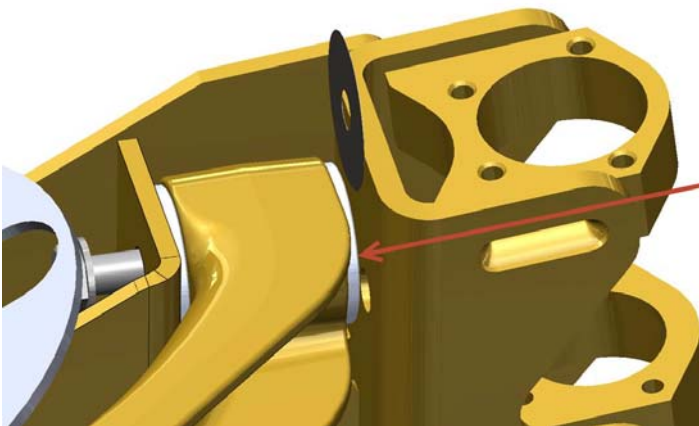


Axle Clevis Shim Installation

1. Set the parking brakes and chock the drive tires.
2. Place the axle on the ground with no air pressure in the suspension springs
3. If replacing bushings at the same time go to step 11.
4. Using a $\frac{3}{4}$ socket remove the (2) $\frac{1}{2}$ -13 bolts from the bottom of the air spring.
5. Using a $\frac{1}{2}$ open end wrench push the collar on the push to connect fitting to release the $\frac{1}{2}$ tubing.
6. Using a 1-1/16 open end wrench remove the fitting from the top of the air spring.
7. Using a 9/16 wrench remove the (2) 3/8-16 bolts in the top of the air spring.
8. Set the air spring aside
9. Repeat steps 4 thru 8 on the opposite side.
10. Using a 1-1/8 wrench and socket remove the top pivot nut and washer.
11. Pull the pivot bolt inward until the end of the bolt is flush with the outward face of the bushing.



PUSH THE CONTROL ARM INBOARD AS MUCH AS POSSIBLE. THIS WILL ALLOW SHIM INSTALLATION.

12. Using a pry bar push the bushing inward as much as possible.
13. Install shims between the bushing face and the inside of the clevis. NOTE: Try to have the .02 thick shims on the outsides with thinner shims in between.
14. Install the $\frac{3}{4}$ washer and nut onto the end of the bolt
15. Torque the bolt to 225 – 275ft/lbs.
16. Repeat steps 10 thru 15 on the other (3) clevis positions.
17. Using a 9/16 wrench re-install the (2) 3/8-16 bolts that attach the top of the air spring to the bracket. Torque to 15 – 20ft/lbs.
18. Using a 1-1/16 open end wrench re-install the fitting into the top of the air spring.
19. Using a $\frac{3}{4}$ socket re-install the (2) $\frac{1}{2}$ -13 bolts into the bottom of the air spring piston. Torque the $\frac{1}{2}$ -13 bolts to 25 - 35ft/lbs.
20. Air up the truck to 100psi. Apply a minimum of 50psi to the air springs. Using soapy suds check for air leaks at the air spring fittings on both air springs.
21. Remove wheel chocks