

AXLE CAPACITY	TR (i) TRACK WIDTH		S-CAM BRAKE		D INSIDE TIRE	BC (ii) BEAM CENTERS	AC (iii) AIR SPRING CENTERS	RC REMOTE SHOCK CENTERS	GM (iv) BRAKE CHAMBER CENTERS	LP OVERALL WIDTH	12T AXLE WEIGHT 420x180 (KG)	12T AXLE WEIGHT 420x220 (KG)	13T AXLE WEIGHT 420x180 (KG)	13T AXLE WEIGHT 420x220 (KG)
	MM NOM.	INCH												
	AXLE TRACKS: HP WITH KIC 335mm HUB													
A	1816	71.5	420X180	420X220	1179	889	748	240	252	2107	369	380	378	389
	1829	72	420X180	420X220	1192	901	760	253	264	2120	370	380	379	390
	1842	72.5	420X180	420X220	1204	914	773	265	277	2132	370	381	380	390
	1854	73	420X180	420X220	1217	927	786	278	290	2145	371	381	380	391
	1867	73.5	420X180	420X220	1230	939	798	291	303	2158	371	382	381	392
	1880	74	420X180	420X220	1243	952	811	304	315	2170	372	383	382	392
	1892	74.5	420X180	420X220	1255	965	824	316	328	2183	372	383	382	393
	1905	75	420X180	420X220	1268	978	837	329	341	2196	373	384	383	393
	1918	75.5	420X180	420X220	1281	990	849	342	353	2208	373	384	383	394
	1930	76	420X180	420X220	1293	1003	862	354	366	2221	374	385	384	395
B	1943	76.5	420X180	420X220	1306	1016	875	367	379	2234	375	385	385	395
	1956	77	420X180	420X220	1319	1028	887	380	391	2247	375	386	385	396
	1968	77.5	420X180	420X220	1331	1041	900	392	404	2259	376	386	386	397
	2040	81.25	420X180	420X220	1427	1136	995	488	499	2354	380	391	391	401

(i) ADDITIONAL TRACKS WIDTHS ARE AVAILABLE.
(ii) BC MAY VARY. CONTACT HENDRICKSON ENGINEERING FOR SPECIFIC APPLICATIONS.
(iii) NOMINAL AC VALUE SHOWN. AC - 50mm MAY BE POSSIBLE FOR AIR SPRING MOUNTING STUD OR FOR LARGE TIRES.
(iv) NOMINAL GM VALUE FOR 604 CAM SHAFT. OTHER CAM SHAFT LENGTHS AVAILABLE.

AIR SUSPENSION TYPE	RH NOMINAL RIDE HEIGHT	RIDE HEIGHT RANGES		AH - AXLE HEIGHT		PH PIVOT HEIGHT	AS AIR SPRING BRACKET	INSTALLED LENGTHS		SHOCK ABSORBER ATTACHMENTS			AUX. REBOUND LIMITER		12T SUSPENSION WEIGHT (KG)	13T SUSPENSION WEIGHT (KG)
		FOR AXLE ASSEMBLIES	FOR AXLE ASSEMBLIES WITH LIFT	UNLADEN WITHOUT AIR	LADEN WITHOUT AIR			L1	L2	SX	SY	RY (v)	AX	AY		
HSDS 12T/13T	390	370-390	-	300	294	200	5	479	176	198	175	98	275	35	160	179
	400	380-410	410	311	305	250	5	493	162	191	196	85	375	35	164	184
	430	410-440	440	340	333	280	35	493	162	185	192	55	275	35	170	190
	460	440-470	470	370	363	310	65	493	162	179	190	25	375	96	174	196
	490	470-500	500	400	393	340	95	493	162	175	188	-5	275	96	177	200
	530	510-540	540	440	433	380	135	493	162	171	186	-45	415	96	185	207
570	550-580	580	480	473	420	175	493	162	167	184	-85	275	96	191	213	

(v) NEGATIVE VALUES ARE BELOW THE MAIN FRAME RAIL.

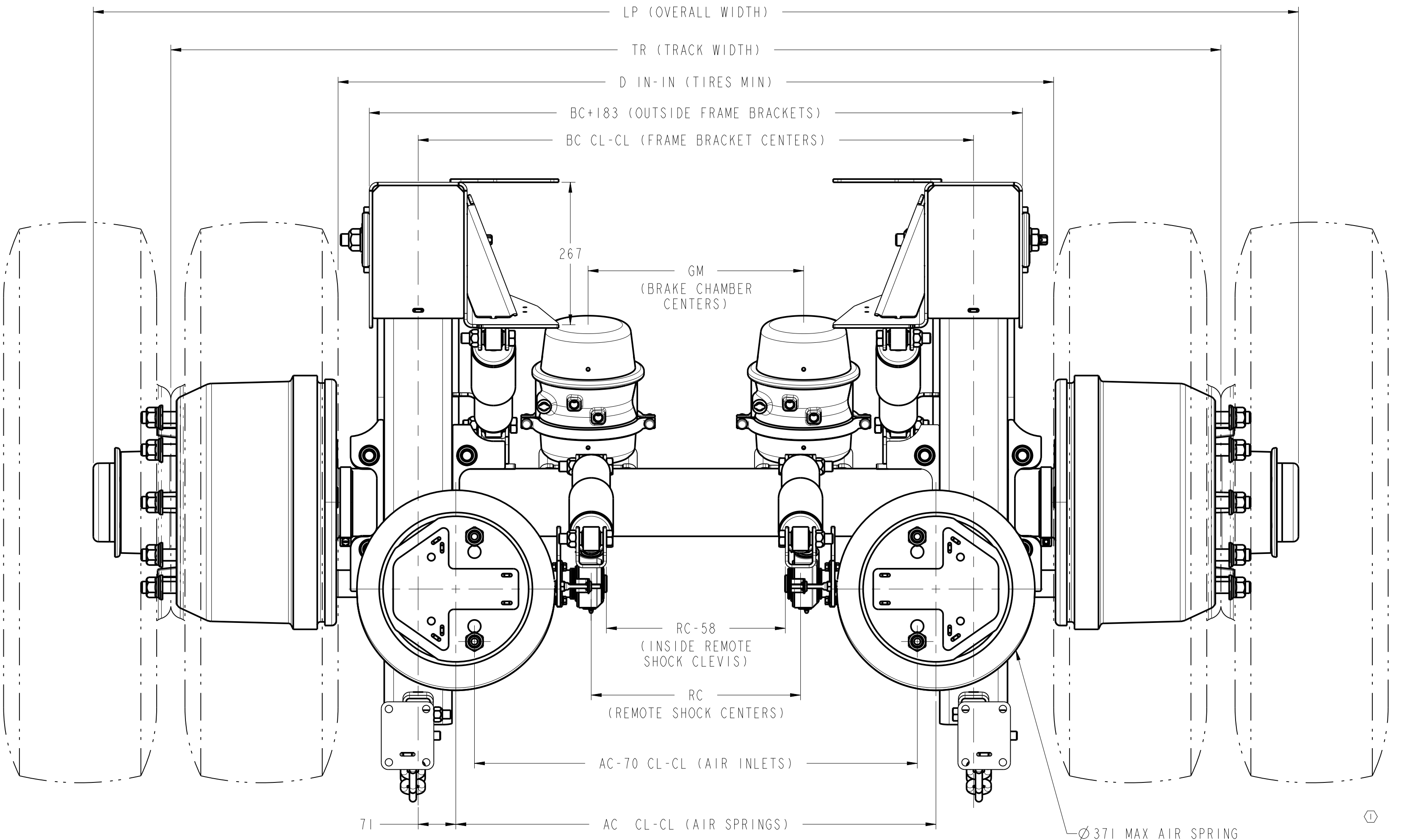
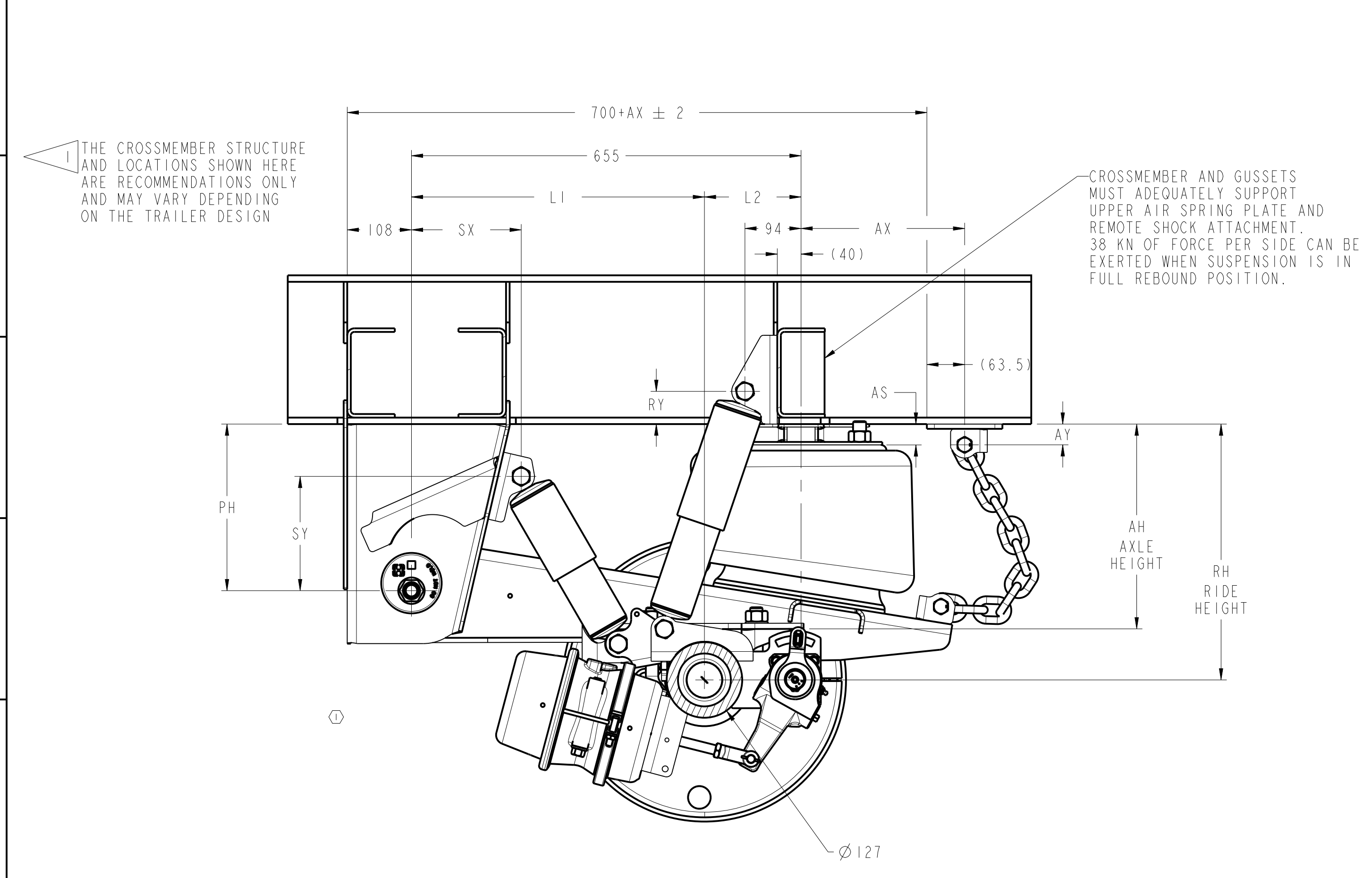
DESCRIPTION	TORQUE SPECIFICATIONS			
	SIZE	TORQUE (N-M)	TORQUE (FT-LBF)	SOCKET SIZE
SHOCK ABSORBER BOLTS	3/4-10	285-320	210-235	1-1/8" OR 29 MM
AIR SPRING NUTS, UPPER	M22X1.5	110-135	80-100	34 MM
AIR SPRING NUTS, LOWER	M14X2	80-90	60-70	18 MM
AIR SPRING PLUG	M12X1.5	15	10	6 MM HEX
U-BOLTS	M22X1.5	645-710	475-525	32 MM
HCV BOLTS	M6X1	7-9	60-80 IN-LBF	10 MM
HCV SHOULDER BOLTS	1/4-20	7-9	60-80 IN-LBF	12 MM
BRAKE CHAMBER JAM NUT	M16X1.5	60-68	45-50	24 MM
BRAKE CHAMBER BOLTS	M16X1.5	180-210	130-155	24 MM
PIVOT BOLTS*	7/8-9	685-810	505-595	E-20 & 36 MM
AIR SPRING SPACER TO FRAME BOLTS	M12X1.75	115-125	85-95	18 MM
AIR SPRING PLATE TO FRAME BOLTS	M12X1.75	115-125	85-95	18 MM
ARL TO FRAME BOLTS	M12X1.75	115-125	85-95	18 MM
FRAME BRACKET TO FRAME BOLTS	M16X2	280-315	210-230	24 MM

* AFTER FINAL AXLE ALIGNMENT, TIGHTEN UNTIL SHEAR HEAD SEPARATES.

- INSTALLATION CHECKLIST:
1. PROPERLY LOCATE AND WELD CROSS MEMBERS, SPACERS, AND GUSSETS.
 2. REMOVE PAINT ON HANGER PER SHEET 5.
 3. PLACE AND WELD THE FOLLOWING:
 - a. SUSPENSION WITH FRAME BRACKETS
 - b. AIR SPRING SPACER
 - c. REMOTE SHOCK BRACKET
 - d. ARL BRACKET
 4. ASSEMBLE AND TORQUE THE FOLLOWING:
 - a. AIR SPRINGS
 - b. SHOCKS
 - c. ARL, NO TWIST IN CHAINS
 - d. BRAKE CHAMBERS
 5. ATTACH SLACK ADJUSTER TO BRAKE CHAMBERS.
 6. TORQUE JAM NUT, TIGHTEN BRAKES THEN BACK OFF 1/2 TURN.
 7. INSTALL BRAKE VALVE, PARKING BRAKE VALVE, AND BRAKE AIR LINES.
 8. INSTALL PPV, HCV, AND AIR SPRING AIR LINES.
 9. ALIGN SUSPENSION PER HENDRICKSON DOCUMENT L579.
 10. TIGHTEN PIVOT BOLTS UNTIL E-20 FEATURE BREAKS OFF.
 11. UNCAGE BRAKES.

- NOTES:
1. IT IS THE RESPONSIBILITY OF THE INSTALLER TO ENSURE PROPER VEHICLE FRAME DESIGN IN AREA OF SUSPENSION ATTACHMENT.
 2. COMPONENT REPRESENTATIONS ARE FOR REFERENCE ONLY. ACTUAL COMPONENT APPEARANCE MAY VARY.
 3. SEE CHART BB FOR TORQUE SPECIFICATIONS OF FASTENERS.
 4. SUSPENSION WEIGHT INCLUDES SUSPENSION COMPONENTS ONLY. WEIGHT REFLECTS STANDARD AIR SPRING, FRAME BRACKETS AND SHOCKS.

- CLEARANCE SPECIFICATIONS:
- a) 25 MM MINIMUM REQUIRED BETWEEN TOP OF TIRE AND BOTTOM OF TRAILER STRUCTURE WHEN AXLE IS AT FULL JOUNCE.
 - b) 50 MM MINIMUM REQUIRED BETWEEN INSIDE OF TIRE AND TRAILER STRUCTURE FOR LATERAL MOVEMENT.
 - c) 25 MM MINIMUM CLEARANCE MUST BE MAINTAINED AROUND AIR SPRING WHEN IT IS AT MAXIMUM DIAMETER.



This print remains the property of Hendrickson. All information contained hereon is confidential. It is loaned, subject to return on demand, and on the express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.

NOTE: ORIGINAL DRAWING CREATED IN CREO. ALL REVISIONS TO THIS DRAWING MUST BE PERFORMED ON THE CREO DRAWING AND THEN CONVERTED TO THE APPLICABLE FORMAT.

HSDS 12T, HSDS 13T

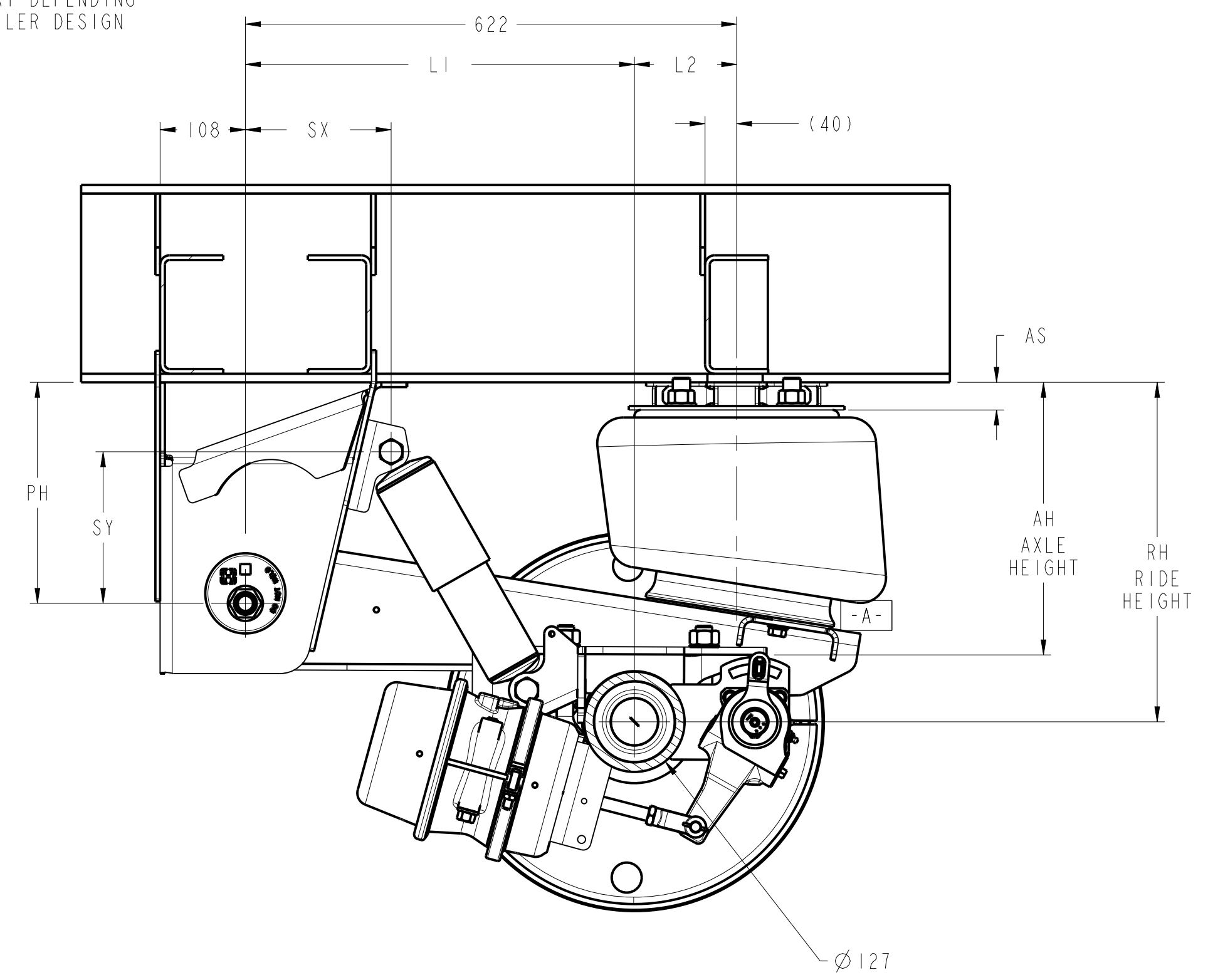
		UNLESS OTHERWISE NOTED TOLERANCES ARE: X: ± .15 Y: ± .30 Z: ± .50 ANGULAR ± .5°		DIMENSIONS ARE: MM (INCHES) 1 2452 SS 08-11-15 0 19206 AJB 07-08-11		DRAWN BY: A. BRUGGER CHECKED BY: C. ANDERSON APPROVED BY: M. OYSTER		DATE: 15-Jul-15 THIS DRAWING IS THE CONFIDENTIAL PROPERTY OF HENDRICKSON		SCALE: 1:6 PAGE: 1 OF 10	
TRAILER COMMERCIAL VEHICLE SYSTEMS 2076 INDUSTRIAL PLACE S.E. CANTON, OH 44707-2600 U.S.A.						DIMENSIONS ADHERE TO ANSI Y14.5M-1987 REV. ECN. NO. BY DATE		HSDS INSTALLATION		SIZE: D DRAWING NUMBER: D-32106	

AXLE CAPACITY	TR (i) TRACK WIDTH		S-CAM BRAKE		D INSIDE TIRE	FC (ii) FRAME ATTACHMENT CENTERS	BC (ii) BEAM CENTERS	AC (iii) AIR SPRING CENTERS	GM (iv) BRAKE CHAMBER CENTERS	LP OVERALL WIDTH	AXLE WEIGHT 420x180 (KG)	AXLE WEIGHT 420x220 (KG)
	MM NOM.	INCH										
	AXLE TRACKS: HP WITH KIC 335mm HUB											
A	1816	71.5	420X180	420X220	1179	914	889	788	252	2107	341	352
	1829	72	420X180	420X220	1192	926	901	800	264	2120	341	352
	1842	72.5	420X180	420X220	1204	939	914	813	277	2132	342	352
	1854	73	420X180	420X220	1217	952	927	826	290	2145	342	353
	1867	73.5	420X180	420X220	1230	964	939	838	303	2158	343	353
	1880	74	420X180	420X220	1243	977	952	851	315	2170	343	354
	1892	74.5	420X180	420X220	1255	990	965	864	328	2183	343	354
	1905	75	420X180	420X220	1268	1003	978	877	341	2196	344	355
	1918	75.5	420X180	420X220	1281	1016	990	889	353	2208	344	355
	1930	76	420X180	420X220	1293	1028	1003	902	366	2221	345	355
B	1943	76.5	420X180	420X220	1306	1041	1016	915	379	2234	345	356
	1956	77	420X180	420X220	1319	1053	1028	927	391	2247	346	356
	1968	77.5	420X180	420X220	1331	1066	1041	940	404	2259	346	357
	2040	81.25	420X180	420X220	1427	1161	1136	1035	499	2354	349	360

- (i) ADDITIONAL TRACKS WIDTHS ARE AVAILABLE.
- (ii) FC AND BC MAY VARY. CONTACT HENDRICKSON ENGINEERING FOR SPECIFIC APPLICATIONS.
- (iii) NOMINAL AC VALUE SHOWN. AC - 50mm MAY BE POSSIBLE FOR AIR SPRING MOUNTING STUD OR FOR LARGE TIRES.
- (iv) NOMINAL GM VALUE FOR 604 CAM SHAFT. OTHER CAM SHAFT LENGTHS AVAILABLE.

AIR SUSPENSION TYPE	RH NOMINAL RIDE HEIGHT	RIDE HEIGHT RANGES		AH - AXLE HEIGHT		PH PIVOT HEIGHT	AS AIR SPRING BRACKET	INSTALLED LENGTHS		SHOCK ABSORBER ATTACHMENTS		SUSPENSION WEIGHT (KG)
		FOR AXLE ASSEMBLIES	FOR AXLE ASSEMBLIES WITH LIFT	UNLADEN WITHOUT AIR	LADEN WITHOUT AIR			L1	L2	SX	SY	
D HSDS 10T	390	370-390	-	300	294	200	5	479	143	198	175	138
	400	380-410	410	311	305	250	5	493	129	191	196	143
	430	410-440	440	340	333	280	35	493	129	185	192	149
	460	440-470	470	370	363	310	65	493	129	179	190	154
	490	470-500	500	400	393	340	95	493	129	175	188	158
	530	510-540	540	440	433	380	135	493	129	171	186	164
570	550-580	580	480	473	420	175	493	129	167	184	170	

THE CROSSMEMBER STRUCTURE AND LOCATIONS SHOWN HERE ARE RECOMMENDATIONS ONLY AND MAY VARY DEPENDING ON THE TRAILER DESIGN



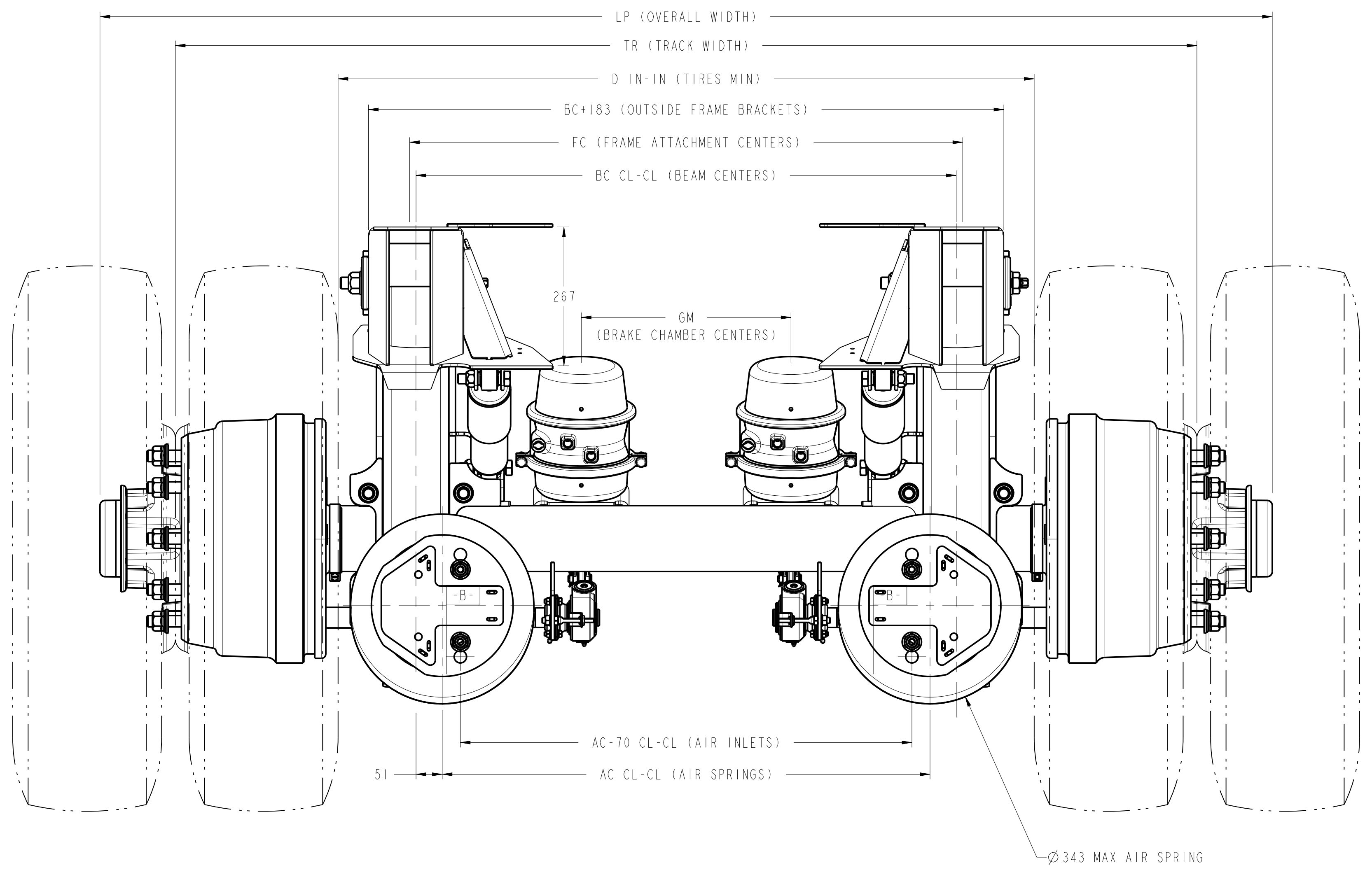
DESCRIPTION	TORQUE SPECIFICATIONS			SOCKET SIZE
	SIZE	TORQUE (N·M)	TORQUE (FT·LBF)	
	SHOCK ABSORBER BOLTS	3/4-10	285-320	
AIR SPRING NUTS, UPPER	M22X1.5	110-135	80-100	34 MM
AIR SPRING NUTS, LOWER	M14X2	80-90	60-70	18 MM
AIR SPRING PLUG	M12X1.5	15	10	6 MM HEX
U-BOLTS	M22X1.5	645-710	475-525	32 MM
HCV BOLTS	M6X1	7-9	60-80 IN-LBF	10 MM
HCV SHOULDER BOLTS	1/4-20	7-9	60-80 IN-LBF	12 MM
BRAKE CHAMBER JAM NUT	M16X1.5	60-68	45-50	24 MM
BRAKE CHAMBER BOLTS	M16X1.5	180-210	130-155	24 MM
PIVOT BOLTS*	7/8-9	685-810	505-595	E-20 & 36 MM
AIR SPRING SPACER TO FRAME BOLTS	M12X1.75	115-125	85-95	18 MM
AIR SPRING PLATE TO FRAME BOLTS	M12X1.75	115-125	85-95	18 MM
FRAME BRACKET TO FRAME BOLTS	M16X2	280-315	210-230	24 MM

* AFTER FINAL AXLE ALIGNMENT, TIGHTEN UNTIL SHEAR HEAD SEPARATES.

- INSTALLATION CHECKLIST:
- PROPERLY LOCATE AND WELD CROSS MEMBERS, SPACERS, AND GUSSETS.
 - REMOVE PAINT ON HANGER PER SHEET 7.
 - PLACE AND WELD THE FOLLOWING:
 - SUSPENSION WITH FRAME BRACKETS
 - AIR SPRING SPACER
 - REMOTE SHOCK BRACKET
 - ARL BRACKET
 - ASSEMBLE AND TORQUE THE FOLLOWING:
 - AIR SPRINGS
 - SHOCKS
 - BRAKE CHAMBERS
 - ATTACH SLACK ADJUSTER TO BRAKE CHAMBERS.
 - TORQUE JAM NUT, TIGHTEN BRAKES THEN BACK OFF 1/2 TURN.
 - INSTALL BRAKE VALVE, PARKING BRAKE VALVE, AND BRAKE AIR LINES.
 - INSTALL PPV, HCV, AND AIR SPRING AIR LINES.
 - ALIGN SUSPENSION PER HENDRICKSON DOCUMENT L579.
 - TIGHTEN PIVOT BOLTS UNTIL E-20 FEATURE BREAKS OFF.
 - UNCAGE BRAKES.

- NOTES:
- IT IS THE RESPONSIBILITY OF THE INSTALLER TO ENSURE PROPER VEHICLE FRAME DESIGN IN AREA OF SUSPENSION ATTACHMENT.
 - COMPONENT REPRESENTATIONS ARE FOR REFERENCE ONLY. ACTUAL COMPONENT APPEARANCE MAY VARY.
 - SEE CHART BB FOR TORQUE SPECIFICATIONS OF FASTENERS.
 - SUSPENSION WEIGHT INCLUDES SUSPENSION COMPONENTS ONLY. WEIGHT REFLECTS STANDARD AIR SPRING, FRAME BRACKETS AND SHOCKS.

- CLEARANCE SPECIFICATIONS:
- 25 MM MINIMUM REQUIRED BETWEEN TOP OF TIRE AND BOTTOM OF TRAILER STRUCTURE WHEN AXLE IS AT FULL JOUNCE.
 - 50 MM MINIMUM REQUIRED BETWEEN INSIDE OF TIRE AND TRAILER STRUCTURE FOR LATERAL MOVEMENT.
 - 25 MM MINIMUM CLEARANCE MUST BE MAINTAINED AROUND AIR SPRING WHEN IT IS AT MAXIMUM DIAMETER.

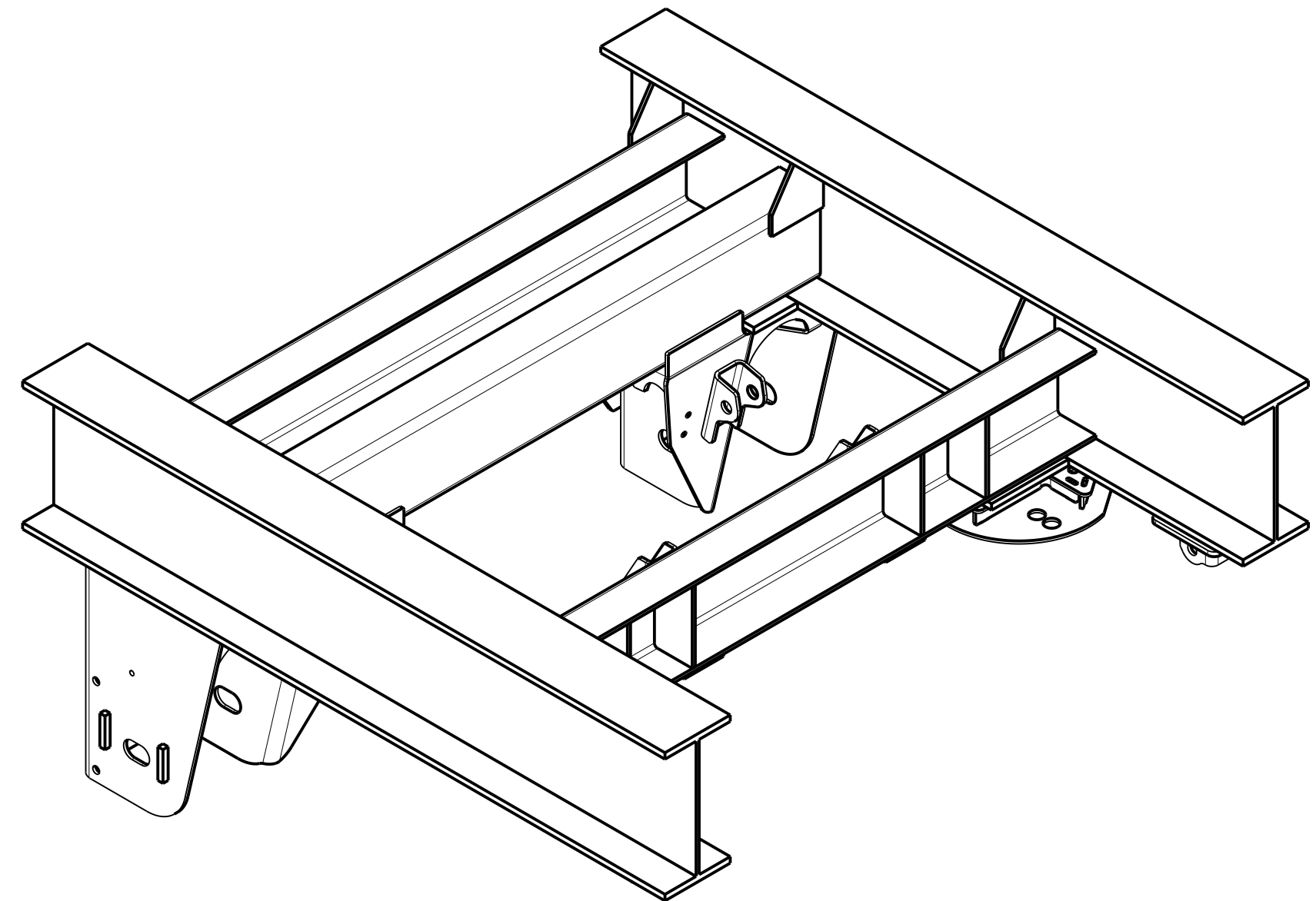
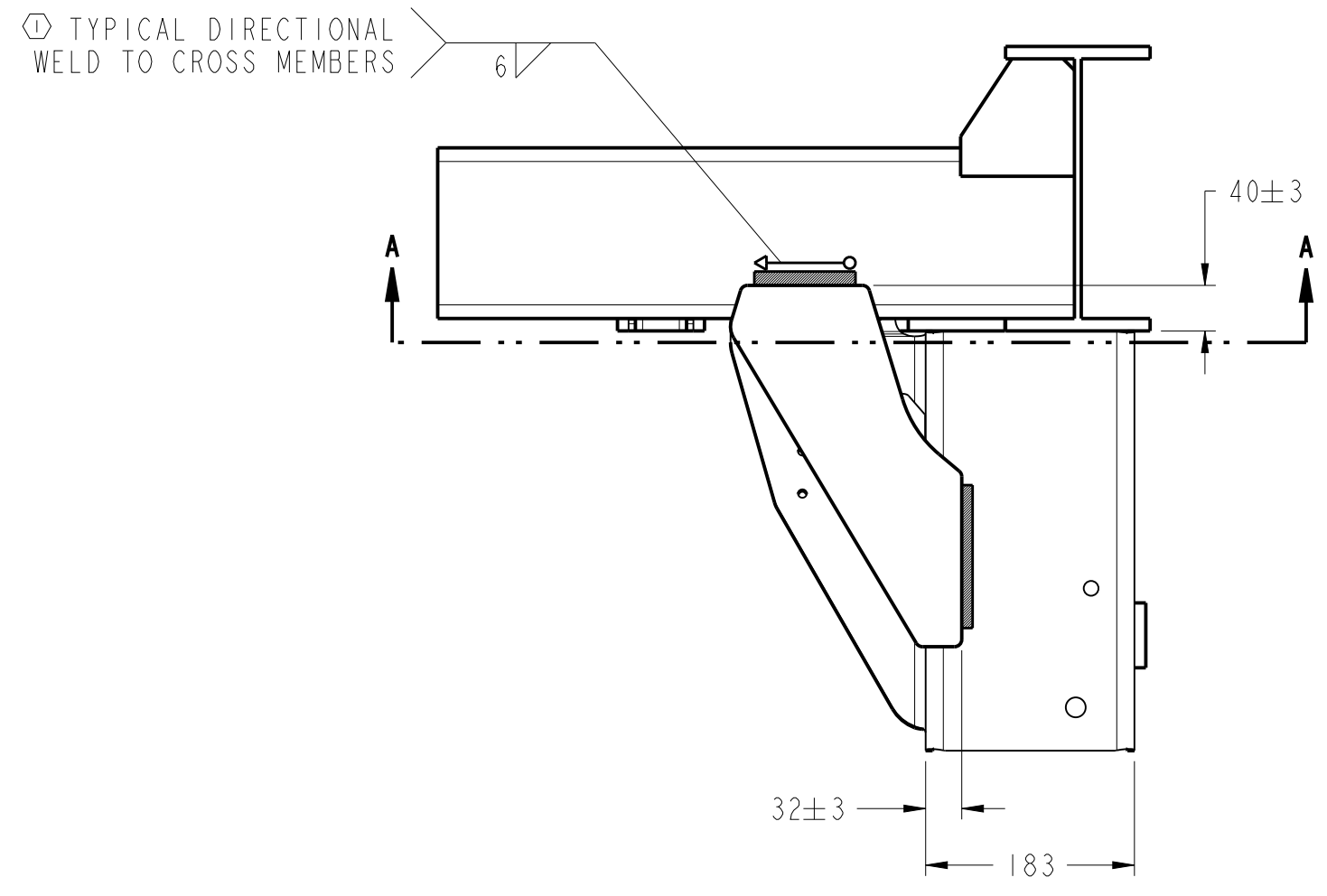
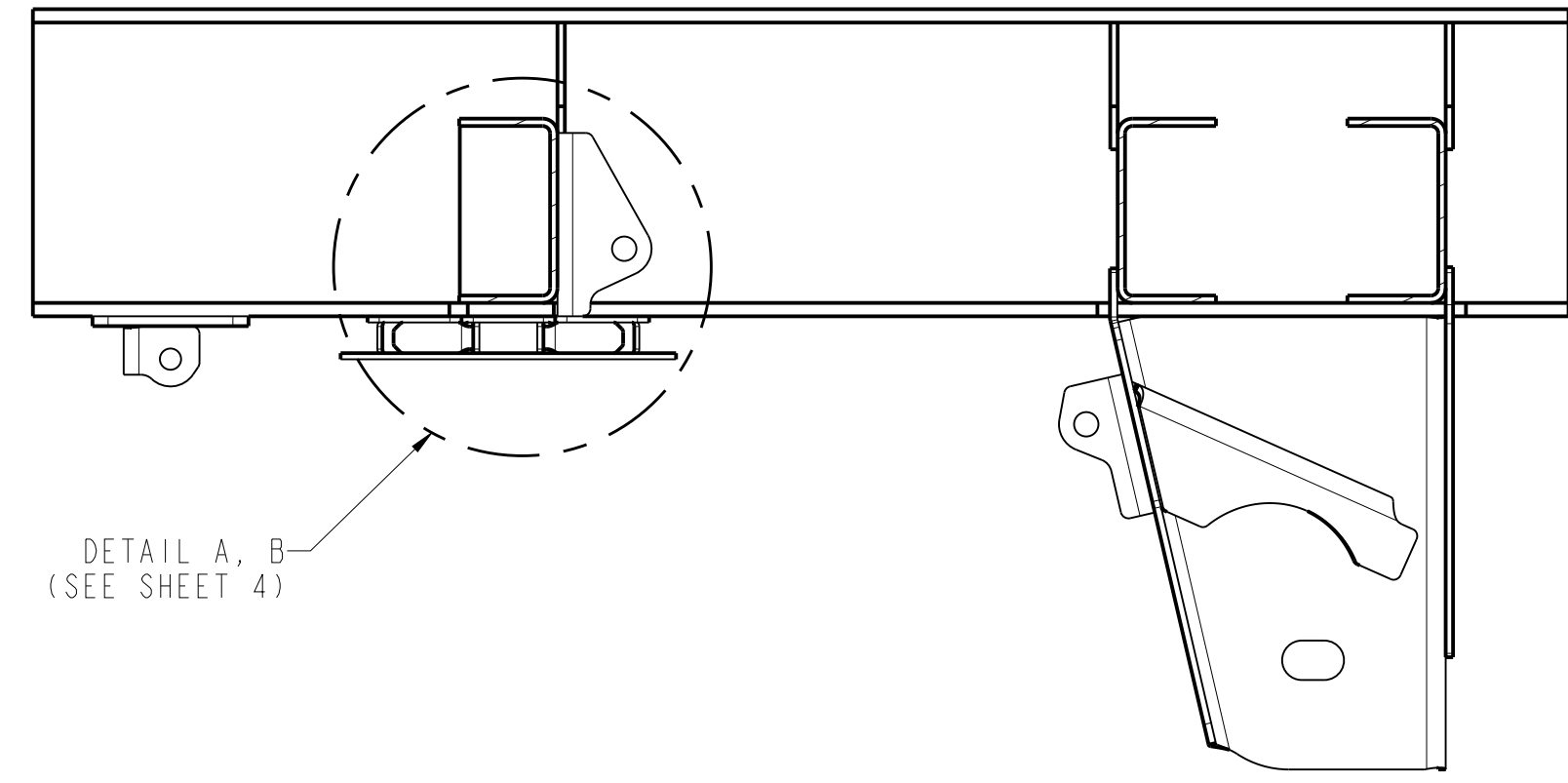


This print remains the property of Hendrickson. All information contained hereon is confidential. It is loaned, subject to return on demand, and on the express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.

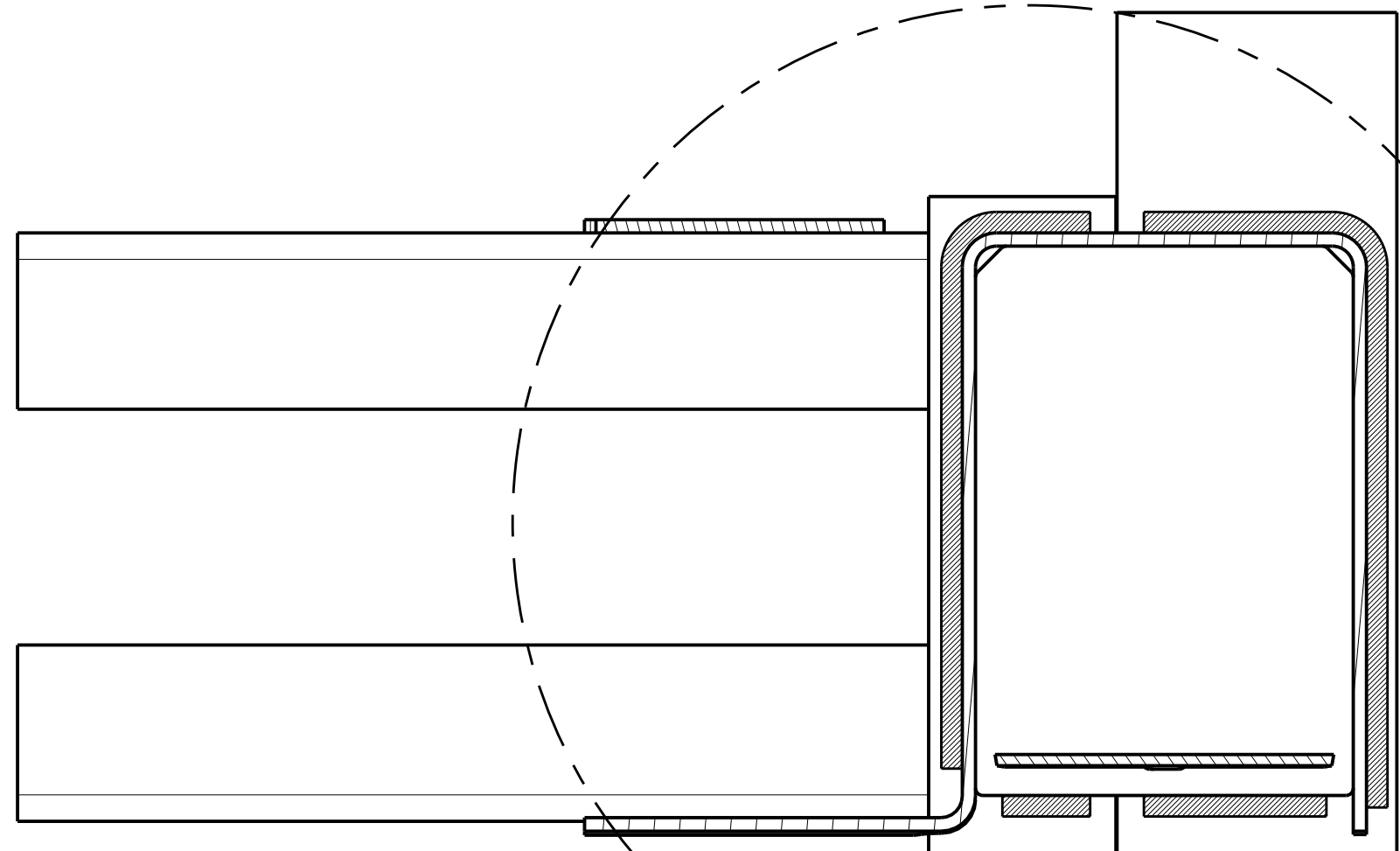
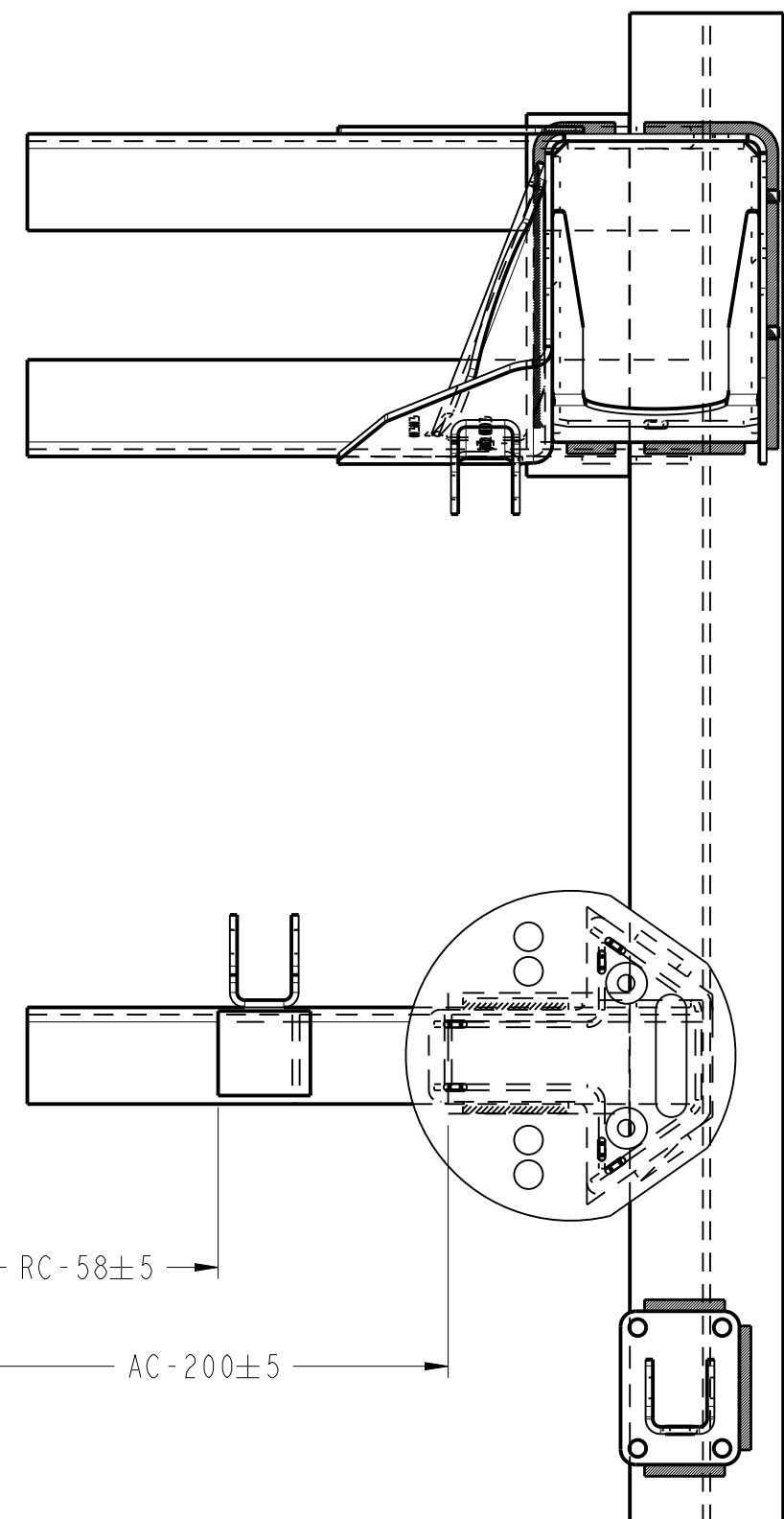
NOTE: ORIGINAL DRAWING CREATED IN CREO. ALL REVISIONS TO THIS DRAWING MUST BE PERFORMED ON THE CREO DRAWING AND THEN CONVERTED TO THE APPLICABLE FORMAT.

HSDS 10T

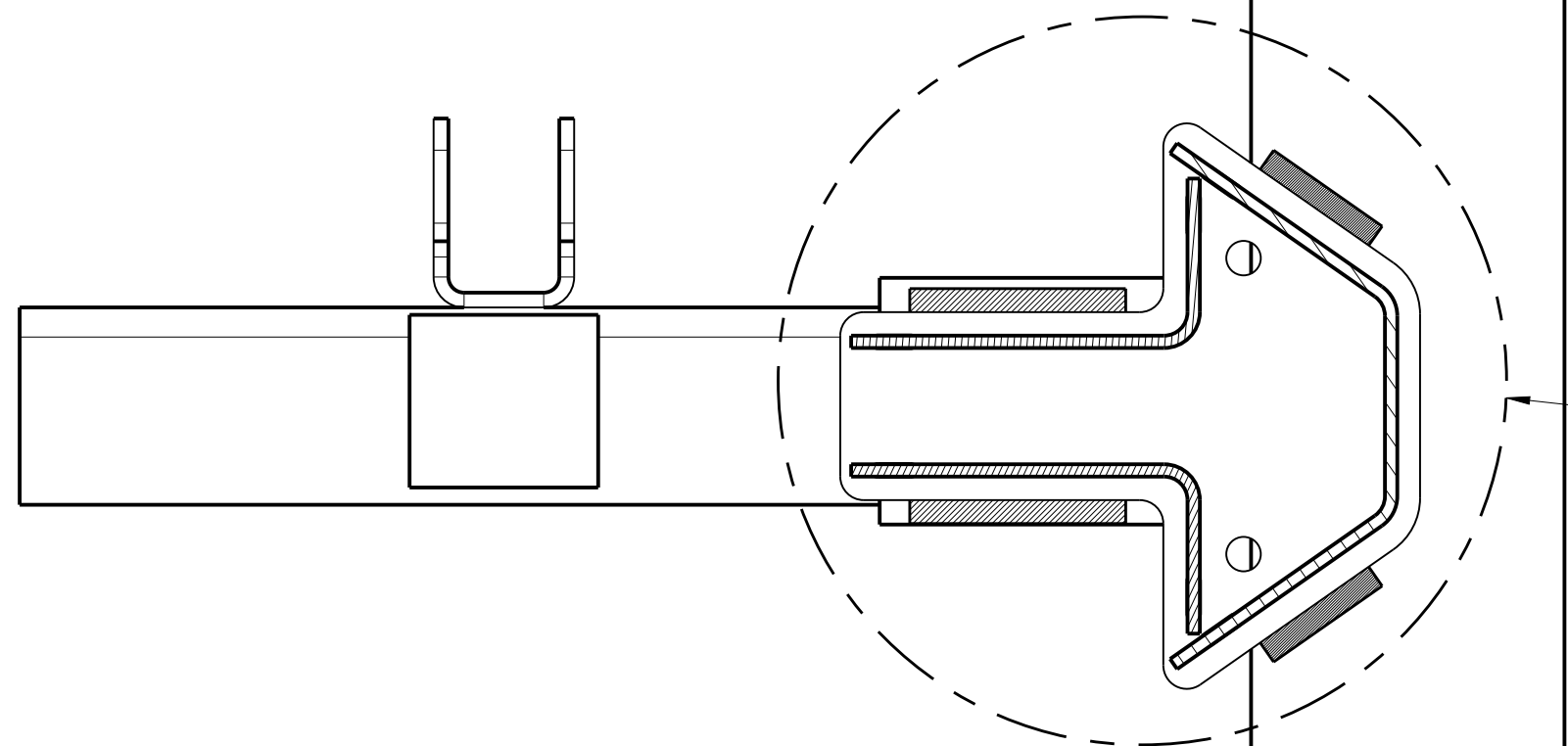
NOTE: ORIGINAL DRAWING CREATED IN CREO. ALL REVISIONS TO THIS DRAWING MUST BE PERFORMED ON THE CREO DRAWING AND THEN CONVERTED TO THE APPLICABLE FORMAT.



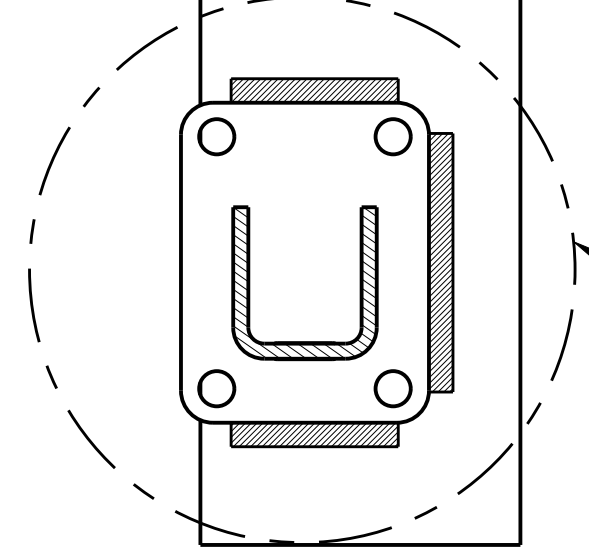
SCALE 1:8



DETAIL G, H, I
(SEE SHEET 5)



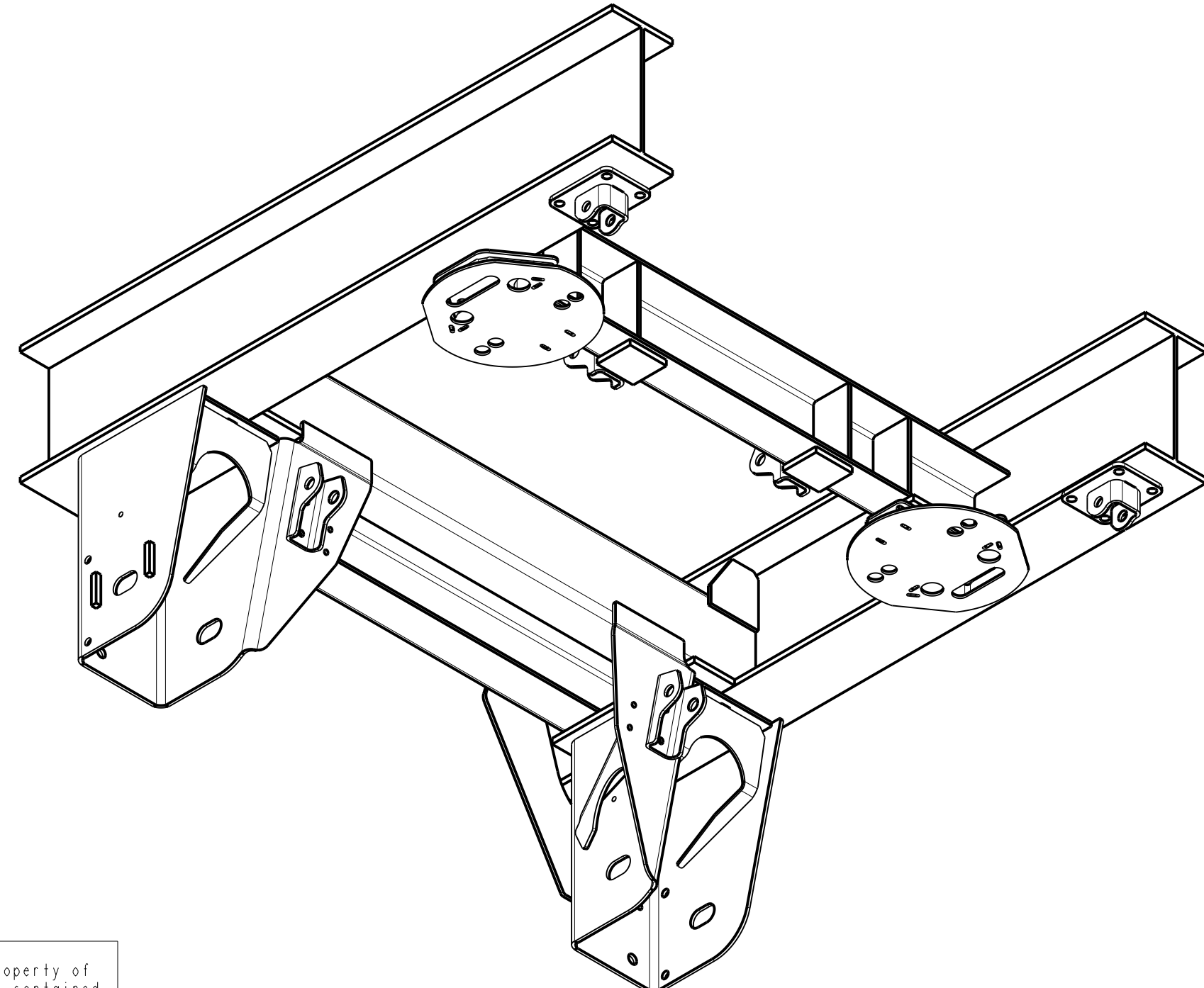
DETAIL D, E, F
(SEE SHEET 4)



DETAIL C
(SEE SHEET 4)

SECTION A-A
SCALE 1:3

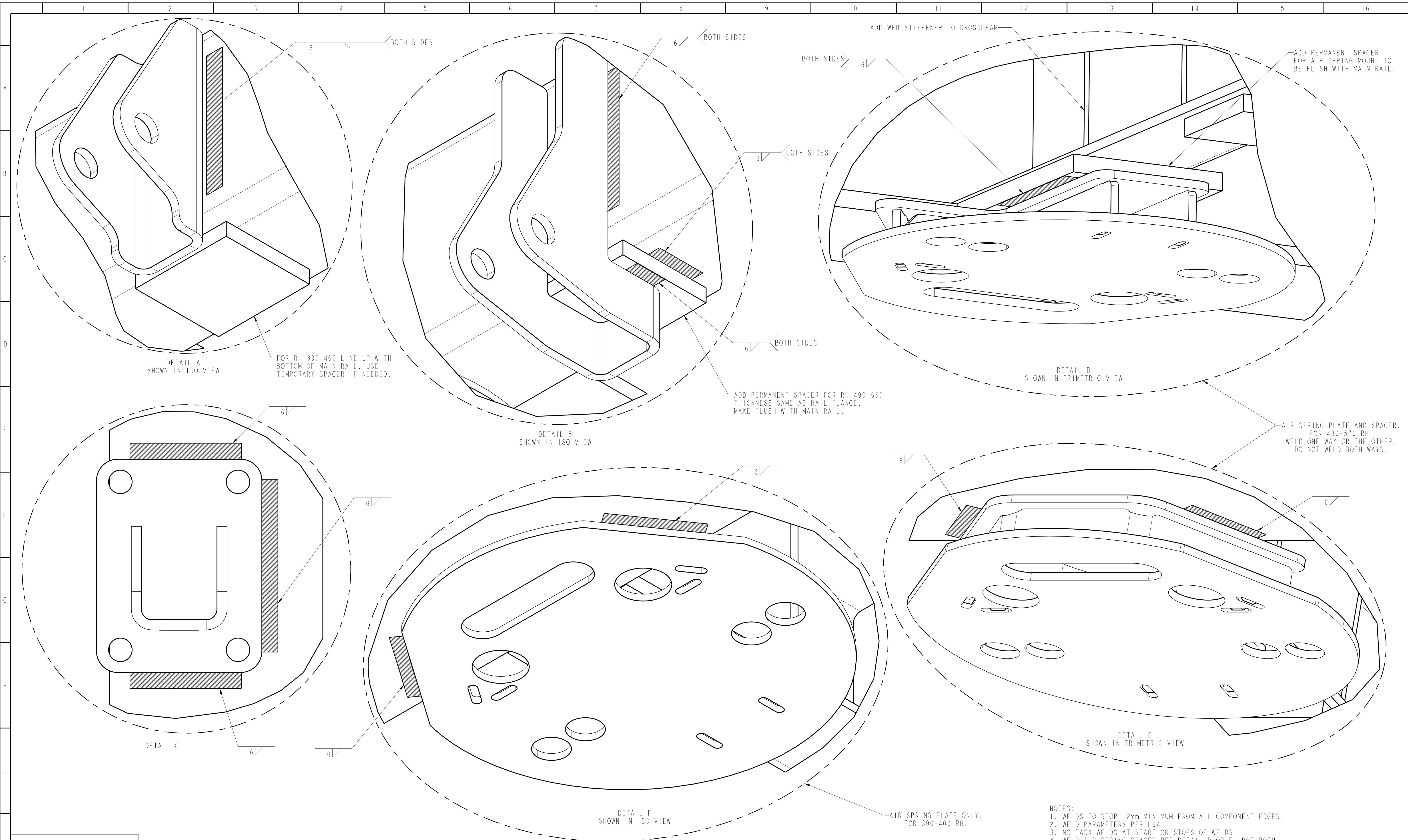
- NOTES:
 1. WELDS TO STOP 12mm MINIMUM FROM ALL COMPONENT EDGES.
 2. WELD PARAMETERS PER L64.
 3. NO TACK WELDS AT START OR STOPS OF WELDS.



SCALE 1:8

This print remains the property of Hendrickson. All information contained hereon is confidential. It is loaned, subject to return on demand, and on the express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.

HENDRICKSON		UNLESS OTHERWISE NOTED		DRAWN BY: A. BRUGGER		DATE: 28-Jul-15		SCALE: 1:6		PAGE: 3 OF 10	
TRAILER COMMERCIAL VEHICLE SYSTEMS 2076 INDUSTRIAL PLACE S.E. CANTON, OH 44707-2666 U.S.A.		TOLERANCES ARE: X: ± .15 Y: ± .30 Z: ± .50 XXX: ± .13 ANGULAR: ± 0.5°		DIMENSIONS ARE: MM (IN/DEC)		CHECKED BY: C. ANDERSON		THIS DRAWING IS THE CONFIDENTIAL PROPERTY OF HENDRICKSON		DRAWING NUMBER: D-32106	
		DIMENSIONS ADHERE TO ANSI Y14.5M-1987		REV. ECN NO. BY DATE		APPROVED BY: M. OYSTER		HSDS INSTALLATION			



DETAIL A
SHOWN IN ISO VIEW

FOR RH 390-460 LINE UP WITH
BOTTOM OF MAIN RAIL. USE
TEMPORARY SPACER IF NEEDED.

DETAIL B
SHOWN IN ISO VIEW

DETAIL D
SHOWN IN TRIMETRIC VIEW

DETAIL C

DETAIL F
SHOWN IN ISO VIEW

DETAIL E
SHOWN IN TRIMETRIC VIEW

- NOTES:
1. WELDS TO STOP 12mm MINIMUM FROM ALL COMPONENT EDGES.
 2. WELD PARAMETERS PER L64.
 3. NO TACK WELDS AT START OR STOPS OF WELDS.
 4. WELD AIR SPRING SPACER PER DETAIL D OR E, NOT BOTH.

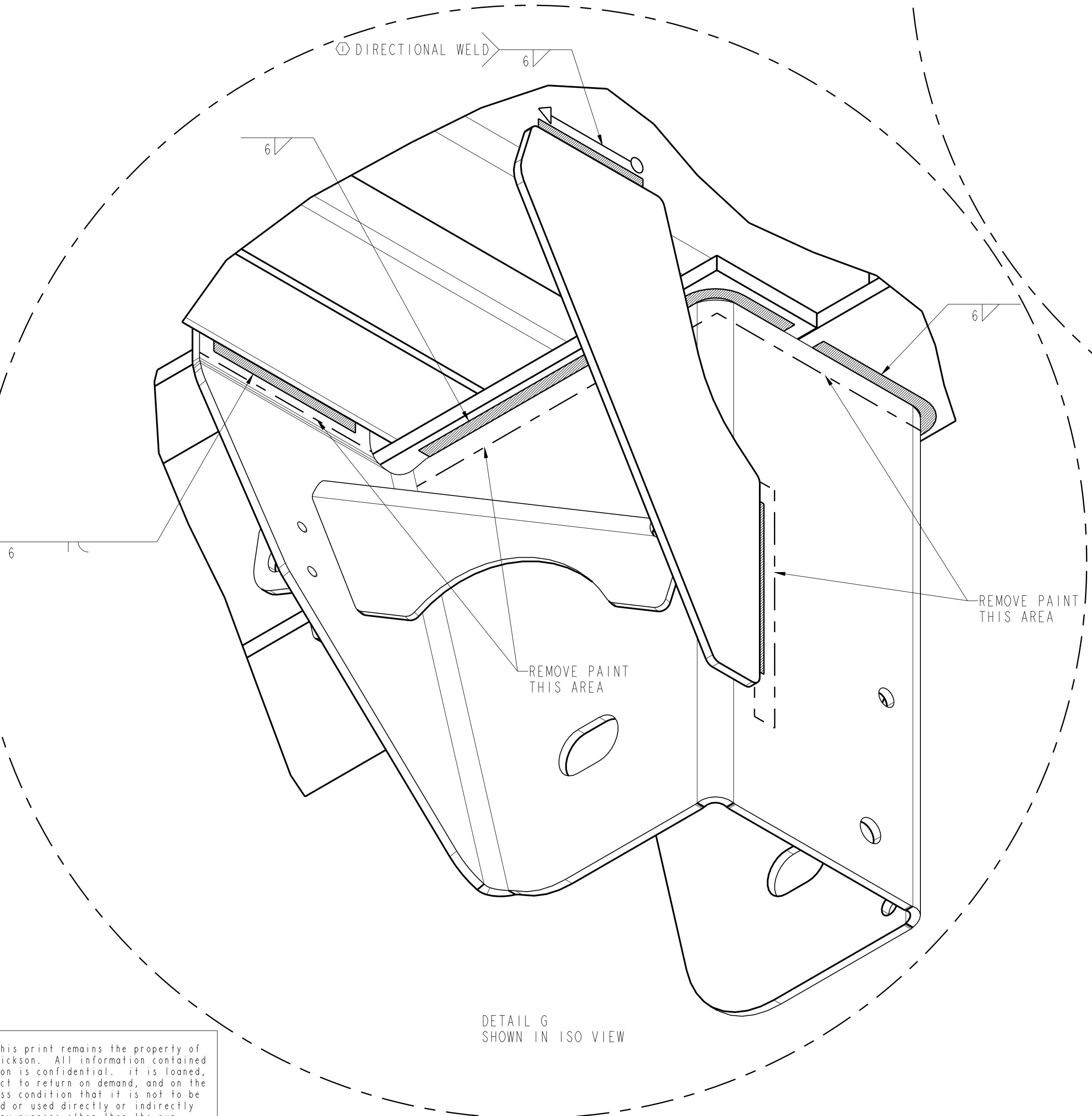
This print remains the property of Hendrickson. All information contained hereon is confidential. It is loaned, subject to return on demand, and on the express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.

NOTE: ORIGINAL DRAWING CREATED IN CREO. ALL REVISIONS TO THIS DRAWING MUST BE PERFORMED ON THE CREO DRAWING AND THEN CONVERTED TO THE APPLICABLE FORMAT.

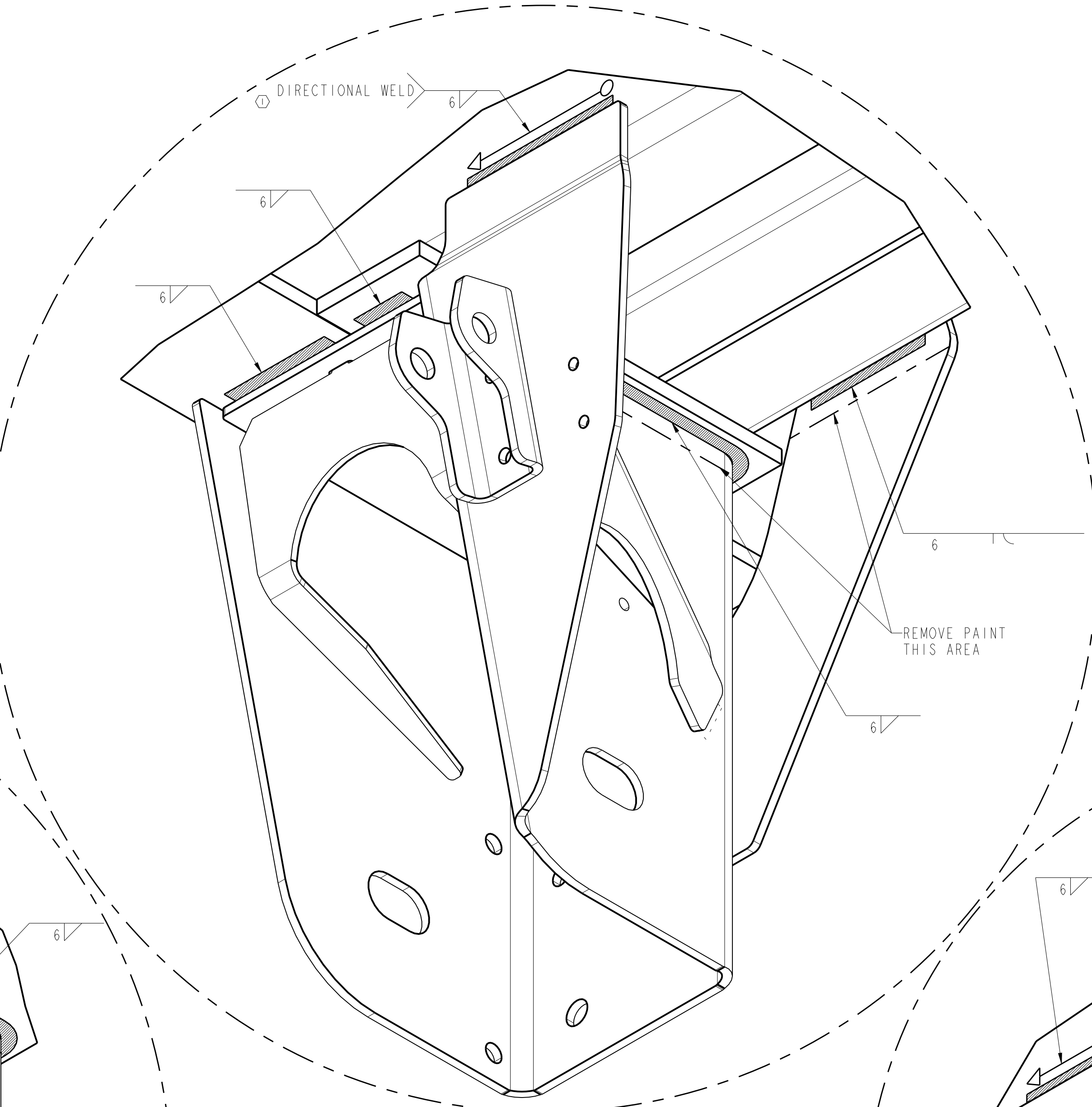
NOTE: ORIGINAL DRAWING CREATED IN CREO. ALL REVISIONS TO THIS DRAWING MUST BE PERFORMED ON THE CREO DRAWING AND THEN CONVERTED TO THE APPLICABLE FORMAT.

A
B
C
D
E
F
G
H
J
K

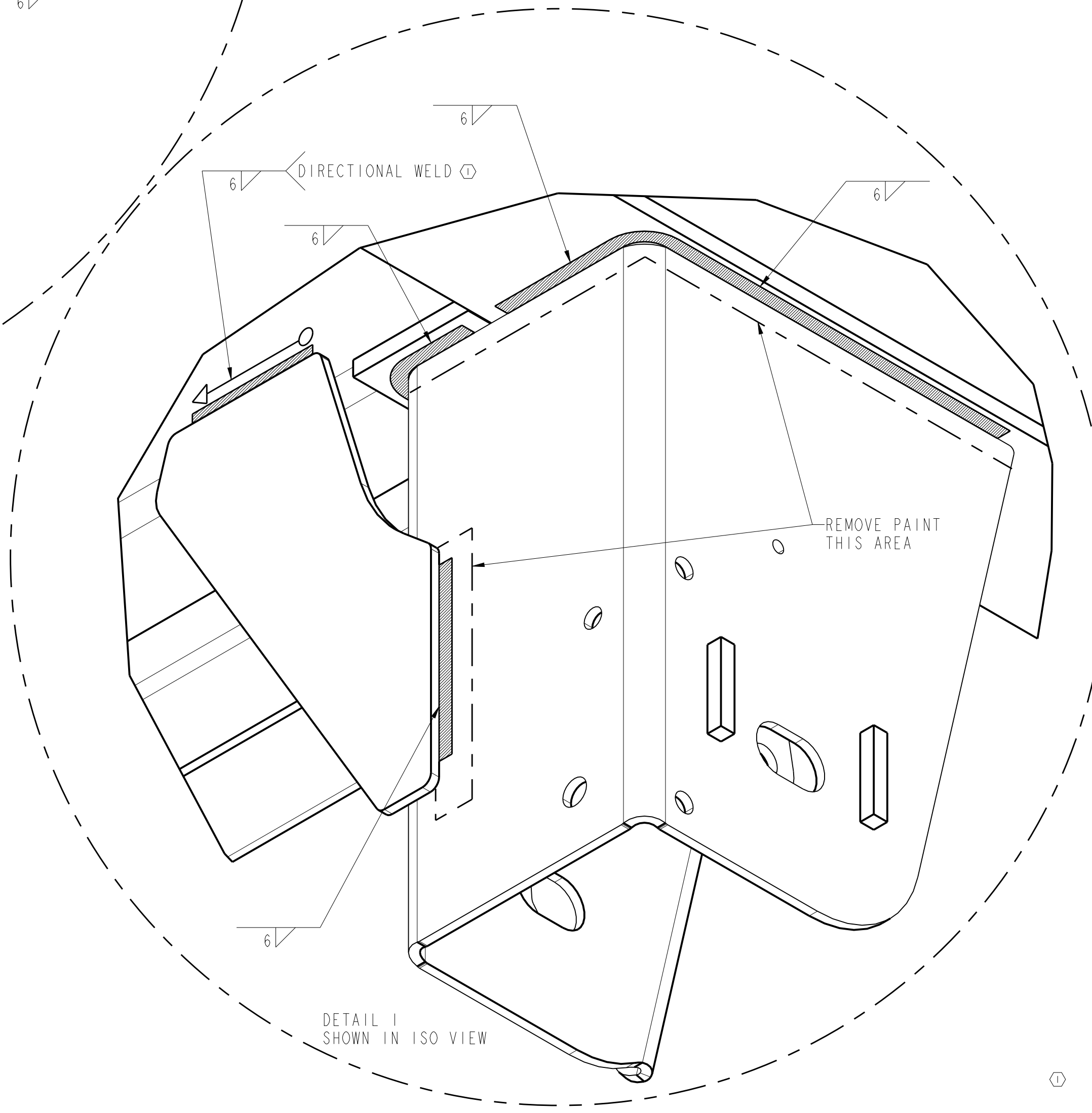
1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16



DETAIL G
SHOWN IN ISO VIEW



DETAIL H
SHOWN IN ISO VIEW



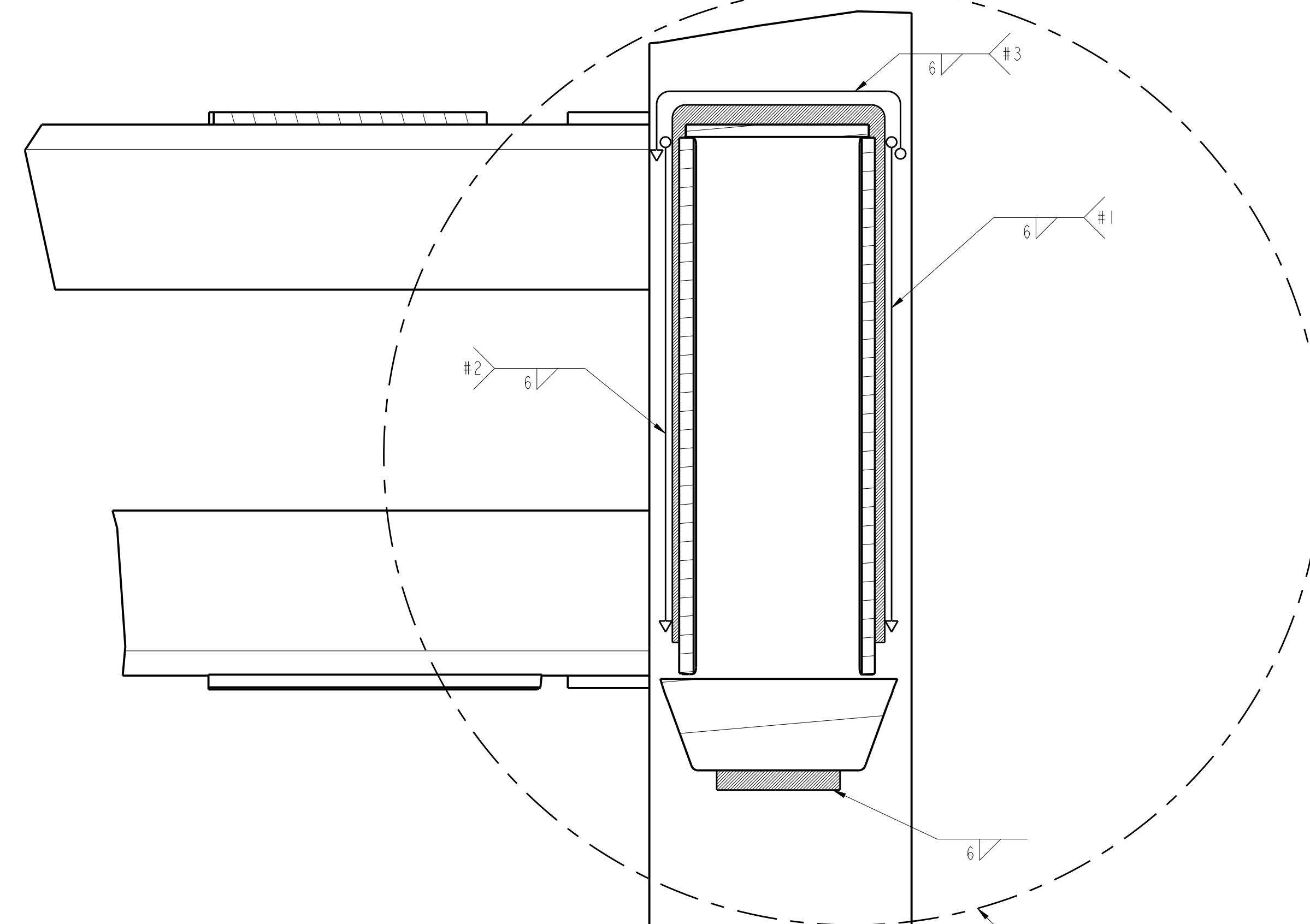
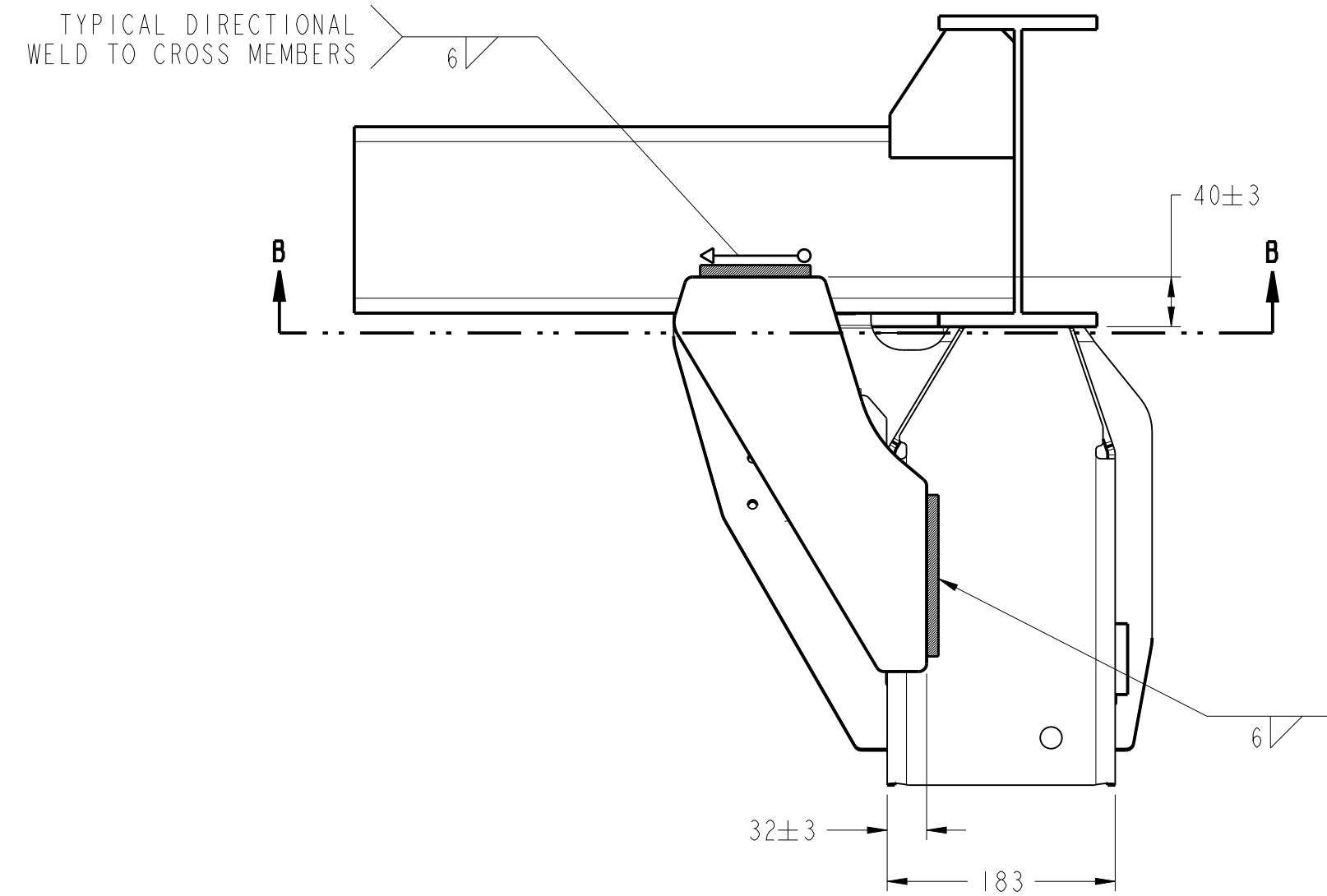
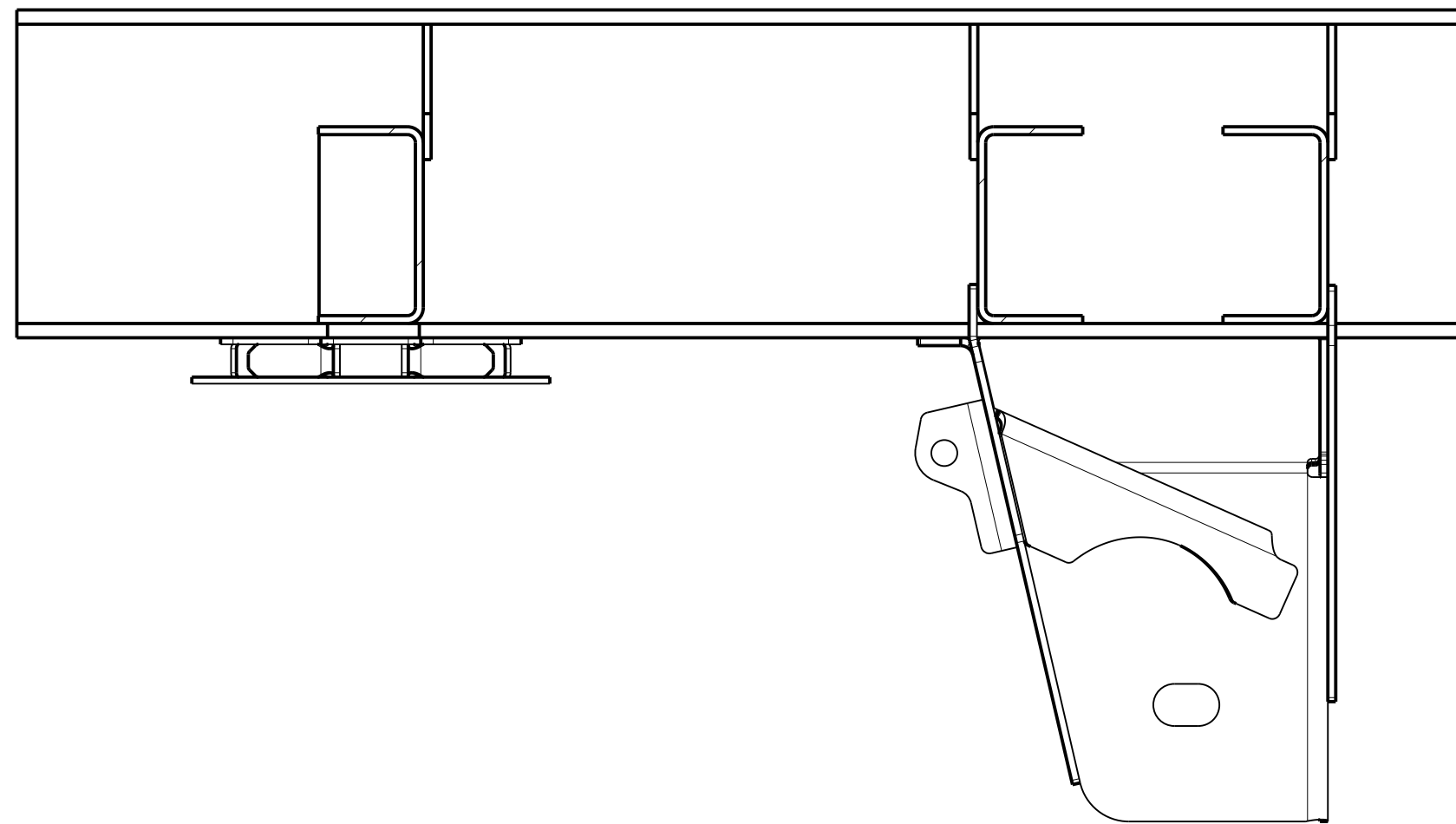
DETAIL I
SHOWN IN ISO VIEW

- NOTES:
1. WELDS TO STOP 12mm MINIMUM FROM ALL COMPONENT EDGES.
 2. WELD PARAMETERS PER L64.
 3. REMOVE PAINT ALONG TOP EDGE OF FRAME BRACKET, ON BACK SIDE OF HANGER WING, AND FRONT SIDE OF FRAME BRACKET FOR GUSSET WELDING.
 4. MAX 3mm GAP AROUND FRAME BRACKET TO FRAME RAIL INTERFACE BEFORE WELDING.

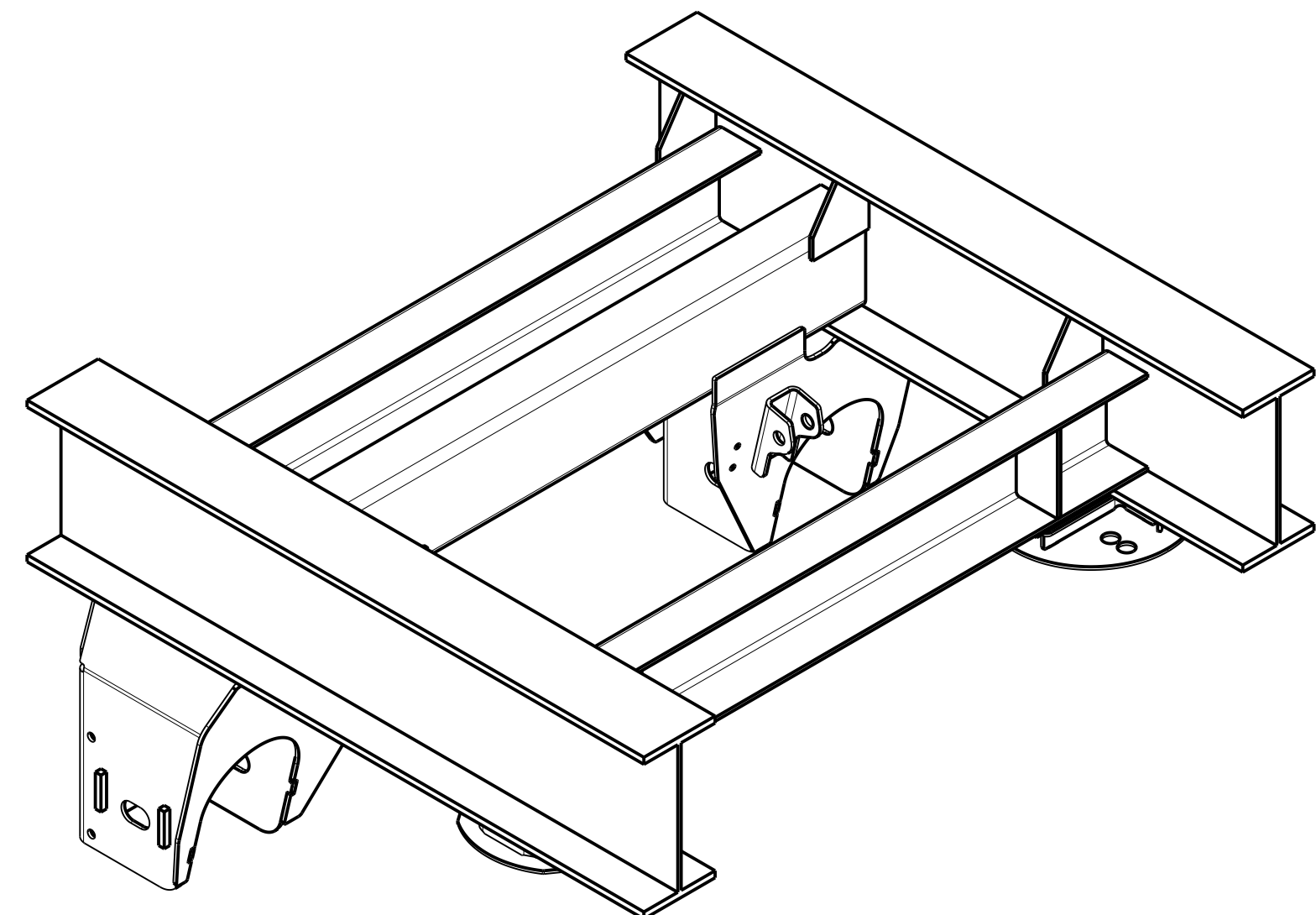
This print remains the property of Hendrickson. All information contained hereon is confidential. It is loaned, subject to return on demand, and on the express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.

<p>HENDRICKSON TRAILER COMMERCIAL VEHICLE SYSTEMS 2076 INDUSTRIAL PLACE S.E. CANTON, OH 44707-2666 U.S.A.</p>	<p>UNLESS OTHERWISE NOTED</p> <p>TOLERANCES ARE: X: ± .15 XX: ± .30 XXX: ± .50 ANGULAR: ± 0.5°</p>		<p>DIMENSIONS ARE: MM (INCHES)</p>		<p>1 24542 SS 08-11-15</p>		<p>DATE: 05-Aug-15</p>		<p>SCALE: 1:2</p>		<p>PAGE: 5 OF 10</p>	
	<p>DIMENSIONS ADHERE TO ANSI Y14.5M-1987</p>		<p>3RD ANGLE PROJECTION</p>		<p>REV. ECN NO. BY DATE</p>		<p>DRAWN BY: A. BRUGGER CHECKED BY: C. ANDERSON APPROVED BY: M. OYSTER</p>		<p>THIS DRAWING IS THE CONFIDENTIAL PROPERTY OF HENDRICKSON</p>		<p>HSDS INSTALLATION</p>	
										<p>SIZE: D</p>	<p>DRAWING NUMBER: D-32106</p>	

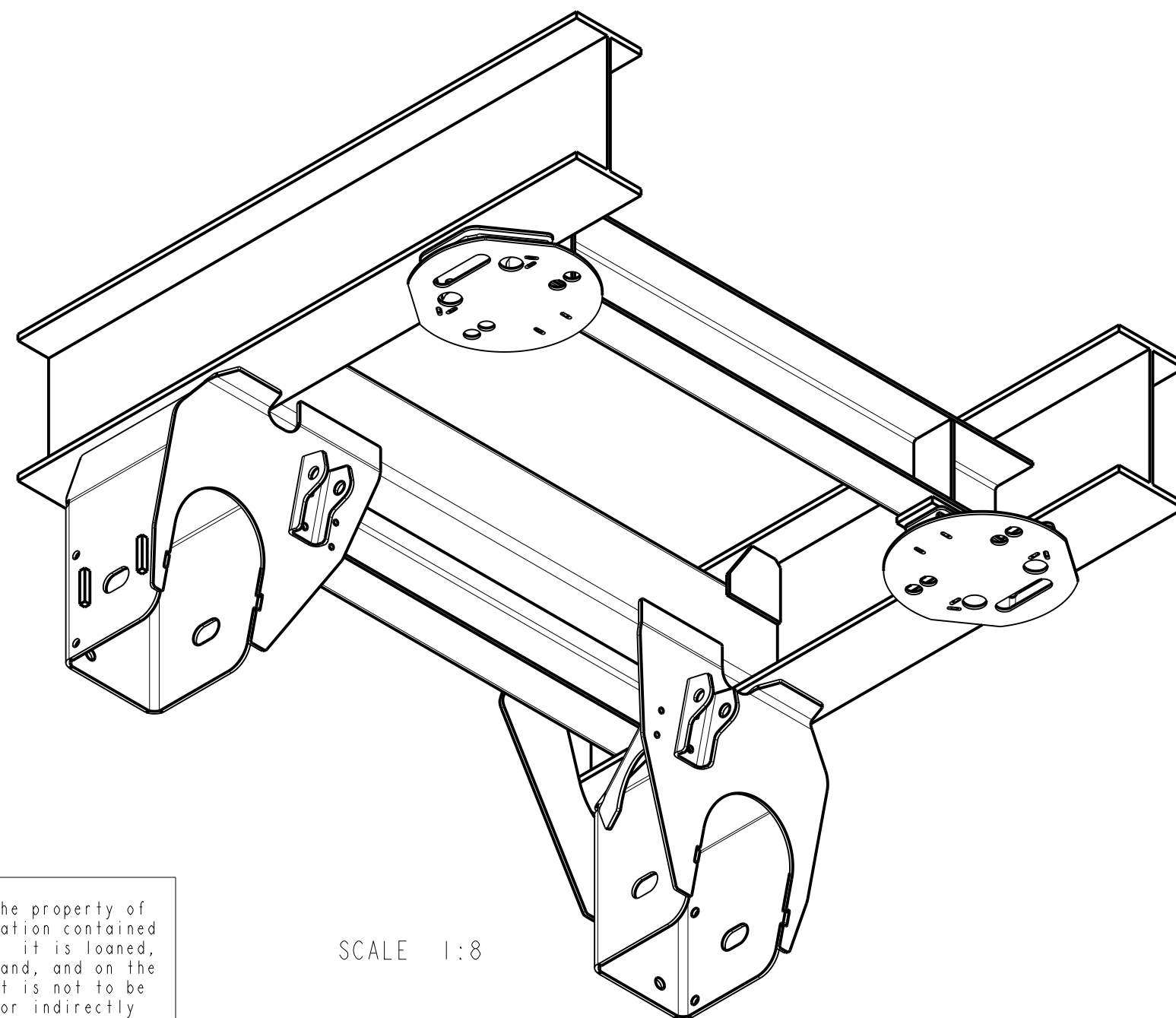
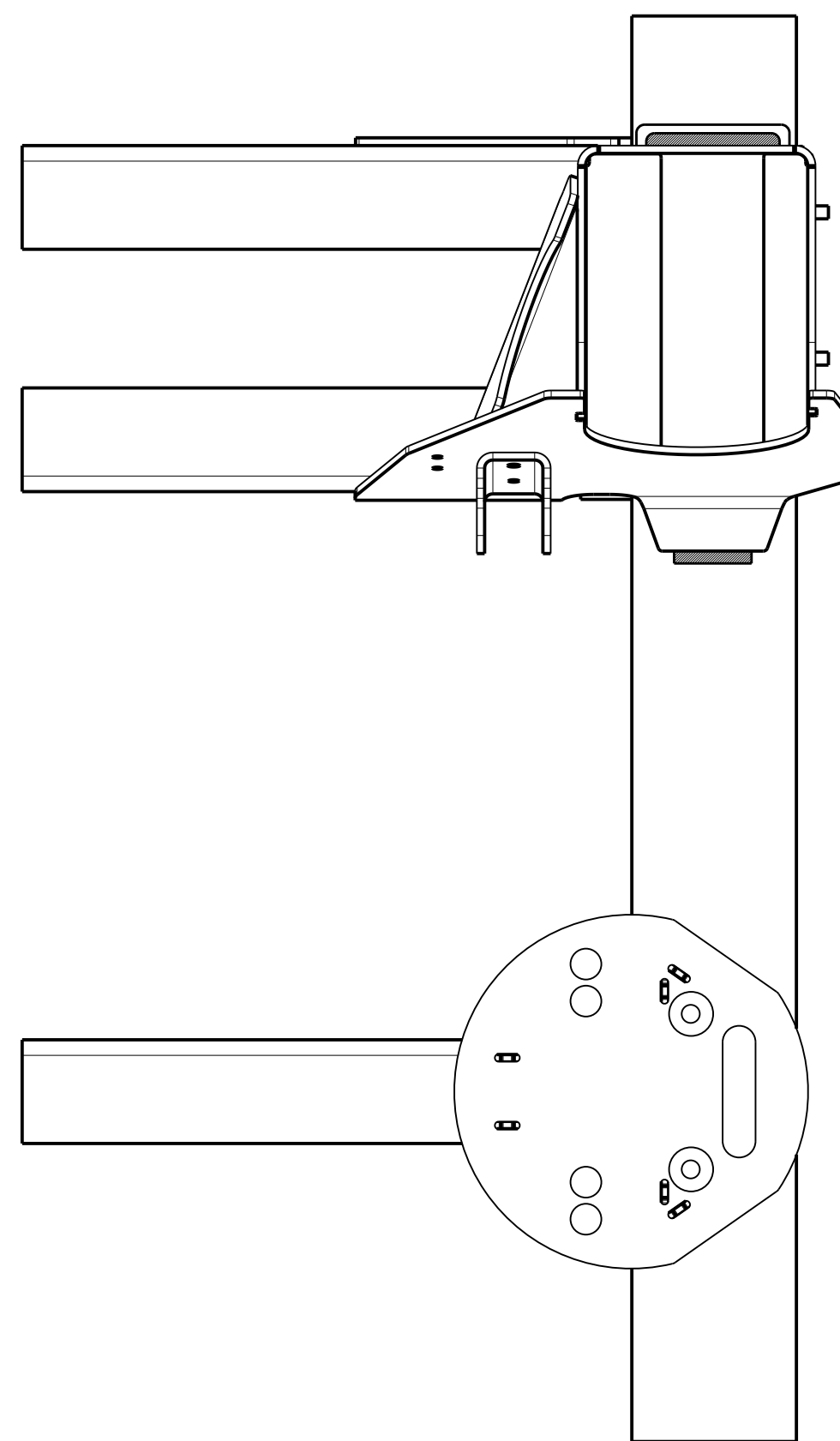
NOTE: ORIGINAL DRAWING CREATED IN CREO
ALL REVISIONS TO THIS DRAWING MUST BE
PERFORMED ON THE CREO DRAWING AND
THEN CONVERTED TO THE APPLICABLE FORMAT.



DETAIL J, K, L
(SEE SHEET 7)



SCALE 1:8



SCALE 1:8

- NOTES:
1. WELDS TO STOP 12mm MINIMUM FROM ALL COMPONENT EDGES.
 2. WELD PARAMETERS PER L64.
 3. NO TACK WELDS AT START OR STOPS OF WELDS.

SECTION B-B
SCALE 1:2

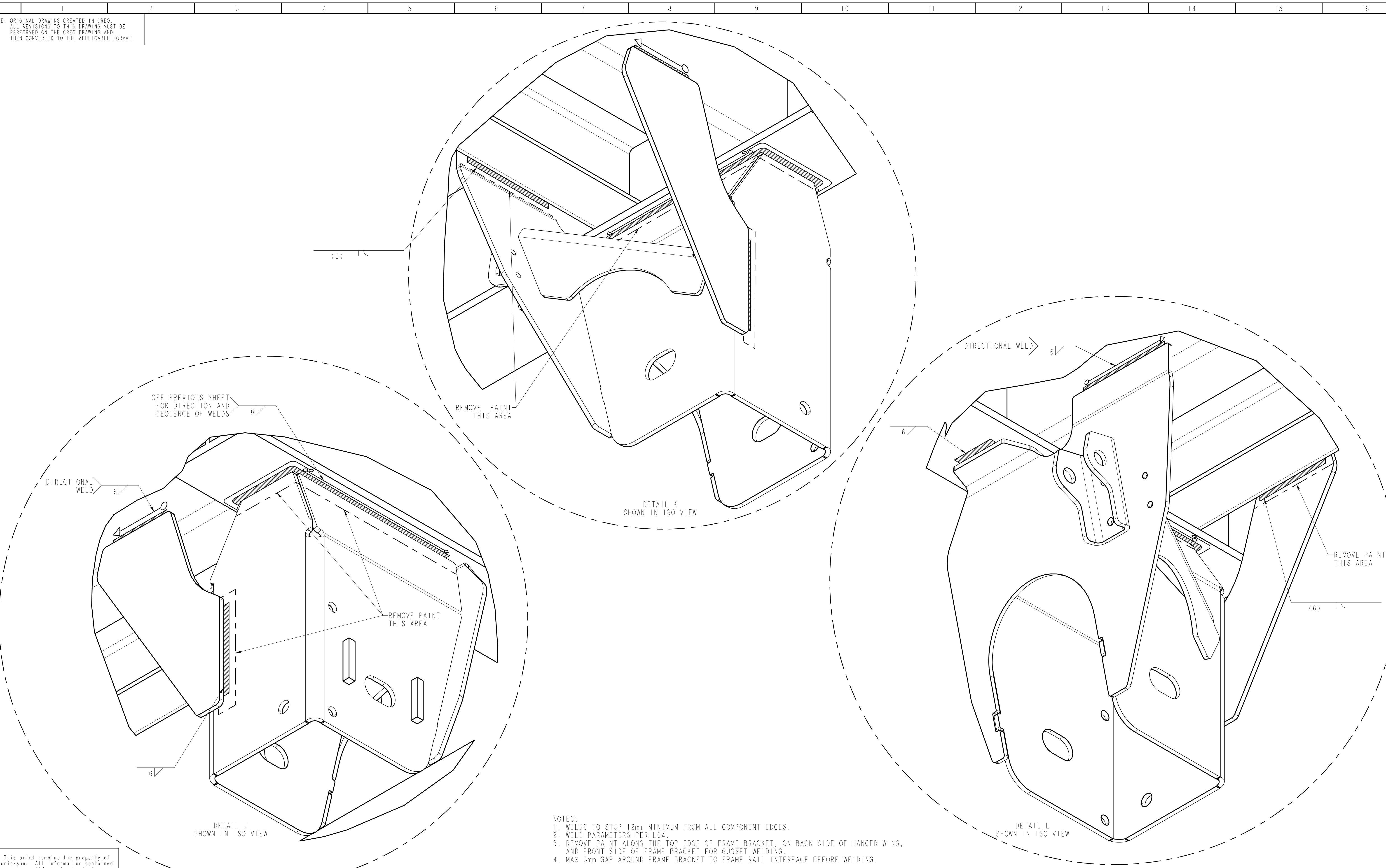
FOR AIR SPRING PLATE
AND SPACER WELDING,
SEE SHEET 4,
DETAIL D, E, F

This print remains the property of
Hendrickson. All information contained
thereon is confidential. It is loaned,
subject to return on demand, and on the
express condition that it is not to be
copied or used directly or indirectly
for any purpose other than the pur-
pose for which it has been loaned to
you.

HENDRICKSON		UNLESS OTHERWISE NOTED		DRAWN BY: SCABILLONI	DATE: 05-Aug-15
TOLERANCES ARE:	DIMENSIONS ARE:	1	24542	SS	08-11-15
X: ± .15	MM (IN/DEC):	REV.	ECN NO.	BY	DATE
XX: ± .30					
XXX: ± .50					
ANGULAR: ± 0.5°					
DIMENSIONS ADHERE TO ANSI Y14.5M-1987		REV. ECN NO. BY DATE		APPROVED BY: -	
TRAILER COMMERCIAL VEHICLE SYSTEMS 2076 INDUSTRIAL PLACE S.E. CANTON, OH 44707-2666 U.S.A.				THIS DRAWING IS THE CONFIDENTIAL PROPERTY OF HENDRICKSON	
				HSDS INSTALLATION	
SCALE: 1:5	PAGE: 6 OF 10		SIZE: D		DRAWING NUMBER: D-32106

NOTE: ORIGINAL DRAWING CREATED IN CREO
 ALL REVISIONS TO THIS DRAWING MUST BE
 PERFORMED ON THE CREO DRAWING AND
 THEN CONVERTED TO THE APPLICABLE FORMAT.

A
B
C
D
E
F
G
H
J
K



SEE PREVIOUS SHEET
 FOR DIRECTION AND
 SEQUENCE OF WELDS

REMOVE PAINT
 THIS AREA

DETAIL K
 SHOWN IN ISO VIEW

DIRECTIONAL WELD

REMOVE PAINT
 THIS AREA

DETAIL J
 SHOWN IN ISO VIEW

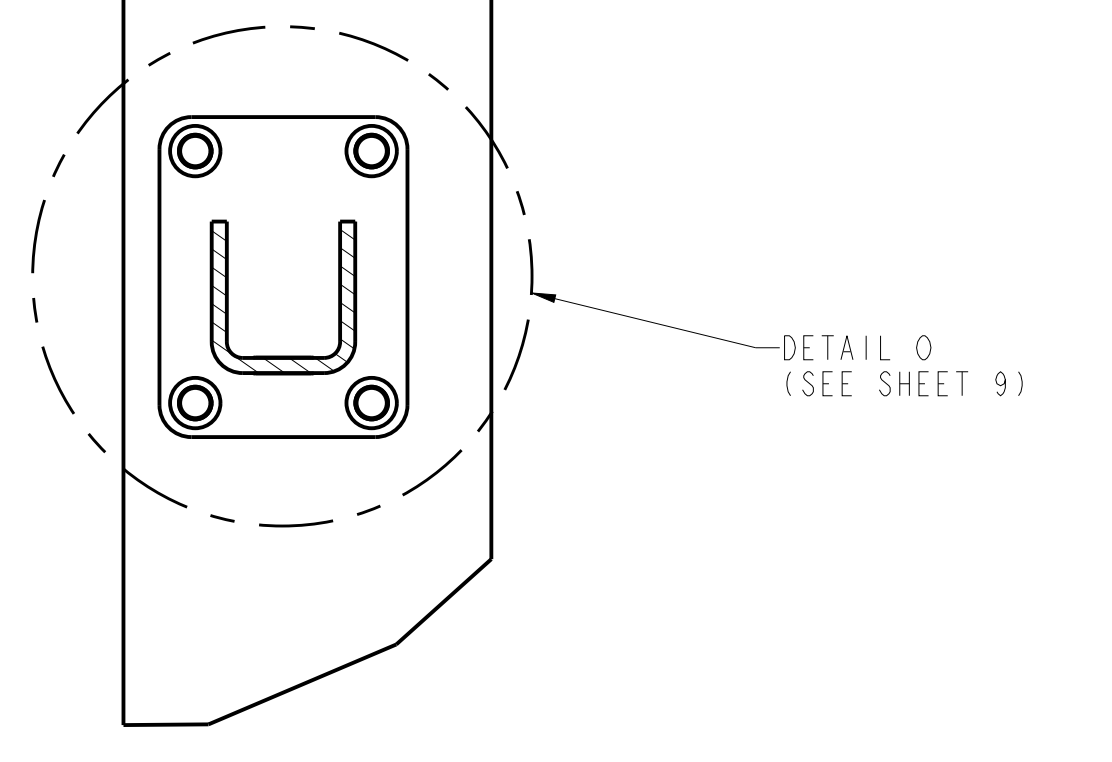
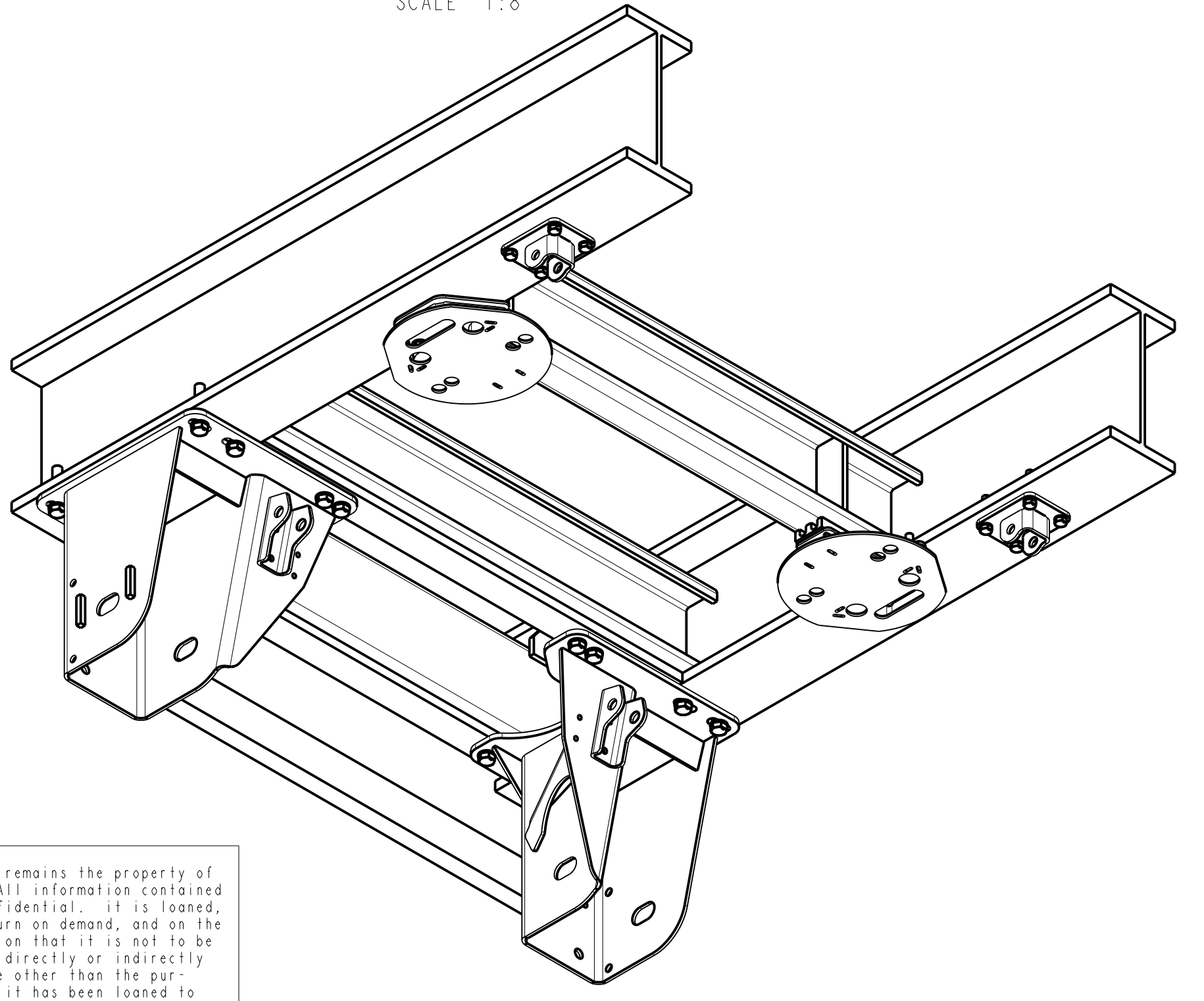
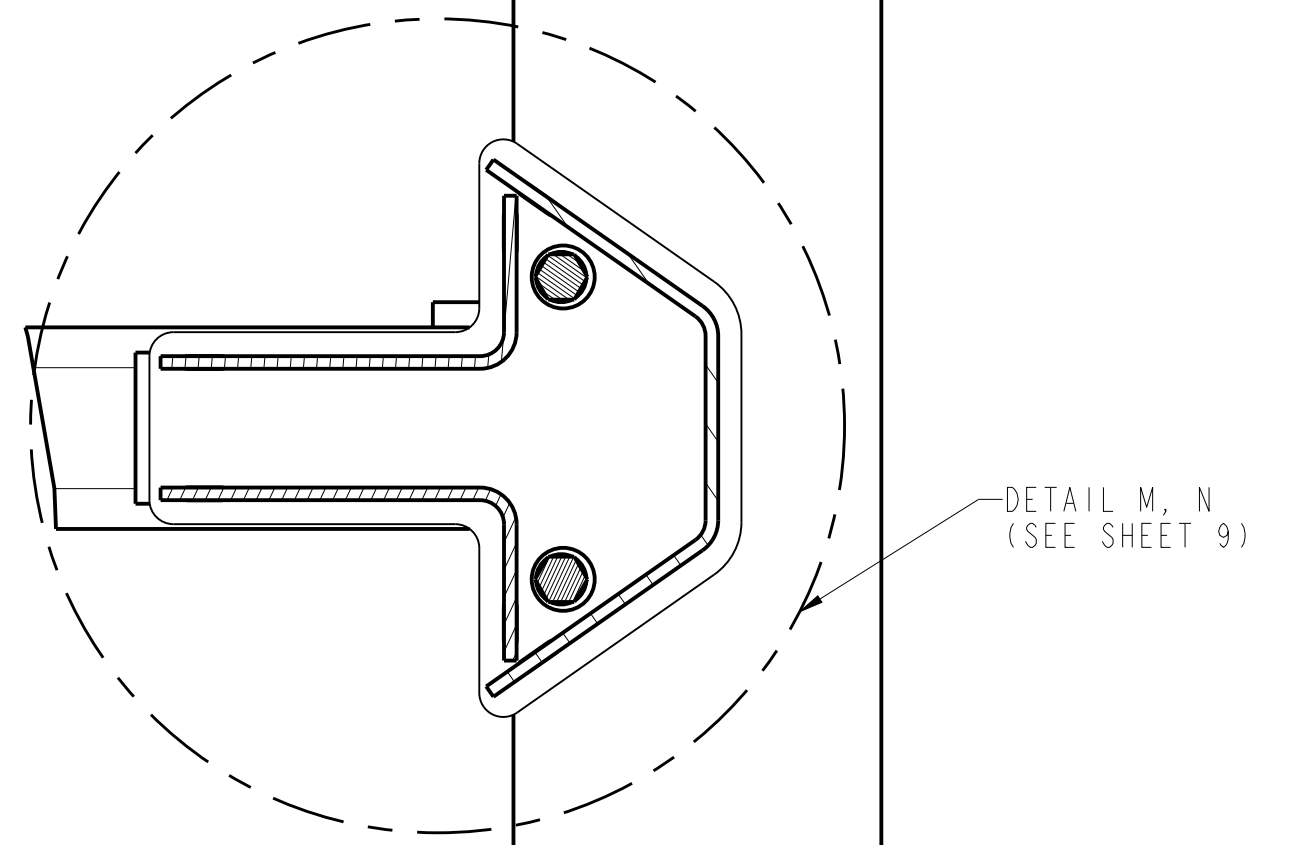
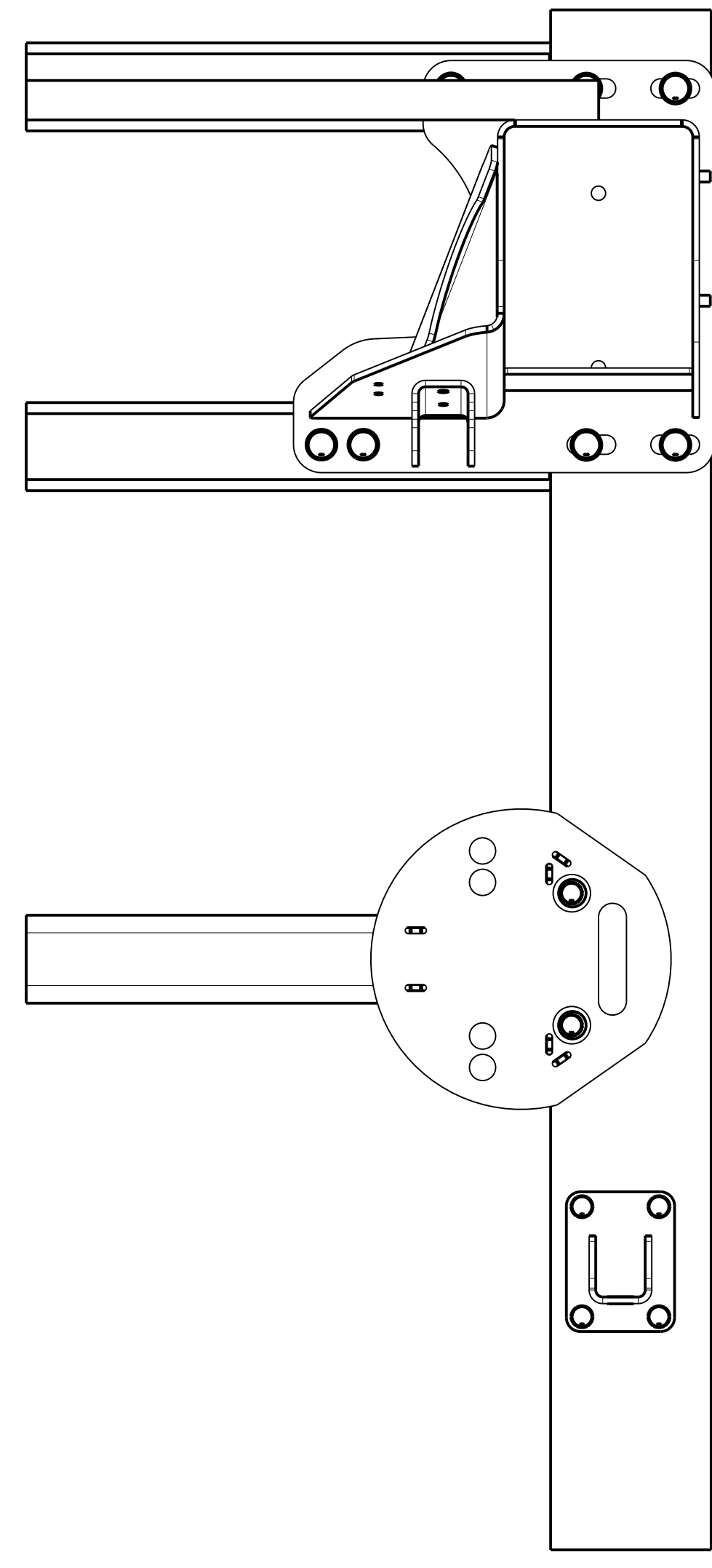
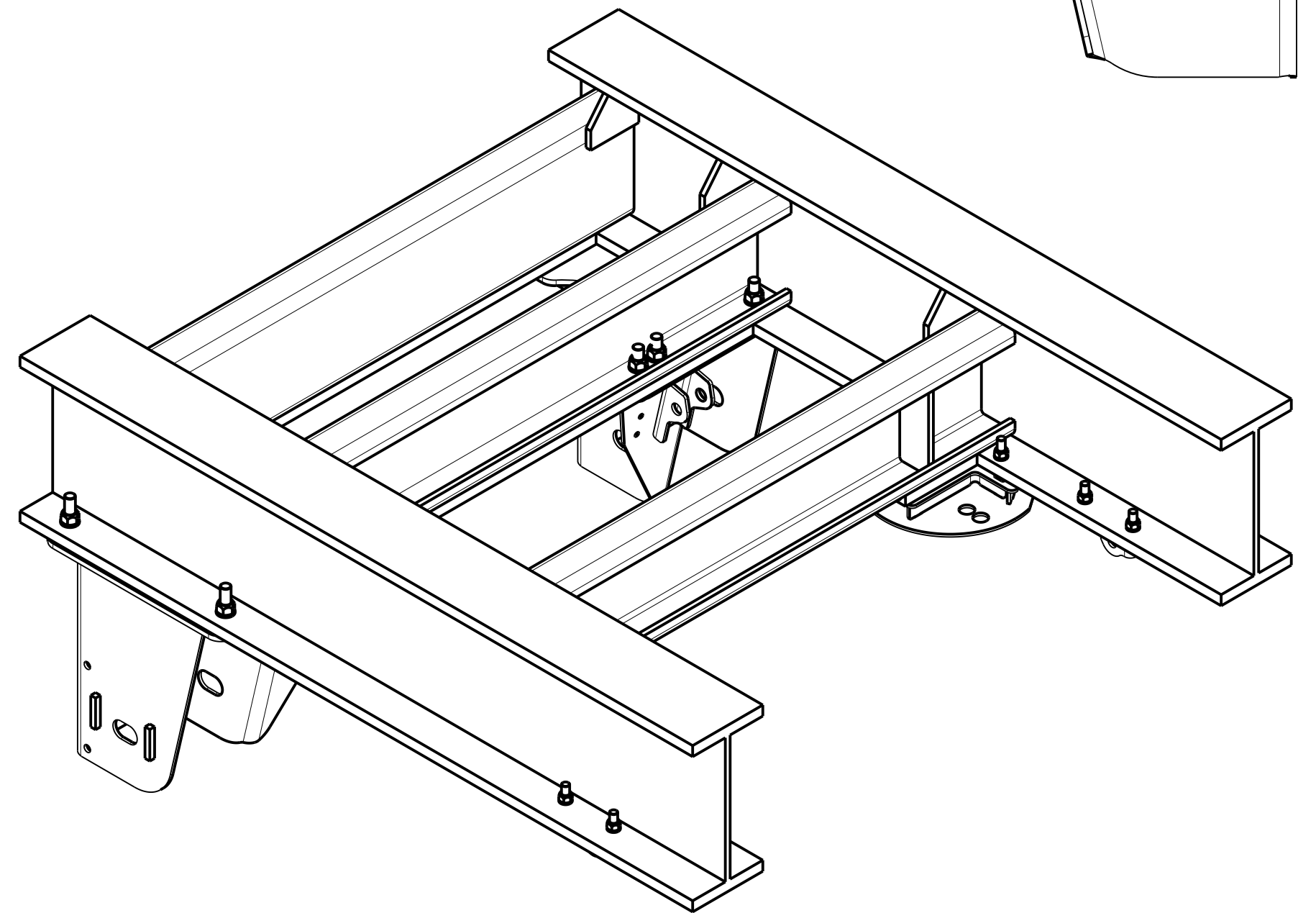
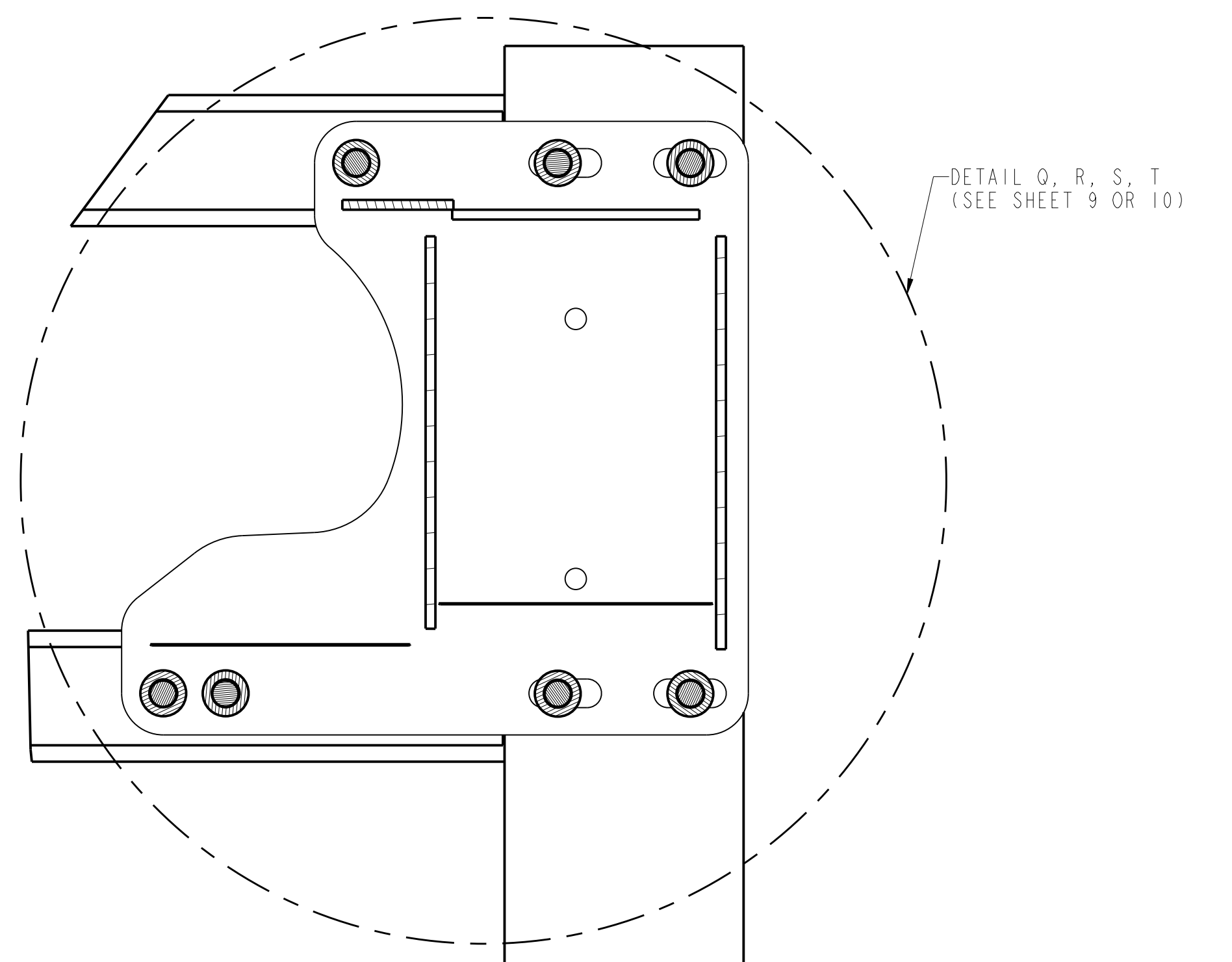
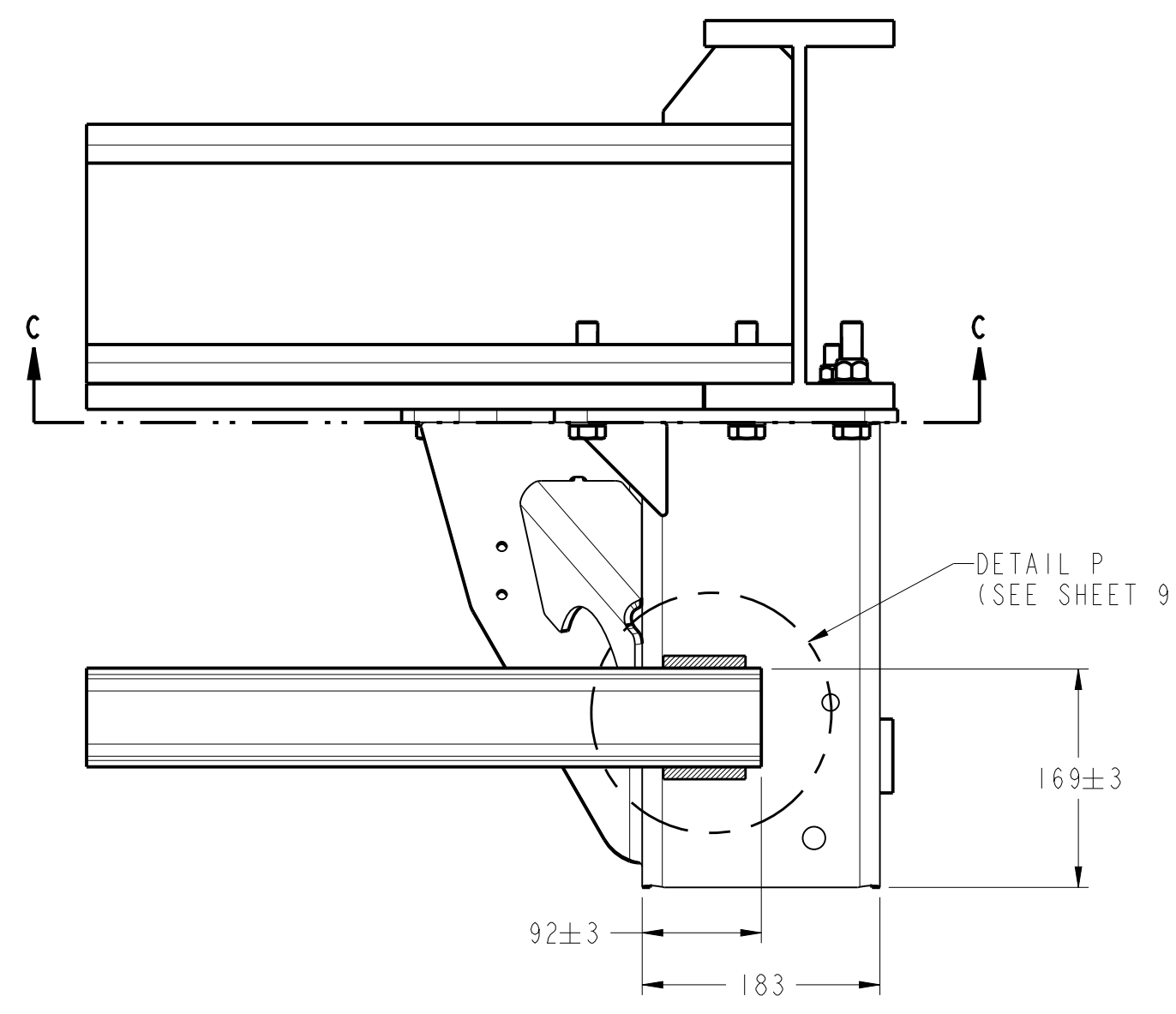
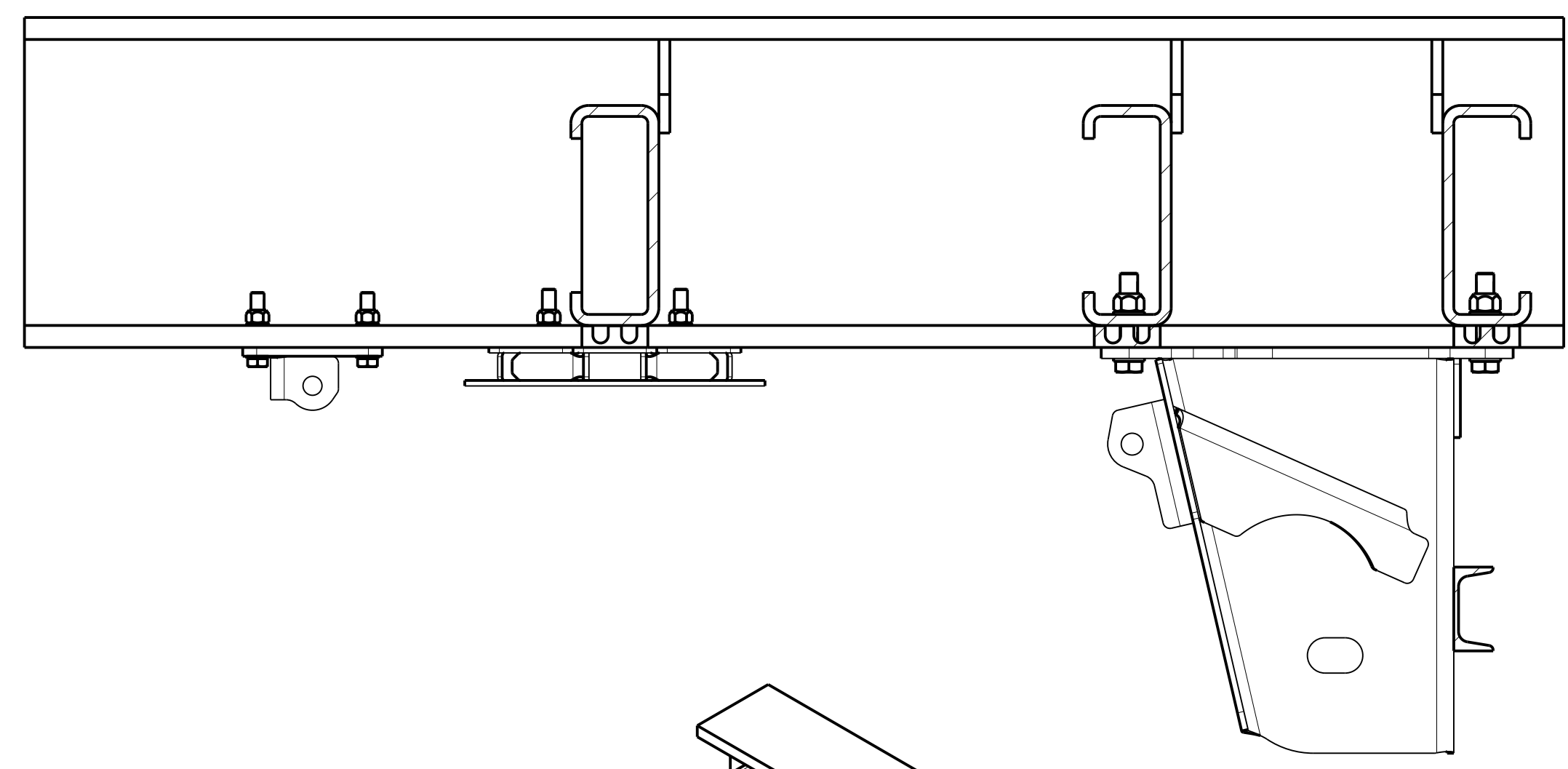
DETAIL L
 SHOWN IN ISO VIEW

- NOTES:
1. WELDS TO STOP 12mm MINIMUM FROM ALL COMPONENT EDGES.
 2. WELD PARAMETERS PER L64.
 3. REMOVE PAINT ALONG THE TOP EDGE OF FRAME BRACKET, ON BACK SIDE OF HANGER WING, AND FRONT SIDE OF FRAME BRACKET FOR GUSSET WELDING.
 4. MAX 3mm GAP AROUND FRAME BRACKET TO FRAME RAIL INTERFACE BEFORE WELDING.

This print remains the property of
 Hendrickson. All information contained
 thereon is confidential. It is loaned,
 subject to return on demand, and on the
 express condition that it is not to be
 copied or used directly or indirectly
 for any purpose other than the pur-
 pose for which it has been loaned to
 you.

	UNLESS OTHERWISE NOTED TOLERANCES ARE: X: ± .15 Y: ± .30 XX: ± .50 XXX: ± .13 ANGULAR: ± 0.5°		DIMENSIONS ARE: MM (INCHES) 		DRAWN BY: S. SCABILLONI	DATE: 05-Aug-15	SCALE: 1:2	PAGE: 7 OF 10	
	TRAILER COMMERCIAL VEHICLE SYSTEMS 2076 INDUSTRIAL PLACE S.E. CANTON, OH 44707-2666 U.S.A.				CHECKED BY: -	THIS DRAWING IS THE CONFIDENTIAL PROPERTY OF HENDRICKSON	HSDS INSTALLATION		SIZE: D
DIMENSIONS ADHERE TO ANSI Y14.5M-1987		REV: 1	ECN NO: 24542	SS	08-11-15	APPROVED BY: -			

NOTE: ORIGINAL DRAWING CREATED IN CREO. ALL REVISIONS TO THIS DRAWING MUST BE PERFORMED ON THE CREO DRAWING AND THEN CONVERTED TO THE APPLICABLE FORMAT.



SECTION C-C
SCALE 1:3

- NOTES:
1. WELDS TO STOP 12mm MINIMUM FROM ALL COMPONENT EDGES.
 2. WELD PARAMETERS PER L64.
 3. NO TACK WELDS AT START OR STOPS OF WELDS.

This print remains the property of Hendrickson. All information contained hereon is confidential. It is loaned, subject to return on demand, and on the express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.



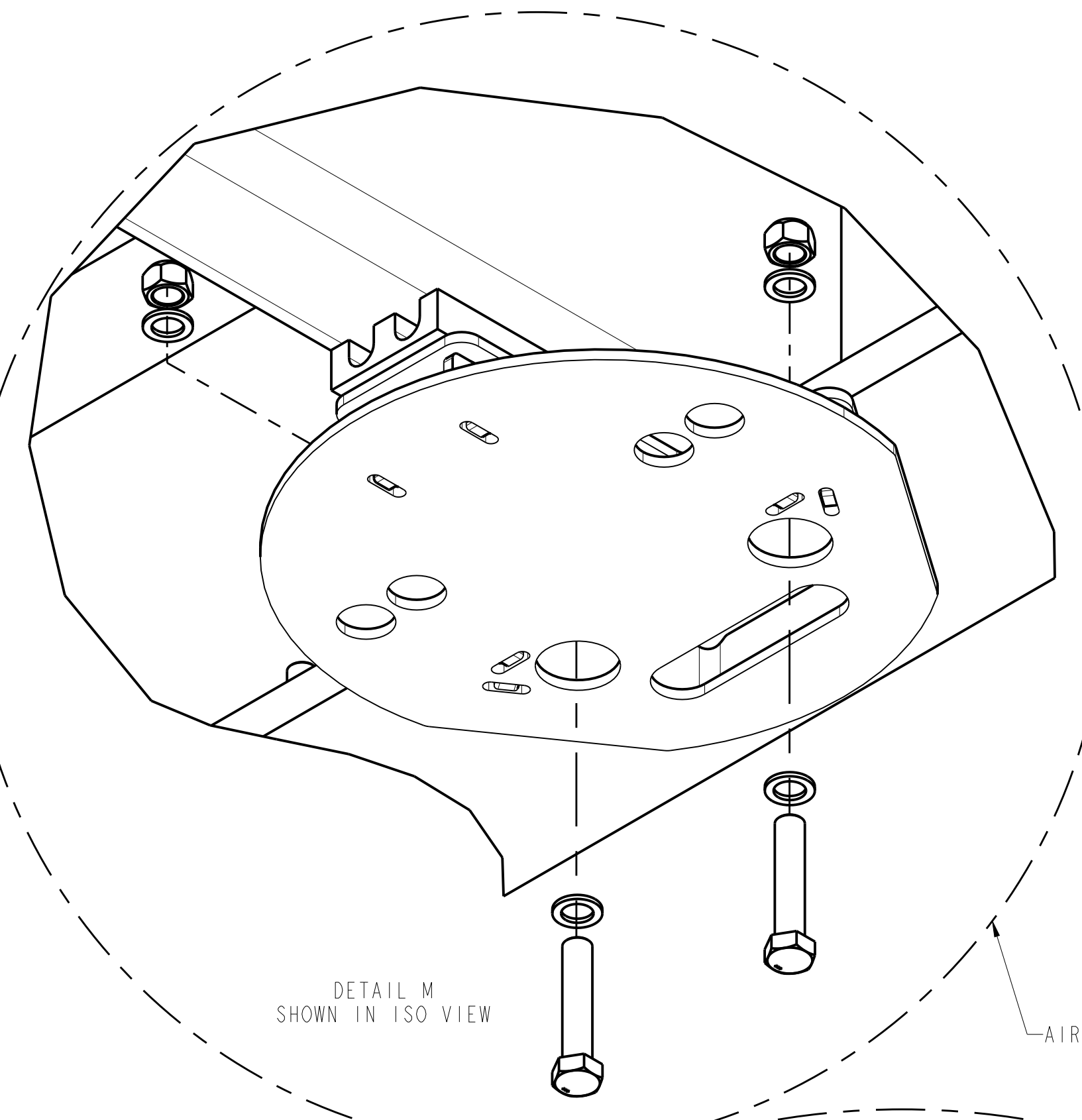
UNLESS OTHERWISE NOTED	
TOLERANCES ARE:	DIMENSIONS ARE:
X: ± .15	MM (INCHES)
Y: ± .30	
Z: ± .50	
ANGULAR: ± 0.5°	
DIMENSIONS ADHERE TO ANSI Y14.5M-1987	

DRAWN BY: S. SCABILLONI	DATE: 05-Aug-15
CHECKED BY:	
APPROVED BY:	

HSDS INSTALLATION

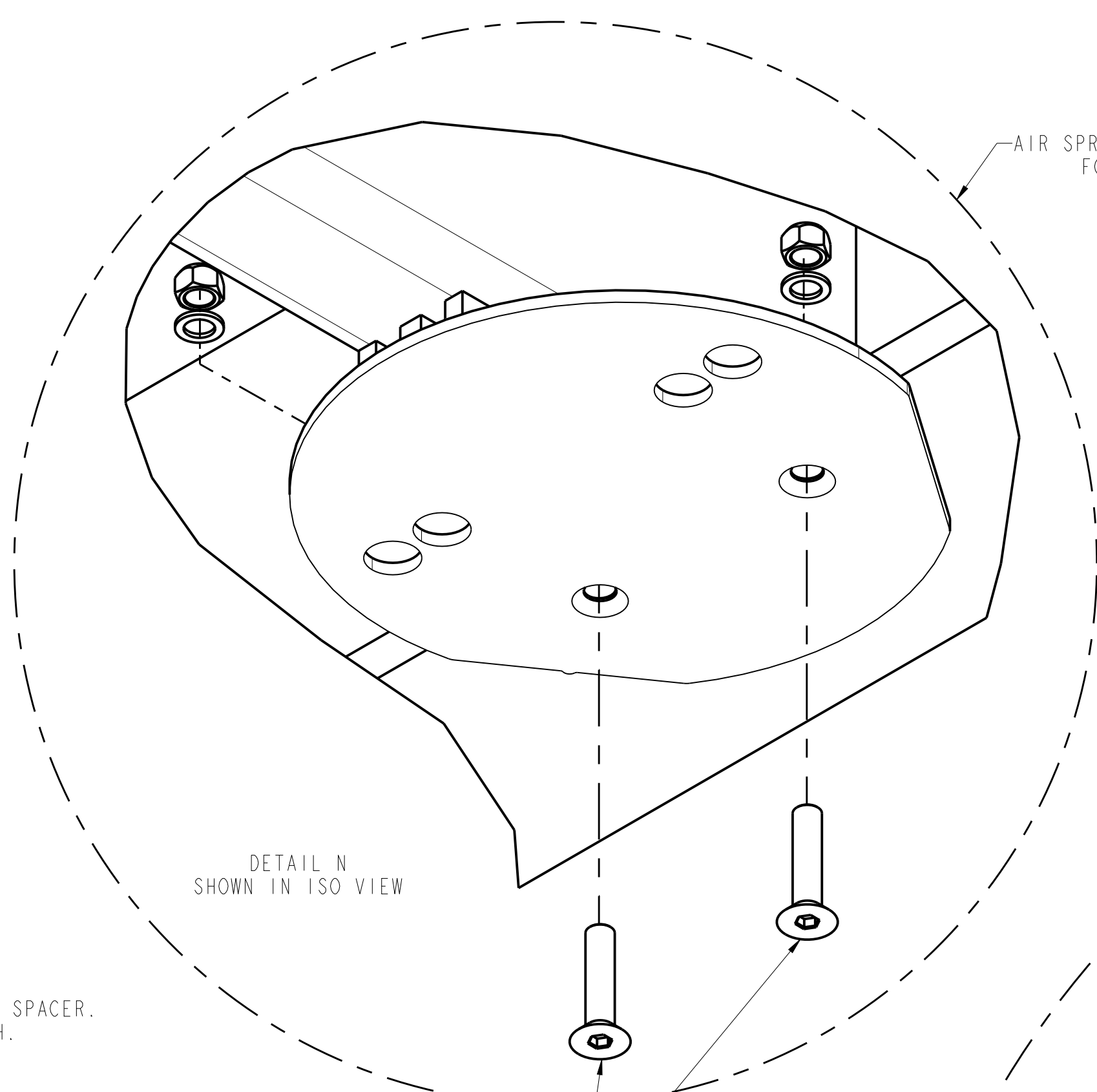
SCALE: 1:5	PAGE: 8 OF 10
SIZE: D	DRAWING NUMBER: D-32106

NOTE: ORIGINAL DRAWING CREATED IN CREO. ALL REVISIONS TO THIS DRAWING MUST BE PERFORMED ON THE CREO DRAWING AND THEN CONVERTED TO THE APPLICABLE FORMAT.



DETAIL M SHOWN IN ISO VIEW

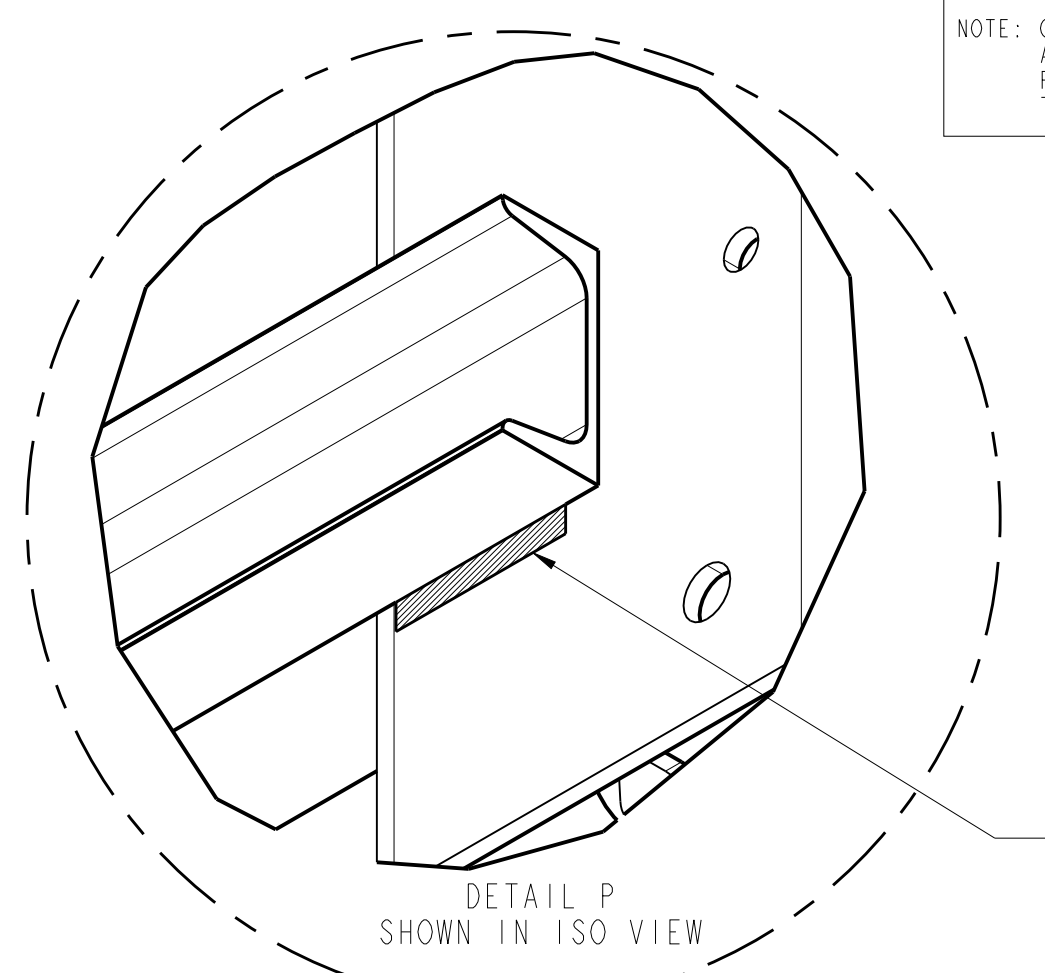
AIR SPRING PLATE AND SPACER. FOR 430-570 RH.



DETAIL N SHOWN IN ISO VIEW

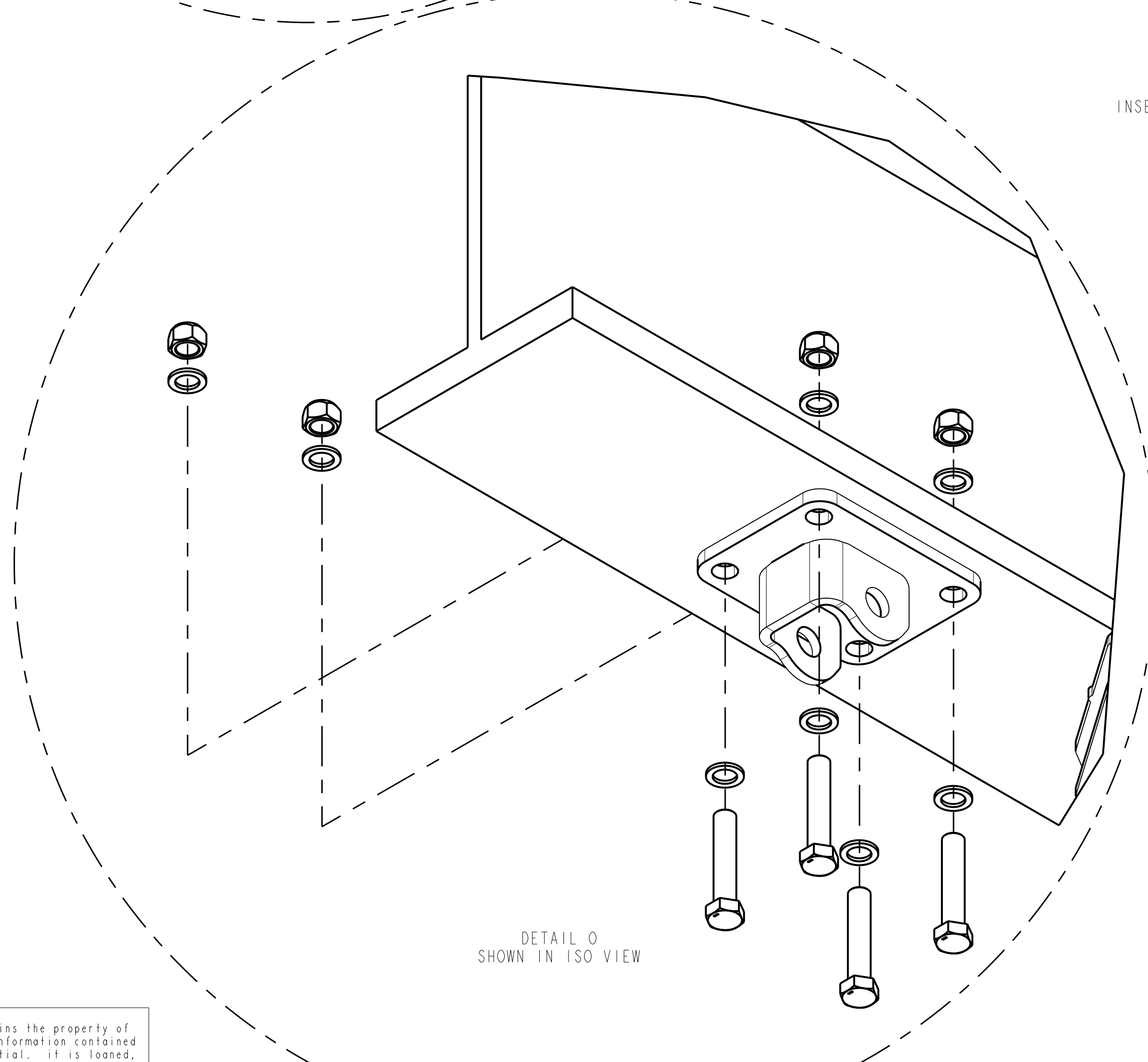
AIR SPRING PLATE ONLY. FOR 400 RH.

BOLTS MUST BE INSERTED FROM BELOW.

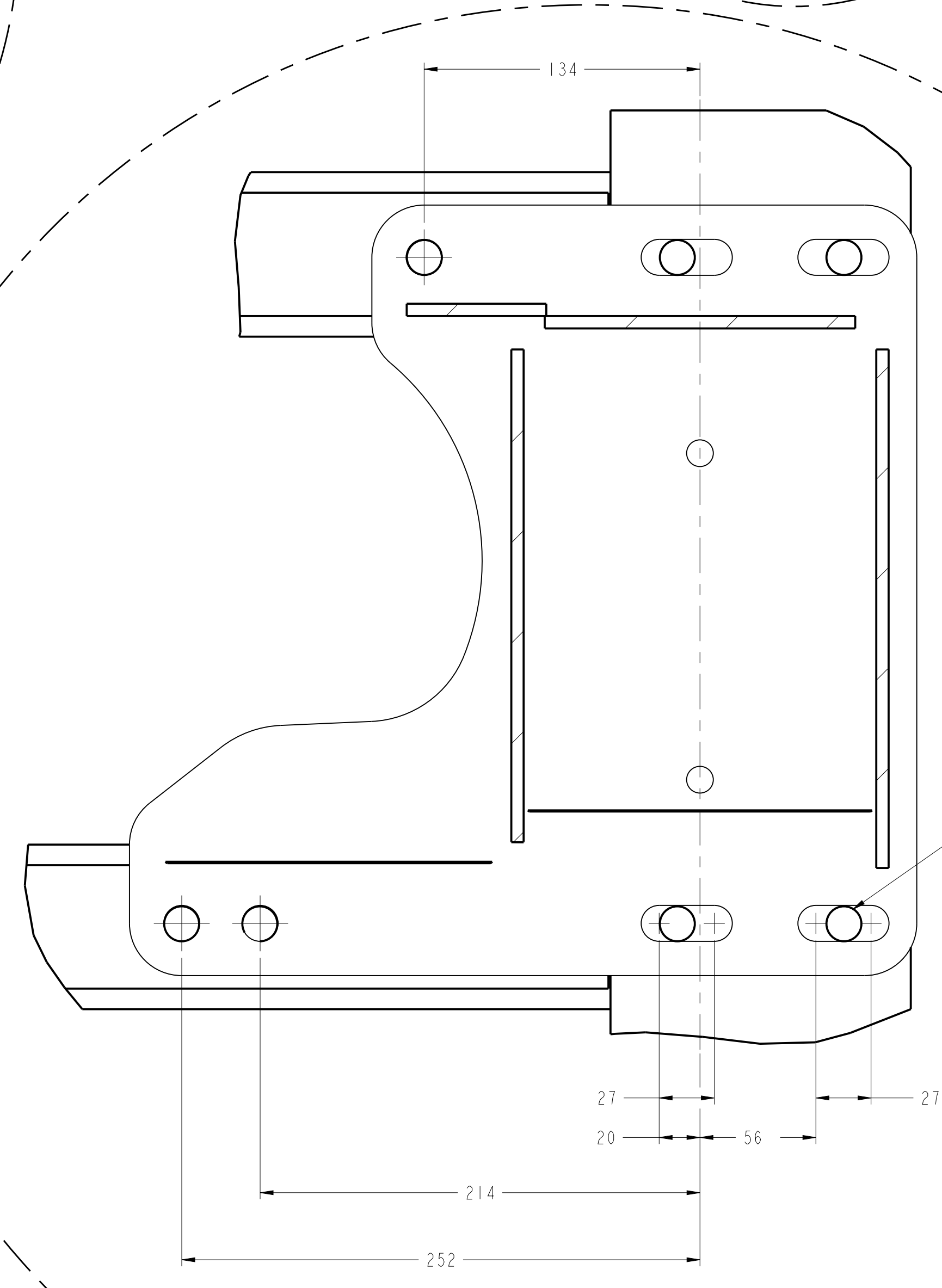


DETAIL P SHOWN IN ISO VIEW

6° BOTH SIDES



DETAIL O SHOWN IN ISO VIEW



DETAIL Q SECTION C-C BOLTS, NUTS, AND WASHERS OMITTED FOR CLARITY

FRAME HOLES PERMITTED ANYWHERE INSIDE SLOTS

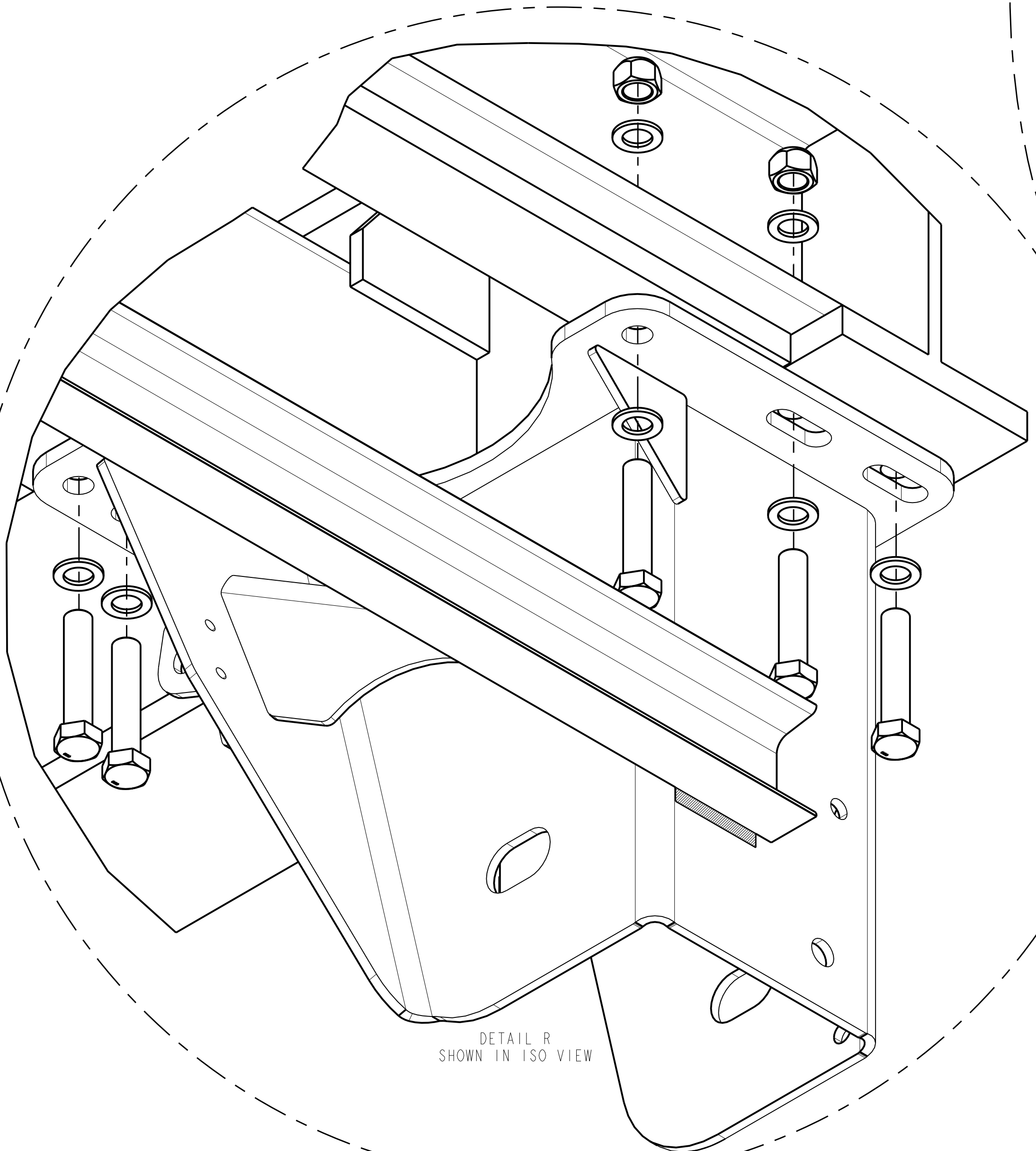
- NOTES:
1. WELDS TO STOP 12mm MINIMUM FROM ALL COMPONENT EDGES.
 2. WELD PARAMETERS PER L64.
 3. NO TACK WELDS AT START OR STOPS OF WELDS.
 4. BOLTS MAY BE INSERTED FROM EITHER TOP OR BOTTOM UNLESS OTHERWISE NOTED.

This print remains the property of Hendrickson. All information contained hereon is confidential. It is loaned, subject to return on demand, and on the express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.

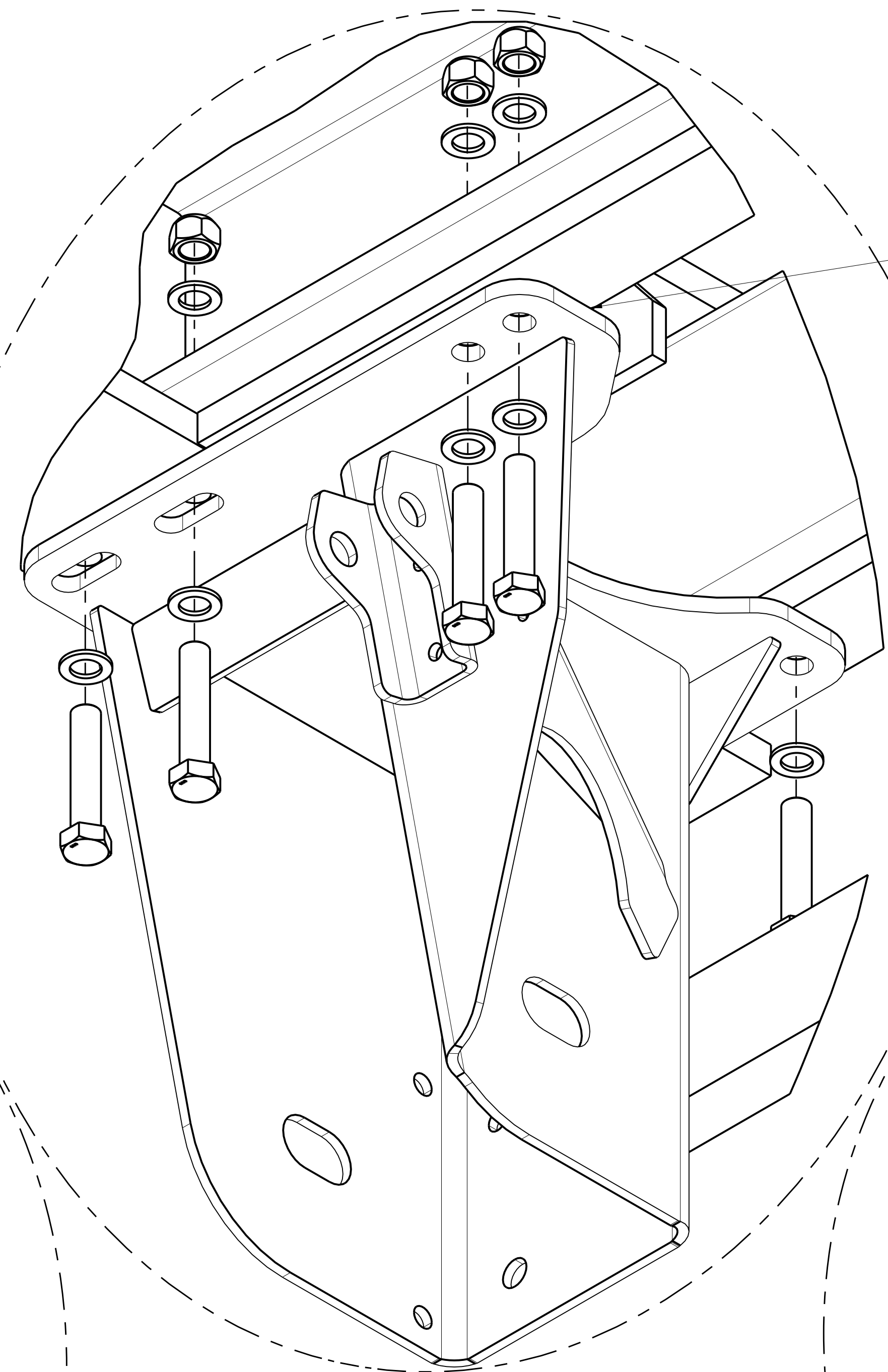
NOTE: ORIGINAL DRAWING CREATED IN CREO. ALL REVISIONS TO THIS DRAWING MUST BE PERFORMED ON THE CREO DRAWING AND THEN CONVERTED TO THE APPLICABLE FORMAT.

This print remains the property of Hendrickson. All information contained therein is confidential. It is loaned, subject to return on demand, and on the express condition that it is not to be copied or used directly or indirectly for any purpose other than the purpose for which it has been loaned to you.

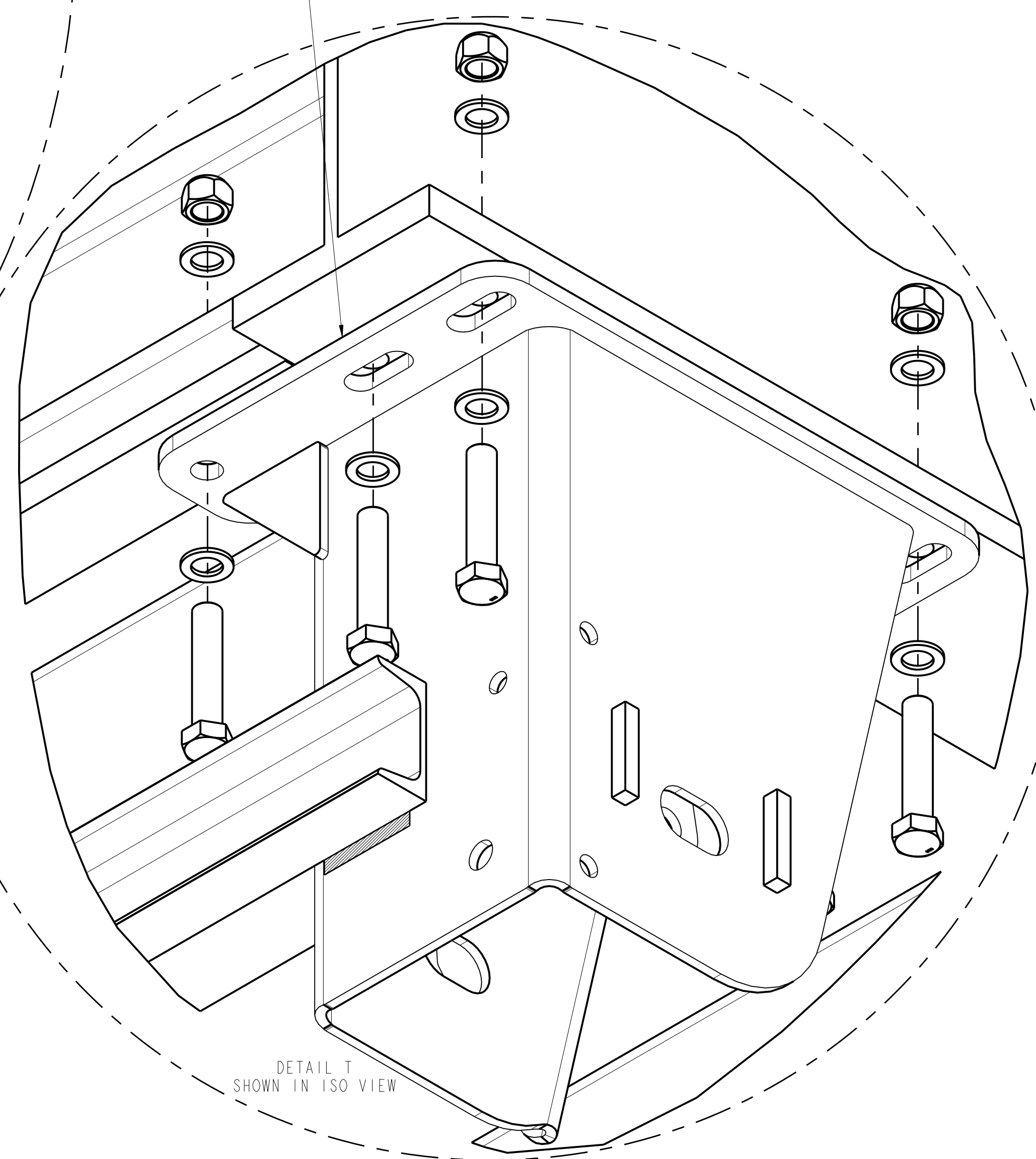
NOTE:
 GALVANIC CORROSION BARRIER NEEDED BETWEEN ALUMINUM RAIL AND STEEL FRAME BRACKET.
 ADD ONE OF THE FOLLOWING:
 1. PVC TAPE (OR PVC BACKED ELECTRICAL TAPE)
 a. .2-1 mm THICK (7-30 mils/ 200-1000 mic)
 b. 50-100 mm WIDE
 2. MYLAR SHEET
 a. .2-1 mm THICK (7-30 mils/ 200-1000 mic)



DETAIL R
 SHOWN IN ISO VIEW



DETAIL S
 SHOWN IN ISO VIEW



DETAIL T
 SHOWN IN ISO VIEW

- NOTES:
 1. WELDS TO STOP 12mm MINIMUM FROM ALL COMPONENT EDGES.
 2. WELD PARAMETERS PER L64.
 3. NO TACK WELDS AT START OR STOPS OF WELDS.
 4. BOLTS MAY BE INSERTED FROM EITHER TOP OR BOTTOM UNLESS OTHERWISE NOTED.