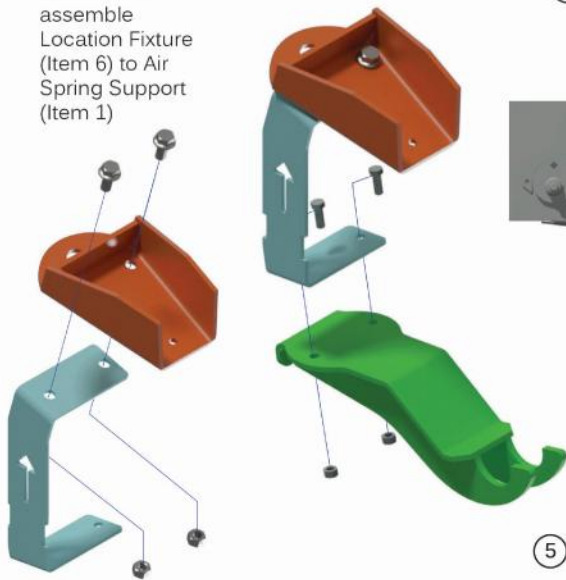


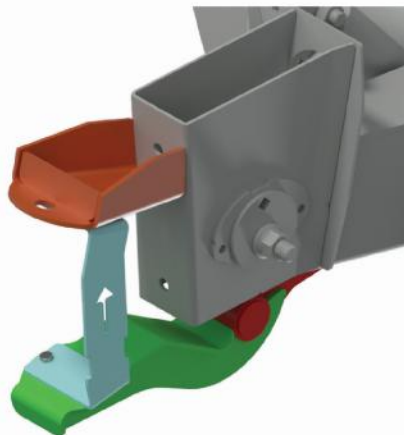
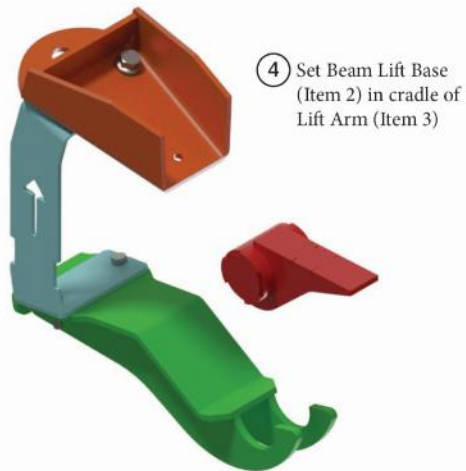
- ① Use enclosed fasteners to assemble Location Fixture (Item 6) to Air Spring Support (Item 1)
- ② Now assemble Lift Arm (Item 3) to Location Fixture (Item 6)



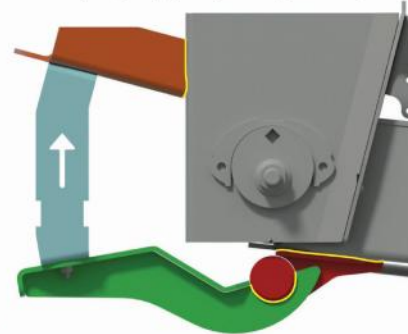
- ③ Dump air in suspension system and lift (jack if necessary) axle to maximum lift position.



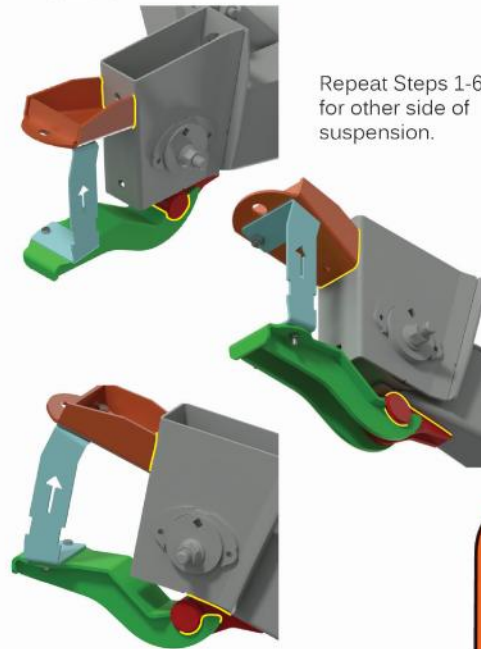
- ④ Set Beam Lift Base (Item 2) in cradle of Lift Arm (Item 3)
- ⑤ Properly position Location Fixture with assembled Air Spring Support (Item 1) and Lift Arm (Item 3) on suspension hanger. Prepare to tack weld in place.



- ⑥ Rotate Beam Lift Base (Item 2) to proper position on air suspension beam and tack weld to lift arm (Item 3). Then, tack weld Beam Lift Base (Item 2) to suspension arm. Last, tack weld air spring support (Item 1) to hanger.














- ⑦ Weld Air Spring Support (Item 1), Lift Arm (Item 3), and Beam Lift Base (Item 2) all around.

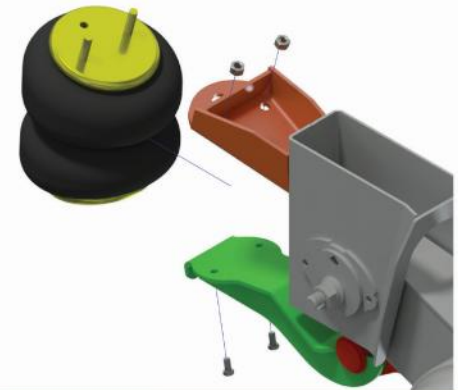


Repeat Steps 1-6 for other side of suspension.

### Item List

Hanger Weldment.....	Item 1	
Weld-on Beam Bracket.....	Item 2	
Weld-on Air Spring Bracket.....	Item 3	
Air Spring.....	Item 4	
Bagged Bolt Kit for Air Spring		
HHCS, Flangelock 0.38 UNC x 1".....	Item #5a	
L'Nut 0.5-13UNC.....	Item #5b	
Quick Fit Location Bracket.....	Item 6	
Bagged Bolt Kit for Fixture Bracket		
HHCS, Flangelock 1/2-13 x 1"lg.....	Item #7a	
HHCS 3/8-16 x 1" lg.....	Item #7b	
Hex Nut 3/8-16, Plain.....	Item #7c	
Hex Nut 1/2-13, Plain.....	Item #7d	

- ⑧ After welds have cooled, remove Location Fixtures (Item 6) and install Air Springs (Item 4).



Part/Drawing No:  
**CAL-50U\_M**

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