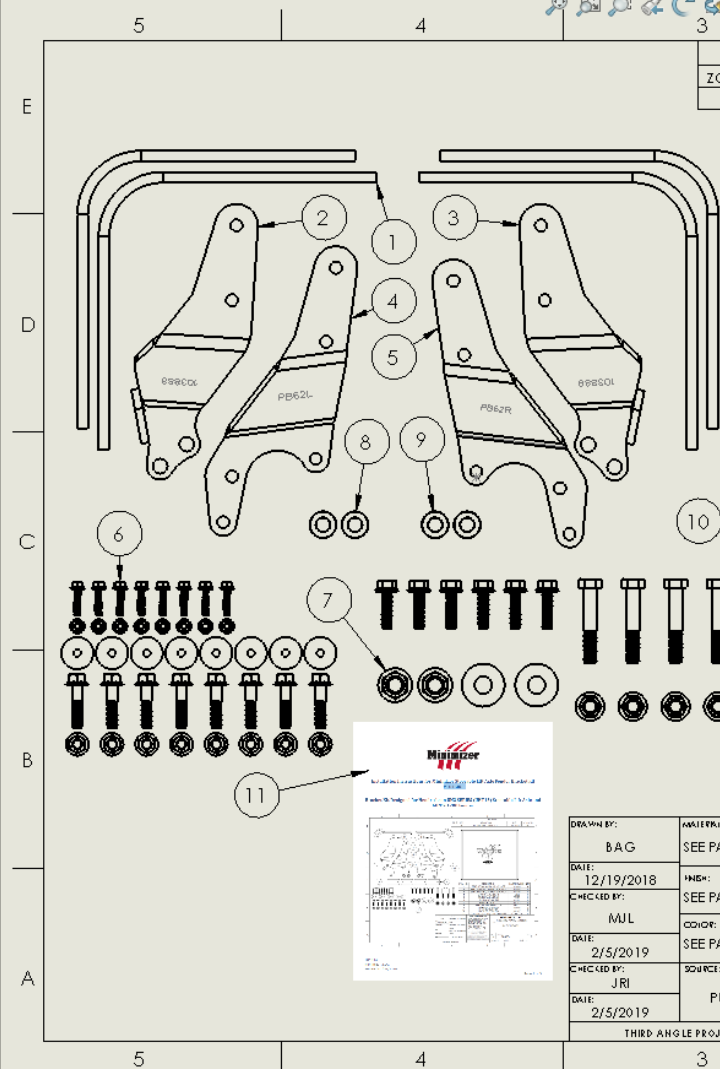
	Document Title:			Document #	Revision:
	Installation Instructions For Fender Bracket Kit 104386			104443	A
	Created By:	Checked By:	Effective Date:	DCN #	Page 1 of 3
Bob Grunklee	MJL	04/04/2019	200		

Installation Instructions for Minimizer Steerable Axle Fender Bracket kit #104386

Bracket Kit is Designed for Hendrickson SERIES UHT13 Steerable Lift Axle and Model MIN161200 Fender



REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
A		RELEASED FOR PRODUCTION	2/19/2019	BAG

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	101043	BRKT,LIFTAXL,ALUM.,5X13X13,SR	4
2	103888	BRKT,LIFTAXL-UHT13,LH,WLDMNT	1
3	103889	BRKT,LIFTAXL-UHT13,RH,WLDMNT	1
4	PB62L	BRKT,LIFTAXL-62L,STL	1
5	PB62R	BRKT,LIFTAXL-62R,STL	1
6	101559	HDWR-K,LIFTAXL,RBZ	1
7	104383	HDWR-K,LIFTAXL-UHT13	1
8	103908	HDWR,SPCR,STL,RND	2
9	103907	HDWR,SPCR,STL,RND	2
10	XLIFTAXLED/C BOX,21X19X5,CRBRD,ECT40,MNZR		1
11	104443	BRKT-K,LIFTAXL-UHT13,INST	1

DRAWN BY: BAG	DATE: 12/19/2018	CHECKED BY: MJL	DATE: 2/5/2019	APPROVED BY: JRI	DATE: 2/5/2019	UNLESS OTHERWISE SPECIFIED UNIT OF MEASUREMENTS: INCHES ZERO PLACE DECIMAL ±.1 ONE PLACE DECIMAL ±.1 TWO PLACE DECIMAL ±.05 THREE PLACE DECIMAL ±.020 ANGLE TOLERANCE: ONE PLACE DECIMAL ±.5° TWO PLACE DECIMAL ±.2° WEIGHT UNIT OF MEASURE: LBS.	MINIMIZER, L.L.C. BLOOMING PRAIRIE, MN 55917 DESCRIPTION: BRKT-K,LIFTAXL-UHT13	SEE: A	PART NO. 104386	REV: A
THIRD ANGLE PROJECTION						PROPERTY AND CONFIDENTIAL FOR COMPANY USE ONLY. NO REUSE OR REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF MINIMIZER, L.L.C.	SCALE: 1X	WEIGHT: 42	SHEET 1 OF 1	

Installation Steps

1. Remove wheels and the brake drums
2. Remove the two 5/8" locknuts and bolts on the rear side of the spindle and discard.
3. Remove and discard the 3/4" nut on the steering arm that attaches the stabilizer to the bump stop bracket (Support the stabilizer so it stays engaged when removing nut).



Document Title:
Installation Instructions For Fender Bracket Kit 104386

Document #
104443

Revision:
A

Created By:
Bob Grunklee

Checked By:
MJL

Effective Date:
04/04/2019

DCN #
200

Page 2 of 3

4. Replace the spindle bolts (step 2) with 5/8-11 X 3 ½ bolts (provided in PN # 104383 hardware kit).
5. Install spacers (provided in kit) on the bolts from step 4 prior to installing brackets. Use PN# 103908 (longer) spacer on the upper bolt, use PN 103907 (shorter) spacer on the lower bolt.
6. Install the PN#103889 bracket RH & PN# 103888 LH against the spacers as shown in Figure 1. Ensure that welded on tab of brackets sits directly on top of bump stop. Fasten with the 5/8 -11 locknuts (provided in PN #104383 hardware kit) and tighten to axle manufacturer's specification.
7. Install a new ¾ flat washer along with a ¾ flange locknut (provided in PN # 104383 hardware kit) and tighten to the axle manufacturer's specification.
8. Remove and discard (3) of (4) the ½" bolts from cam tube flange at the locations shown in Figure 2.
9. Install the PB62L and PB62R brackets to the cam flange as shown in Figure 2. Use the ½-13 x 1.75 flange bolts (provided in PN #104383 hardware kit) and tighten per axle manufacturer's specifications.
10. Re-install the brake drums.
11. Re-install wheels.
12. Place a 1 ½" shim centered on the top of the tire. Place the fender on the shim centered on the tire.
13. Clamp the aluminum arms (PN 101043) in place. As a starting point, rest the face of aluminum arm against the fender, and align the top edge of the of the aluminum arm with the top edge of the brackets installed in previous steps. See Figure 3.

STEP 4
INSTALLING
BOLTS

STEP 5
INSTALLING
SPACERS

STEP 6
INSTALL REAR
BRACKETS

STEP 7
INSTALLING
HARDWARE

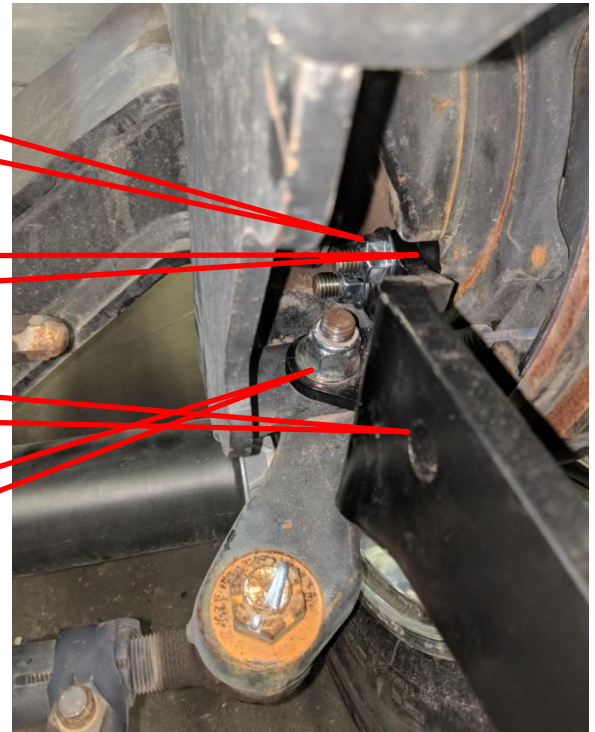


Figure 2 – Rear View of Lift Axle

STEP 9
INSTALL FRONT
BRACKETS

STEP 9
REPLACE WITH ½-13x1.75
FLANGE BOLTS

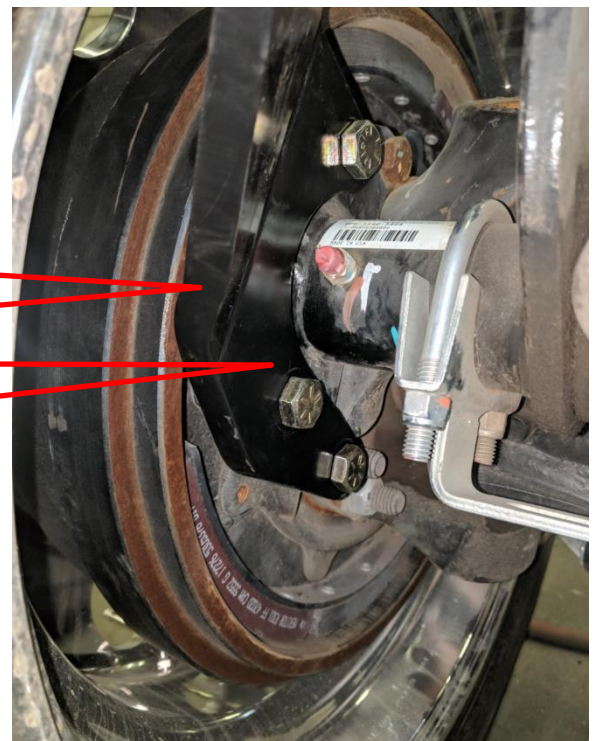



Figure 1 - Front View of Lift Axle

	Document Title:			Document #	Revision:
	Installation Instructions For Fender Bracket Kit 104386			104443	A
	Created By:	Checked By:	Effective Date:	DCN #	Page 3 of 3
Bob Grunklee	MJL	04/04/2019	200		

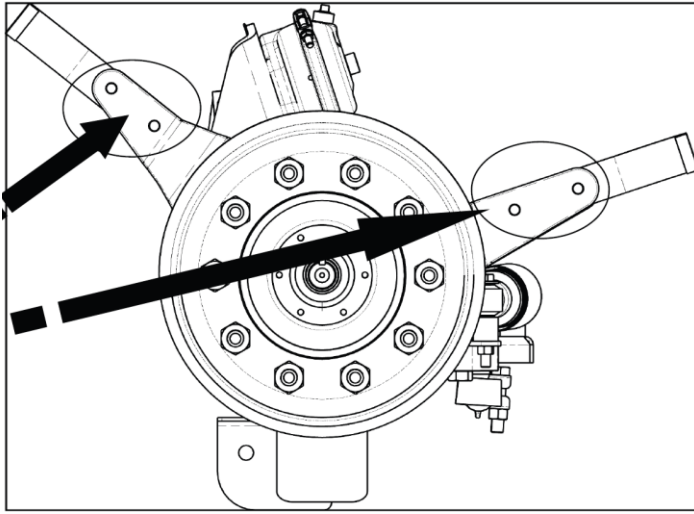


Figure 3 – Outside View of Bracket Assembly

14. Adjust the position of fender and aluminum arms as desired.
15. Cut the aluminum arms (Part # 101043) to length if needed (arms may be too long depending on the application).
16. As shown in Figure 3 use the holes in the steel brackets as a template to mark the mounting hole locations for the aluminum arms
17. Attach aluminum arms using the 1/2" x 2" flange head bolts provided in hardware kit 101559.
18. Clamp the fender under the aluminum arms as shown in Figure 4.



Figure 4 – Front View of Lift axle with fender

19. Mark and drill two 11/32" diameter holes thru each arm and into the fender. Use 5/16" bolts w/self-locking nuts as shown in Figure 4 (provided in hardware kit 101559).
20. Tighten the 5/16-18X1-1/4 bolts to a recommended torque of 5-7 ft.-lbs. Do not exceed the recommended torque.