

AXLES AND SUSPENSION

Purpose

This document outlines the basic instructions for removing and replacing an axle beam and associated hardware.

Safety

⚠ WARNING

Lift and support unit per manufacturer's requirements.

Lift unit by the frame and never the axle or suspension. Do not go under unit unless it is properly supported by jack stands. Unsupported units can fall causing death or serious injury.

Axle Beam Removal and Replacement

NOTE: See [TI-073](#) for proper axle orientation.

1. Lift and support the unit per manufacturer's requirements.
2. Remove lug nuts from the wheel on the axle receiving the new beam. Dismount the wheel.
3. Remove the dust cap.
4. Remove the cotter pin and discard. A new cotter pin is required after each replacement.
5. Remove the castle nut and other hardware on the spindle holding the hub on the spindle.
6. Remove hub from the spindle.
7. Cut the brake wires and remove fasteners to the backing plate.
8. Remove the backing plate with brake assembly from the spindle.
9. Remove nuts from the U-bolts and remove U-bolts from the axle beam.
10. Remove the axle beam from under the unit.
11. Install new axle beam under the unit.

NOTE: Be sure axle info tag and brake wires are facing the rear of the unit.

12. Install new U-bolts (mandatory) and tie plates (if necessary).

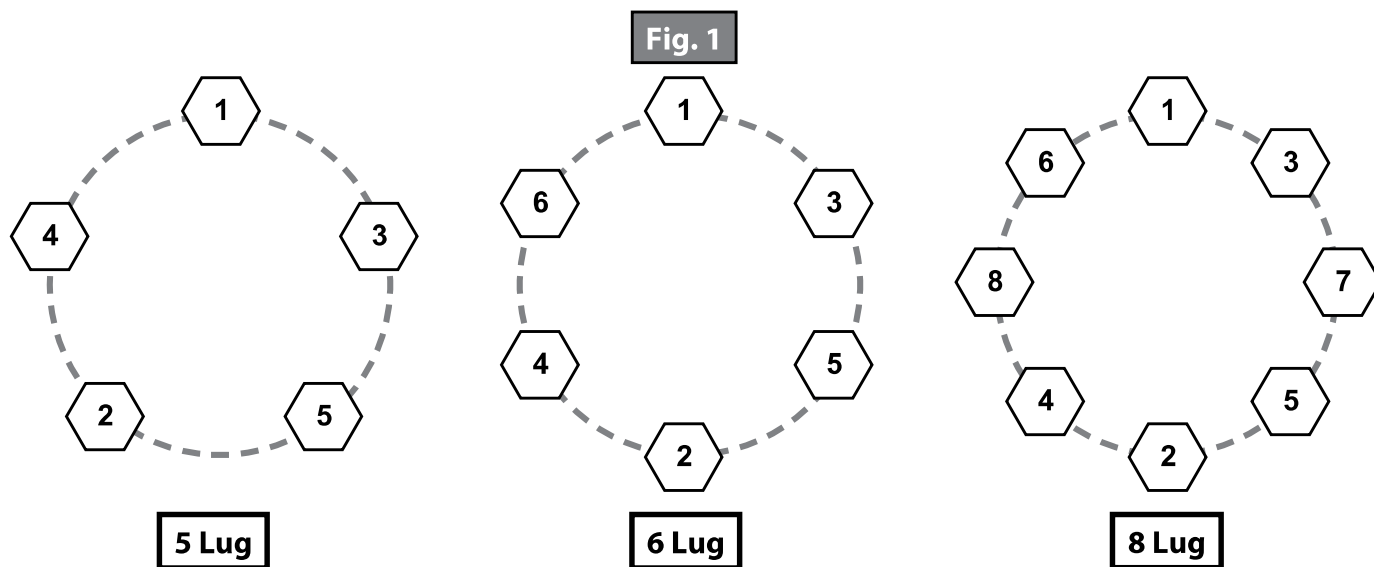
NOTE: Be sure springs are centered on spring perches on the new axle beam. Spring clips should be installed toward the front of the unit unless 2 clips are used.

13. Torque U-bolt nuts per the Torque Guide below. Tighten the bolts in a star pattern.

Torque Guide	
2K Axle	25 ft-lbs
3.5K Axle with ½" U-Bolt	50 ft-lbs
5.2K Axle	65 ft-lbs
6-8K Axle	90 ft-lbs

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14. Install backing plate with the brake assembly onto the spindle.
15. Install the fasteners to the backing plate and reconnect the brake wires. Torque specs: 35-55 ft-lbs
16. Install the hub on the spindle.
17. Install the outer wheel bearing, followed by the spindle washer, followed by the castle nut onto the spindle.
18. The castle nut should be torqued to 50 ft-lbs. Rotate the hub during this process.
19. Loosen castle nut to back off the torque.
20. Tighten castle nut finger tight until snug.
21. Insert the new cotter pin. If cotter pin does not line up with hole, back castle nut up slightly until pin can be inserted.
22. Bend cotter pin over to lock the castle nut in place. Nut should be free to move with only the cotter pin keeping it in place.
23. Re-install the dust cap.
24. Mount the wheel and lug nuts and tighten to proper torque guidelines in a star pattern (Fig. 1). Check with unit manufacturer for lug nut torque specs.
25. Lift unit per manufacturer's requirements and remove the jack stands. Lower the unit to the ground.
26. Re-torque the wheel lug nuts in case settling occurred as the trailer was lowered.



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