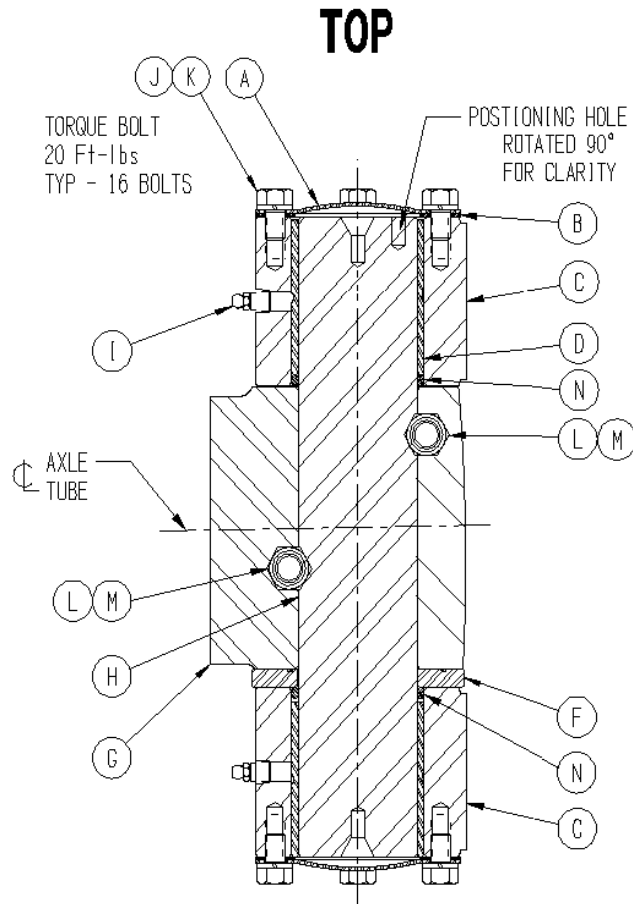


MAINTENANCE INSTRUCTIONS

Knuckle Installation Draw Keys on Self-Steering Axle



Disassembly

1. Support knuckle "C" to prevent injury when king pin is removed.
2. Remove king pin caps "A" and gaskets "B".
3. Remove nuts "M" and draw keys "L".
4. Drive king pin "H" out of the knuckle "C" and beam "G".
5. Remove knuckle "C".
6. Remove thrust bearing "F".

Assembly

1. Clean and inspect all parts. Insert new O-rings "N" in knuckle "C". Mount knuckle "C" on beam "G". Slide thrust washer "F" into place, as shown.
2. Select left king pin "H" for left side. Verify slot positions on KP to match holes in the beam "G". Slide king pin "H" into place with positioning hole in front to align draw key slots correctly.

3. Insert draw keys "L" with threads towards the front of axle, and torque flange nut "M" to **50 ft.-lbs.** Do opposite for right side.
4. Install top and bottom gaskets "B" and caps "A". Lubricate four grease nipples.
5. Re-torque draw key nuts "M" two weeks after unit is put into service, and at every major maintenance interval. (**50 ft.-lbs.**).

Recommendation

When significant wear is identified, you should replace both king pins, the four bushings, four draw keys and nuts, and both thrust washers. Genuine replacement kits are available from Dexter and distributors. (700040-KIT)