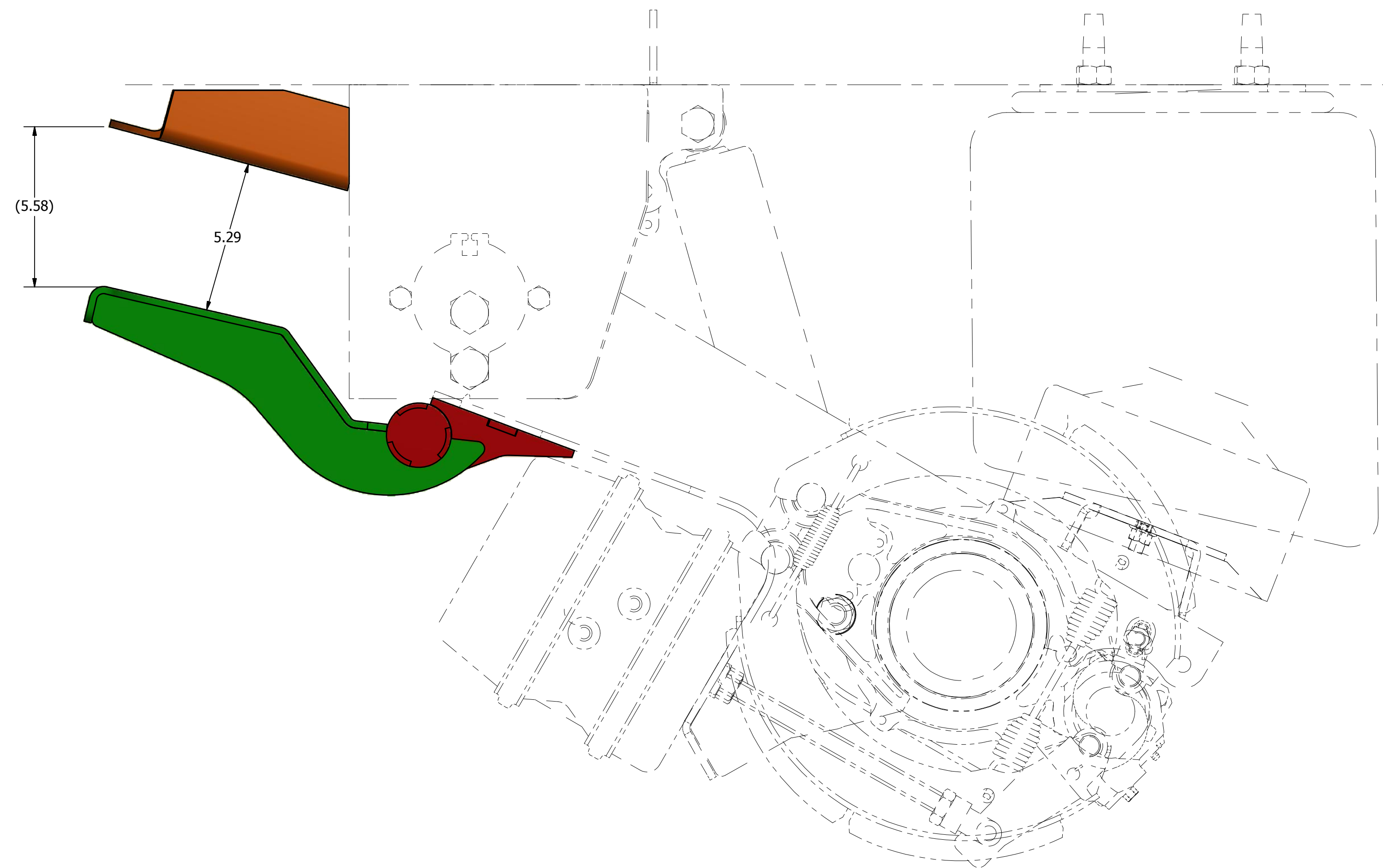
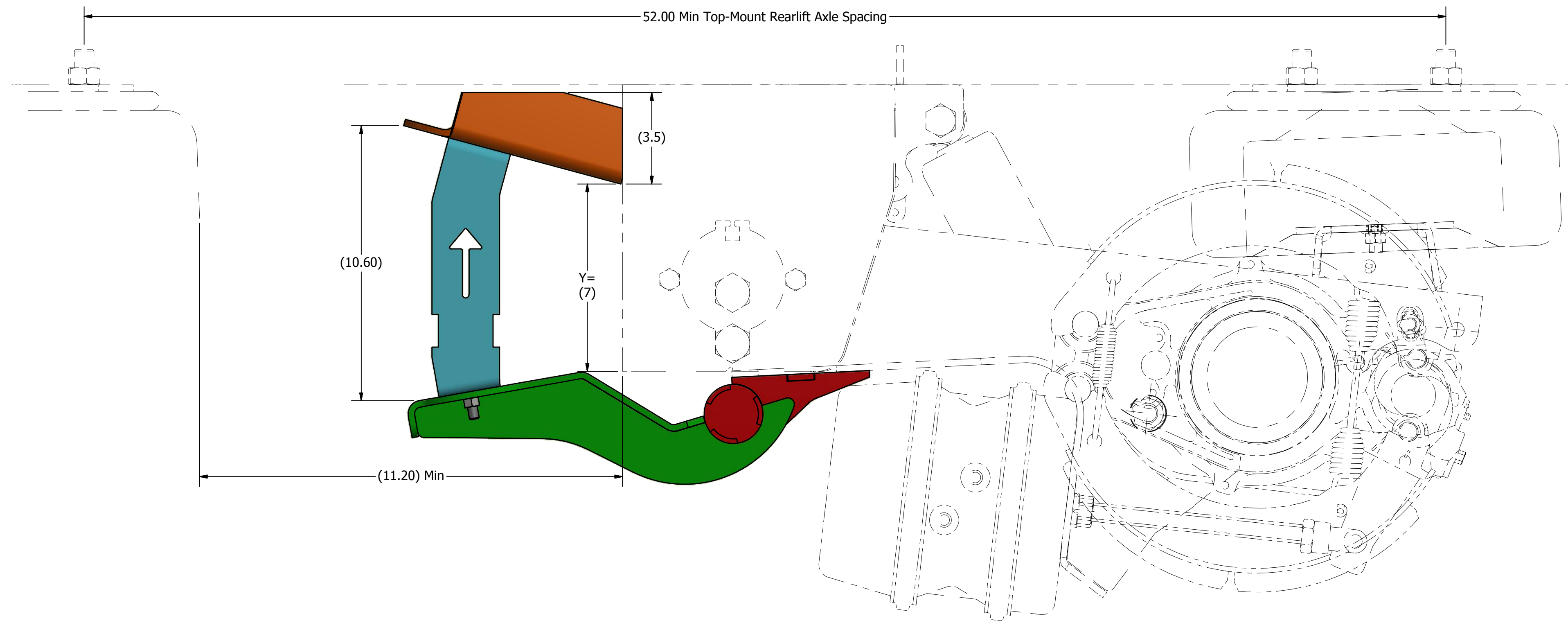


Ref for Rear Lifmount
 54.5 Min for Lowmount
 49 Min for Topmount Spacing
 (Customer to Verify Fit Before Mounting)



Universal Mounting w/
 Rotating Bracket Support Base

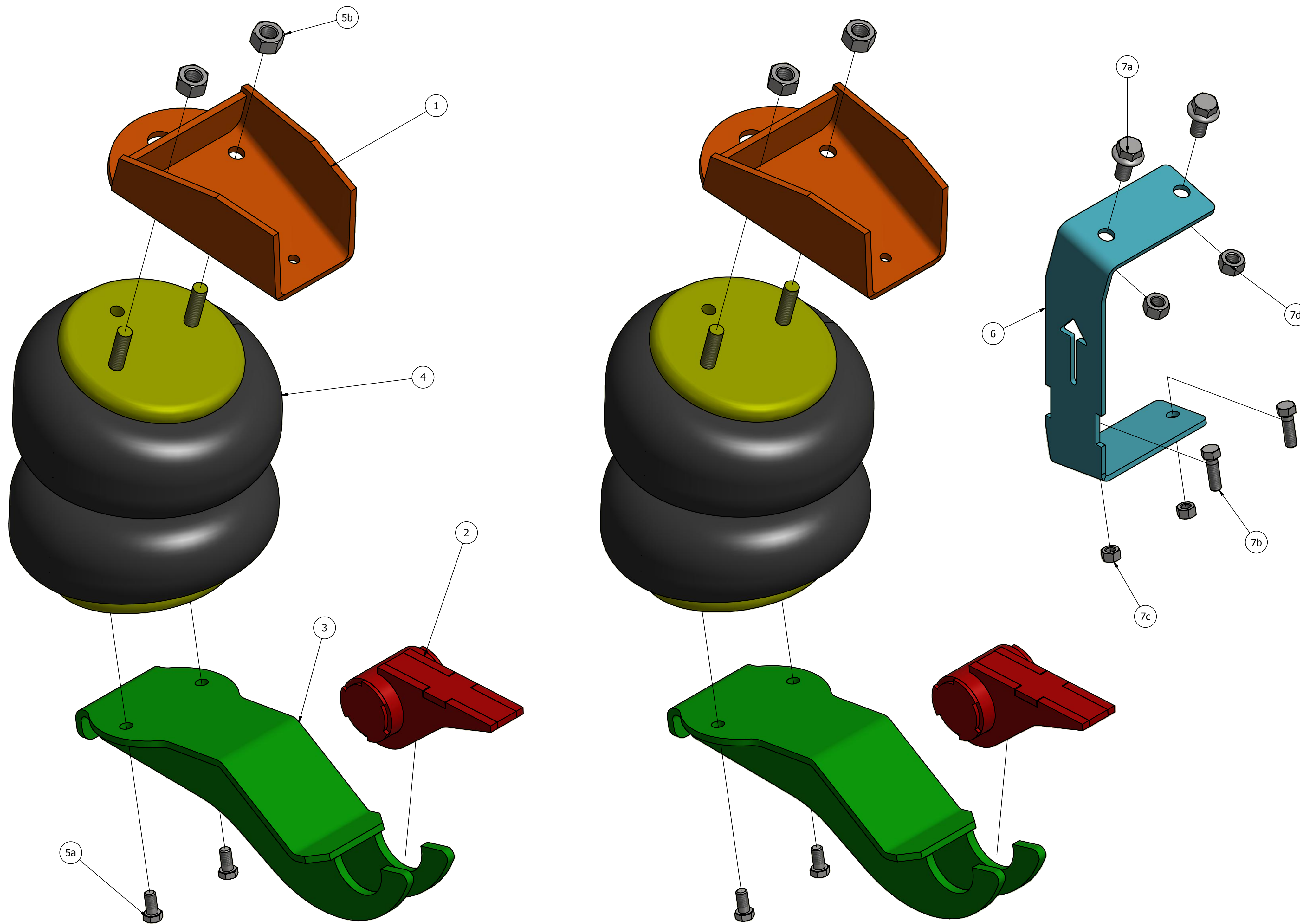
To Fit
 Hendrickson
 Saf
 Ridewell
 Cush
 Watson
 and More

Note: Cush suspension w/ 12.25" brakes take a shorter fixture bracket (B1716) Y=5 1/2" for best clearance.

DCN#	REV	REVISION DESCRIPTION	DATE	BY	CHK	APP
DRAFTSMAN: DWalker	01/16/2015	TITLE:				
CHECKED: CHK		Cush Air Liftkit - Universal Mount Hanger and Beam Mounted No Hanger Cutting Required				
RELEASED: APP						
WEIGHT: N/A						
MATERIAL:						
All of the Information shown herein is the intellectual property of Cush Corp and is submitted only on a confidential basis. The recipient agrees that no disclosure of this information will be made to a third party without written consent of Cush Corp.		TOLERANCE UNLESS OTHERWISE STATED: XX = +/- .002 FRACTIONS = +/- .116 XXX = +/- .031 ANGLES = +/- .1°		PROJECT NO:		15132
		SCALE:		SHEET:		1 OF 2
		A-SIZE: NTS B-SIZE: 1/X D-SIZE: 1/2		REV:		-
		PART/DRAWING NO:		CAL-50U		



Nixa, MO, USA
 PHONE: 417-724-1239
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Item	Description	P/N	Qty
1	Air Spring Support	W0827	2
2	Beam Lift Base	W1329	2
3	Lift Arm	W1110	2
4	Air Spring, Goodyear 2b9-251 (2B9-206)	C0080	2
5	Air Spring Mounting Kit	K0031	1
5a	HHCS, Flangelock 3/8"-16 UNC x 1" Long	H0401	4
5b	L'Nut 1/2"-13 UNC	H1301	4
6	Quick Fit Location Bracket (10.6" Tall)	B1704	1
7	Bolt Kit for Location Bracket	K0601	1
7a	HHCS Flangelock 1/2"-13 UNC x 1" Long	H0304	2
7b	HHCS 3/8"-16 UNC x 1" Long	H0701	2
7c	Hex Nut 3/8"-16 UNC, Plain	H1403	2
7d	Hex Nut 1/2" -13 UNC, Plain	H1304	2

- For 16 1/2" Brakes
- Step 1
Used enclosed fasteners to assemble Location Fixture (Item 6) to Air Spring Support (Item 1).
 - Step 2
Now assemble Lift Arm (Item 3) to Location Fixture (Item 6).
 - Step 3
Dump air in suspension system and lift (jack if necessary) axle to maximum lift position
 - Step 4
Set Beam Lift Base (Item 2) in cradle of Lift Arm (Item 3).
 - Step 5
Properly position Location Fixture with assembled Air Spring Support (Item 6) and Lift Arm (Item 3) on suspension hanger then tack weld. Note: For 12 1/4" Brakes Use (Item #6) fixture B1716 and a Dimension of Y=5 1/2"
 - Step 6
Rotate Beam Lift Base (Item 2) to proper position on air suspension beam and tack weld.
 - Step 7
Weld Air Spring Support (Item 1), Lift Arm (Item 3), and Beam Lift Base (Item 2) all around. Repeat Steps 1-6 for other side of suspension.
 - Step 8:
After welds have cooled, remove Location Fixtures (Item 6) and install Air Springs (Item 4).

*See enclosed Cush Drawing CAL-50U Weld Procedures and more technical information.

RECOMMENDED STEEL WELDING PROCEDURES:

WARNING: If these procedures and specifications are not followed, damage to the axle or suspension could result. The resulting axle or suspension damage could cause an accident, property damage, and/or serious injury.

NOTE: A welder qualified in 2G position per ANSI/AWS D1.1-94 Section 5 Part C "Welder Qualification" must perform the welding.

NOTE: The specification shown below is for horizontal (2F) positioning.

- 1) Suspension components and their mating parts must be at a minimum temperature of 60°F(15.5°C) and free from moisture, dirt, scale, paint, grease, and other contaminants.
- 2) All welds must be performed in a flat, or horizontal, position.
- 3) Achieve spray arc transfer with the following welding parameters:

Standard Electrode: AWS E-7018(Oven Dried), 0.125"DIA., 120-140 AMPS D.C., Electrode positive.

Standard Wire: AWS ER-70S-6, 0.045"DIA

Volts: 26-30 DCRP

Current: 275-325 AMPS

Wire Feed Speed: 380-420 Inches per Minute

Electrode Extension: 0.75" to 1"

Gas: 86%AR 14%CO2 at 30 to 35 CFH

Any deviation from these welding parameters must be approved by Cush Corporation in writing.

Customer to torque all fasteners!				(Ft*Lbs)		(Nm)	
General Fastener Torque Specs	Size	Thread	Grade	Min.	Max.	Min	Max.
Air Spring Mount Bolt	3/8	16-UNC	5/B	25	35	34	47
Air Spring Bottom Mount Nut	1/2	13-UNC	5/B	25	35	34	47
Brake Chamber Mounting Nut	5/8	11-UNC	5/B	100	110	136	149

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PROJECT NO:	SHEET:	SCALE:	REV:	PART/DRAWING NO:		
15132	2 OF 2	A-SIZE: NTS B-SIZE: 1/X D-SIZE: 1/2	-	CAL-50U		



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