

- Place the brake line back on the axle.
- Install the new zip ties in the old locations.
- Secure the brake lines tightly back to the axle.



Exchange Procedure

Electric Drum Brake Axle

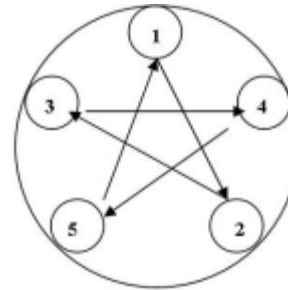
Now that the axle and chassis mounting hardware are securely tightened

- Replace the tire. Make sure to keep clear of the spindle cap.
- Tighten on the lug nuts about 50% pressure.
- Repeat the process on the other side.
- If there is more than one recalled axle on this trailer, identify the other axle and/or axles configurations and follow the exchange procedure instructions for that axle and/or axles.

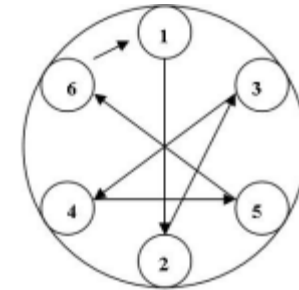
Exchange Procedure

Electric Drum Brake Axle

- Place the jack under the trailer frame and lift the trailer up just enough to remove jack stands and return trailer to ground on both sides.
- Torque lug nuts to 80 lbs./ft. using a crisscross pattern as shown in diagram
- Exchange procedure complete.



Five-Bolt



Six-Bolt