

The following instructions describe methods that can be used to attach your Torflex® axles to the vehicle frame.

Step 1: The user must first decide where to place the axle(s) on the trailer. The position of the wheel center relative to the CG (center of gravity) will determine the final axle loading as well as the hitch load.

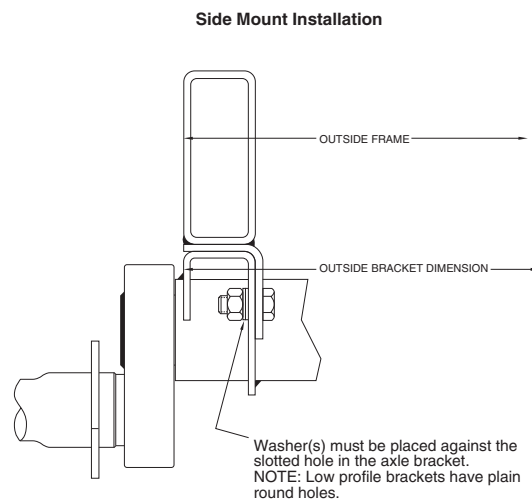
Step 2: Determine the method of attachment you wish to use. a. For structural tube type frame rails, refer to Figure 1 for the recommended attachment. b. For “C” channel or “I” beam type frame, refer to Figure 2.

Step 3: Once the method of attachment is decided, the axle(s) must be carefully aligned on the trailer frame. The axle(s) centerline must be perpendicular to the longitudinal centerline of the trailer. See figure 3.

CAUTION: Misalignment of the axle(s) can cause poor tracking and accelerated tire wear.

Attachment to Structural Tube Type Frame

- Dexter recommends the use of side mounting hangers when mounting axles to tubular type frames. These hangers provide a convenient means for bolting the axles in place. All of the necessary components are included in the Side Mount A/P Kits listed in Chart 1.
- Refer to Chart 2 to find the mounting bracket dimensions of your axles. This chart shows the dimensions from the wheel center to the bolt holes of the brackets.
- The preferred way to use the side mount hanger is to pre-assemble the hangers to the axle using the hardware provided in the A/P kit. Make sure the hangers are clamped firmly against the axle brackets and the bolts are tightened to the torque specifications shown in Chart 1. Position the axle assembly on the frame rails in the desired location and weld the side mount hangers to the frame.
- Axle bracket position is the distance as measured over the outboard edges of the brackets. This dimension is usually matched to the outside measurement of the frame members but depending on the type of frame may not always be suitable. The preferred arrangement should place the longest vertical section of the axle bracket directly under the most rigid section of the frame member.



Side mount hangers should be welded to frame with three (3) ¼" fillet welds, 2½" long on each side of the hanger and a fillet weld on each end. Welds should meet the quality standards of the American Welding Society, D1.1, Structural Welding Code.

Chart 1

Attaching Parts Kits and Torque Specifications					
Axle Size	A/P Kit Top Mount	A/P Kit Side Mount	A/P Kit Side Mount Aluminum	Bolt Size	Torque Lb-Ft.
lbs. 8	A/P-161-00	A/P-165-00	A/P-180-00	1/2"	70-90
lbs. 9	A/P-161-00	A/P-165-00	A/P-180-00	1/2"	70-90
lbs. 10	A/P-148-00	A/P-166-00	A/P-181-00	5/8"	120-155
lbs. 10L	A/P-148-00	A/P-166-00	A/P-181-00	5/8"	120-155
lbs. 10F	A/P-148-00	A/P-166-00	A/P-181-00	5/8"	120-155
lbs. 11	A/P-148-00	A/P-167-00	A/P-182-00	5/8"	120-155
lbs. 12	A/P-148-00	A/P-168-00	A/P-183-00	5/8"	120-155
lbs. 12T	A/P-148-00	A/P-169-00	N/A	5/8"	120-155
lbs. 12V	A/P-148-00	A/P-168-00	N/A	5/8"	120-155
lbs. 13	A/P-148-00	A/P-169-00	N/A	5/8"	120-155
lbs. 13T	A/P-148-00	A/P-169-00	N/A	5/8"	120-155

Side mount hangers and fasteners for mounting axle are provided in the A/P Attaching Parts Kits shown in Chart 1. Torque fasteners to levels specified in Chart 1.

Attachment to Structural Tube Type Frame

- Refer to Chart 2 to find the mounting bracket dimensions of your axles. This chart shows the dimensions from the wheel center to the bolt holes of the brackets.
- Lay out the bolt hole locations on the bottom flanges of the frame rails. Make sure the hole pattern matches the mounting brackets of your axles and is properly oriented to allow proper alignment of the axle(s).
- An alternate method for determining hole location is to position the axle assembly on the frame rails, align it perpendicular to the trailer centerline, clamp in place and transfer the holes directly from the brackets.
- Drill the holes through the frame rails and attach the axle using the hardware provided in the A/P kit. Tighten the bolts to the torque specified in Chart 1.

CAUTION: When bolting to structural shapes that have tapered flanges, bevel washers must be used to prevent uneven clamping and bending of the fasteners.

Note: In the unlikely event a Torflex® axle must be replaced during the warranty period, Dexter cannot assume responsibility for additional costs incurred for removal and reinstallation of axles that have been welded directly to the frame.

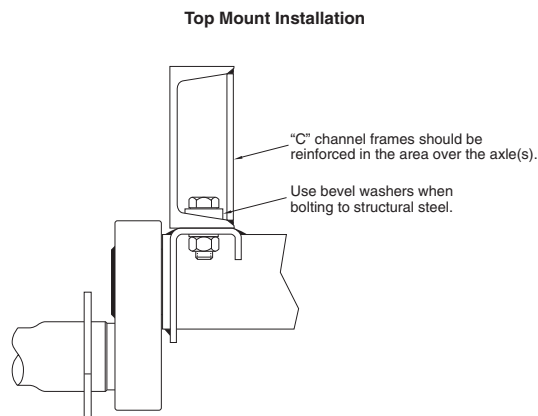
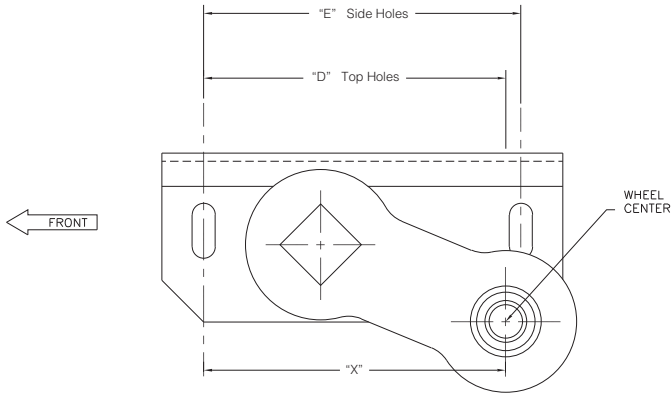


Figure 2

CAUTION: “C” channel and “I” beam type frame sections should be reinforced in the area over the axle mounting brackets. It is recommended that the vertical leg of the axle bracket be positioned directly under the vertical segment or reinforcement of the frame member.

Chart 2
Bracket Dimensions



Fender Clearance: allow 3" over the tire at full load.

Start Angle of Trailing Arm Mounting Hole to Wheel Center - Dimension "X" (Inches)

Torflex® Axle Model	45° Down		32° Down		22.5° Down		10° Down		0°		10° Up		22.5° Up		Mounting Hole Spacing (Inches)	
	No Load	Full Load	No Load	Full Load	No Load	Full Load	No Load	Full Load	No Load	Full Load	No Load	Full Load	No Load	Full Load	Dim "D" (Top)	Dim "E" (Side)
lbs. 8 (4" arm)	5.21	6.08	5.77	6.33	6.08	6.38	6.32	6.29	6.38	6.08	6.32	5.75	6.08	5.21	7.75	8.00
lbs. 9 (6" arm)	6.62	7.92	7.47	8.30	7.92	8.38	8.29	8.24	8.38	7.92	8.29	7.44	7.92	6.62	7.75	8.00
lbs. 10 (6" arm)	6.74	8.04	7.59	8.42	8.04	8.50	8.41	8.36	8.50	8.04	8.41	7.56	8.04	6.74	8.00	8.00
lbs. 10L (6" arm)	6.74	8.04	7.59	8.42	8.04	8.50	8.41	8.36	8.50	8.04	8.41	7.56	8.04	6.74	8.00	8.00
lbs. 10F (6" arm)	6.74	8.04	7.59	8.42	8.04	8.50	8.41	8.36	8.50	8.04	8.41	7.56	8.04	6.74	8.00	8.00
lbs. 11 (6" arm)	7.74	9.04	8.59	9.42	9.04	9.50	9.41	9.36	9.50	9.04	9.41	8.56	9.04	7.74	9.00	9.50
lbs. 12 (6" arm)	7.74	9.04	8.59	9.42	9.04	9.50	9.41	9.36	9.50	9.04	9.41	8.56	9.04	7.74	9.00	9.50
lbs. 12T (6" arm)	7.87	9.17	8.72	9.55	9.17	9.63	9.54	9.49	9.63	9.17	9.54	8.69	9.17	7.87	10.56	10.56
lbs. 12V (6" arm)	7.74	9.04	8.59	9.42	9.04	9.50	9.41	9.36	9.50	9.04	9.41	8.56	9.04	7.74	9.00	9.50
lbs. 13 (6" arm)	7.87	9.17	8.72	9.55	9.17	9.63	9.54	9.49	9.63	9.17	9.54	8.69	9.17	7.87	10.56	10.56
lbs. 13T (6" arm)	7.87	9.17	8.72	9.55	9.17	9.63	9.54	9.49	9.63	9.17	9.54	8.69	9.17	7.87	10.56	10.56

Axle Alignment Dimensions

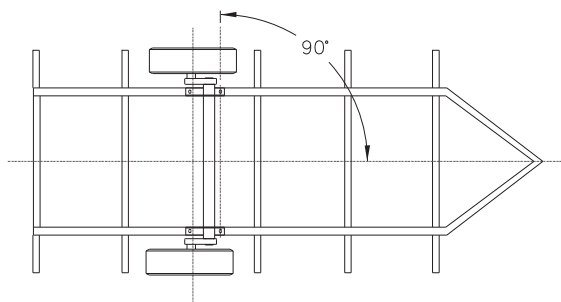


Figure 3

To ensure proper tracking, the axle must be placed on the frame perpendicular to the centerline of the vehicle. The accuracy must be within plus or minus one half degree. For multiple axle applications, each axle must be parallel with the others within one sixteenth of an inch when measured at the wheel centers.

CAUTION: When laying out the position for the axle(s), measuring from the front cross member should only be done if the cross member has been checked for squareness to the frame centerline. Any error in the cross member will be transferred to the axle and can result in poor tracking and excessive tire wear.



Dexter Axle Limited Warranty

What Products Are Covered

All Dexter Axle Company (“Dexter”) trailer axles, suspensions, and brake control systems manufactured on or after September 1, 2016, excluding Dexter 6000 series Manufactured Housing Axles. Additional exclusions include the following brands: UFP by Dexter, AL-KO (IAC), Titan Brakes and Actuators by Dexter, and BrakeRite by Dexter products, which are covered under separate warranties.

Limited 1 Year Warranty

As specified in Dexter’s current publication “Operation Maintenance Service Manual”, grease and oil seals FOR ALL PRODUCTS have a one (1) year limited warranty to the original purchaser from the date of first sale of the trailer incorporating such components. **Except as to grease and oil seals, the following four other warranties are available.**

Limited 2 Year Warranty

Dexter warrants to the original purchaser that its electric/hydraulic brake actuators shall be free from defects in material and workmanship for a period of two (2) years from the date of first sale of the trailer incorporating such components.

Limited 5 Year Warranty

Dexter warrants to the original purchaser that its axles, suspension systems and Genuine Replacement Parts shall be free from defects in material and workmanship for a period of five (5) years. The warranty period shall begin from the date of the original purchase of the trailer and/or Genuine Replacement Parts.

Limited 7 Year Warranty

Dexter warrants to the original purchaser that its Predator Series® electric brake controllers shall be free from defects in material and workmanship for a period of seven (7) years from the date of purchase.

Limited 10 Year Warranty

Dexter warrants to the original purchaser that the suspension components of its Torflex® axles shall be free from defects in material and workmanship for a period of ten (10) years from the date of first sale of the trailer incorporating such suspension components.

Exclusive Remedy

Dexter will, at its option, repair or replace the affected components of any defective axle, repair or replace the entire defective axle, or refund the lesser of the original purchase price and the then-current list price of the axle or components. In all cases, a reasonable time period must be allowed for warranty repairs to be completed. Allowance will only be made for installation costs specifically approved by Dexter.

What You Must Do

In order to make a claim under these warranties:

1. You must be the original purchaser of the trailer in which the sprung suspension axles or Torflex® axles or components were originally installed.
2. You must promptly notify Dexter after detection of any defect, but in any case within the applicable warranty period of such defect, and provide us with the axle or applicable component serial number and any substantiation of such defect which may include, but is not limited to, the return of part(s) that we may reasonable request.
3. The axles, suspensions and components must have been installed and maintained in accordance with good industry practice and any specific Dexter recommendations, including those specified in Dexter’s current publication “Operation Maintenance Service Manual”.

Exclusions

These warranties do not extend to and do not cover defects caused by:

1. The connecting of brake wiring to the trailer wiring or trailer

wiring to the towing vehicle wiring.

2. The attachment of the running gear to the frame.
3. Parts not supplied by Dexter.
4. Any damage whatsoever caused by or related to any alteration of the axle including welding supplemental brackets to the axle.
5. Use of an axle on a unit other than the unit to which it was originally mounted.
6. Normal wear and tear.
7. Improper alignment.
8. Improper installation.
9. Unreasonable use (including failure to provide reasonable and necessary maintenance as specified in Dexter’s current publication “Operation Maintenance Service Manual including required maintenance after “Prolonged Storage”.)
10. Improper torque values and torquing of wheel nuts. (The proper torquing procedure and torque values are contained in Dexter’s current publication “Operation Maintenance Service Manual”).
11. Cosmetic finish or corrosion.

Limitations

1. **In all cases, Dexter reserves the right to fully satisfy its obligations under the Limited Warranties by refunding the lesser of the original purchase price and the then-current list price of the defective axle (or, if the axle has been discontinued, of the most nearly comparable current product).**
2. Dexter reserves the right to furnish a substitute of replacement component or product in the event an axle or any component of the axle is discontinued or is otherwise unavailable.
3. These warranties are nontransferable.

General

THE FOREGOING WARRANTIES ARE EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES EXCEPT THAT OF TITLE, WHETHER WRITTEN, ORAL OR IMPLIED, IN FACT OR IN LAW (INCLUDING ANY WARRANTY AGAINST INFRINGEMENT OR OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE).

These warranties give you specific legal rights, and you may also have other rights which vary from state to state.

DEXTER HEREBY EXCLUDES INCIDENTAL AND CONSEQUENTIAL DAMAGES, INCLUDING LOSS OF TIME, INCONVENIENCE, LOSS OF USE, TOWING FEES, TELEPHONE CALLS, COST OF MEALS OR LODGING, FOR ANY BREACH OF ANY EXPRESS OR IMPLIED WARRANTY.

Some states do not allow limitations on how long an implied warranty lasts, or the exclusion or limitation if incidental or consequential damages, so the above exclusion or limitation may not apply to you.

Inquiries regarding these warranties should be sent to:

Dexter Axle Company
P.O. Box 250
Elkhart, IN 46515

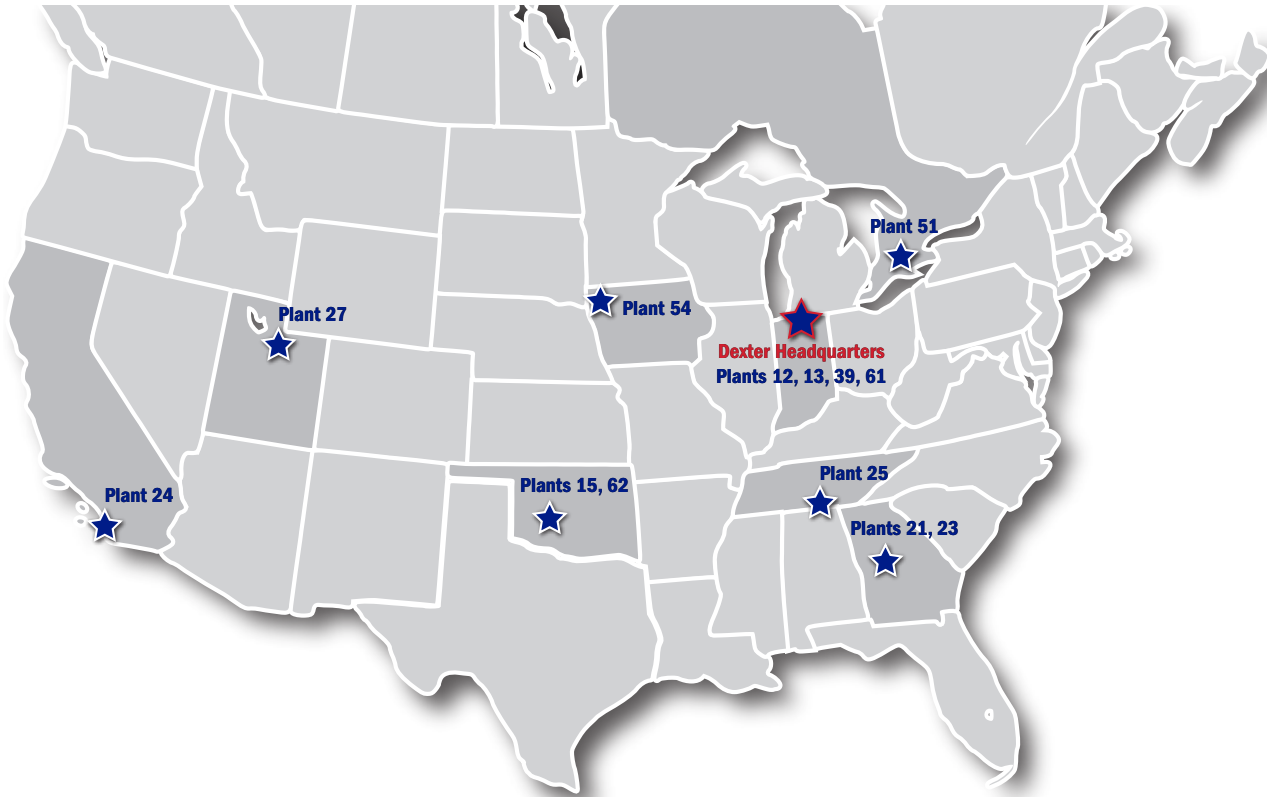
Note: Current publication “Operation Maintenance Service Manual” can be found at www.dexteraxle.com.

Locations



**ADDITIONAL
INFORMATION**

Genuine Dexter axles and components are available nationwide from our plant locations listed below or through our network of distributors. Check our website for the distributor nearest you.



Dexter - Headquarters

2900 Industrial Parkway East ■ Elkhart, Indiana 46516
 Phone: 574-295-7888 ■ Fax: 574-295-8666
www.dexteraxle.com

Dexter - Plant 12

301 West Pearl Street
 Fremont, Indiana 46737
 Phone: 260-495-5100
 Fax: 260-495-1701

Dexter - Plant 13

500 South 7th Street
 Albion, Indiana 46701
 Phone: 260-636-2195
 Fax: 260-636-3030

Dexter - Plant 15

500 Southeast 27th Street
 El Reno, Oklahoma 73036
 Phone: 405-262-6700
 Fax: 405-262-9089

Dexter - Plant 21

199 Perimeter Road
 Monticello, Georgia 31064
 Phone: 706-468-6495
 Fax: 706-468-2966

Dexter - Plant 23

5600 Bucknell Drive SW
 Atlanta, Georgia 30336
 Phone: 404-477-6899
 Fax: 470-443-1715

Dexter - Plant 24

135 Sunshine Lane
 San Marcos, California 92069
 Phone: 760-744-1610
 Fax: 760-744-1616

Dexter - Plant 25

1041 Baxter Lane
 Winchester, Tennessee 37398
 Phone: 931-967-5101
 Fax: 877-457-9861

Dexter - Plant 27

1845 South 300 West
 Salt Lake City, UT 84115
 Phone: 801-486-4916
 Fax: 801-486-1711

Dexter - Plant 39

902 South Division Street
 Bristol, Indiana 46507
 Phone: 574-848-4491
 Fax: 574-848-4825

Dexter - Plant 51

347 King Street West
 Ingersoll, Ontario N5C 2K9
 Phone: 226-242-5291
 Fax: 226-444-0474

Silent Drive by Dexter - Plant 54

1300 Arizona Place SW
 Orange City, Iowa 51041
 Phone: 712-737-4865

Dexter - Plant 61

21611 Protecta Drive
 Elkhart, Indiana 46516
 Phone: 574-294-6651
 Fax: 574-295-6626

Dexter - Plant 62

301 North Kennedy Street
 Shawnee, Oklahoma 74801
 Phone: 405-273-9315
 Fax: 405-273-1054

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