



## Primaax EX International Parts Manual

Pro Gear's Hendrickson Primaax EX International Parts Manual to assist in identifying your Hendrickson unit.

If you need any assistance identifying the correct transfer case unit for your truck and equipment, contact your Hendrickson replacement part specialists at Pro Gear and Transmission.

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# H PARTS LIST

## PRIMAAX® EX / PRIMAAX® Rear Air Suspension for International Truck Vehicles

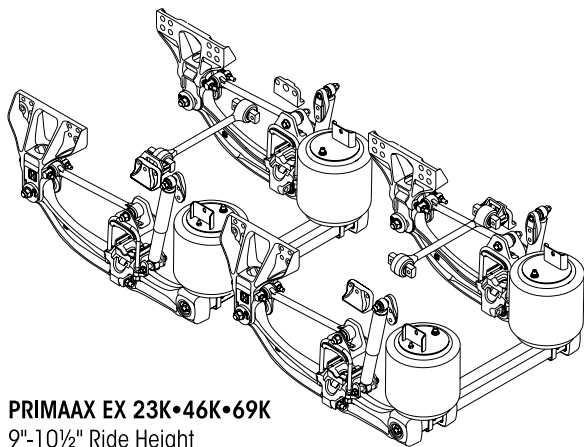
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DATE: December 2017

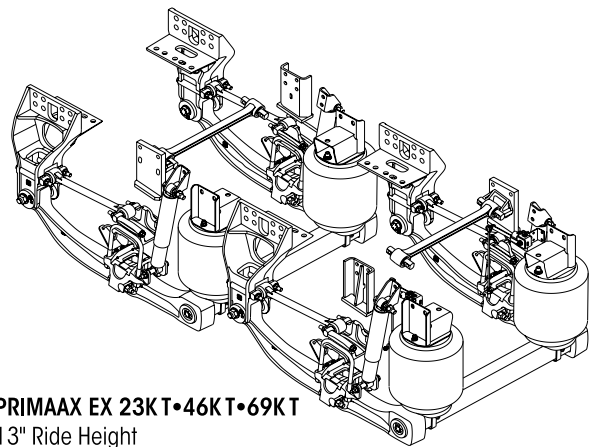
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### CONTENTS

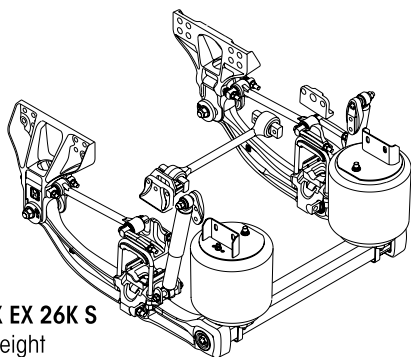
DESCRIPTION	PAGE	DESCRIPTION	PAGE
Technical Notes . . . . .	2	PRIMAAX	
Selection Guides . . . . .	3	■ 230 • 460 • 690 . . . . .	12
<b>PRIMAAX® EX</b>		Severe Service Kits . . . . .	14
■ 23K • 46K • 69K   26K S . . . . .	6	Notes . . . . .	14
■ 23K T • 46K T • 69K T . . . . .	8	Special Tools . . . . .	15
■ 26K • 52K • 78K . . . . .	10		



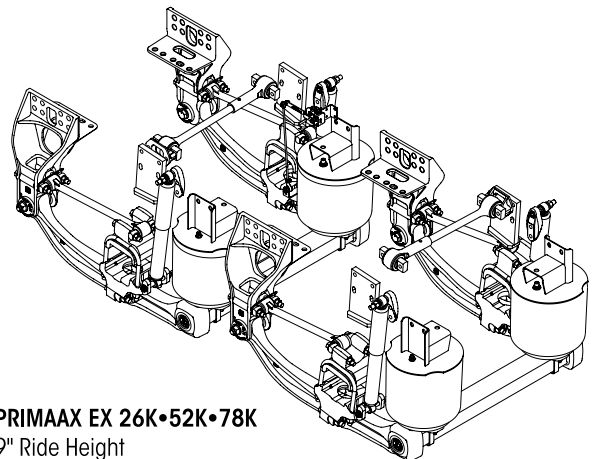
**PRIMAAX EX 23K•46K•69K**  
9"-10½" Ride Height



**PRIMAAX EX 23KT•46KT•69KT**  
13" Ride Height



**PRIMAAX EX 26K S**  
9" Ride Height



**PRIMAAX EX 26K•52K•78K**  
9" Ride Height



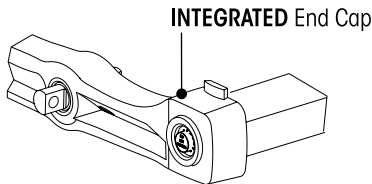
## Technical Notes

The following information is intended to assist in determining which suspension is equipped on the vehicle. As an example, in Figure 1, the end cap / frame hanger helps identify whether the suspension is the current model PRIMAAX EX or the previous production model PRIMAAX. Figure 2 identifies the ride height.

FIGURE 1

PRIMAAX EX • PRIMAAX

**PRIMAAX EX** | Enhanced U-beam Assembly with Integrated End Cap



**PRIMAAX** | Support Beam with Detachable End Cap

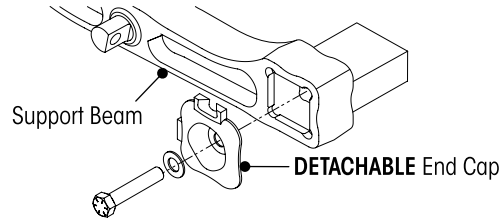
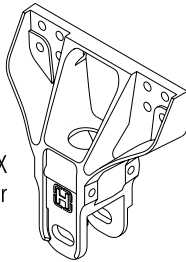


FIGURE 2

RIDE HEIGHT

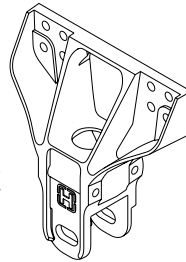
9" Ride Height

PRIMAAX EX / PRIMAAX  
Frame Hanger



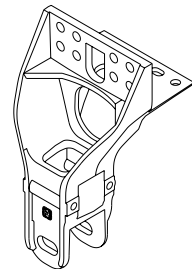
10½" Ride Height

PRIMAAX EX  
Frame Hanger

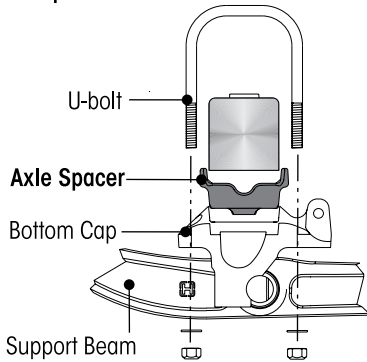


13" Ride Height

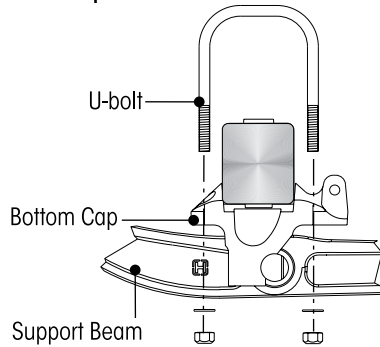
PRIMAAX EX  
Frame Hanger



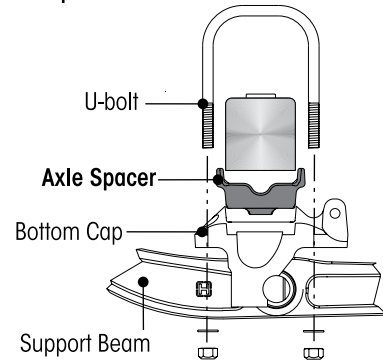
**AND**  
Axle Spacer



**AND**  
No Axle Spacer

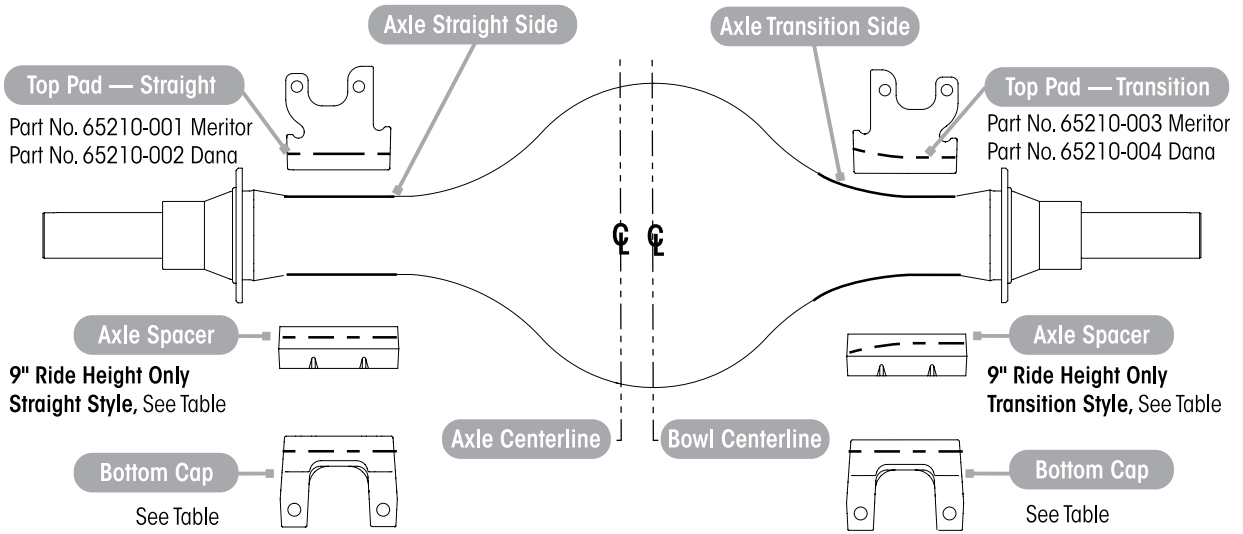


**AND**  
Axle Spacer





Bottom Cap • Axle Spacer • Top Pad • Longitudinal Torque Rod



Page 10		PRIMAAX EX 26K • 52K • 78K							
Axle Manufacturer	Beam Centers	Bottom Cap Part Number				Axle Spacer Part Number			
		Straight Side		Transition Side		Straight Side		Transition Side	
		FRONT	REAR	FRONT	REAR	FRONT	REAR	FRONT	REAR
MERITOR	40.0"	65208-001	65208-003	See Axle Spacer	65276-000		65277-000		
	40.5"				—		67973-004		
DANA	40.0"	65208-002	65208-004		65274-000		65275-000		
	40.5"				—		67973-002		



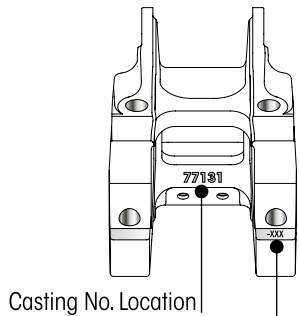
## Bottom Cap, Longitudinal Torque Rod and Top Pad Assembly

Page 6  
Page 8  
Page 12

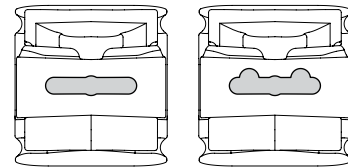
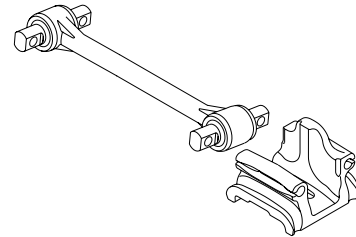
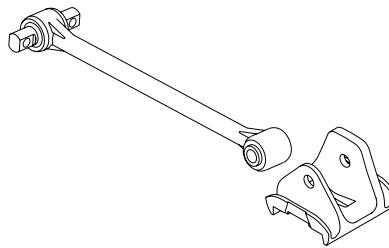
PRIMAAX EX 23K • 46K • 69K | 26K S ■ 9", 10½" Ride Heights  
PRIMAAX EX 23KT • 46KT • 69KT ■ 13" Ride Height  
PRIMAAX 230 • 460 • 690 ■ 9" Ride Height

### DRUM BRAKES

Pinion Angle	Bottom Cap Part No.*	Thru Bolt Style		Bar Pin Style	
		Longitudinal Torque Rod**	Top Pad	Longitudinal Torque Rod	Top Pad
2.5	60556-025	67274-510 67274-515 67274-540	65290-001	62000-640N	65289-000 65289-008
3.0	60556-030			62000-645N	
3.5	60556-035			62035-475N	
5.5	60556-055			62039-440N	
10.0	60556-100			62040-475N	
10.5	60556-105			62040-490N	
11.0	60556-110			62043-430N	



Bottom View



Part Number  
65289-000

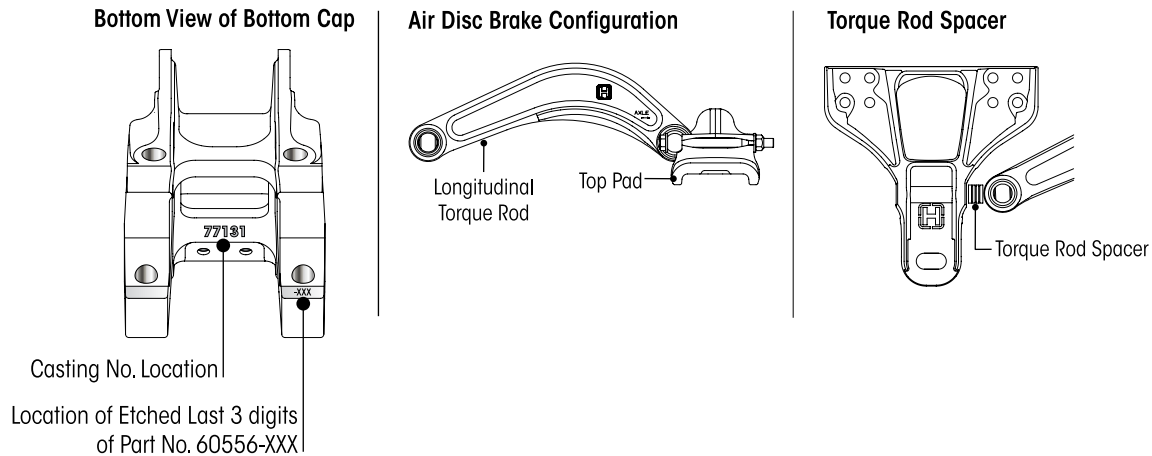
Part Number  
65289-008

Top View

- ◆ For specific part numbers see last three (3) digits etched on the bottom of the bottom cap as shown in the illustration above.
- ◆◆ Non-serviceable torque rod bushings, requires replacement of complete torque rod assembly with bushings.



### Bottom Cap, Longitudinal Torque Rod and Torque Rod Spacer



Page 6 PRIMAAX EX 23K • 46K • 69K | 26K S ■ 9" Ride Height

AIR DISC BRAKES							
Forward Rear			Rear Rear			Torque Rod Spacer	
Pinion Angle	Bottom Cap Part No.*	Longitudinal Torque Rod**	Pinion Angle	Bottom Cap Part No.*	Longitudinal Torque Rod**	Length in mm	Part No.
3.3	60556-025	67219-435	11.26	60556-100	67219-475	0	
3.86	60556-030		11.7	60556-105		0	
4.2	60556-035		12.15	60556-110		0	
4.36	60556-025		12.28	60556-100		6.35	67045-072
4.92	60556-030		12.73	60556-105		6.35	67045-072
5.26	60556-035		13.17	60556-110		6.35	67045-072
5.42	60556-025		13.29	60556-100		12.7	67045-071
5.97	60556-030		13.74	60556-105		12.7	67045-071
5.98	60556-055		13.96	60556-055		0	
6.32	60556-035		14.19	60556-110		12.7	67045-071
6.46	60556-025		14.3	60556-100	19.05	67045-070	
7.02	60556-030				19.05	67045-070	
7.04	60556-055				6.35	67045-072	
7.36	60556-035				19.05	67045-070	
7.5	60556-025				25.4	67045-069	
8.05	60556-030				25.4	67045-069	
8.09	60556-055				12.7	67045-071	
8.4	60556-035				25.4	67045-069	
9.13	60556-055				19.05	67045-070	
10.17	60556-055				25.4	67045-069	

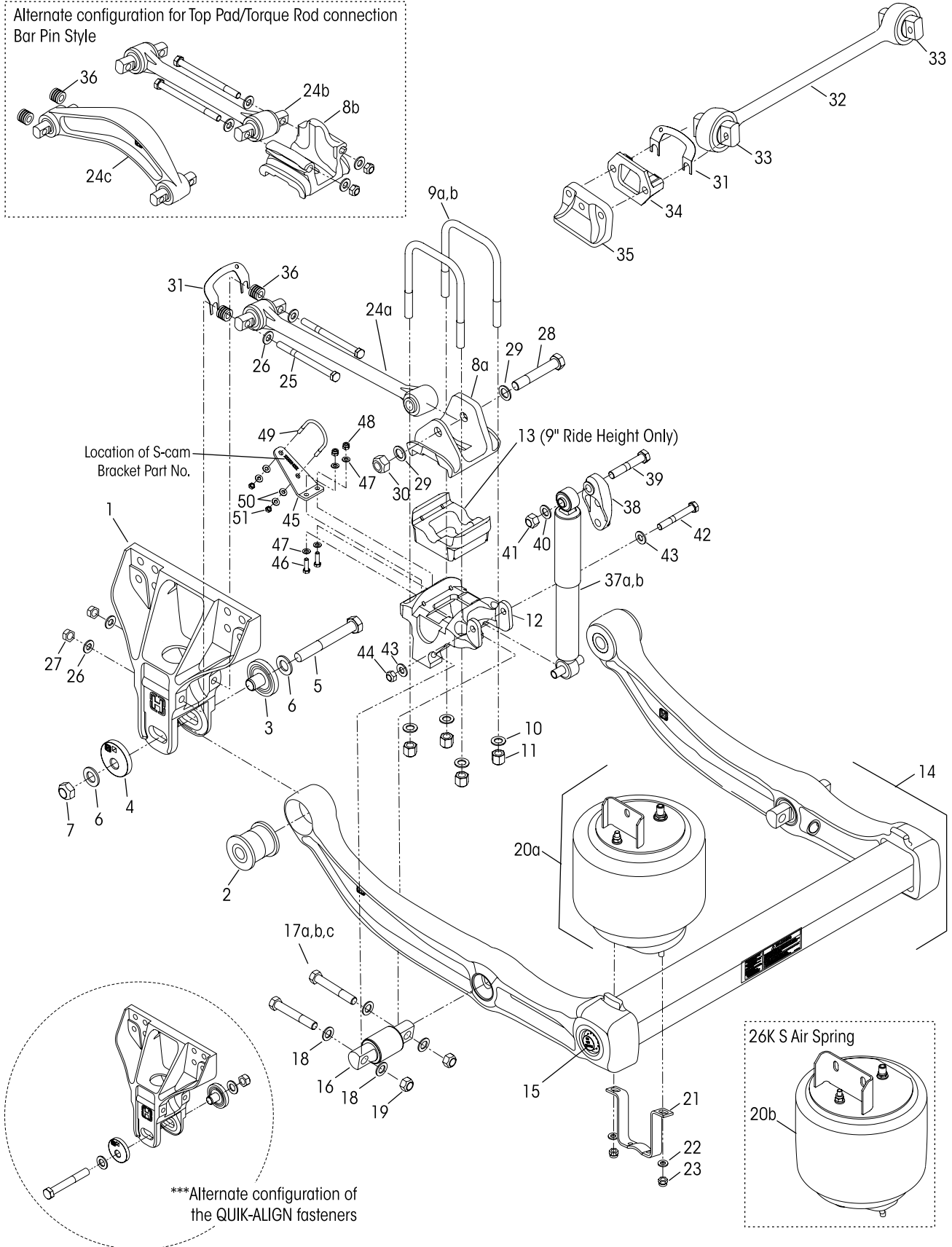
◆ For specific part numbers see last 3 digits etched on the bottom of the bottom cap as shown in the illustration above.  
 ◆◆ Non-serviceable torque rod bushings, requires replacement of complete torque rod assembly with bushings.



PRIMAAX EX 23K•46K•69K - 9", 10½" Ride Height

PRIMAAX EX 26K S - 9" Ride Height - (S – designates Small Clamp Group)

Alternate configuration for Top Pad/Torque Rod connection  
Bar Pin Style





# PRIMAAX® EX 23K•46K•69K•26K S for International Truck Vehicles

KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
1	67706-000	Frame Hanger	4
		<b>QUIK-ALIGN® Pivot Bushing Service Kits,</b> Includes Key Nos. 2-7, 52	
	60961-720	One Wheel End	
	60632-020	Axle Set	
		<b>QUIK-ALIGN Collar Service Kit,</b> Includes Key Nos. 3-7 One Wheel End, <i>Replaces 60632-006</i>	
	60632-019	One Wheel End	
	60632-021	Axle Set	
	60632-018	<b>QUIK-ALIGN Fastener Service Kit, One Wheel End,</b> Includes Key Nos. 5-7, <i>Replaces 60632-005</i>	
2		*Pivot Bushing	4
3		*Concentric Collar	4
4		*Eccentric Collar	4
5		*1"-1 4 UNF-2A x 7 1/2" H-Coat Hex Bolt	4
6		*1" H-Coat Flat Washer	8
7		*1"-1 4 UNF-2B H-Coat Locknut	4
8		Top Pad, <i>See Selection Guide on Page 4</i>	4
a	65290-XXX	Thru Bolt Style	
b	65289-XXX	Bar Pin Style, Air Disc Brake	
		<b>U-bolt Service Kit, One Wheel End,</b> Includes Key Nos. 9a, 10-11	
	48718-108	Includes Key Nos. 9b, 10-11 (Thru Bolt Style)	
	48718-125	Includes Key Nos. 9c, 10-11 (Bar Pin Style)	
9		*3/4" Square U-bolt	
a		8 7/8" Length - 10 1/2" Ride Height	8
b		10 3/8" Length - 9" Ride Height	8
c		10 3/8" Length - 9" Ride Height	8
10		*3/4" Flat Washer	16
11		*3/4"-1 6 UNF U-bolt Locknut	16
12	60556-XXX	Bottom Cap - Front and Rear, <i>See Selection Guide on Page 4 and 5</i>	4
13	65139-003	Axle Spacer, 9" Ride Height Only	4
14		U-beam Assembly, Includes Key Nos. 2, 16	2
		• Front Frame Width	
	67249-012	34.3"	
	67249-010	34.5"	
	67249-024	34.8"	
		• Rear Frame Width	
	67249-011	34.3"	
	67249-009	34.5"	
	67249-023	34.8"	
15	69565-001	<b>U-beam Assembly Enhancement Aftermarket Service Kit, Axle Set,</b> <i>See Page 14 for contents</i>	
		<b>Single D-Pin Bushing Service Kit,</b> Includes Key Nos. 16, 17a, 18-19	
	34013-107	Includes Key Nos. 16, 17b, 18-19	
	34013-116	Includes Key Nos. 16, 17c, 18-19	
	34013-117	Includes Key Nos. 16, 17c, 18-19	
16		*D-Pin Bushing	4
		<b>D-Pin Fastener Service Kit, Axle Set,</b> Includes Key Nos. 17a, 18-19	
	56659-009	Includes Key Nos. 17b, 18-19	
	56659-013	Includes Key Nos. 17c, 18-19	
	56659-012	Includes Key Nos. 17c, 18-19	
17		*3/4"-1 6 UNF Bolt	8
a		5" Length	
b		5 1/2" Length	
c		4 3/4" Length	
18		*3/4" Flat Washer	16
19		*3/4"-1 6 UNF Locknut	8
		<b>Single Air Spring Service Kit,</b> Includes Key Nos. 20a-23	
	60961-664	Includes Key Nos. 20b-23	
	60961-665	Includes Key Nos. 20b-23	

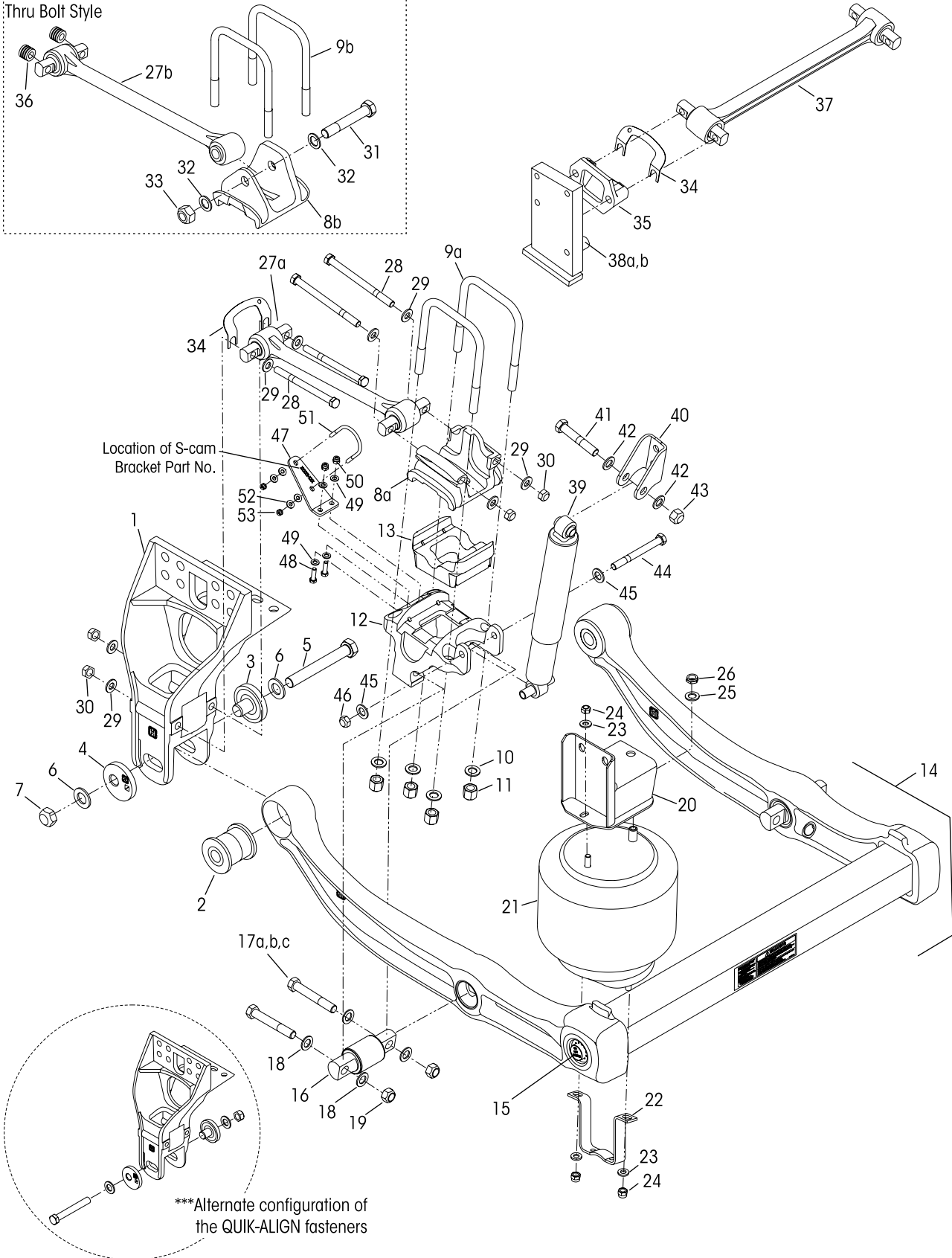
KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
20		Air Spring Assembly with Upper Frame Bracket	4
a	67234-002L	23K•46K•69K	
b	68056-002L	26K S	
21	60911-002	Lower Air Spring Mounting Bracket	4
	49177-006	<b>Lower Air Spring Fastener Service Kit, Single,</b> Includes Key Nos. 22-23	
22		*1/2" Flat Washer	8
23		*1/2"-1 3 UNC Locknut	8
24		Longitudinal Torque Rod Assembly, <i>See Selection Guide on Page 4 and 5</i>	4
a	67274-XXX	Thru Bolt Style	
b	620XX-XXXN	Bar Pin Style	
c	67219-XXX	Air Disc Brake	
		<b>Single Longitudinal Torque Rod Fastener Kit</b> Thru Bolt and Bar Pin Connection, Includes Key Nos. 25-30	
	49176-026	Includes Key Nos. 25-30	
	58821-012	Rear Thru Bolt Connection Only, Includes Key Nos. 28-30	
25		*5/8"-1 1 UNC-2B x 8" Bolt	8
26		*5/8" Flat Washer	16
27		*5/8"-1 1 UNC-2A Locknut	8
28		*7/8"-1 4 UNF-2A x 5 1/2" Hex Bolt	4
29		*7/8" H-Coat Flat Washer	8
30		*7/8"-1 4 UNF-2B Locknut	4
31	49689-000L	Shim	As Req.
32	72000-XXXS	**ULTRA ROD® PLUS™ Transverse Torque Rod Assembly, Includes Key No. 33, Specify length in mm	2
33	64400-002L	Bushing - Straddle Bar Pin (5/8" Holes)	4
34	22186-000	Transverse Torque Rod Frame Bracket	2
35	60593-000L	Axle Stop, Frame Mounted	4
36	67045-XXX	Torque Rod Spacer, <i>See Selection Guide on Page 5</i>	
37a	60657-003L	Shock Absorber	4
b	70807-001	Heavy-duty Shock Absorber, Optional	4
c	60665-011	Shock Absorber - 26K S	2
38	67463-002	Upper Shock Frame Bracket	4
	50754-030	<b>Single Shock Fastener Service Kit,</b> Includes Key Nos. 39-44	
39		*3/4"-1 0 UNC x 4 1/4" Upper Shock Bolt	4
40		*3/4" Flat Washer	4
41		*3/4"-1 0 UNC Locknut	4
42		*5/8"-1 1 UNC x 6" Lower Shock Bolt	4
43		*5/8" Flat Washer	8
44		*5/8"-1 1 UNC-2B Locknut	4
	<b>NOTE</b>	<b>Key Nos. 45-51</b> are not required if equipped with 24c and Air Disc Brake	
45	64508-XXX	S-cam Support Bracket, <i>Locate part number on component</i>	4
	58821-017	<b>S-cam Fastener Service Kit, Axle Set,</b> Includes Key Nos. 46-51	
46		*3/8"-1 6 UNC x 1 1/4" Hex Bolt	8
47		*3/8" Hardened Washer	16
48		*3/8"-1 6 UNC Locknut	8
49		*5/16" S-cam U-bolt	4
50		*5/16" Hardened Washer	16
51		*5/16"-1 8 UNC Locknut	8
52	70867-001	P-80 Lubricant - 10 ml (Not Shown)	per Bushing 1





23KT•46KT•69KT - 13" Ride Height (T – designates Tall Ride Height)

Alternate configuration for Top Pad/Torque Rod connection  
Thru Bolt Style



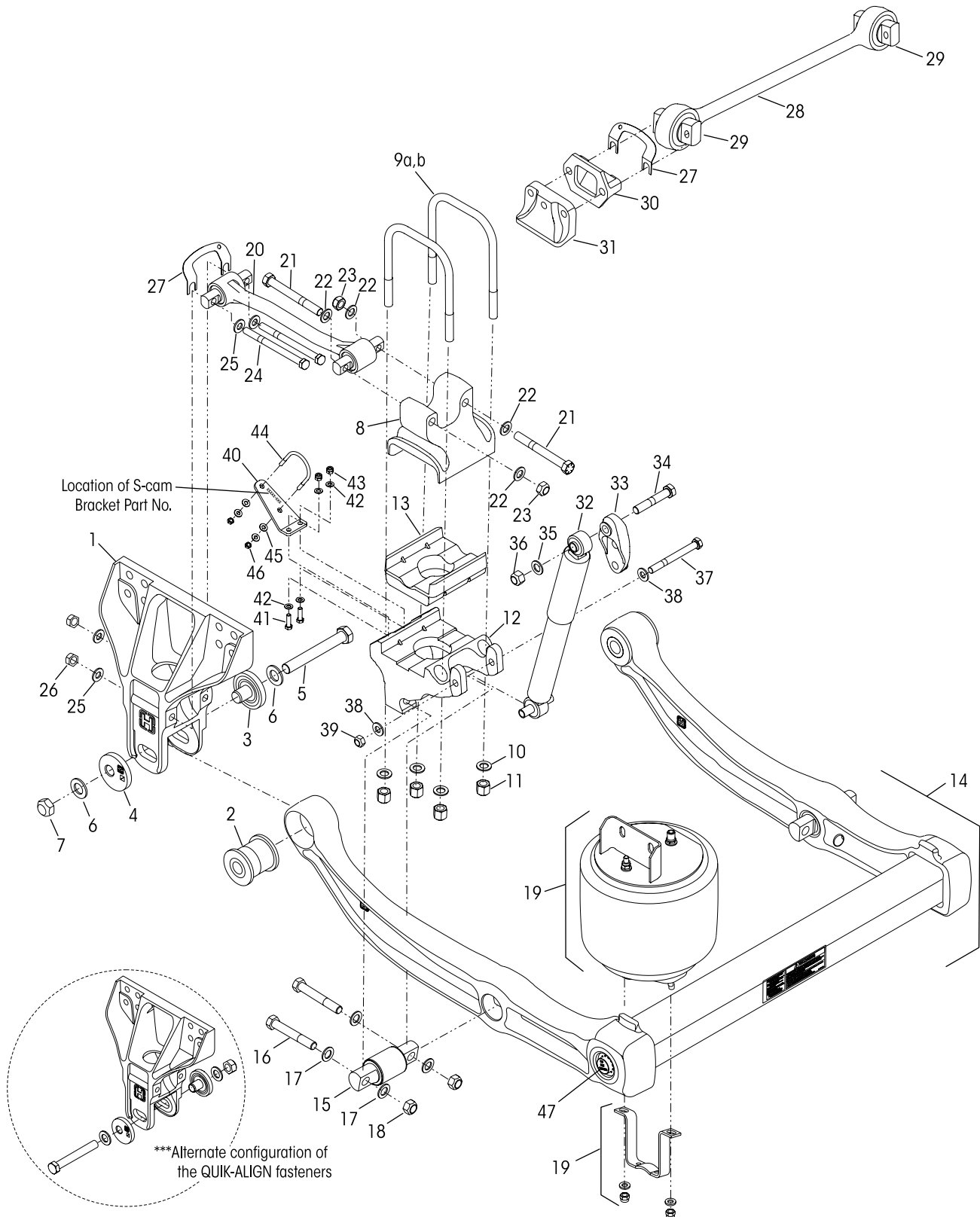


# PRIMAAX® EX 23K•46K•69K for International Truck Vehicles

KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.	KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
1		Frame Hanger					
	67299-001	Left Hand	2		67923-002	Air Spring Assembly, Includes Key Nos. 20-21, 23-26	4
	67299-002	Right Hand	2	20	65031-001	Upper Air Spring Bracket Assembly	4
		<b>QUIK-ALIGN® Pivot Bushing Service Kit,</b> Includes Key Nos. 2-7, 54			60961-724	<b>Single Air Spring Service Kit,</b> Includes Key Nos. 21-26	
	60961-720	One Wheel End		21	68070-002L	Air Spring	4
	60632-020	Axle Set		22	60911-002	Lower Air Spring Mounting Bracket	4
		<b>QUIK-ALIGN Collar Service Kit,</b> Includes Key Nos. 3-7				<b>Air Spring Fastener Service Kit, Single</b> Lower, Includes Key Nos. 23-24	
	60632-019	One Wheel End, <i>Replaces 60632-006</i>			49177-006	Upper/Lower, Includes Key Nos. 23-26	
	60632-021	Axle Set		23		*1/2" Flat Washer	12
	60632-018	<b>QUIK-ALIGN Pivot Bolt Service Kit, One Wheel End,</b> Includes Key Nos. 5-7, <i>Replaces 60632-005</i>		24		*1/2"-13 UNC Locknut	12
2		*Pivot Bushing	4	25		*3/4" Flat Washer	4
3		*Concentric Collar	4	26		*3/4"-16 UNF Locknut	4
4		*Eccentric Collar	4	27 a,b		Longitudinal Torque Rod Assembly, Includes Bushing. Specify length in mm, See <i>Selection Guide on Page 4 and 5</i>	4
5		*1"-14 UNF-2A x 7 1/2" H-Coat Hex Bolt	4			<b>Single Longitudinal Torque Rod Fastener Kit</b> Thru Bolt and Bar Pin Connection, Includes Key Nos. 28-33	
6		*1" H-Coat Flat Washer	8		49176-026	2-Bar Pin Connections, Includes Key Nos. 28-30	
7		*1"-14 UNF-2B H-Coat Locknut	4		49176-032	Rear Thru Bolt Connection Only, Includes Key Nos. 31-33	
8		Top Pad, <i>see Selection Guide on Page 4</i>	4		58821-012	Key Nos. 31-33	
a	65289-XXX	Bar Pin Style		28		*5/8"-11 UNC-2B x 8" Bolt	16
b	65290-XXX	Thru Bolt Style		29		*5/8" Flat Washer	32
		<b>U-bolt Service Kit, One Wheel End,</b> Includes Key Nos. 9a, 10-11 (Bar Pin Style)		30		*5/8"-11 UNC-2A Locknut	16
	48718-130	Includes Key Nos. 9b, 10-11 (Thru Bolt Style)		31		*7/8"-14 UNF-2A x 5 1/2" Hex Bolt	4
	48718-125			32		*7/8" H-Coat Flat Washer	8
9		*3/4" Square U-bolt	8	33		*7/8"-14 UNF-2B Locknut	4
a		10 3/8" Length, Bar Pin Style		34	49689-000L	Shim	As Req.
b		10 3/8" Length, Thru Bolt Style		35	22186-000	Transverse Torque Rod Frame Bracket	2
10		*3/4" Flat Washer	16	36	67045-XXX	Torque Rod Spacer, <i>See Selection Guide on Page 5</i>	
11		*3/4"-16 UNF U-bolt Locknut	16	37	62011-XXXN	**Transverse Torque Rod Assembly, Includes Key No. 38, Specify length in mm	2
12	60556-XXX	Bottom Cap, <i>See Selection Guide on Page 4 and 5</i>	4	38		Axle Stop, Frame Mounted	4
13	65139-003	Axle Spacer (required)	4	a	65510-001	0° Axle Tower	
14		U-beam Assembly, Includes Key Nos. 2, 16	2	b	65510-002	20° Axle Tower	
		• Front Frame Width		39	60665-011	Shock Absorber	4
	67249-012	34.3"		40	59423-001	Upper Shock Frame Bracket	4
	67249-010	34.5"			50754-030	<b>Single Shock Fastener Service Kit,</b> Includes Key Nos. 41-46	
	67249-024	34.8"		41		*3/4"-10 UNC x 4 1/4" Upper Shock Bolt	4
	67249-011	34.3"		42		*3/4" Flat Washer	8
	67249-009	34.5"		43		*3/4"-10 UNC Locknut	4
	67249-023	34.8"		44		*5/8"-11 UNC x 6" Lower Shock Bolt	4
15	69565-001	<b>U-beam Assembly Enhancement Aftermarket Service Kit, Axle Set,</b> <i>See Page 14 for contents</i>		45		*5/8" Flat Washer	8
		<b>Single D-Pin Bushing Service Kit,</b> Includes Key Nos. 16, 17a, 18-19		46		*5/8"-11 UNC-2B Locknut	4
	34013-107	Includes Key Nos. 16, 17b, 18-19				<b>NOTE</b> <b>Key Nos. 47-53</b> are not required if equipped with 24c and Air Disc Brake	
	34013-116	Includes Key Nos. 16, 17c, 18-19		47	64508-XXX	S-cam Support Bracket, <i>Locate part number on component</i>	4
	34013-117				58821-017	<b>S-cam Fastener Service Kit, Axle Set,</b> Includes Key Nos. 48-53	
16		*D-Pin Bushing	4	48		*3/8"-16 UNC x 1 1/4" Hex Bolt	8
		<b>D-Pin Fastener Service Kit, Axle Set,</b> Includes Key Nos. 17a, 18-19		49		*3/8" Hardened Washer	16
	56659-009	Includes Key Nos. 17b, 18-19		50		*3/8"-16 UNC Locknut	8
	56659-013	Includes Key Nos. 17c, 18-19		51		*5/16" S-cam U-bolt	4
	56659-012			52		*5/16" Hardened Washer	16
17		*3/4"-16 UNF Bolt	8	53		*5/16"-18 UNC Locknut	8
a		5" Length		54	70867-001	P-80 Lubricant - 10 ml (Not Shown)	per Bushing 1
b		5 1/2" Length					
c		4 3/4" Length					
18		*3/4" Flat Washer	16				
19		*3/4"-16 UNF Locknut	8				



PRIMAAX EX 26K • 52K • 78K - 9" Ride Height



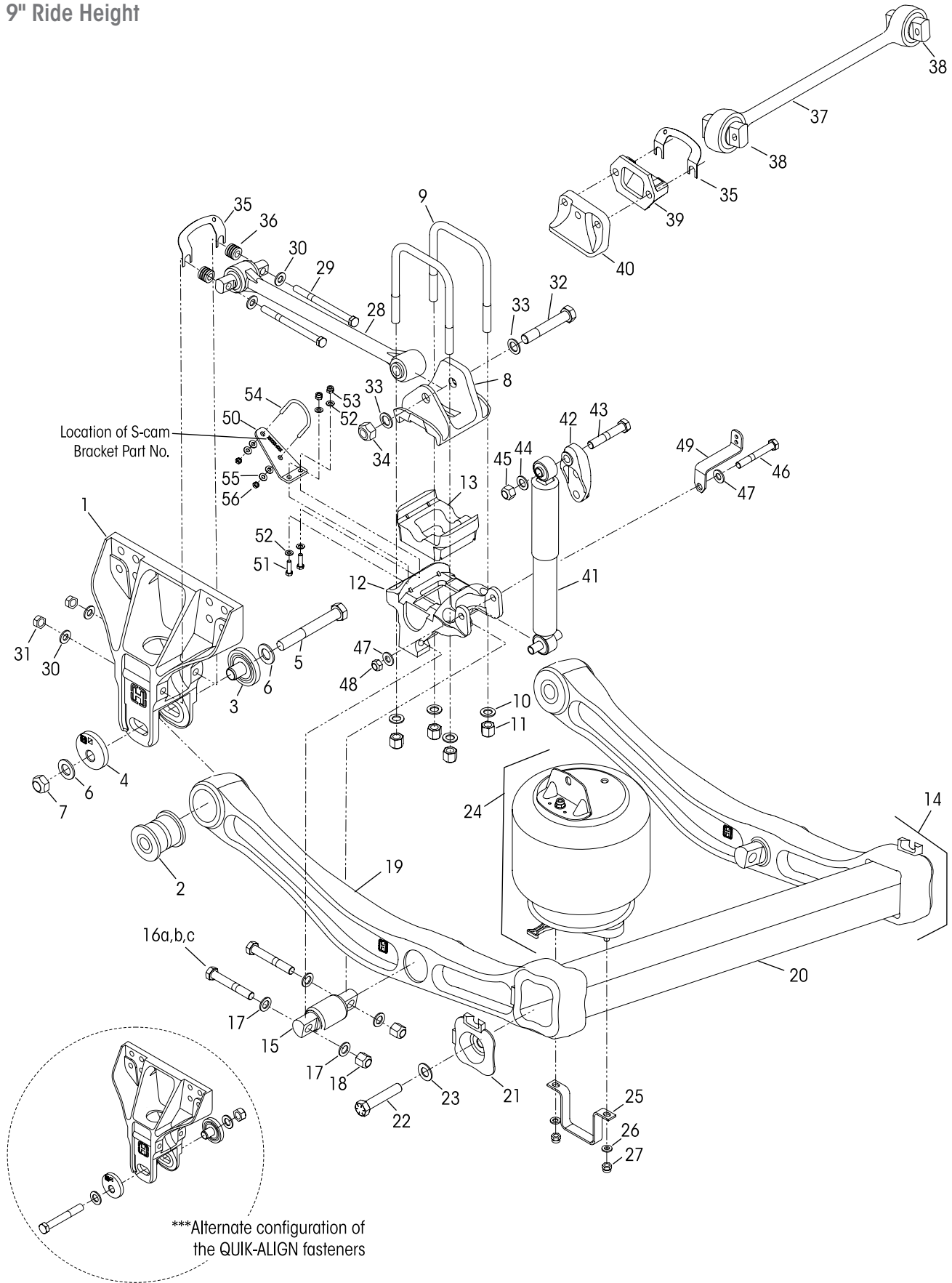


# PRIMAAX® EX 26K•52K•78K for International Truck Vehicles

KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.	KEY NO.	PART NO.	DESCRIPTION	VEHICLE QTY.
1	67706-000	EX Frame Hanger	4	20		Longitudinal Torque Rod Assembly, Specify Length in mm. Contact Hendrickson Truck Parts for specific part number	4
	60961-720	One Wheel End			65302-470A	Left Front	
	60632-020	Axle Set			65302-470B	Right Front	
		<b>QUIK-ALIGN Collar Service Kit</b> , Includes Key Nos. 3-7			65302-520A	Left Rear	
	60632-019	One Wheel End, <i>Replaces 60632-006</i>			65302-520B	Right Rear	
	60632-021	Axle Set			65302-530A	Left Rear	
	60632-018	<b>QUIK-ALIGN Fastener Service Kit, One Wheel End</b> , Includes Key Nos. 5-7, <i>Replaces 60632-005</i>			65302-530B	Right Rear	
2		*QUIK-ALIGN Pivot Bushing	4			<b>Longitudinal Torque Rod Fastener Service Kit</b> , Axle Set, Includes Key Nos. 21-26 Axle Set, Includes Key Nos. 24-26	
3		*QUIK-ALIGN Concentric Collar	4	21		*3/4"-16 UNF x 6" Hex Bolt	8
4		*QUIK-ALIGN Eccentric Collar	4	22		*3/4" Flat Washer	16
5		*1"-14 UNF-2A x 7 1/2" H-Coat Hex Bolt	4	23		*3/4"-16 UNF Locknut	8
6		*1" H-Coat Flat Washer	8	24		*5/8"-11 UNC-2B x 8" Bolt	8
7		*1"-14 UNF-2B H-Coat Locknut	4	25		*5/8" Flat Washer	16
8		Top Pad, <i>See illustration on page 3</i>	4	26		*5/8"-11 UNC-2A Locknut	8
	48718-118	<b>U-bolt Service Kit, Axle Set</b> Includes Key Nos. 9a-9b, 10-11		27	49689-000L	Shim	As Req.
9		*3/4" Square U-bolt	8	28	72000-XXS	**ULTRA ROD PLUS Transverse Torque Rod Assembly, Includes Bushings, Specify length in mm	2
a		1 1/2", Outboard		29	64400-002L	Bushing - Straddle Bar Pin - 5/8" Holes	4
b		12", Inboard		30	22186-000	Transverse Torque Rod Frame Bracket	2
10		*3/4" Flat Washer	16	31	60593-000L	Axle Stop, Frame Mounted	4
11		*3/4"-16 UNF U-bolt Locknut	16	32	60665-013L	Shock Absorber	4
12		Bottom Cap - Front and Rear <i>See Selection Guide on page 3</i>	4	33	67463-002	Upper Shock Frame Bracket	4
13		Axle Spacer - Front and Rear <i>See Selection Guide on page 3</i>	4		50754-036	<b>Shock Absorber Fastener Service Kit</b> One Wheel End, Includes Key Nos. 34-39	
14		U-beam Assembly, Includes Key Nos. 2, 15	2	34		*3/4"-10 UNC x 4 1/2" Upper Shock Bolt	4
		• Front		35		*3/4" Flat Washer	As Req.
	67249-014	34.3" Frame Width		36		*3/4"-10 UNC Locknut	4
	67249-016	34.5" Frame Width		37		*5/8"-11 UNC x 7" Lower Shock Bolt	4
	67249-026	34.8" Frame Width		38		*5/8" Flat Washer	8
		• Rear		39		*5/8"-11 UNC-2B Locknut	4
	67249-013	34.3" Frame Width		40	64508-XXX	S-cam Support Bracket, <i>Locate part number on component</i>	4
	67249-015	34.5" Frame Width			58821-017	<b>S-cam Fastener Service Kit, Axle Set</b> , Includes Key Nos. 41-46	
	67249-025	34.8" Frame Width		41		*3/8"-16 UNC x 1 1/4" Hex Bolt	8
	34013-114	<b>Single D-pin Bushing Service Kit</b> , Includes Key Nos. 15-18		42		*3/8" Hardened Washer	16
15		*D-pin Bushing	4	43		*3/8"-16 UNC Locknut	8
	56659-010	<b>D-pin Fastener Service Kit, Axle Set</b> Includes Key Nos. 16-18		44		*5/16" S-Cam U-bolt	4
16		*7/8"-14 UNF x 5" Bolt	8	45		*5/16" Hardened Washer	16
17		*7/8" Flat Washer	16	46		*5/16"-18 UNC Locknut	8
18		*7/8"-14 UNF Locknut	8	47	69565-001	<b>U-beam Assembly Enhancement Aftermarket Service Kit, Axle Set</b> , <i>See page 14 for contents</i>	
19	68056-002	Air Spring Assembly with Upper Frame Bracket	4	48	70867-001	P-80 Lubricant - 10 ml (Not Shown) per Bushing	1



9" Ride Height





KEY NO. PART NO.		DESCRIPTION	VEHICLE QTY.	KEY NO. PART NO.		DESCRIPTION	VEHICLE QTY.
1	67706-000	Frame Hanger, <i>Replaces 65891-000</i>	4		60961-062	<b>Single Air Spring Service Kit</b> , Includes Key Nos. 24-27	
	60961-720	One Wheel End		24	60271-002L	Air Spring Assembly with Upper Frame Bracket	4
	60632-020	Axle Set		25	60911-002	Lower Air Spring Mounting Bracket	4
	60632-019	<b>QUIK-ALIGN Collar Service Kit</b> , Includes Key Nos. 3-7			49177-006	<b>Lower Air Spring Fastener Service Kit, Single</b> , Includes Key Nos. 26-27	
	60632-021	One Wheel End, <i>Replaces 60632-006</i>		26		*1/2" Flat Washer	8
	60632-018	Axle Set		27		*1/2"-13 UNC Locknut	8
		<b>QUIK-ALIGN Pivot Bolt Service Kit, One Wheel End</b> , Includes Key Nos. 5-7, <i>Replaces 60632-005</i>		28		Longitudinal Torque Rod Assembly, <i>See Selection Guide on Page 4 and 5</i>	4
2		*Pivot Bushing	4		49176-026	<b>Single Longitudinal Torque Rod Fastener Kit</b> Thru Bolt and Bar Pin Connection, Includes Key Nos. 29-34	
3		*Concentric Collar	4		58821-012	Rear Thru Bolt Connection Only, Includes Key Nos. 32-34	
4		*Eccentric Collar	4	29		*5/8"-11 UNC-2B x 8" Bolt	8
5		*1"-14 UNF-2A x 7 1/2" H-Coat Hex Bolt	4	30		*5/8" Flat Washer	16
6		*1" H-Coat Flat Washer	8	31		*5/8"-11 UNC-2A Locknut	8
7		*1"-14 UNF-2B H-Coat Locknut	4	32		*7/8"-14 UNF-2A x 5 1/2" Hex Bolt	4
8	65290-001	Top Pad	4	33		*7/8" H-Coat Flat Washer	8
	48718-125	<b>U-bolt Service Kit, One Wheel End</b> , Includes Key Nos. 9-11		34		*7/8"-14 UNF-2B Locknut	4
9		*3/4" Square U-bolt, 10 3/8" Length	8	35	49689-000L	Shim	As Req.
10		*3/4" Flat Washer	16	36	67045-XXX	Torque Rod Spacer, <i>See Selection Guide on Page 5</i>	
11		*3/4"-16 UNF U-bolt Locknut	16	37	72000-XXS	<b>**ULTRA ROD® PLUS™</b> Transverse Torque Rod Assembly, Includes Key No. 38, Specify length in mm	2
12	60556-XXX	Bottom Cap - Front and Rear, <i>See Selection Guide on Page 4 and 5</i>	4	38	64400-002L	Bushing - Straddle Bar Pin (5/8" Holes)	4
13	65139-003	Axle Spacer	4	39	22186-000	Transverse Torque Rod Frame Bracket	2
14		****U-beam Assembly, Includes Key Nos. 2, 15 <i>(Replaces previous U-beam assembly, support beam and cross tube assembly, See Replacement Guide below)</i>	2	40	60593-000L	Axle Stop, Frame Mounted	4
	34013-107	<b>Single D-Pin Bushing Service Kit</b> , Includes Key Nos. 15, 16a, 17-18		41	60657-003L	Shock Absorber	4
	34013-116	Includes Key Nos. 15, 16b, 17-18		42	67463-002	Upper Shock Frame Bracket, <i>Replaces 65000-002</i>	4
	34013-117	Includes Key Nos. 15, 16c, 17-18			50754-030	<b>Single Shock Fastener Service Kit</b> , Includes Key Nos. 43-48	
15		*D-Pin Bushing	4	43		*3/4"-10 UNC x 4 1/4" Upper Shock Bolt	4
	56659-009	<b>D-Pin Fastener Service Kit, Axle Set</b> , Includes Key Nos. 16a, 17-18		44		*3/4" Flat Washer	4
	56659-013	Includes Key Nos. 16b, 17-18		45		*3/4"-10 UNC Locknut	4
	56659-012	Includes Key Nos. 16c, 17-18		46		*5/8"-11 UNC x 6" Lower Shock Bolt	4
16		*3/4"-16 UNF Bolt	8	47		*5/8" Flat Washer	8
a		5" Length		48		*5/8"-11 UNC-2B Locknut	4
b		5 1/2" Length		49	60921-000	Height Control Valve Linkage Bracket	2
c		4 3/4" Length		50	64508-XXX	S-cam Support Bracket, <i>Locate part number on component</i>	4
17		*3/4" Flat Washer	16		58821-017	<b>S-cam Fastener Service Kit, Axle Set</b> , Includes Key Nos. 51-56	
18		*3/4"-16 UNF Locknut	8	51		*3/8"-16 UNC x 1 1/4" Hex Bolt	8
19		****Support Beam Assembly (66435-xxx, <i>See Replacement Guide below</i> )		52		*3/8" Hardened Washer	16
20		****Cross Tube (60912-xxx, <i>See Replacement Guide below</i> )		53		*3/8"-16 UNC Locknut	8
	46772-001	<b>End Cap and Fastener Kit, Axle Set</b> , Includes Key Nos. 21-23		54		*5/16" S-cam U-bolt	4
21		*End Cap	4	55		*5/16" Hardened Washer	16
22		*7/8"-9 UNC x 3 1/2" Hex Bolt	4	56		*5/16"-18 UNC Locknut	8
23		*7/8" H-Coat Flat Washer	4	57	70867-001	P-80 Lubricant - 10 ml (Not Shown) per Bushing 1	

## Support Beam and Cross Tube Replacement Guide

Key Nos. 19, 20	DISCONTINUED May 2010				NEW		
	Support Beam Assembly Part Number				Cross Tube Part No.	U-beam Assembly Service Kit No.	
	60831-00X • 66435-00X				60912-XXX	60961-XXX	
*Frame Width (Inches)	LH Forward	LH Rear	RH Forward	RH Rear		Forward	Rear
34.3					-003	-261	-262
34.5	-003	-001	-004	-002	-002	-263	-264
34.8					-009	-243	-244

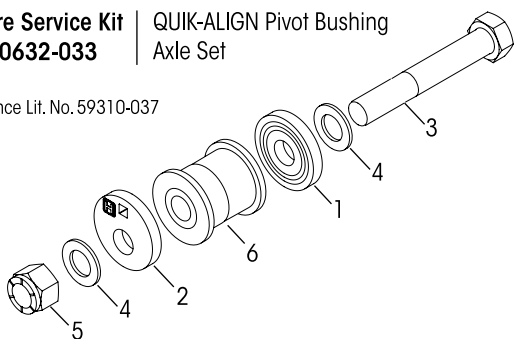
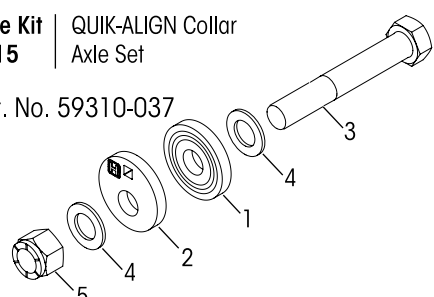
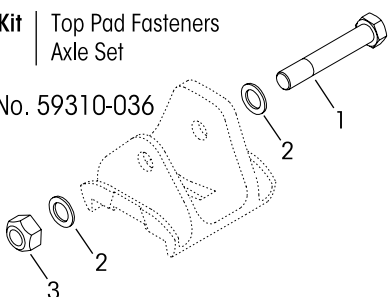
**NOTE:** \*Contact vehicle manufacturer to verify frame width.



## U-beam Assembly Aftermarket Service Kit

Service Kit No. 69565-001, Axle Set			
PART NO.	DESCRIPTION	QTY.	COMMENTS
69351-000	Sikaflex 221 Polyurethane Sealant, 300 ml Tube	1	In the event any service to the suspension requiring disassembly of a U-beam assembly equipped with integrated end caps, the Loctite 277, tamper resistant caps and Sikaflex 221 polyurethane sealant must be properly installed to ensure components function to their highest efficiency.
69570-000	Loctite® 277 - 10 ml Bottle	1	
*	Tamper Resistant Cap	2	
*	7/8"-9 UNC x 3 3/4" Hex Bolt	2	
*	7/8" H-Coat Flat Washer	2	

## Severe Service Kits

<p><b>Severe Service Kit No. 60632-033</b>   QUIK-ALIGN Pivot Bushing Axle Set</p> <p>Reference Lit. No. 59310-037</p> 	<p><b>KIT NO. 60632-033</b> PRIMAAX EX, PRIMAAX – 9", 10½", 13" Ride Height</p> <table border="1"> <thead> <tr> <th>KEY NO.</th> <th>CONTENTS</th> <th>KIT QTY.</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>QUIK-ALIGN Concentric Collar</td> <td>2</td> </tr> <tr> <td>2</td> <td>QUIK-ALIGN Eccentric Collar</td> <td>2</td> </tr> <tr> <td>3</td> <td>1 ¼"-12 UNF Bolt - 8"</td> <td>2</td> </tr> <tr> <td>4</td> <td>1 ¼" Hardened Washer</td> <td>4</td> </tr> <tr> <td>5</td> <td>1 ¼"-12 UNF Nylocknut</td> <td>2</td> </tr> <tr> <td>6</td> <td>QUIK-ALIGN Pivot Bushing</td> <td>2</td> </tr> <tr> <td>7</td> <td>P-80 Bushing Lubricant - 10 ml.</td> <td>per Bushing 1</td> </tr> </tbody> </table>	KEY NO.	CONTENTS	KIT QTY.	1	QUIK-ALIGN Concentric Collar	2	2	QUIK-ALIGN Eccentric Collar	2	3	1 ¼"-12 UNF Bolt - 8"	2	4	1 ¼" Hardened Washer	4	5	1 ¼"-12 UNF Nylocknut	2	6	QUIK-ALIGN Pivot Bushing	2	7	P-80 Bushing Lubricant - 10 ml.	per Bushing 1
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1	QUIK-ALIGN Concentric Collar	2																							
2	QUIK-ALIGN Eccentric Collar	2																							
3	1 ¼"-12 UNF Bolt - 8"	2																							
4	1 ¼" Hardened Washer	4																							
5	1 ¼"-12 UNF Nylocknut	2																							
6	QUIK-ALIGN Pivot Bushing	2																							
7	P-80 Bushing Lubricant - 10 ml.	per Bushing 1																							
<p><b>Severe Service Kit No. 60632-015</b>   QUIK-ALIGN Collar Axle Set</p> <p>Reference Lit. No. 59310-037</p> 	<p><b>KIT NO. 60632-015</b> PRIMAAX EX, PRIMAAX – 9", 10½", 13" Ride Height</p> <table border="1"> <thead> <tr> <th>KEY NO.</th> <th>CONTENTS</th> <th>KIT QTY.</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>QUIK-ALIGN Concentric Collar</td> <td>2</td> </tr> <tr> <td>2</td> <td>QUIK-ALIGN Eccentric Collar</td> <td>2</td> </tr> <tr> <td>3</td> <td>1 ¼"-12 UNF Bolt - 8"</td> <td>2</td> </tr> <tr> <td>4</td> <td>1 ¼" Hardened Washer</td> <td>4</td> </tr> <tr> <td>5</td> <td>1 ¼"-12 UNF Nylocknut</td> <td>2</td> </tr> </tbody> </table>	KEY NO.	CONTENTS	KIT QTY.	1	QUIK-ALIGN Concentric Collar	2	2	QUIK-ALIGN Eccentric Collar	2	3	1 ¼"-12 UNF Bolt - 8"	2	4	1 ¼" Hardened Washer	4	5	1 ¼"-12 UNF Nylocknut	2						
KEY NO.	CONTENTS	KIT QTY.																							
1	QUIK-ALIGN Concentric Collar	2																							
2	QUIK-ALIGN Eccentric Collar	2																							
3	1 ¼"-12 UNF Bolt - 8"	2																							
4	1 ¼" Hardened Washer	4																							
5	1 ¼"-12 UNF Nylocknut	2																							
<p><b>Severe Service Kit No. 58821-026</b>   Top Pad Fasteners Axle Set</p> <p>Reference Lit. No. 59310-036</p> 	<p><b>KIT NO. 58821-026</b> Top Pad Thru Bolt Style Only Does Not Include Top Pad</p> <table border="1"> <thead> <tr> <th>KEY NO.</th> <th>CONTENTS</th> <th>KIT QTY.</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>M24 x 3.0-6G H-coat Hex Bolt</td> <td>2</td> </tr> <tr> <td>2</td> <td>M24 Hardened Washer</td> <td>4</td> </tr> <tr> <td>3</td> <td>M24 x 3.0-6H Locknuts</td> <td>2</td> </tr> </tbody> </table>	KEY NO.	CONTENTS	KIT QTY.	1	M24 x 3.0-6G H-coat Hex Bolt	2	2	M24 Hardened Washer	4	3	M24 x 3.0-6H Locknuts	2												
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**NOTES:** Quantities specified are shown for a tandem suspension. Adjust quantities for single or tridem suspensions. Quantities of service kit components may vary from amount shown in lists.

\* Item included in assembly / kit only, part not sold separately.

\*\* Transverse Rods are mandatory for the PRIMAAX EX • PRIMAAX suspensions regardless of axle spacing, see Literature No. 59310-004 and 59310-058 for more information.

\*\*\* Alternate configuration of the QUIK-ALIGN fasteners. The locknuts located inboard will allow additional clearance for wider tires or tires with chains. Tightening is still required ONLY on the locknut.

\*\*\*\* No longer available for service, See Replacement Guide on Page 13. For more information, refer to Hendrickson Technical Bulletin Literature No. SEU-0229 or contact Hendrickson Tech Services.

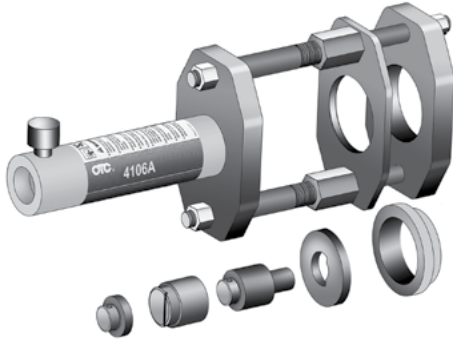


### Special Tools

#### D-PIN / QUIK-ALIGN PIVOT BUSHING SERVICE TOOLS

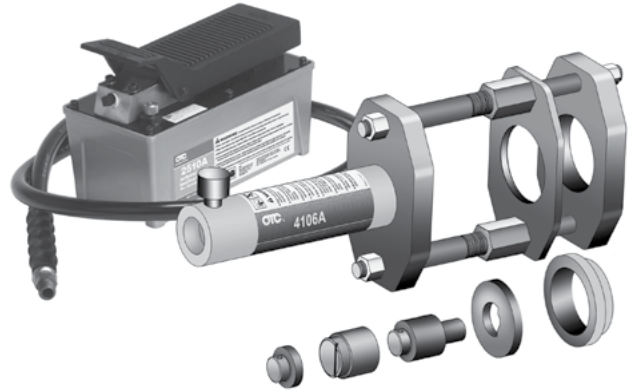
Hendrickson Part No. 66086-202

OTC Part No. 4246 Visit [otctools.com](http://otctools.com)



Hendrickson Part No. 66086-204

OTC Part No. 4247 Visit [otctools.com](http://otctools.com)

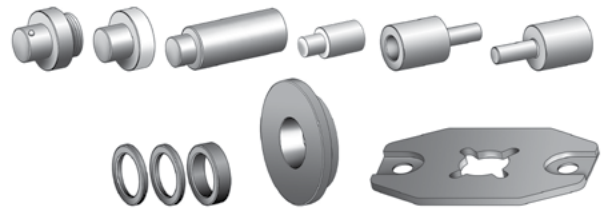


Hendrickson Part No. 66086-205

OTC Part No. 4254

Visit [otctools.com](http://otctools.com)

**NOTE:** In conjunction with Hendrickson Part No. 66086-204 (OTC 4247) this additional adapter tool kit is available to purchase to be used on Hendrickson SOFTEK NXT suspension (not needed for this suspension).



#### QUIK-ALIGN PIVOT BUSHING SERVICE TOOL

Hendrickson Part No. 66086-203L

Reference Literature No. 59310-061



#### QUIK-ALIGN SOCKET TOOL

Hendrickson Part No. 66086-200

OTC Part No. 1767

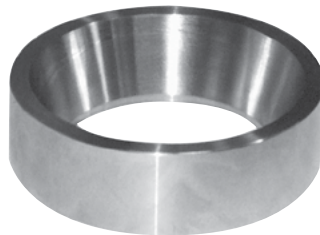
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#### TORQUE ROD BUSHING FUNNEL TOOL

ULTRA ROD PLUS

Hendrickson Part No. 66086-000



#### QUIK-WRENCH TOOL

Hendrickson Part No. 66086-201

OTC Part No. 1768

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This is a general parts list to provide directional information. Components may vary by model. Questions in regards to parts, contact Hendrickson Truck Parts at 1.866.755.5968 (Toll-free U.S. and Canada), 1.630.910.2800 (Outside U.S. and Canada) or e-mail: [truckparts@hendrickson-intl.com](mailto:truckparts@hendrickson-intl.com).

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[www.hendrickson-intl.com](http://www.hendrickson-intl.com)

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Truck Commercial Vehicle Systems  
800 South Frontage Road  
Woodridge, IL 60517-4904 USA

1.866.755.5968 (Toll-free U.S. and Canada)  
1.630.910.2800 (Outside U.S. and Canada)  
Fax 1.630.910.2899