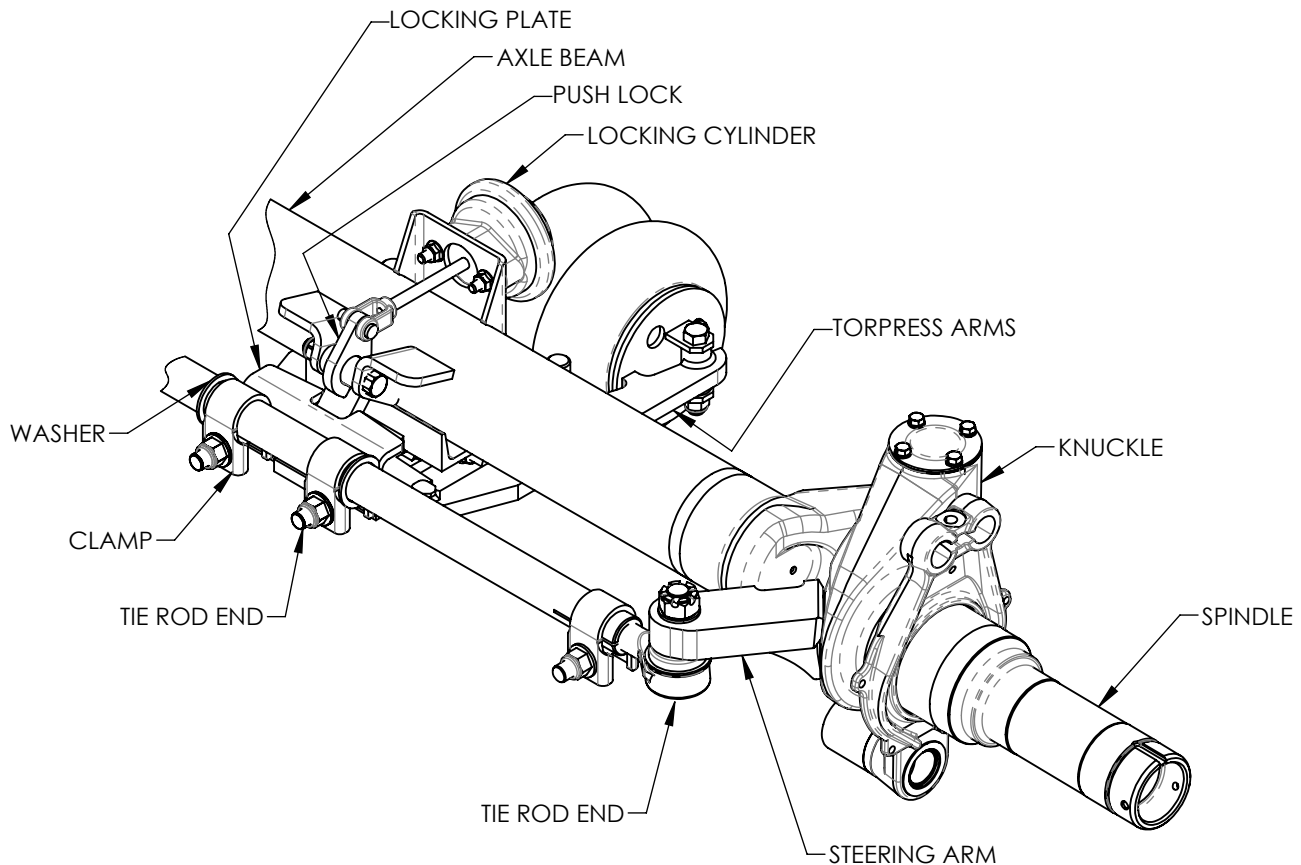


MAINTENANCE INSTRUCTIONS

Self-Steering Axle Locking Plate (Removal of 3/4" Tie Rod Height, Installation of 5" Height)



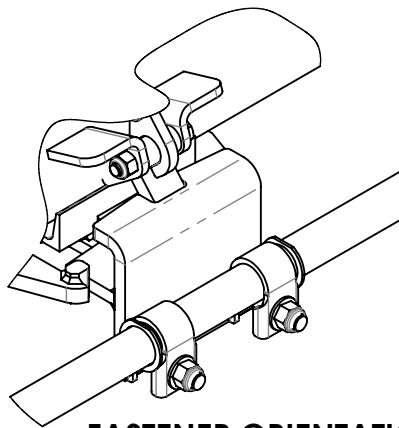
CAUTION

Do not lift or support the trailer on any part of the axle or suspension system. Never go under any trailer unless it is properly supported on jack stands which have been rated for the load. Improperly supported vehicles can fall unexpectedly and cause serious injury or death.

Procedure

1. Relieve pressure in centralizing air bag (Torpress Bag).
2. Grind off tack welds on washer on LH side of axle only, be careful not to gouge into the tie rod tube.
3. Remove bolts and nuts to disconnect clamps from the locking plate.
4. Remove the nut off of the tie rod ends, knock the tie rod down to remove it from the steering arms.
5. Remove the locking plate.
6. Using a ball marker, mark the thread on the tie rod end at the edge of the tie rod tube to ensure proper tie rod length when reinstalling.
7. Loosen clamp on LH side of tie rod and wind tie rod end out of the tube.
8. Slide old clamps and washer off of the tie rod tube. Replace with new clamps and washer
9. Install the locking plate onto the new clamps (Fig. 2 for fastener orientation) and fit snugly up to the tube.
10. Place clamp, nut and bolt on to the end of the tie rod tube approximately 1.5" from center of bolt to edge of tube, snug up do not fully tighten.
11. Thread tie rod back into tube, adjust till mark on tie rod end reaches the tube.
12. Remove LH, and RH knuckles, refer to 059-C42-00.
13. After new knuckles have been installed, ensure all components required for locking plate are in place on the tie rod tube.
14. Reinstall tie rod ends to steering arms.

15. Pull Torpress Arm out as far as possible and slide locking plate into place.
16. Slide the clamps up to the washer that remains tacked on the tube.
17. Torque nut on tie rod ends to **150 ft.-lbs.** Align cotter pin hole with groove on nut (DO NOT loosen nut to align hole) and lock in place with cotter pin.
18. Align the locking plate to be in the center of the guide plate and tighten nuts and bolts to the clamps, make sure center hole in guide plate matches up with slot in locking plate.
19. Rotate knuckles to max turn on LH, and RH to ensure there is no interference between the locking plate and the guide plate. If there is interference, loosen and readjust.
20. When correctly adjusted tighten bolts fully, torque nut to **150-200 ft.-lbs.**
21. Weld clamps to locking plate (Fig. 3).
22. Slide washer up to clamps and tack (Fig. 3).
23. Apply grease at all greasing points.
24. Refer to Installation and Maintenance Manual for new Toe Settings, and Alignment Procedure (059-C21-00).



FASTENER ORIENTATION

