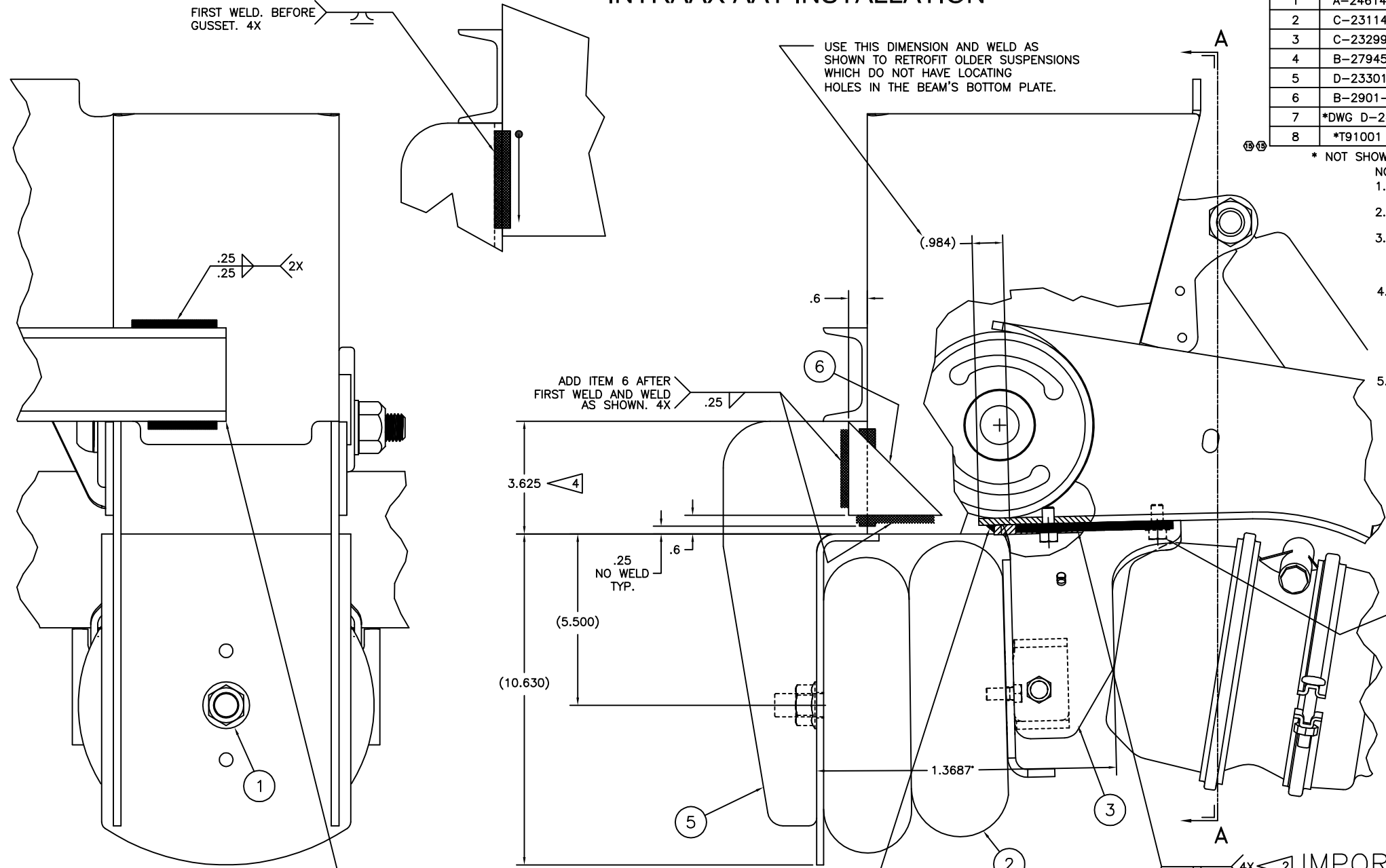


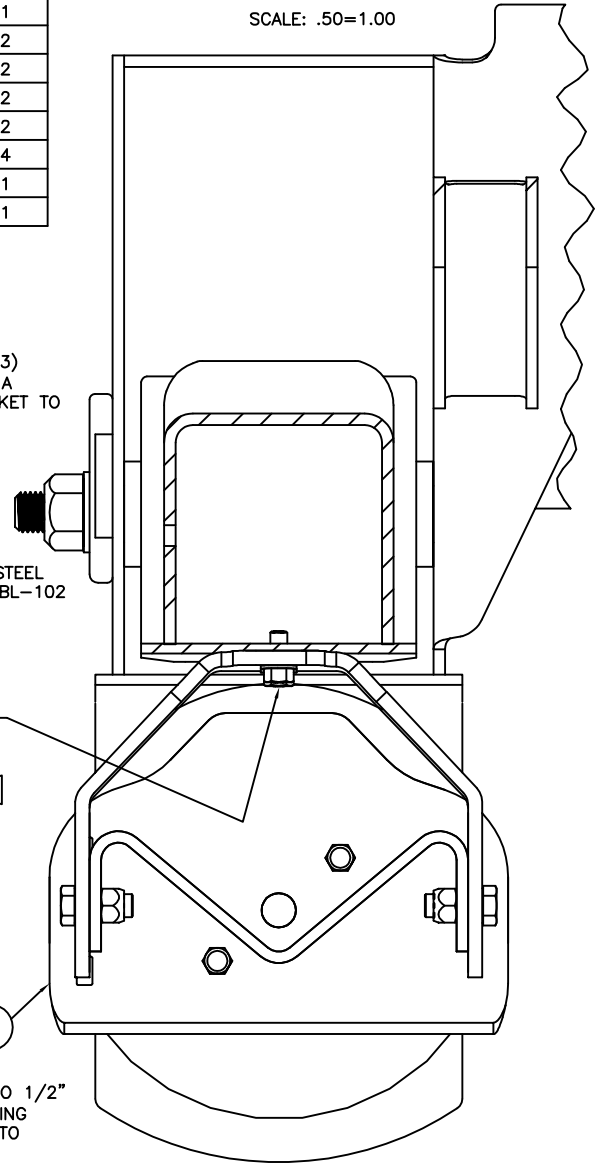
# INTRAAAX AAT INSTALLATION

ITEM	PART NO.	DESCRIPTION	QTY.
1	A-24614	LIFT ASSEMBLY BOLT KIT	1
2	C-23114	AIR SPRING	2
3	C-23299C	LIFT BRACKET	2
4	B-27945	BEAM PLATE ASSEMBLY	2
5	D-23301C	HANGER SUPPORT ASSEMBLY	2
6	B-2901-37	.25 GUSSET	4
7	*DWG D-24343	UBL-001	1
8	*T91001	UBL HARDWARE KIT INFORMATION	1

**SECTION AA**  
SCALE: .50=1.00



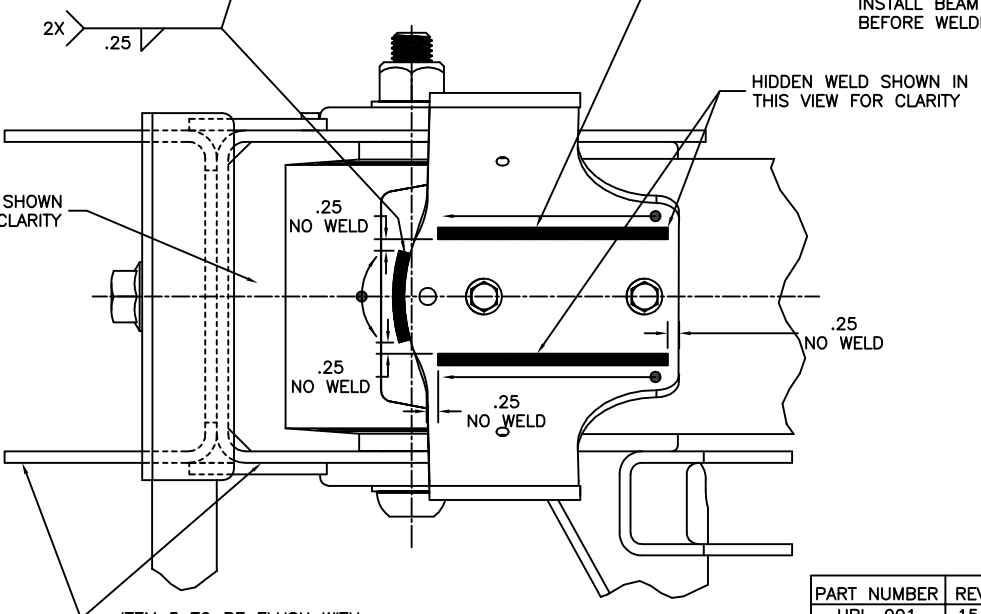
- \* NOT SHOWN
- NOTES:
- 14.0 RIDE HEIGHT SHOWN, INSTALLATION IS SAME FOR ALL RIDE HEIGHTS.
  - WEIGHT: 70.49 LB  
INCLUDES .98 LB FOR WELD.
  - IF GAP EXISTS BETWEEN LIFT BRACKET (ITEM 3) AND BEAM PLATE ASSEMBLY (ITEM 4), USE A C-CLAMP TO COMPRESS LEGS OF LIFT BRACKET TO ALLOW BEAM PLATE ASSEMBLY TO FIT.
  - WELD:  
28.5 VOLTS, 400 IPM, 275-300 AMPS,  
35 CFH (GAS FLOW), .045 WIRE  
FILL ALL CRATERS AT END OF WELDS.  
WELD DIRECTION: START  
STOP
  - UBL-001 INTENDED FOR USE WITH CARBON STEEL FRAME BRACKETS ONLY. USE UBL-101 OR UBL-102 FOR STAINLESS STEEL FRAME BRACKETS.



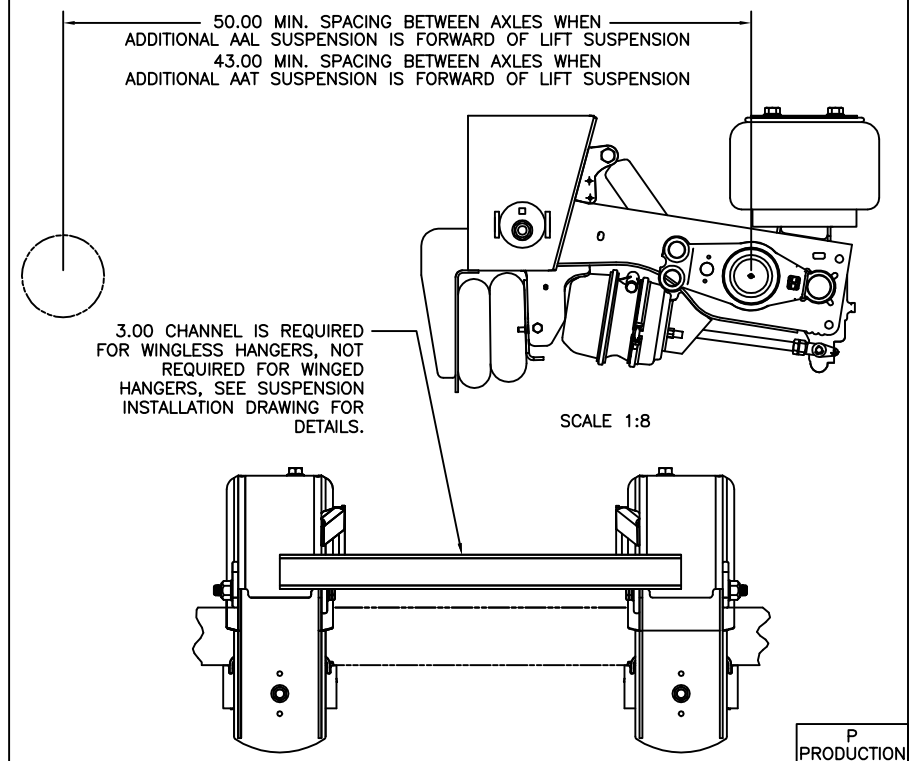
- IMPORTANT!**  
IF CROSS CHANNEL IS REQUIRED INSTALL HANGER SUPPORT BRACKET (ITEM 5) FIRST, REST CHANNEL ON TOP OF BRACKET SURFACE AND WELD AS SHOWN.
- IF RETROFIT, TAKE OFF CHANNEL AND RELOCATE.
- ASSEMBLY PROCEDURE:**
- 1 LOCATE LIFT BRACKETS (ITEM 3) WITH SELF-TAPPING SCREWS.
  - 2 INSTALL BEAM PLATE ASSEMBLIES (ITEM 4) TO LIMIT DISTORTION OF LIFT BRACKETS (ITEM 3) DURING WELDING.
  3. WELD TO BEAMS AS SHOWN.
  - 4 LOCATE TOP OF HANGER SUPPORT ASSEMBLY (ITEM 5) 3 5/8 FROM BOTTOM OF HANGERS AND WELD AS SHOWN.
  - 5 LOCATE AND WELD "C" CHANNEL AS SHOWN IF REQUIRED.
  - 6 IF PARKING BRAKES ARE REQUIRED, INSTALL AT THIS TIME.
  7. INSTALL AIR SPRINGS (ITEM 2).

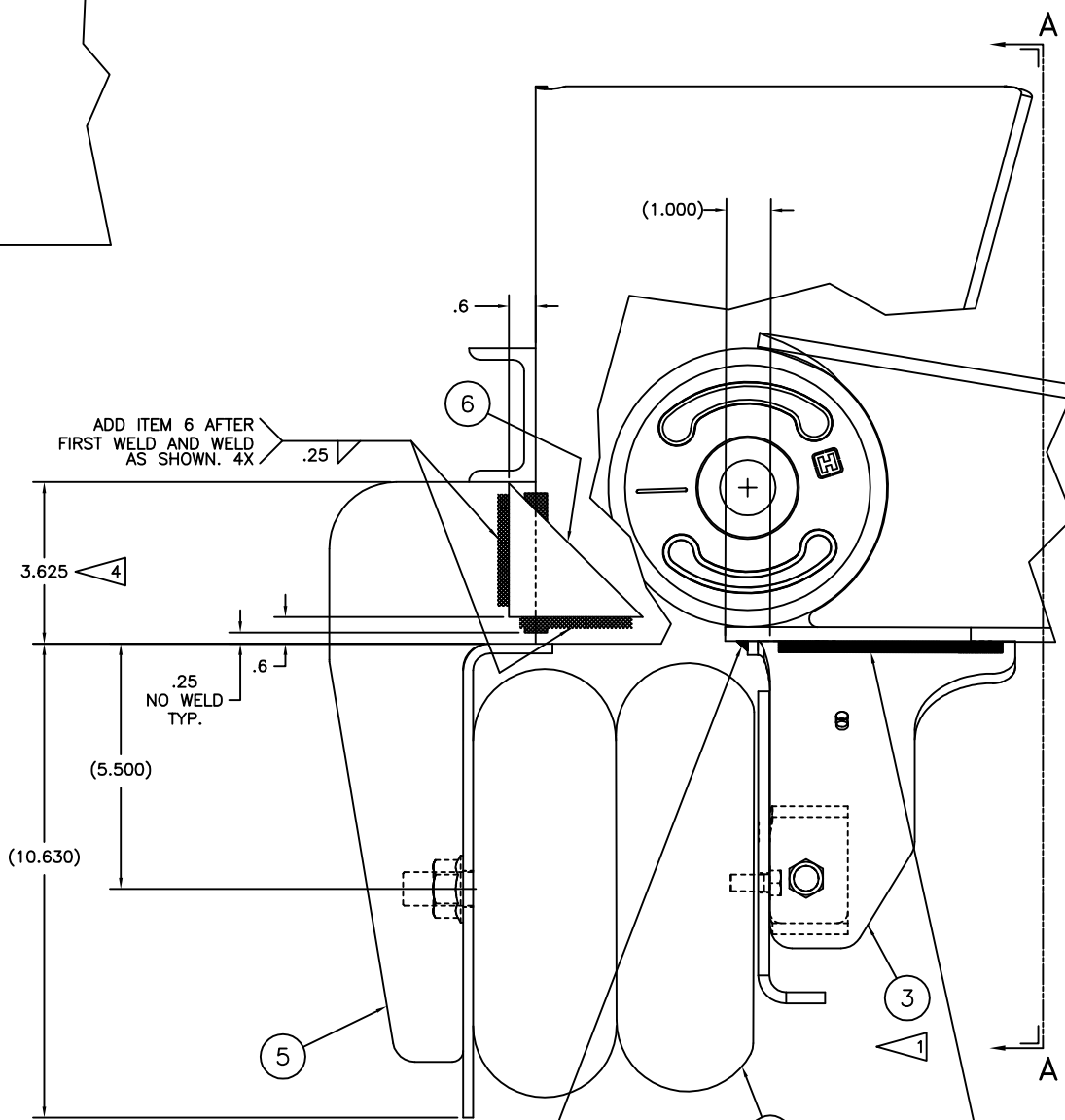
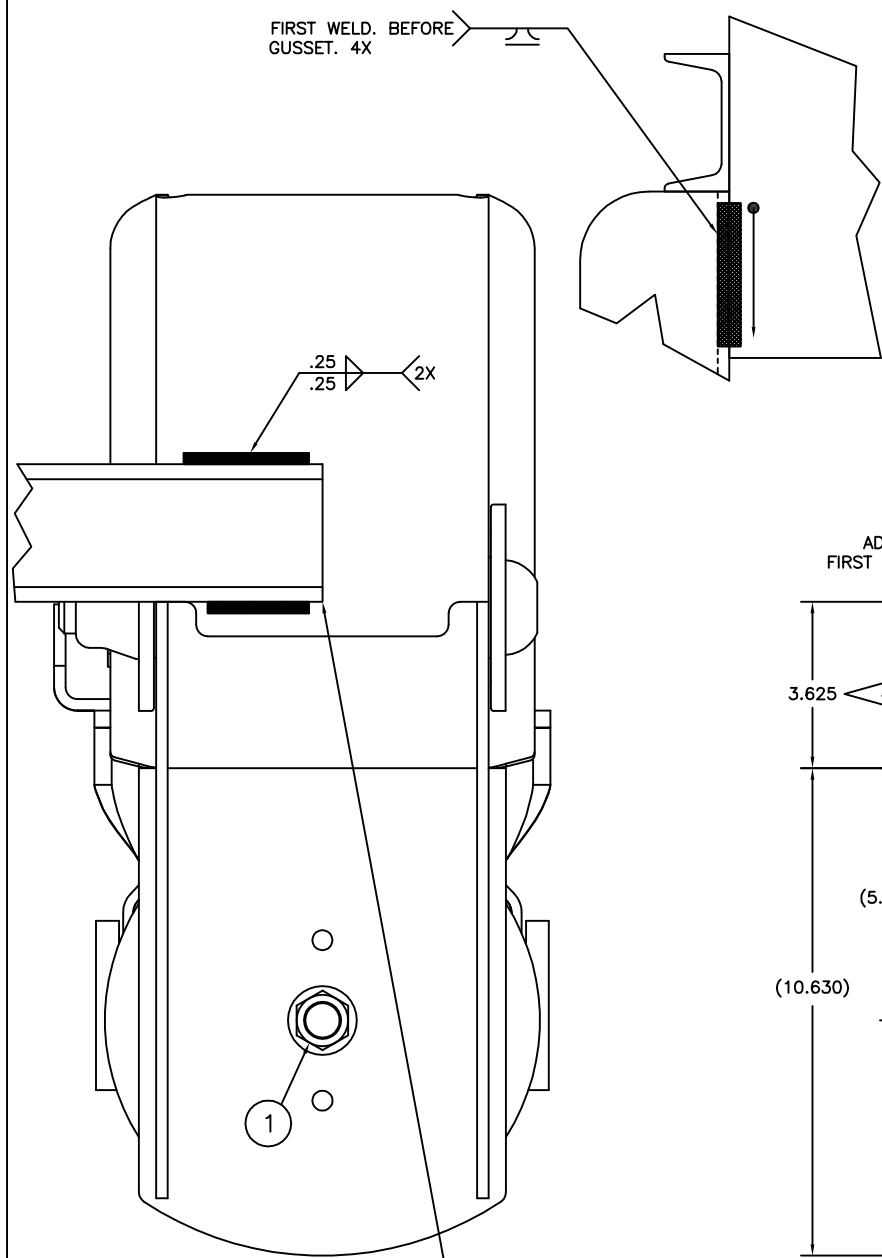
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TORQUE SPECIFICATIONS		
DESCRIPTION	SIZE	TORQUE(FT-LB)
AIR SPRING BOLTS	3/8-16	25-35
AIR SPRING NUT	3/4-16	45-55
BEAM PLATE ASSEMBLY BOLTS	1/2-13	55-75
BRAKE CHAMBER MTG. NUTS	5/8-11	100-110
SELF TAPPING SCREWS	3/8	160-180 IN-LB



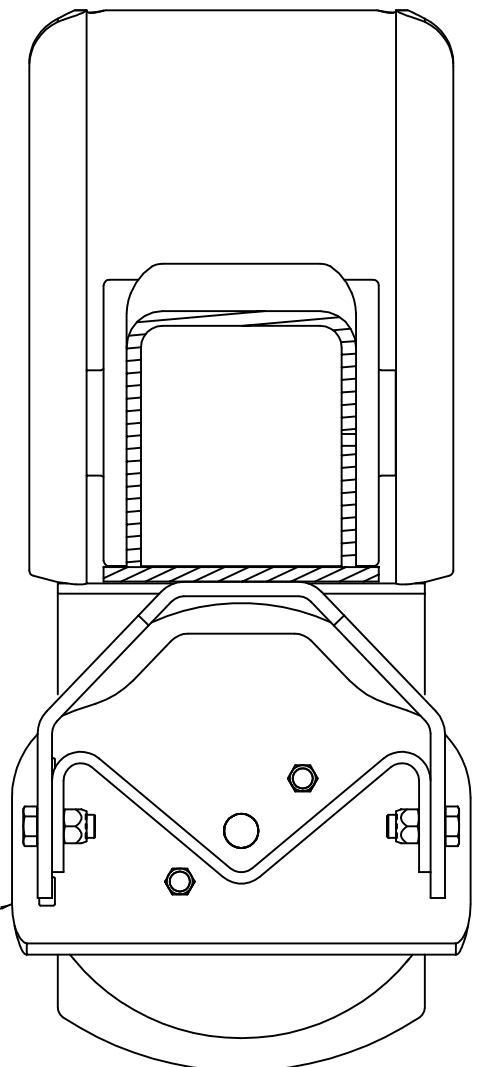
**IMPORTANT!**  
INSTALL BEAM PLATE ASSEMBLIES BEFORE WELDING.





ITEM	PART NO.	DESCRIPTION	QTY.
1	A-24614	LIFT ASSEMBLY BOLT KIT	1
2	C-23114	AIR SPRING	2
3	C-23299C	LIFT BRACKET	2
4	B-27945	BEAM PLATE ASSEMBLY	2
5	D-23301C	HANGER SUPPORT ASSEMBLY	2
6	B-2901-37	.25 GUSSET	4
7	*DWG D-24343	UBL-001	1
8	*T91001	UBL HARDWARE KIT INFORMATION	1

**SECTION AA**  
SCALE: .50=1.00



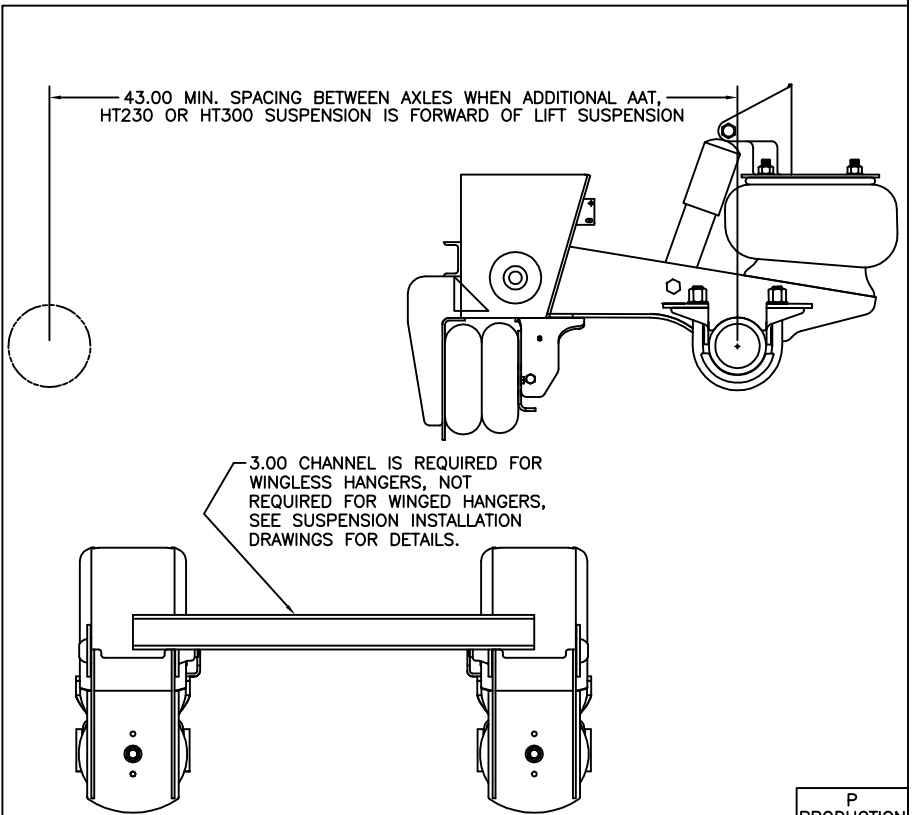
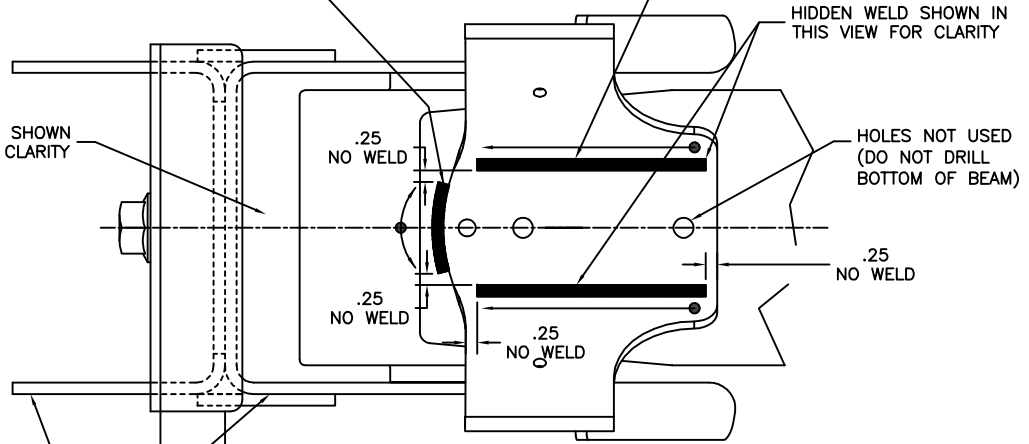
- NOTES:
- 15.0 RIDE HEIGHT SHOWN, INSTALLATION IS SAME FOR ALL RIDE HEIGHTS.
  - WEIGHT: 70.49 LB  
INCLUDES .98 LB FOR WELD.
  - IF GAP EXISTS BETWEEN LIFT BRACKET (ITEM 3) AND BEAM PLATE ASSEMBLY (ITEM 4), USE A C-CLAMP TO COMPRESS LEGS OF LIFT BRACKET TO ALLOW BEAM PLATE ASSEMBLY TO FIT.
  - WELD:  
28.5 VOLTS, 400 IPM, 275-300 AMPS,  
35 CFH (GAS FLOW), .045 WIRE  
FILL ALL CRATERS AT END OF WELDS.  
WELD DIRECTION:  
STOP → START
  - DO NOT USE THIS LIFT KIT WITH DUAL TIRE SELF-STEER AXLE.
  - UBL-001 INTENDED FOR USE WITH CARBON STEEL FRAME BRACKETS ONLY. USE UBL-101 OR UBL-102 FOR STAINLESS STEEL FRAME BRACKETS.

**HT230 INSTALLATION**

**IMPORTANT!**  
IF CROSS CHANNEL IS REQUIRED  
INSTALL HANGER SUPPORT BRACKET  
(ITEM 5) FIRST, REST CHANNEL ON  
TOP OF BRACKET SURFACE AND  
WELD AS SHOWN.  
IF RETROFIT, TAKE OFF CHANNEL  
AND RELOCATE.

- ASSEMBLY PROCEDURE:
- 1 LOCATE LIFT BRACKETS (ITEM 3) AND CLAMP INTO PLACE. HOLES IN LIFT BRACKETS NOT USED (DO NOT DRILL BEAM).
  - 2 INSTALL BEAM PLATE ASSEMBLIES (ITEM 4) TO LIMIT DISTORTION OF LIFT BRACKETS (ITEM 3) DURING WELDING.
  3. WELD TO BEAMS AS SHOWN.
  - 4 LOCATE TOP OF HANGER SUPPORT ASSEMBLY (ITEM 5) 3 5/8 FROM BOTTOM OF HANGERS AND WELD AS SHOWN.
  - 5 LOCATE AND WELD "C" CHANNEL AS SHOWN IF REQUIRED.
  6. INSTALL AIR SPRINGS (ITEM 2).

**IMPORTANT!**  
INSTALL BEAM PLATE ASSEMBLIES  
BEFORE WELDING.



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TORQUE SPECIFICATIONS		
DESCRIPTION	SIZE	TORQUE(FT-LB)
AIR SPRING BOLTS	3/8-16	25-35
AIR SPRING NUT	3/4-16	45-55
BEAM PLATE ASSEMBLY BOLTS	1/2-13	55-75

**H. HENDRICKSON**  
TRAILER COMMERCIAL VEHICLE SYSTEMS  
2070 INDUSTRIAL PLACE SE., CANTON, OH 44707-2000 U.S.A.

UNLESS OTHERWISE NOTED:  
TOLERANCES ARE: DIMENSIONS ARE: INCHES  
X: ± .01  
Y: ± .01  
Z: ± .01  
ANGULAR: ± 0.5°  
DIMENSIONS ADHERE TO ANSI Y14.5M-1982 (REV. EDN. NO. BY DATE)

DESIGNED BY: P. BILLMAN 5-4-05  
CHECKED BY: S. B. OS K. GALIGHER  
APPROVED BY: R. GORE  
SCALE: .50=1.00  
PAGE: 2 OF 2  
D-24343