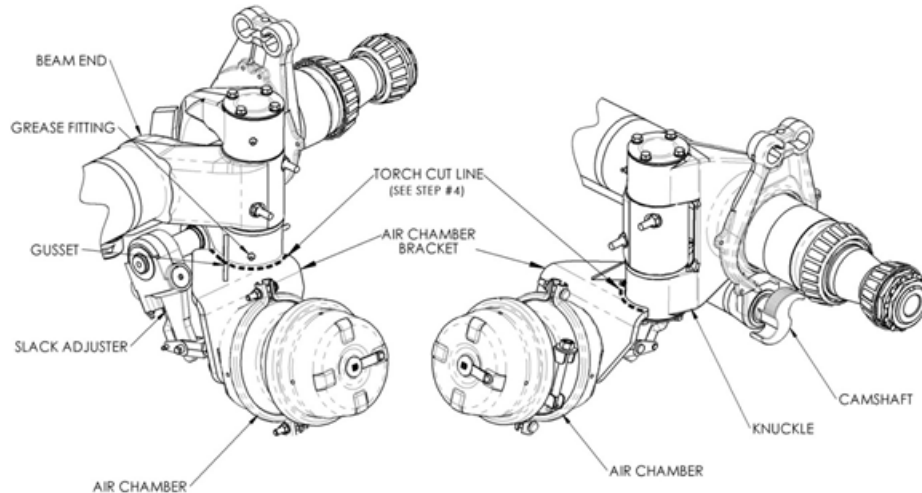


MAINTENANCE INSTRUCTIONS

Self-Steer Axle Air Chamber Bracket Field Replacement

Figure 1



CAUTION

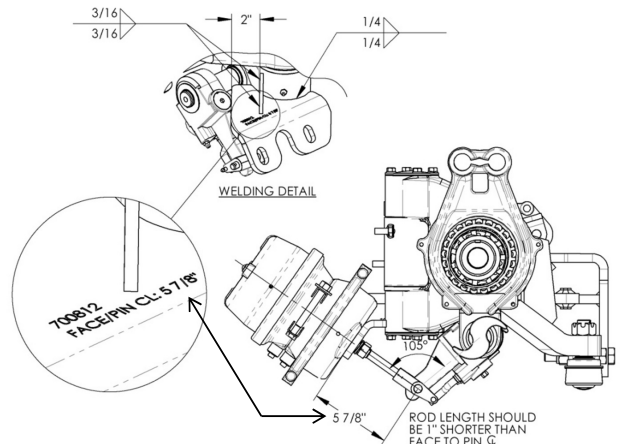
Do not lift or support the trailer on any part of the axle or suspension system. Never go under any trailer unless it is properly supported on jack stands which have been rated for the load. Improperly supported vehicles can fall unexpectedly and cause serious injury or death.

Procedure

1. Cage brake chamber, and remove clevis pin when fully caged, then remove chamber.
2. Rotate slack adjuster away from air chamber bracket.
3. Remove grease fitting closest to bracket; protect hole from molten debris.
4. Cut existing air chamber and gusset off with cutting torch; leave at least 1/4" (6mm) from the surface of the knuckle. Care must be taken to ensure no excessive heat is being applied to the knuckle. There can be no gouges in the knuckle surface.
5. Grind the remaining bracket, gusset and weld down to knuckle surface with a flexible disc grinder; take care to not create any gouges into the surface of the knuckle.
6. Bolt air chamber onto new A/C bracket, ensure ports are in desired position.
7. Attach clevis to air chamber and install slack adjuster. Note: See weld detail (Fig. 2) for push rod length calculation.

8. Rotate slack and align bracket and chamber assembly into position on the knuckle. Top of bracket should be parallel with bottom of knuckle. Verify the angle between the push rod and the slack adjuster centerline is 105 degrees $\pm$ 1 degree.
9. Tack bracket into place (2 tacks on top of bracket, 2 tacks on the bottom of the bracket). Ensure top of bracket stays parallel.
10. Remove air chamber, rotate slack out of the way and verify angle of bracket is correct.
11. Fully weld bracket top and bottom.
12. Tack gusset into correct location, weld fully both sides.

Figure 2



NOTE: YOUR AIR CHAMBER AND KNUCKLE MAY NOT LOOK EXACTLY AS SHOWN