



INSTALLATION INSTRUCTIONS

Hanger and Attaching Parts Kits – Rubber Bushed Suspension

- HAP-105-00 8K-9K Single Axle Kit
- HAP-205-06 8K Multi-Axle Kit for 33-1/2" Axle Spacing
- HAP-205-01 8K-9K Multi-Axle Kit for 8K - 36" & 9K - 38" Axle Spacing
- HAP-205-02 8K-9K Multi-Axle Kit for 42-1/4" Axle Spacing
- HAP-205-03 8K-9K Multi-Axle Kit for 48-1/2" Axle Spacing
- HAP-103-00 10K-15K Single Axle Kit
- HAP-203-01 10K-15K Multi-Axle Kit for 38" Axle Spacing

- HAP-203-02 10K-15K Multi-Axle Kit for 42-1/4" Axle Spacing
- HAP-203-03 10K-15K Multi-Axle Kit for 48-1/2" Axle Spacing
- HAP-158-00 10KGD Single Axle Kit
- HAP-258-01 10KGD Multi-Axle Kit for 38" Axle Spacing
- HAP-258-02 10KGD Multi-Axle Kit for 42-1/4" Axle Spacing
- HAP-258-03 10KGD Multi-Axle Kit for 48-1/2" Axle Spacing

Safety Precautions

Before welding and installing any suspension component parts to the trailer frame requiring the raising of the vehicle, make sure that the vehicle is properly supported on lift stands of sufficient capacity. Follow the vehicle manufacturer's recommendations for lifting and supporting the unit.

Do not lift with or place supports under any part of the suspension system unless specifically directed to do so during these installation steps.

CAUTION

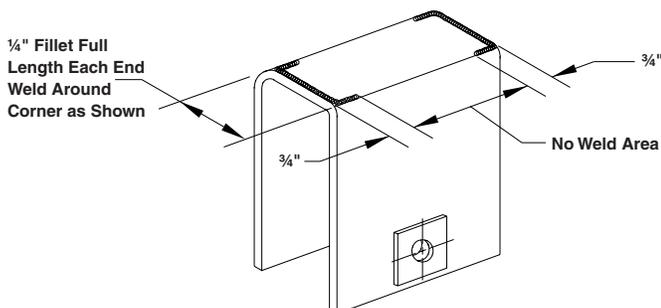
Never rely on jacks alone to support the vehicle. A vehicle that is not securely supported may fall and cause severe injuries or death.

Safety glasses should be worn at all times when assembling or disassembling axles and their components. Failure to comply may result in serious eye injury.

General Guidelines for Hanger Welding

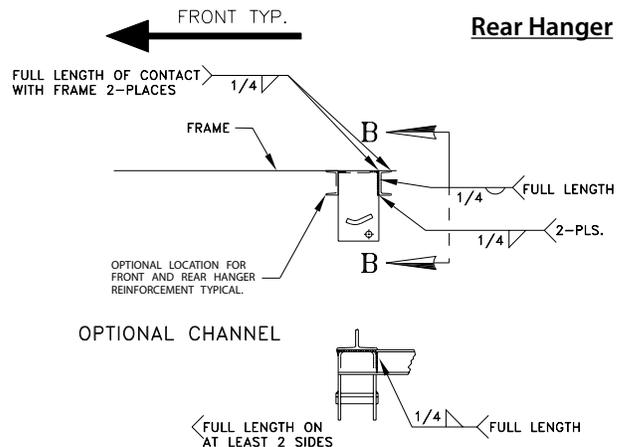
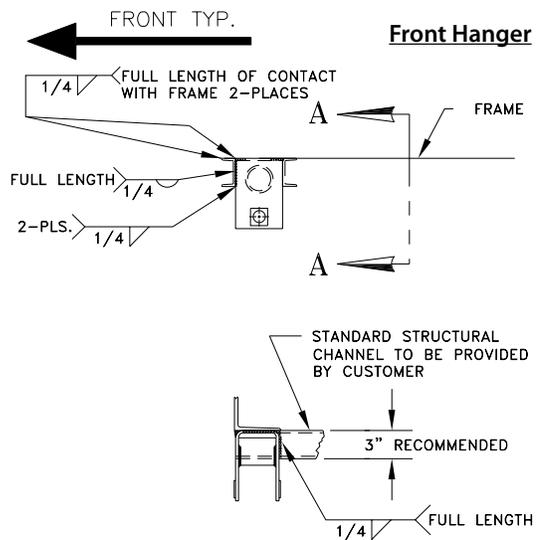
- It is recommended that the hangers be centered on the frame rails.
- Starting and stopping at the corners of the hangers is NOT recommended.
- Craters/ends of welds should be back-filled to prevent cracking.
- The weld should be inspected for cracks, undercut, poor porosity, and inadequate penetration that may cause the hanger to fail.

Recommended Hanger Welding Procedure

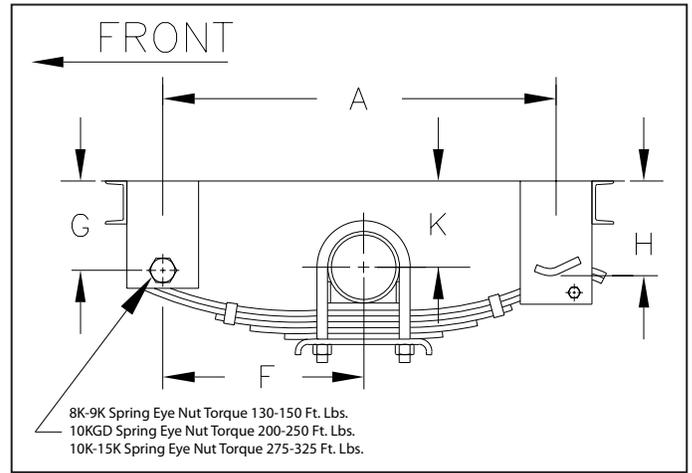
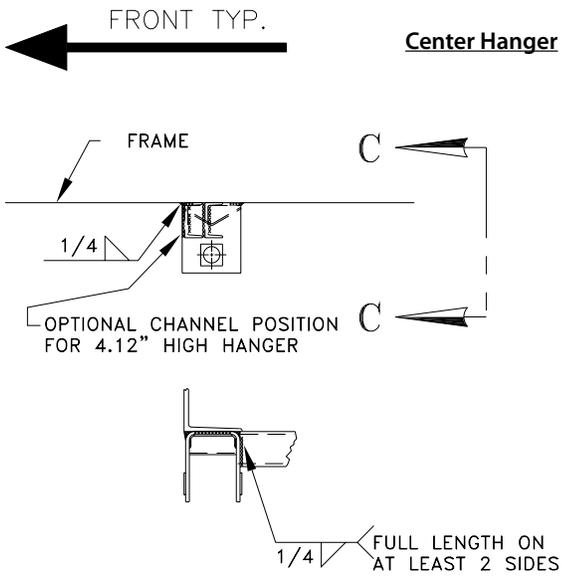


Cross Frame Reinforcement

Cross frame reinforcement recommended on hangers to assure full load carrying capacity of axle suspension. Standard 3" structural channel is suggested as reinforcement members. Weld as indicated.

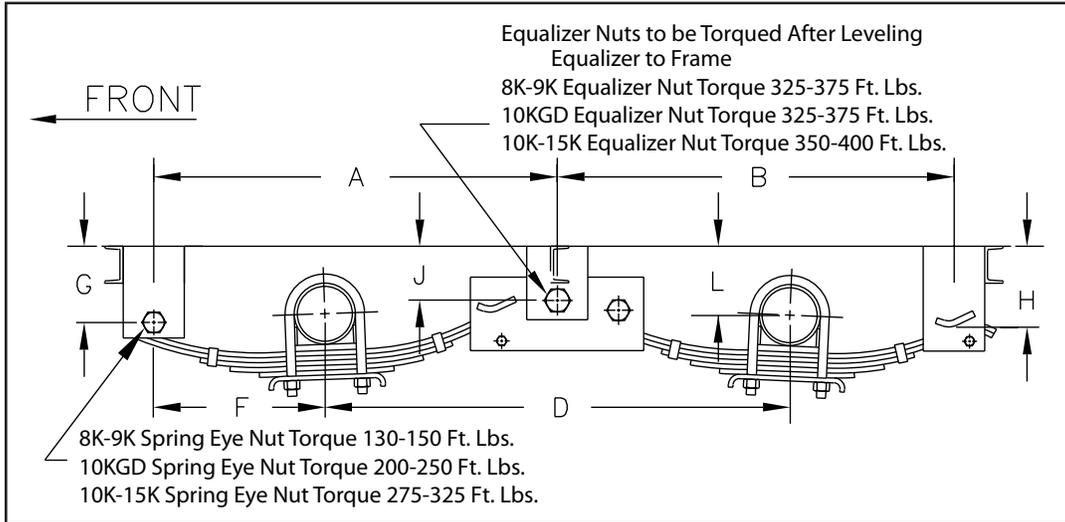


8K-15K Axle Installation Instructions - Single



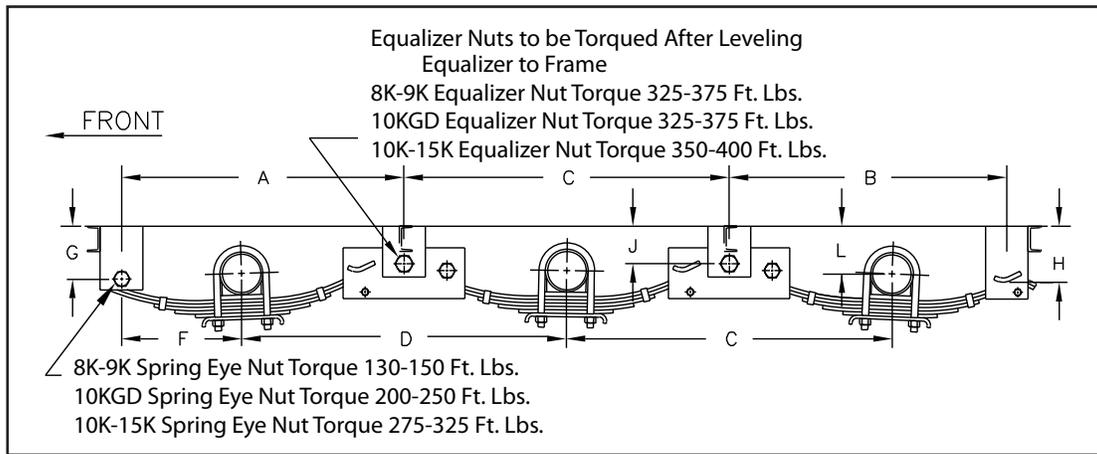
Axle - Single	Kit	A	F	G	H	K
8K	HAP-105-00	24.00	11.50	5.00	4.90	4.40
9K	HAP-105-00	26.88	13.65	5.00	4.90	5.10
10KGD	HAP-158-00	27.44	14.00	5.21	5.46	5.00
10K-15K	HAP-103-00	27.44	14.00	6.25	6.63	6.10

8K-15K Axle Installation Instructions - Tandem



Axle	Kit	A	B	D	F	G	H	J	L
8K Multi	HAP-105-00	30.44	30.44	36.00	11.50	5.00	4.90	4.50	4.20
	HAP-205-01								
8K Multi	HAP-105-00	29.19	29.19	33.50	11.50	5.00	4.90	4.50	4.20
	HAP-205-06								
9K Multi	HAP-105-00	32.44	32.88	38.00	13.65	5.00	4.90	4.50	4.70
	HAP-105-00								
	HAP-205-02								
9K Multi	HAP-105-00	34.56	35.00	42.25	13.65	5.00	4.90	4.50	4.70
	HAP-205-01								
	HAP-205-03								
10KGD Multi	HAP-158-00	33.00	32.44	38.00	14.00	5.21	5.46	4.12	4.80
	HAP-258-01								
	HAP-158-00								
10KGD Multi	HAP-158-00	35.12	34.56	42.25	14.00	5.21	5.46	4.12	4.80
	HAP-258-02								
	HAP-258-03								
10K-15K Multi	HAP-103-00	33.00	32.44	38.00	14.00	6.25	6.63	4.12	5.30
	HAP-203-01								
	HAP-103-00								
10K-15K Multi	HAP-103-00	35.12	34.56	42.25	14.00	6.25	6.63	4.12	5.30
	HAP-203-02								
	HAP-203-03								
10K-15K Multi	HAP-103-00	38.25	37.69	48.50	14.00	6.25	6.63	4.12	5.30
	HAP-203-01								
	HAP-203-03								

8K-15K Axle Installation Instructions - Triple



Axle	Kit	A	B	C	D	F	G	H	J	L
8K Multi	HAP-105-00	30.44	30.44	36.00	36.00	11.50	5.00	4.90	4.50	4.20
	HAP-205-01									
8K Multi	HAP-105-00	29.19	29.19	33.50	33.50	11.50	5.00	4.90	4.50	4.20
	HAP-205-06									
9K Multi	HAP-105-00	32.44	32.88	38.00	38.00	13.65	5.00	4.90	4.50	4.70
	HAP-205-01									
	HAP-205-02	34.56	35.00	42.25	42.25	13.65	5.00	4.90	4.50	4.70
9K Multi	HAP-105-00	37.69	38.12	48.50	48.50	13.65	5.00	4.90	4.50	4.70
	HAP-205-03									
	HAP-205-03									
10KGD Multi	HAP-158-00	33.00	32.44	38.00	38.00	14.00	5.21	5.46	4.12	4.80
	HAP-258-01									
	HAP-258-02	35.12	34.56	42.25	42.25	14.00	5.21	5.46	4.12	4.80
10KGD Multi	HAP-158-00	38.25	37.69	48.50	48.50	14.00	5.21	5.46	4.12	4.80
	HAP-258-03									
	HAP-258-03									
10K-15K Multi	HAP-103-00	33.00	32.44	38.00	38.00	14.00	6.25	6.63	4.12	5.30
	HAP-203-01									
	HAP-203-02	35.12	34.56	42.25	42.25	14.00	6.25	6.63	4.12	5.30
10K-15K Multi	HAP-103-00	38.25	37.69	48.50	48.50	14.00	6.25	6.63	4.12	5.30
	HAP-203-03									