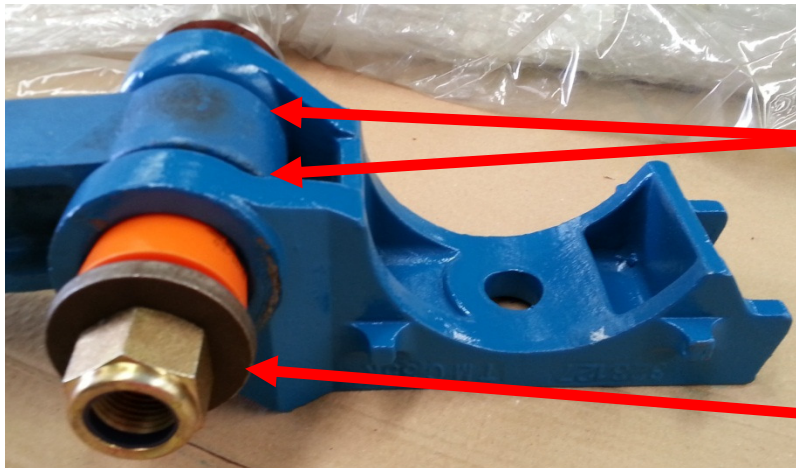


Date: 03.04.2013 (Rev B)

Subject: Torque Arm Bush Assembly

This Bulletin covers the assembly of torque arms (fixed and adjustable) using rubber and poly bushes.

Assembly Steps as Follows:

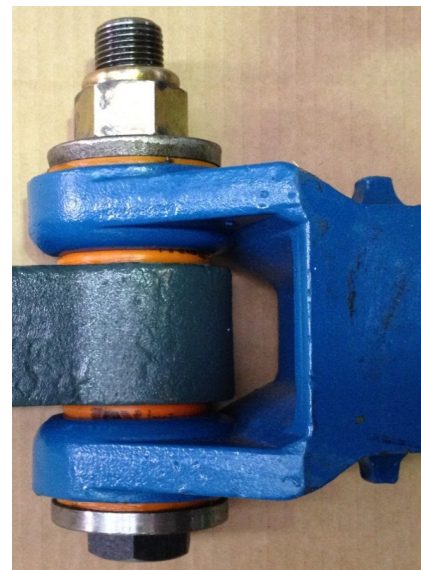
Assemble torque arm pins with bushes into the castings. Ensure that torque arm sits centrally on hanger/seats

Recommend to have nut facing outside of the trailer

1. Oil the pins and apply sufficient anti-seize compound to the thread.
2. Lubricate bushes using 50% liquid soap and 50% water. **DO NOT SOAK** bushes.
3. Insert pin with bush into the assembly (Recommend to have nut facing outside of the trailer). Fit another bush into the opposite side. Tap bushes into castings to ensure that they are seated properly.
4. Insert 3mm steel spacer as shown on bottom picture. Ensure spacer fits snug between hanger/seat and torque arm.



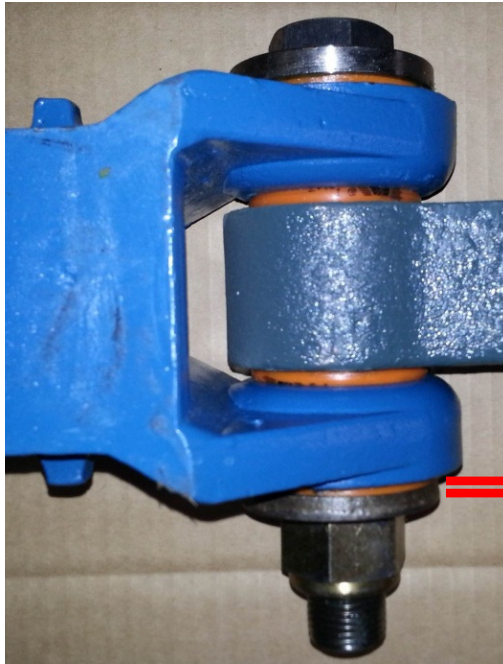
Steel spacers inserted into casting



5. Fit washer and nyloc nut and tighten accordingly using a pneumatic gun.

Date: 03.04.2013 (Rev B)

6. Check allowable protrusion below. Rework if necessary. Remove steel spacer.

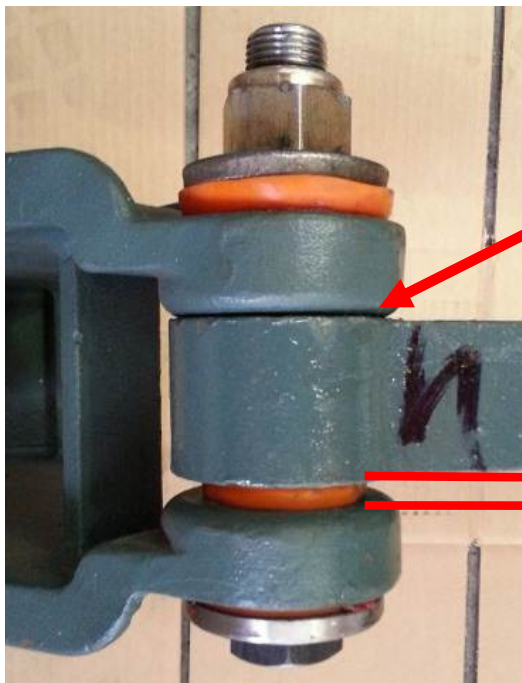


Allowable protrusion (Poly)
Min: 2mm
Max: 4mm

Allowable protrusion (Rubber)
Min: 5mm
Max: 7mm



7. See picture below showing examples of excessive buldge/protrusion on poly bush and torque arm not located centrally on assembly.



Fixed torque arm not located centrally on assembly.
- Unacceptable.

Excessive poly protrusion shown. (>7mm) – Unacceptable.



8. Torque settings:

- a. Torque Arm Pin Nut 1" or M24 (Rubber)
- b. Torque Arm Pin Nut 1" or M24 (Poly)

150/200Nm.
200/250Nm.