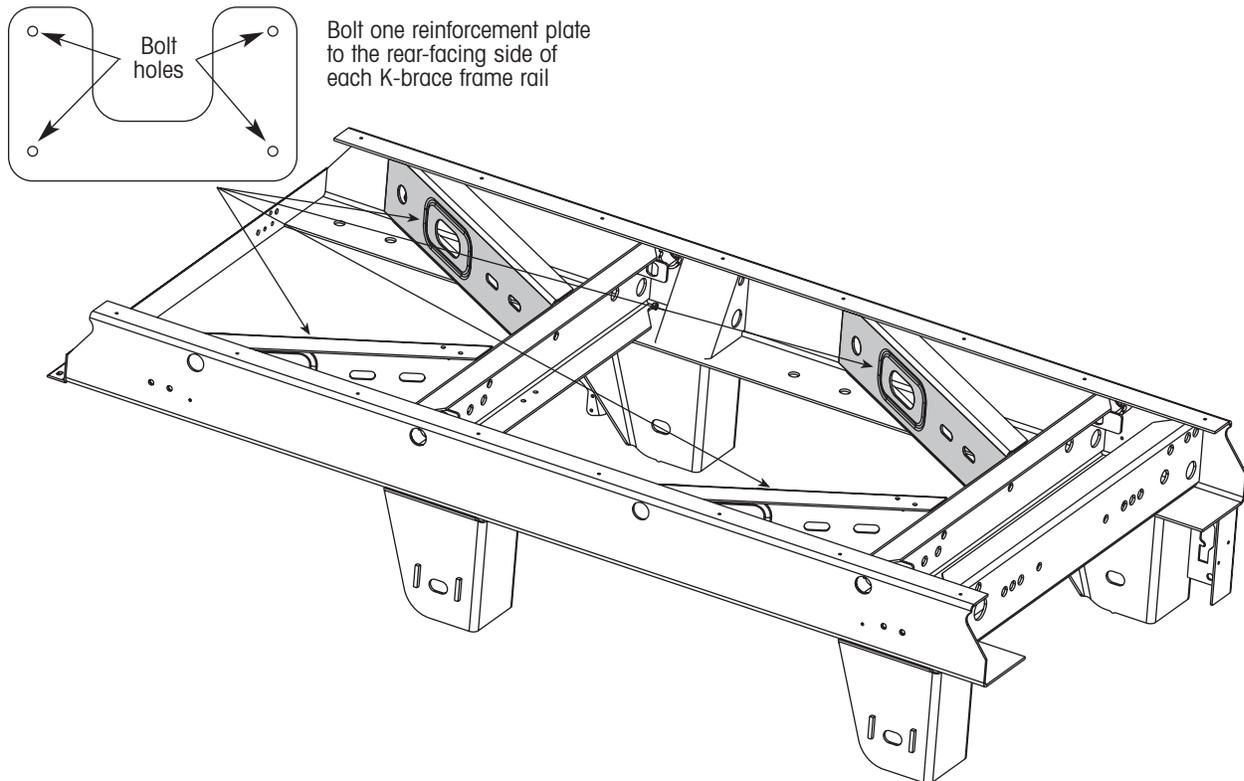# TECHNICAL BULLETIN

## HKA250 SUSPENSIONS

**SUBJECT:** K-Brace Reinforcement Installation
**LIT NO:** B108
**DATE:** February 2003     **REVISION:** C

To prevent the K-brace frame rails on HKA250 suspensions from bending or buckling under inappropriate dynamic overloading or when operated without sufficient air in the air springs, Hendrickson is recommending the installation of four reinforcement plates. These plates, collectively identified as reinforcement kit S-27316-2, are to be bolted to the rear-facing side of all four K-brace frame rails on HKA250 suspensions.



Bolt holes

Bolt one reinforcement plate to the rear-facing side of each K-brace frame rail

Effective immediately, Hendrickson will begin sending reinforcement kit S-27316-2 to all identified HKA250 suspension owners. Upon arrival, you are authorized to install or have these reinforcement plates installed.

If you have an HKA250 suspension and you did not receive the reinforcement kit, contact the Hendrickson trailer technical service department at 800-455-0043 in the United States, 800-668-5360 in Canada or +52 (81) 8156-1300 in Mexico to obtain an RGO number and the reinforcement kit.

If you have any questions about obtaining or installing these reinforcement plates or questions concerning warranty details, please contact the Hendrickson technical service department at the number previously listed.
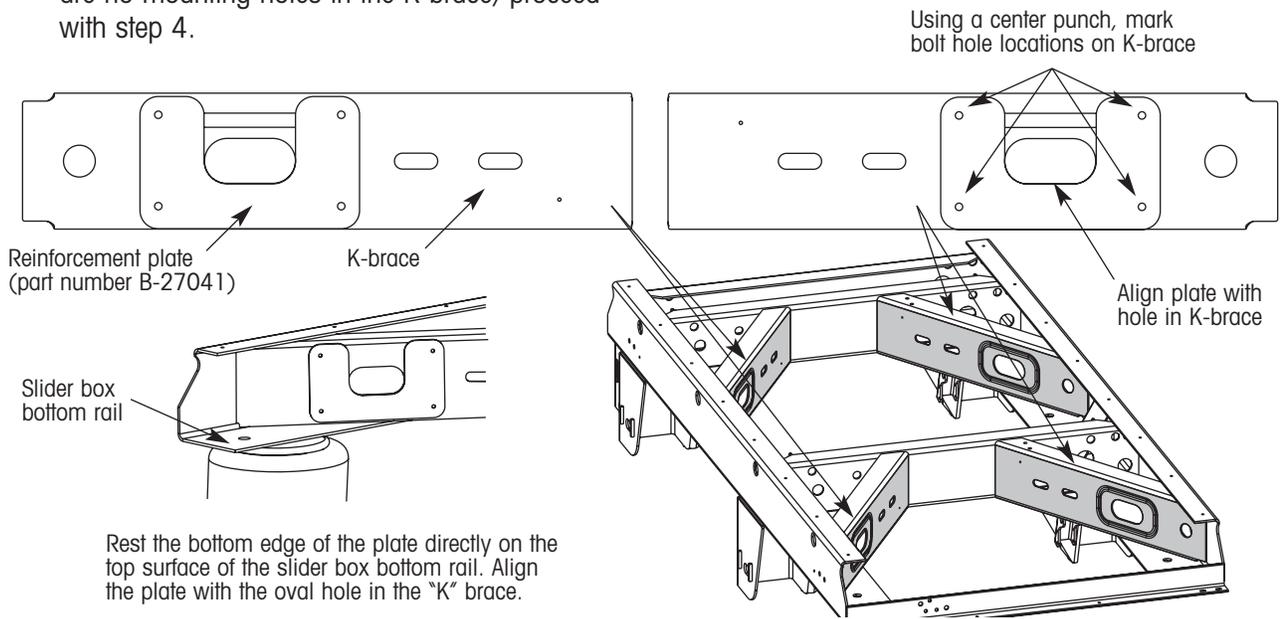
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The K-brace frame rails must be as flat and straight as possible before installing the reinforcement plates. If the K-brace frame rails are bent or buckled, they must first be straightened before the reinforcement plates can be installed. Contact the Hendrickson technical service department at the number previously listed for complete K-brace frame rail straightening recommendations.

The recommended installation procedure is to bolt the reinforcement plates to the K-brace frame rails using the hardware provided in the kit. Most newer HKA250 model suspensions already have mounting holes in the K-brace frame rails to accommodate the reinforcement plates. However on older HKA250 model suspensions, holes must be drilled into the K-brace frame rails before the reinforcement plates can be bolted in place. Use the following procedure to install the reinforcement plates.

1. Chock the trailer wheels and exhaust all air from the suspension system.

2. If necessary, disconnect the air line from the air spring to gain clear access to the K-brace.

3. If your suspension already has mounting holes in the K-brace frame rails, skip to step 7. If there are no mounting holes in the K-brace, proceed with step 4.

4. Using a C-clamp, temporarily clamp the plate to the K-brace as shown below. Orient the plate so that the open end is at the top. Rest the plate directly on the slider box bottom rail and align the plate with the oval hole in the K-brace.

5. Using the reinforcement plate as a template, mark the location of the four bolt holes on the K-brace with a center punch.

6. Remove the C-clamp and reinforcement plate and drill four $^{13}/_{32}$-inch (.406) mounting holes completely through the K-brace frame rail in the locations just marked.

7. Using the flanged nuts and bolts provided in the kit, bolt the plate to the K-brace. Orient the plate so that the open end is at the top. Rest the plate directly on the slider box bottom rail and align the plate with the oval hole in the K-brace. Tighten to a torque of 35 to 45 ft. lbs. (47 to 61 N•m).

8. If required, reconnect the air line to the air spring.

9. Repeat steps 2 through 8 at the other three K-brace frame rails.

10. Inflate the suspension and check for air leaks.

Using a center punch, mark bolt hole locations on K-brace

Reinforcement plate
(part number B-27041)

K-brace

Align plate with hole in K-brace

Slider box bottom rail

Rest the bottom edge of the plate directly on the top surface of the slider box bottom rail. Align the plate with the oval hole in the "K" brace.

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