

REMOVAL

- Use established procedures for teardown.

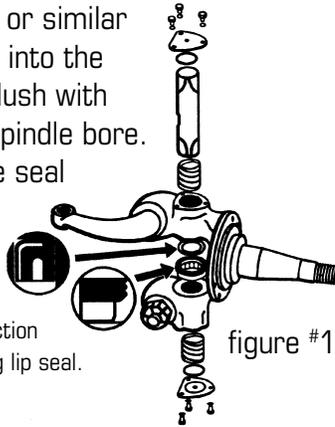
STEERING KNUCKLE AND AXLE PREPARATION

- Clean spindle and axle eyes, wipe dry.
- Remove any burrs from spindle bores and axle eyes using brake hone or similar device.

INSTALLING BUSHING LIP SEALS

- Handle with care, lip seals are easily damaged.
- Using a bushing driver or similar device, drive the seals into the bore leaving the seal flush with the axle side of each spindle bore.
- Be sure to position the seal so the lip is pointing towards the axle eye. (see figure #1)

Cross section of bushing lip seal.



SPECIAL INSTRUCTIONS FOR INSTALLING SPIRAL BUSHING ASSEMBLY

- Using the STEMCO Kaiser™ bushing driver specifically designed for the kit, drive both bushings into bores.

CHECK BEFORE ASSEMBLY

- Wipe bushings clean.
- Using king pin check for fit, first insert pin into each bushing individually then insert pin into both bushings, king pin should slide through both bushings simultaneously.
- If pin fits through bushings individually but not simultaneously the spindle has spread and may need replacement.

BEARING INSTALLATION

- Prepack bearings with grease.

- For proper bearing orientation refer to figure #1.
- Place needed shims under upper spindle bore.
- Position king pin through upper spindle bore and through needed shims, be sure TOP of pin is parallel to axle for proper lock flat alignment.
- Place spindle, shims and pin into axle, allow pin to drop into axle bore about 2".
- Tap bearing into place, a properly fit bearing will require a slight tap fit without damaging the bearing case.
- If bearing is too tight or too loose, adjust the number of shims being used.
- When working on an application where the bearing has a shoulder, the bearing must be installed before the shims.

COMPLETE PIN INSTALLATION

- Once the bearing fit is correct, allow pin to slip into lower bushing.
- Position lock pin flats on pin so they line up with lock holes.
- Pound lock pins into place, lock pins with threads apply 25-30 ft. lbs of torque.

END PLATE OR END PLUG INSTALLATION

- Install end plates or end plugs, using the proper seal under plates.
- Install grease fitting into end plate or end plug.

GREASING

- Apply grease until it can be seen between axle and spindle.

CHECK INSTALLATION

- Once greased the spindle should turn easily from side to side.
- There should be very little up and down movement.
- If unit seems loose or too tight we recommend calling our tech line for assistance.

Customer Service - www.stemcokaiser.com or 888-854-6474



The first step in using STEMCO Kaiser products is SAFETY FIRST SAFETY ALWAYS. Please take a moment to make sure these safety precautions are in place. Some components are heavy! For your protection wear safety shoes, safety glasses, safety gloves, use proper lifting techniques and secure the unit before work begins.



4641 Industrial Drive, Millington, MI 48746 • 888-854-6474 • Fax: 989-871-4640