

**Tech Tip #101**

**STEMCO Kaiser 50.121.08 INSTALLATION NOTES**

**APPLICATION**

This Tech Tip applies to the following products:

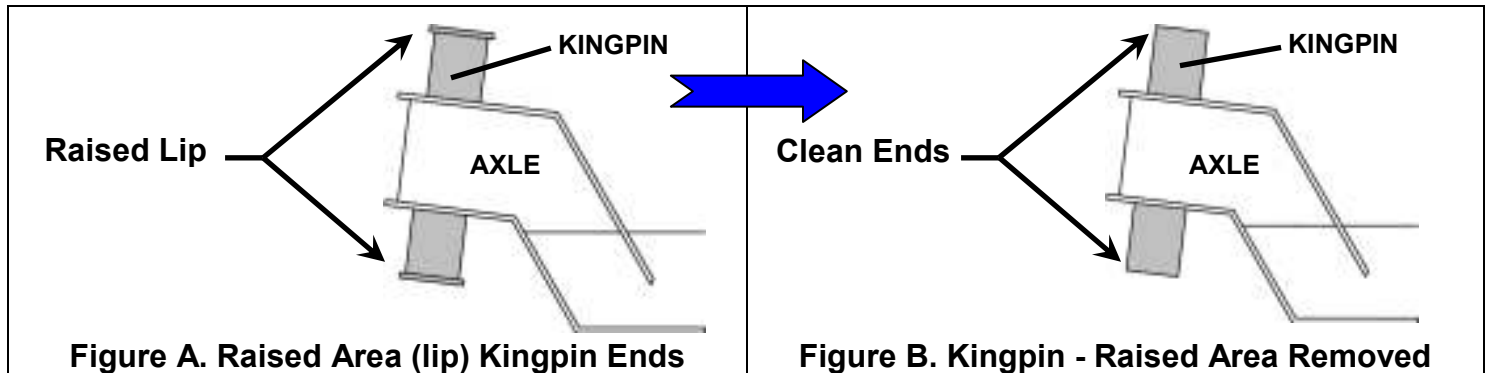
<p>Hendrickson® <b>FRONT STEER AXLES:</b> Airtek; Softek (60961-040)</p>	<p>STEMCO Kaiser <b>KINGPIN KITS:</b> Kingpin ECONOkit™ (50.121.08)</p>
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Due to the unique design of the axle you are working on it is recommend that you refer to the axle manufacturer’s 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.