

INSTALLATION INSTRUCTIONS

Hanger and Attaching Parts Kits – Rubber Bushed Suspension

HAP-105-00 8K-9K Single Axle Kit
HAP-205-01 8K-9K Multi-Axle Kit for 38" Axle Spacing
HAP-205-01 8K-9K Multi-Axle Kit for 42¼" Axle Spacing
HAP-205-01 8K-9K Multi-Axle Kit for 48½" Axle Spacing
HAP-103-00 10K-15K Single Axle Kit
HAP-203-01 10K-15K Multi-Axle Kit for 38" Axle Spacing
HAP-203-02 10K-15K Multi-Axle Kit for 42¼" Axle Spacing
HAP-203-03 10K-15K Multi-Axle Kit for 48½" Axle Spacing
HAP-158-00 10KGD Single Axle Kit
HAP-258-01 10KGD Multi-Axle Kit for 38" Axle Spacing
HAP-258-02 10KGD Multi-Axle Kit for 42¼" Axle Spacing
HAP-258-03 10KGD Multi-Axle Kit for 48½" Axle Spacing

Safety Precautions

Before welding and installing any suspension component parts to the trailer frame requiring the raising of the vehicle, make sure that the vehicle is properly supported on lift stands of sufficient capacity. Follow the vehicle manufacturer's recommendations for lifting and supporting the unit.

Do not lift with or place supports under any part of the suspension system unless specifically directed to do so during these installation steps.

CAUTION

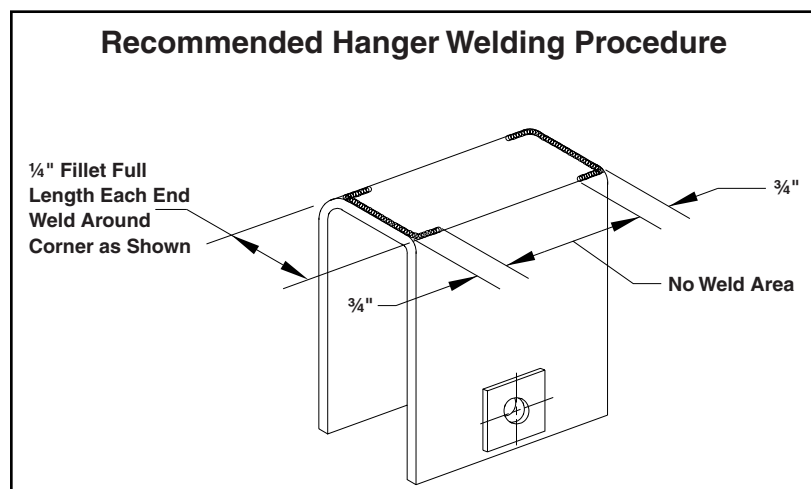
Never rely on jacks alone to support the vehicle. A vehicle that is not securely supported may fall and cause severe injuries or death.

CAUTION

Safety glasses should be worn at all times when assembling or disassembling axles and their components. Failure to comply may result in serious eye injury.

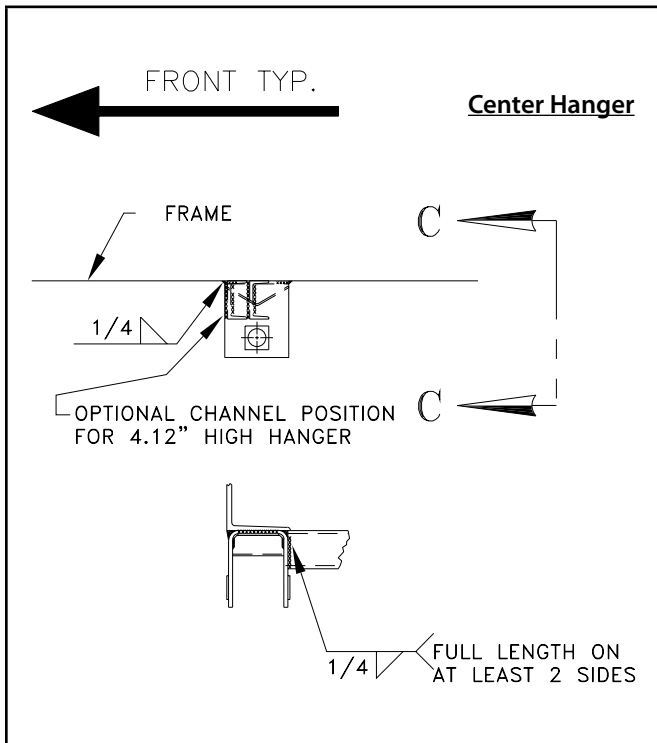
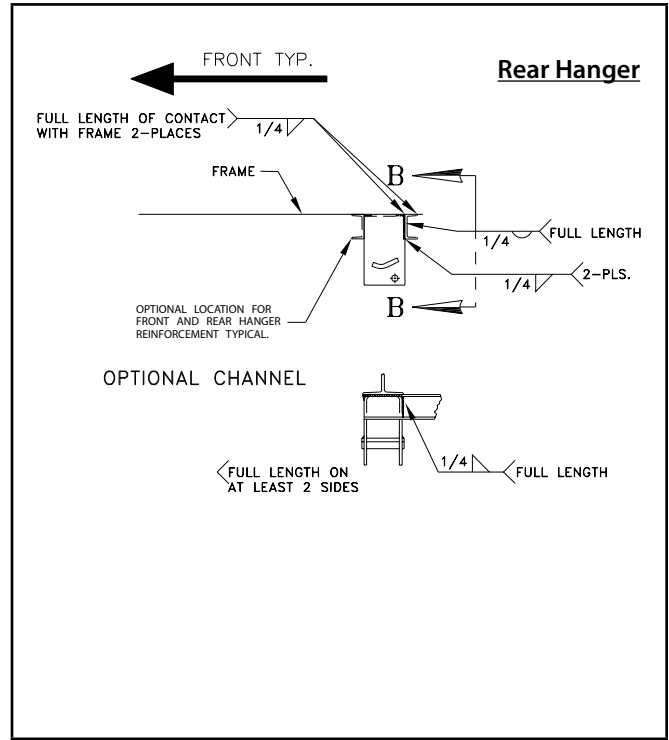
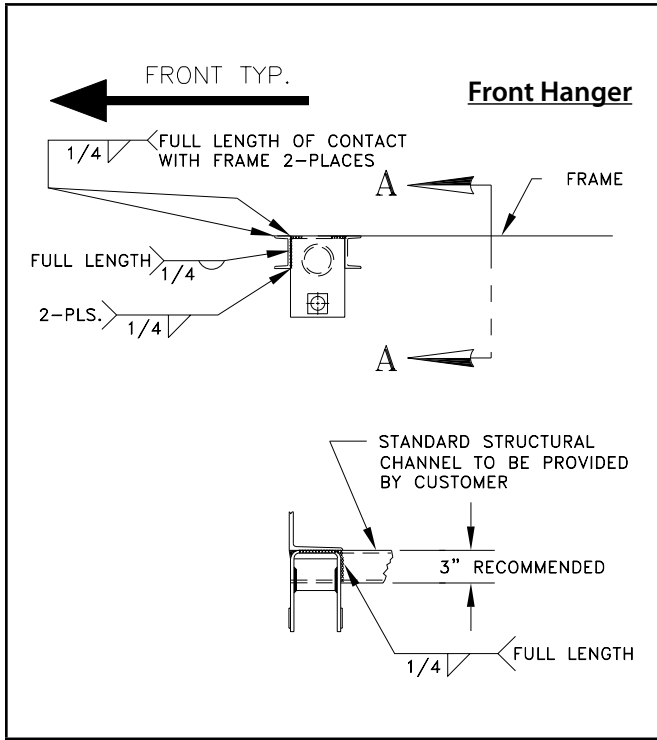
General Guidelines for Hanger Welding

1. It is recommended that the hangers be centered on the frame rails.
2. Starting and stopping at the corners of the hangers is NOT recommended.
3. Craters/ends of welds should be back-filled to prevent cracking.
4. The weld should be inspected for no cracks, no undercut, poor porosity, and inadequate penetration that may cause the hanger to fail.

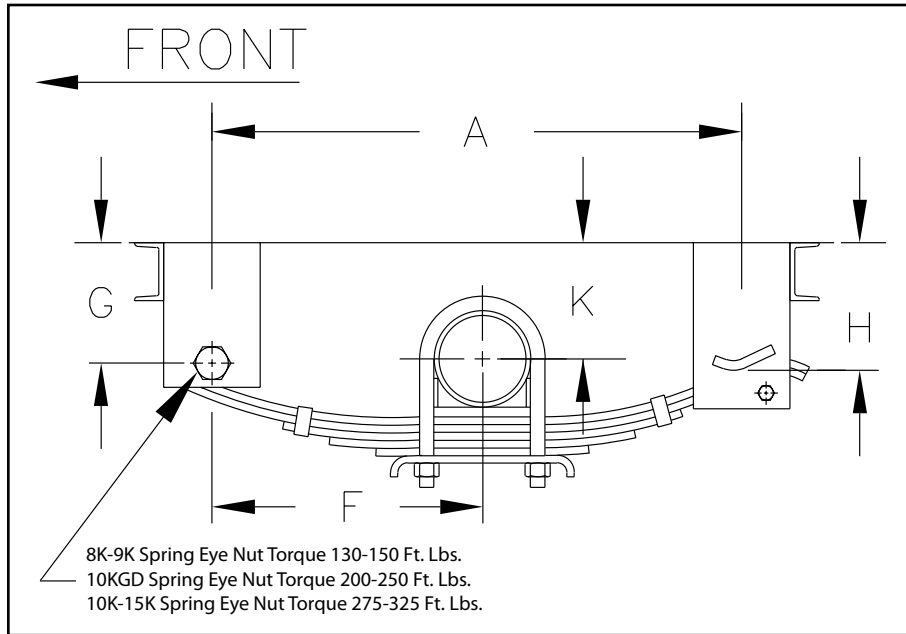


Cross Frame Reinforcement

Cross frame reinforcement recommended on hangers to assure full load carrying capacity of axle suspension. Standard 3" structural channel is suggested as reinforcement members. Weld as indicated.

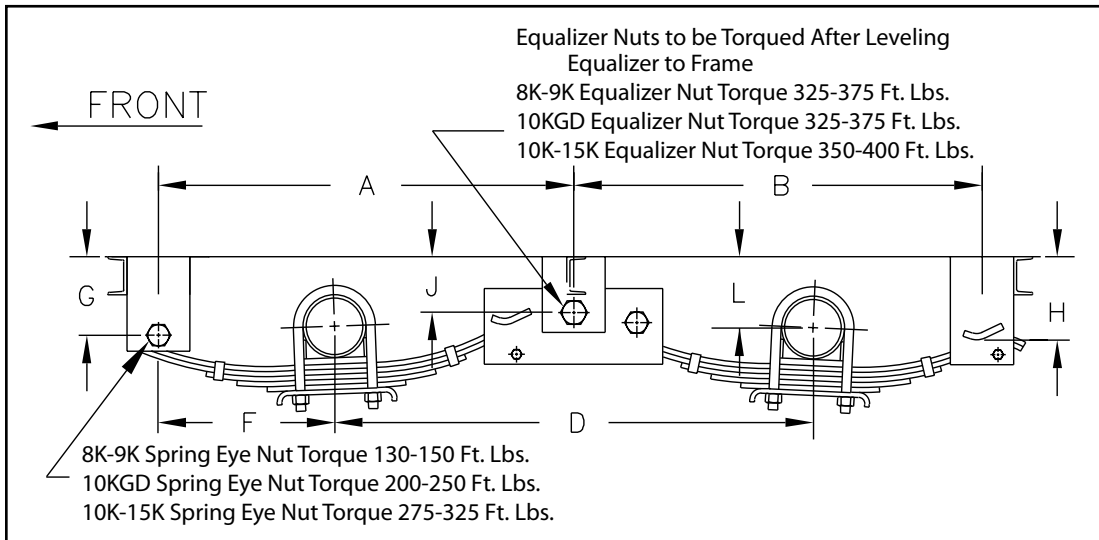


8K-15K Axle Installation Instructions - Single



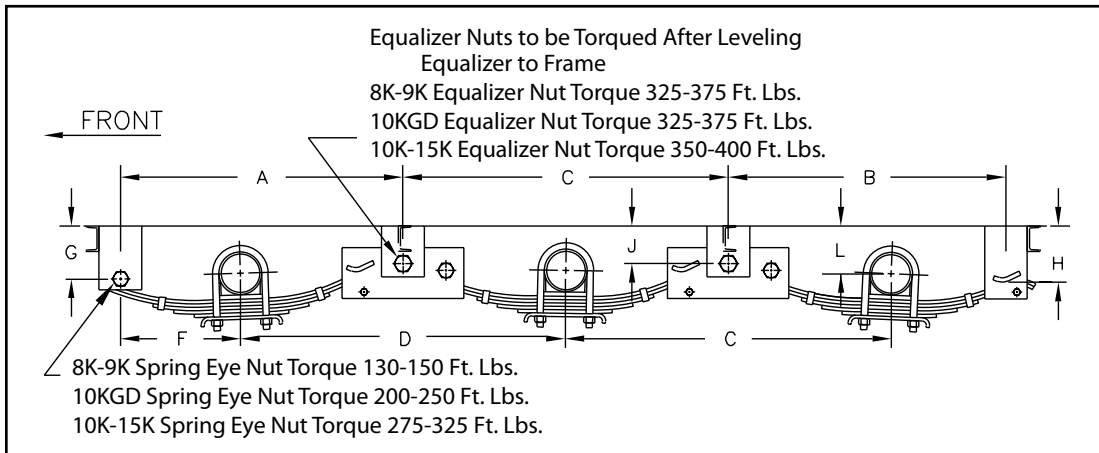
Axle	Kit	A	F	G	H	K
8K Single	HAP-105-00	24.00	11.50	5.00	4.90	4.40
9K Single	HAP-105-00	26.88	13.65	5.00	4.90	5.10
10KGD Single	HAP-158-00	27.44	14.00	5.21	5.46	5.00
10K-15K Single	HAP-103-00	27.44	14.00	6.25	6.63	6.10

8K-15K Axle Installation Instructions - Tandem



Axle	Kit	A	B	D	F	G	H	J	L
8K Multi	HAP-105-00	30.44	30.44	36.00	11.50	5.00	4.90	4.50	4.20
	HAP-205-01								
9K Multi	HAP-105-00	32.44	32.88	38.00	13.65	5.00	4.90	4.50	4.70
	HAP-205-01								
	HAP-105-00	34.56	35.00	42.25	13.65	5.00	4.90	4.50	4.70
	HAP-205-02								
HAP-105-00	37.69	38.12	48.50	13.65	5.00	4.90	4.50	4.70	
HAP-205-03									
10KGD Multi	HAP-158-00	33.00	32.44	38.00	14.00	5.21	5.46	4.12	4.80
	HAP-258-01								
	HAP-158-00	35.12	34.56	42.25	14.00	5.21	5.46	4.12	4.80
HAP-258-02									
HAP-158-00	38.25	37.69	48.50	14.00	5.21	5.46	4.12	4.80	
HAP-258-03									
10K-15K Multi	HAP-103-00	33.00	32.44	38.00	14.00	6.25	6.63	4.12	5.30
	HAP-203-01								
	HAP-103-00	35.12	34.56	42.25	14.00	6.25	6.63	4.12	5.30
HAP-203-02									
HAP-103-00	38.25	37.69	48.50	14.00	6.25	6.63	4.12	5.30	
HAP-203-03									

8K-15K Axle Installation Instructions - Triple



Axle	Kit	A	B	C	D	F	G	H	J	L
8K Multi	HAP-105-00	30.44	30.44	35.00	36.00	11.50	5.00	4.90	4.50	4.20
	HAP-205-01									
9K Multi	HAP-105-00	32.44	32.88	38.00	38.00	13.65	5.00	4.90	4.50	4.70
	HAP-205-01									
	HAP-105-00	34.56	35.00	42.25	42.25	13.65	5.00	4.90	4.50	4.70
	HAP-205-02									
10KGD Multi	HAP-105-00	37.69	38.12	48.50	48.50	13.65	5.00	4.90	4.50	4.70
	HAP-205-03									
	HAP-158-00	33.00	32.44	38.00	38.00	14.00	5.21	5.46	4.12	4.80
	HAP-258-01									
10K-15K Multi	HAP-158-00	35.12	34.56	42.25	42.25	14.00	5.21	5.46	4.12	4.80
	HAP-258-02									
	HAP-158-00	38.25	37.69	48.50	48.50	14.00	5.21	5.46	4.12	4.80
	HAP-258-03									
10K-15K Multi	HAP-103-00	33.00	32.44	38.00	38.00	14.00	6.25	6.63	4.12	5.30
	HAP-203-01									
	HAP-103-00	35.12	34.56	42.25	42.25	14.00	6.25	6.63	4.12	5.30
	HAP-203-02									
	HAP-103-00	38.25	37.69	48.50	48.50	14.00	6.25	6.63	4.12	5.30
	HAP-203-03									