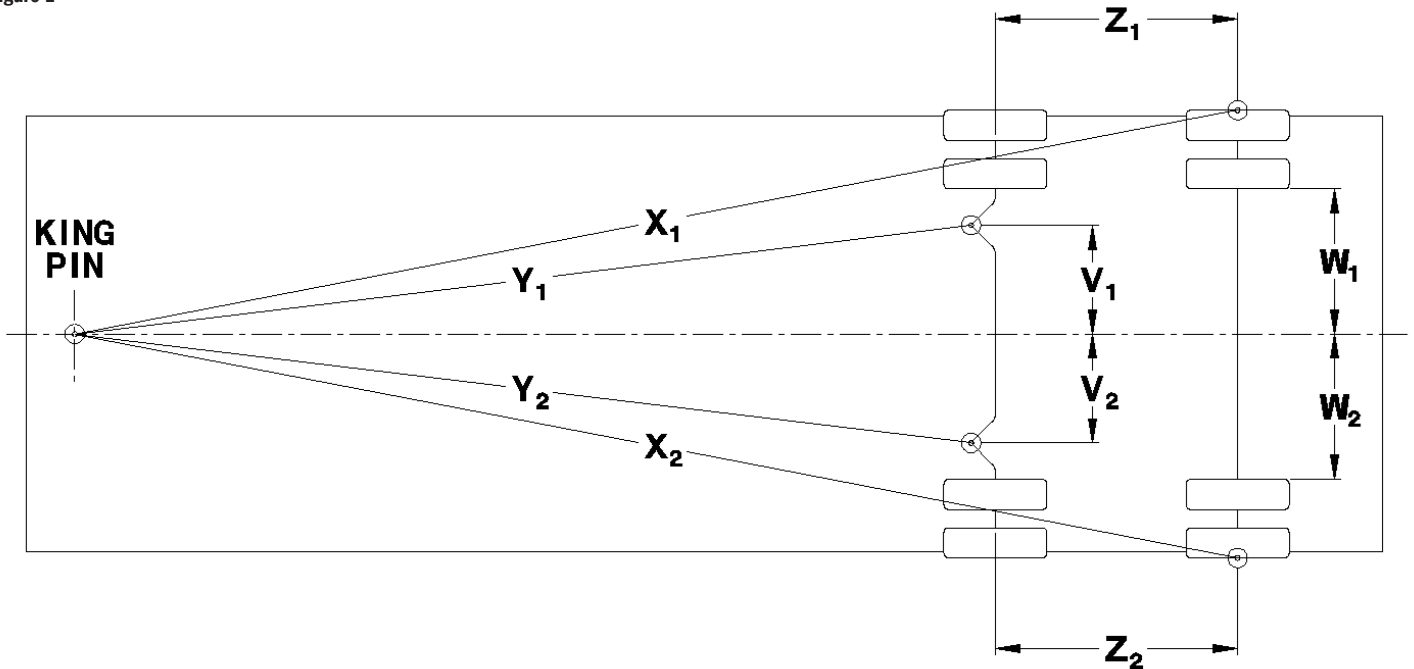


INSTALLATION INSTRUCTIONS

Alignment Self-Steering Axles for New Installation

Figure 1



ALL SELF-STEERING AXLES MUST HAVE A DEXTER ENGINEERING APPROVAL NUMBER.

1. Install and center the axle in the suspension and set the caster on the SSA per Procedure 059-C15-00. Secure by hard tack welding or clamping.
2. Center the axle and suspension assembly on the vehicle centerline using the SSA king pin centers for reference. $Y_1=Y_2$, $V_1=V_2$. Do not use a fabric measuring tape or a string. Use steel measuring tape only.
3. Set the "fixed axle" alignment $X_1=X_2$, $W_1=W_2$.
4. Safely hard tack weld suspension into place. Verify caster at working height again (059-C15-00). When axle and suspension are correctly aligned and caster is correct, complete all welding per suspension manufacturer's recommendations.
5. Remove the shipping bar that locks the SSA to center position.
6. When SSA king pin location is correct, adjust SSA alignment at spindle end, using the centralizer position bolts: $Z_1 = Z_2$. Centralizer bag must be at normal operating pressure.

7. Verify that both lever arms contact the centralizer position bolt and the push-lock plate (4 points of contact). The torpress must be centered and the axle must be at zero turning angle (centered).
8. Tack weld the Locking Clamp Locator Rings on the tie-rod, to positively locate the push-lock plate. Rotate and torque the tie-rod end locking clamps in correct positions per drawing to avoid all contact with suspension parts and frame. Next operation is Toe-In & Toe-Out Adjustments (059-C21-00).

Figure 2

