INSTALLATION INSTRUCTIONS

Front Pivot Bushing Replacement Kit for one Airflex® Axle (K71-734-01)

Notice to Buyer

It is recommended that both pivot bushings be replaced at the same time to ensure continued axle alignment. Additionally, each side needs to be replaced while the other side remains intact to maintain control over the suspension components.

Safety Precautions

It is recommended that if you are unfamiliar with this type of work, you should refer to a qualified service center specializing in trailer suspensions. It is also recommended that if you choose to do this yourself, that a factory service manual be obtained for the proper procedures pertaining to removal, replacement and proper torque specifications for your trailer. This instruction set is intended as a guideline for the safe replacement of polyurethane bushings used in Dexter's Airflex suspension system.

⚠ CAUTION

Do not lift or support the trailer on any part of the axle or suspension system. Never go under any trailer unless it is properly supported on jack stands which have been rated for the load. Improperly supported vehicles can fall unexpectedly and cause serious injury or death.

Pivot Bushing Replacement

Disassemble 3/4" nut and bolt. Remove original rubber/polyurethane bushings (you may need a punch for this) and clear the Airflex® joint of any old rubber or rust. When installing polyurethane bushings, please follow the steps closely as each procedure is required. For units built after August 2018, please skip steps 1 through 3.

1. Use collar template as shown in Figure 3 as a guide to drill out the existing mounting bracket hole.
2. Insert collar reinforcements into mounting bracket (part number 014-199-00) as shown in Figure 1.
3. Collar reinforcements MUST be welded into place as instructed in Figure 2.
4. Apply light coat of grease to inside of the axle bracket sleeve.
5. Apply light coat of grease to the inside and outside of the bushing (all parts that contact metal).
6. Apply light coat of grease to the outside of the sleeve.
7. Insert bushing and sleeve in the same order as removed.
8. Apply light coat of grease to the faces of the bushings after they are installed.
9. Torque the 1" pivot bolts/nuts to 445-455 Ft. Lbs.
10. After final torque is completed, weld 2 opposing flats of the hex bolts and nuts to the collar as shown in figure 2.

Figure 1

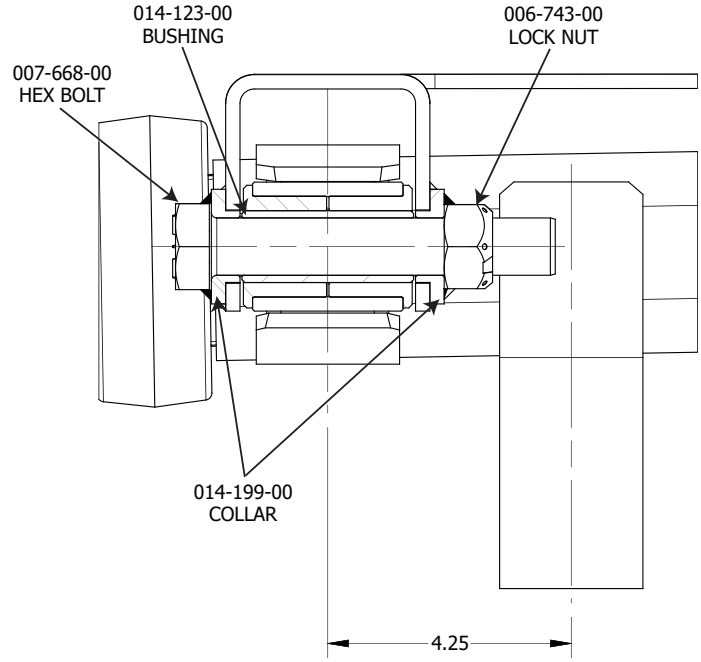
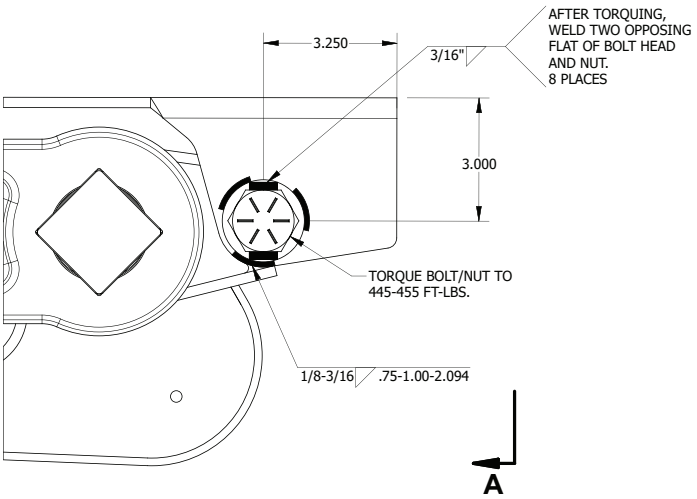


Figure 2



Collar Template

Figure 3 template should be used on the mounting bracket to locate proper hole position. Align template with frame bracket and tape in place. Spray paint cutout hole in template. Grind painted area to a 1.25" diameter hole to clear shoulder of collar. Elongate the hole if needed for axle alignment. **MAKE SURE THE TEMPLATE IS PRINTED TO SCALE BY MATCHING THE DIMENSIONS LISTED.**