

# **H** TECHNICAL PROCEDURE

## R™ Heavy-duty

**SUBJECT:** 100,000/120,000 lbs. Capacity  
Tightening Torque for Torque Rod  
and Saddle Assembly Fasteners

**LIT NO:** 17730-134

**DATE:** October 2008

**REVISION:** D

### INTRODUCTION

This publication is intended to acquaint and assist maintenance personnel in the recommended tightening torque specifications of the mounting hardware for the R™ 100,000/120,000 pound capacity rear suspension.

Following appropriate inspection procedure is important to help ensure the proper maintenance and operation of the suspension system and component parts. Hendrickson recommends the R heavy-duty rear suspension is inspected at pre-delivery, the first 1,000 miles of service and at annual regular preventive maintenance intervals. To obtain maximum service life, fasteners should be checked at least once a year and tightened to specified torque.


#### CAUTION

A MECHANIC USING A SERVICE PROCEDURE OR TOOL WHICH HAS NOT BEEN RECOMMENDED BY HENDRICKSON MUST FIRST SATISFY HIMSELF THAT NEITHER HIS SAFETY NOR THE VEHICLE'S SAFETY WILL BE JEOPARDIZED BY THE METHOD OR TOOL SELECTED. INDIVIDUALS DEVIATING IN ANY MANNER FROM THE INSTRUCTIONS PROVIDED WILL ASSUME ALL RISKS OF CONSEQUENTIAL PERSONAL INJURY OR DAMAGE TO EQUIPMENT INVOLVED.

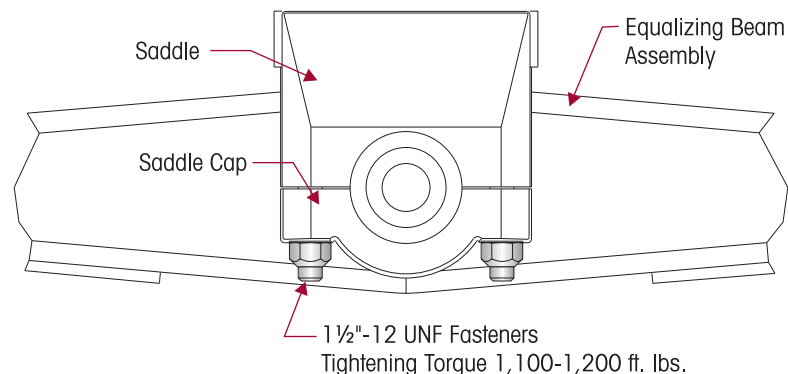
#### CAUTION

WEAR PROPER EYE PROTECTION TO HELP AVOID SERIOUS PERSONAL INJURY.

### SADDLE CAP FASTENERS

Tighten the 1½"-12 UNF locknuts to  1,100-1,200 foot pounds to maintain an even gap between the saddle and saddle cap and prevent wear of the beam center bushing into the saddle, see Figure 1.

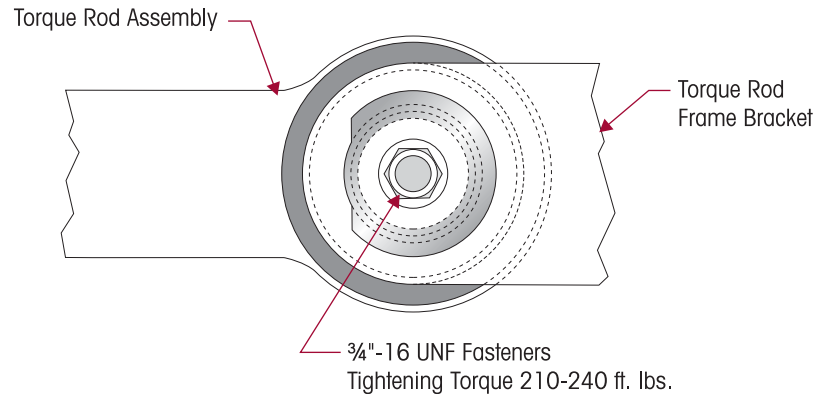
**FIGURE 1**



### TORQUE ROD END BUSHING ADAPTER FASTENERS

Tighten the 3/4"-16 UNF locknuts to 210-240 foot pounds to clamp the bushing to the inner legs of the torque rod bracket, see Figure 2. See Technical Publication 45745-148 for preventive maintenance and service for torque rod bushings.

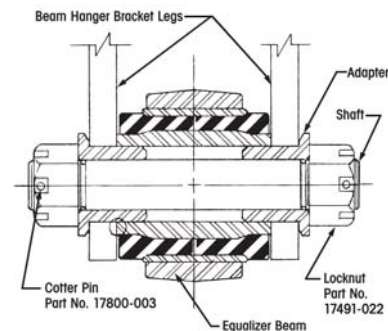
**FIGURE 2**



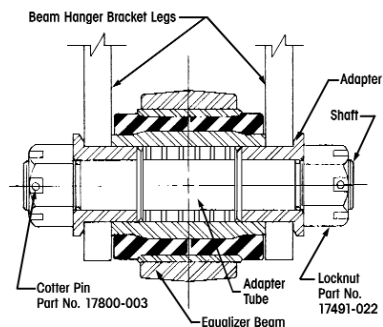
### BEAM END ADAPTER FASTENERS

See Hendrickson Technical Publication 17730-149 for proper tightening procedures, see Figures 3 and 4.

**FIGURE 3 Two Piece Adapter Type**



**FIGURE 4 Three Piece Adapter Type**



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