



## AL II U-BOLT ASSEMBLY INSTRUCTIONS

Parts are to be assembled in line with the following instructions.

Grease spring U-bolt thread and the contact surfaces of the lock nuts.

Spring seats and trailing arm are to be aligned parallel to the axle beam and self locking nuts are to be equally tightened diagonally until contact with the spring plate.

Control parallel position of spring seats and trailing arms towards the axle beam and tighten the self locking nuts diagonally 1,2,3 and 4 until all have achieved a tightening torque of 200Nm, then 300Nm, then 450Nm and then all to 550Nm. Finally, further tighten all the nuts in sequence by a further 90° angle.

### NOTE

**Replace** 'U' bolts **in pairs** and **do not** re-use 'U' bolts that have been fitted. **Always** fit new nuts and washers.

Wear to the clamping parts or axle beam due to loss of clamping force **must** be fully investigated and any worn items **replaced**.