Tech Tip #101
STEMCO Kaiser 50.121.08 INSTALLATION NOTES

APPLICATION
This Tech Tip applies to the following products:

<table>
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<th>Hendrickson® FRONT STEER AXLES:</th>
<th>STEMCO Kaiser KINGPIN KITS:</th>
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<td>Airtek; Softek (60961-040)</td>
<td>Kingpin ECONOkit™ (50.121.08)</td>
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Due to the unique design of the axle you are working on it is recommend that you refer to the axle manufacturer’s installation instructions. The axle manufacturer recommends the kingpin on this axle never be removed. Therefore, a kingpin change implies changing the bushings and bearings only. Due to this design, reaming the bushing will always be required! In addition to the axle manufacturer’s instructions, please refer to the following notes:

(1) Clean Up the Kingpin Ends.
It is likely that the kingpins have developed a unique wear pattern. Both ends of the kingpin quite possibly have a noted raised area (lip). Remove the raised lip from the kingpin. This raised area (lip) on the kingpin must be removed prior to sizing the bushings. Refer to Figures A and B below.
WARNING: Not removing the raised area on the kingpin may cause errors with reaming.

(2) Install & Ream the Kingpin Bushings to Size.
- Install the kingpin bushings into the spindle bores.
- Size the kingpin bushings with the appropriate measurement device.
- Ream the kingpin bushings per the axle manufacturer’s instructions.
  (This includes reassembling the 2-piece spindle using the 4 bolts for proper alignment.)
- Prior to installation, check for appropriate bushing/ kingpin fit.