

CUSH GENERAL INSTALLATION NOTES, SEE CUSH SERVICE/INSTALLATION MANUAL

- INSTALLATION DISCLAIMER NOTES:**
- The suspension is chosen for the trailer application. The following criteria must be considered when selecting a suspension: required suspension capacity, loaded frame-to-ground measurement, ride height, axle travel, axle spacing, and axle GAWR.
 - It is the responsibility of the installer to determine the correct location of the suspension in order to provide the proper trailer load distribution. The gross axle weight rating (GAWR) of each axle must not exceed the rated capacity of any of the components involved. The suspension capacity ratings are for suspension components and axle beam only.
 - Repairs and modifications may be required. Actual size and shape may vary per trailer design. It is the responsibility of the suspension installer to ensure structural adequacy of the trailer frame and cross members. Verify that the actual trailer cross member locations correspond with those specified on the suspension drawing.
 - It is the responsibility of the suspension installer to read the instructions on all the drawing sheets thoroughly before proceeding with a suspension installation.
- CUSTOMER TORQUE INSTRUCTIONS:**
- "DUAL RATE PIVOT BUSHING JOINT" SNUG FROM FACTORY. CUSTOMER TO TORQUE THIS JOINT TO SPECIFICATION AFTER AXLE ALIGNMENT.
 - It is the customer's responsibility to check and tighten fasteners to specified torque at installation, after clamping contact CUSH for replacement fasteners.
 - Torque values given are specified for the fasteners in the condition supplied by CUSH Corporation. DO NOT APPLY ANY ADDITIONAL LUBRICANTS.
 - CAUTION: Fasteners should never be reused if removed or loss of clamp load occurs. For proper joint clamping contact CUSH for replacement fasteners.
 - CAUTION: Over-torquing fasteners could result in material failure.

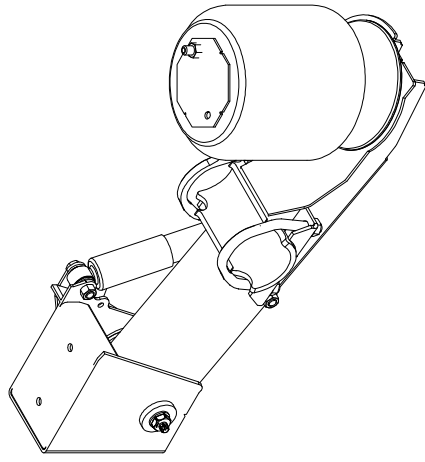
Customer to torque all fasteners!

General Fastener Torque Specs	Size	Thread	Grade	(Ft/Lbs)		(Nm)	
				Min.	Max.	Min.	Max.
Air Spring Bottom Mount Nut	1/2	13-UNC	5/B	25	35	34	47
Air Spring Bottom Mount Bolt	1/2	13-UNC	5/B	40	50	54	68
Air Spring Top Mount Nut	3/4	16-UNF	5/B	40	50	54	68
Shock Mount Nut/Bolt	3/4	10-UNC	5/B	210	235	265	319
(25K) U-Bolt Nut	7/8	14-UNF	8/C	475	525	644	712
Auditor™ Shear Bolt (Secured, OK™)	7/8	9-UNC	8/C	550	600	746	813

INSTALLATION OF "SLOT-ALIGN" NOTES:
OVERVIEW: The "SLOT-Align" pivot joint features outside eccentric cam gear washer that cover the alignment slo and gives the user a economical way to get axle alignment feature. **CAUTION:** DO NOT APPLY undercoating to the area until after alignment and torque of the pivot bolt.

- With the pivot bolt loose.
- For adjustment, use a breaker bar or other to move the axle forward/rearward.
- The Slot gives you 3/8" pivot movement fore and aft per hanger side.
- To align the axle, move one side of the suspension to get the axle aligned. If needed, go to the other side of the suspension and move in the opposite direction to fully align the axle.
- After alignment, clamp the joint per CUSH torque specifications. After alignment, the suspension installer can weld the outside washer to the hanger side with 1/2" welds two opposite places to prevent tampering & for off-road applications.

Ride Height	Max Jounce	Bumper Contact "UP"	Rebound "DOWN"	Min Jounce Height	Full Rebound Height
7.0	2.8	2.5	6.5	4.2	13.5
7.5	3.3	3.0	6.0	4.2	13.5
8.0	3.8	3.5	5.5	4.2	13.5
8.5	4.3	4.0	5.0	4.2	13.5
9.0	4.8	4.5	4.5	4.2	13.5
9.5	5.3	5.0	4.0	4.2	13.5
10.0	5.8	5.5	3.5	4.2	13.5
10.5	6.3	6.0	3.0	4.2	13.5



- ORIGINAL INSTALLATION INSECTION NOTES, verify that:**
- The installation clearance requirements have been met.
 - The axles have been aligned properly.
 - The suspension frame bracketry and air spring plate welds have been properly completed per specifications.
 - All suspension bolt torques are to CUSH specifications.
 - The suspension ride height is set properly.
 - The suspension can articulate freely through its entire travel and adequate component clearances have been provided.
- INSECTION:** 30-DAY, 90-DAY, & at every brake lining change. 1) Check installation clearance requirements. 2) Check for any signs of wear or component interferences. 3) Check suspension attachment welds for signs of problems. 4) Check that all bolts are in place and securely torqued. 5) Check pivot bushings & clamping connections for problems. 6) Check that the trailer is level. 7) Check the wear that might indicate an alignment problem.

- INSTALLATION NOTES:**
- Measure trailing arm centers and track to verify your requirements.
 - DO NOT APPLY undercoating to the suspension until after completing the alignment. Undercoating will block the mounting of the axle hangers.
 - Mount hangers onto trailer frame per suspension drawing sheets.
 - Place plastic washers on both sides of bush inner metal and insert spacer collars into bush inner sleeve.
 - Measure for fitup then mount Cushman trailer arm/axle assembly into suspension hangers. DO NOT GRIND material from suspension components.
 - Place "Align" gear washer, with indicator in neutral position, and insert pivot bolt/washer from center of hanger/nut onto axle for proper alignment.
 - Adjust "Align" gear washer to proper torque following instructions.
 - Torque bushing pivot bolts per CUSH torque instructions.

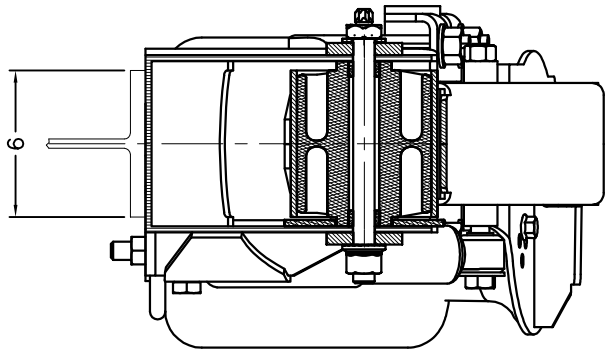
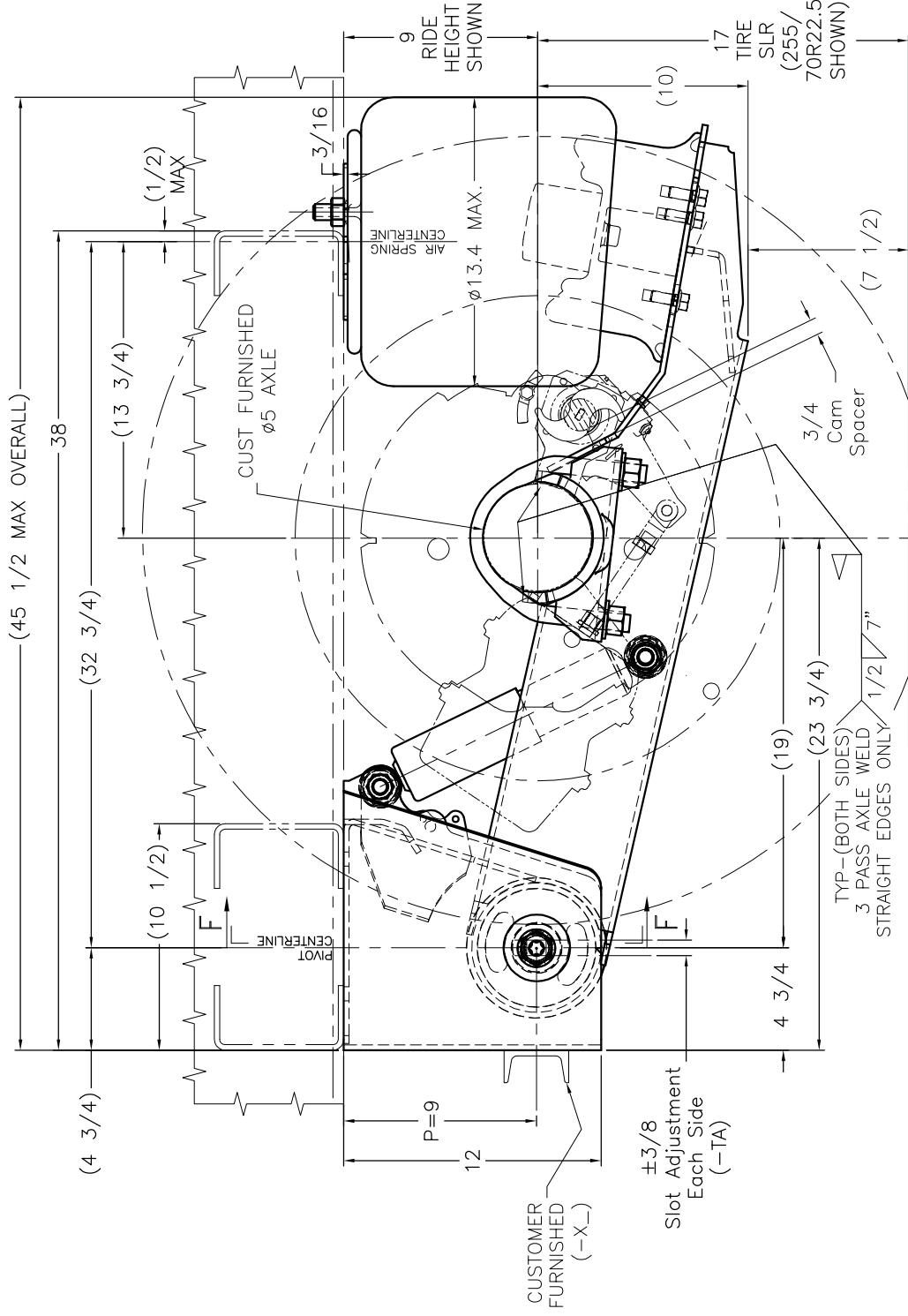
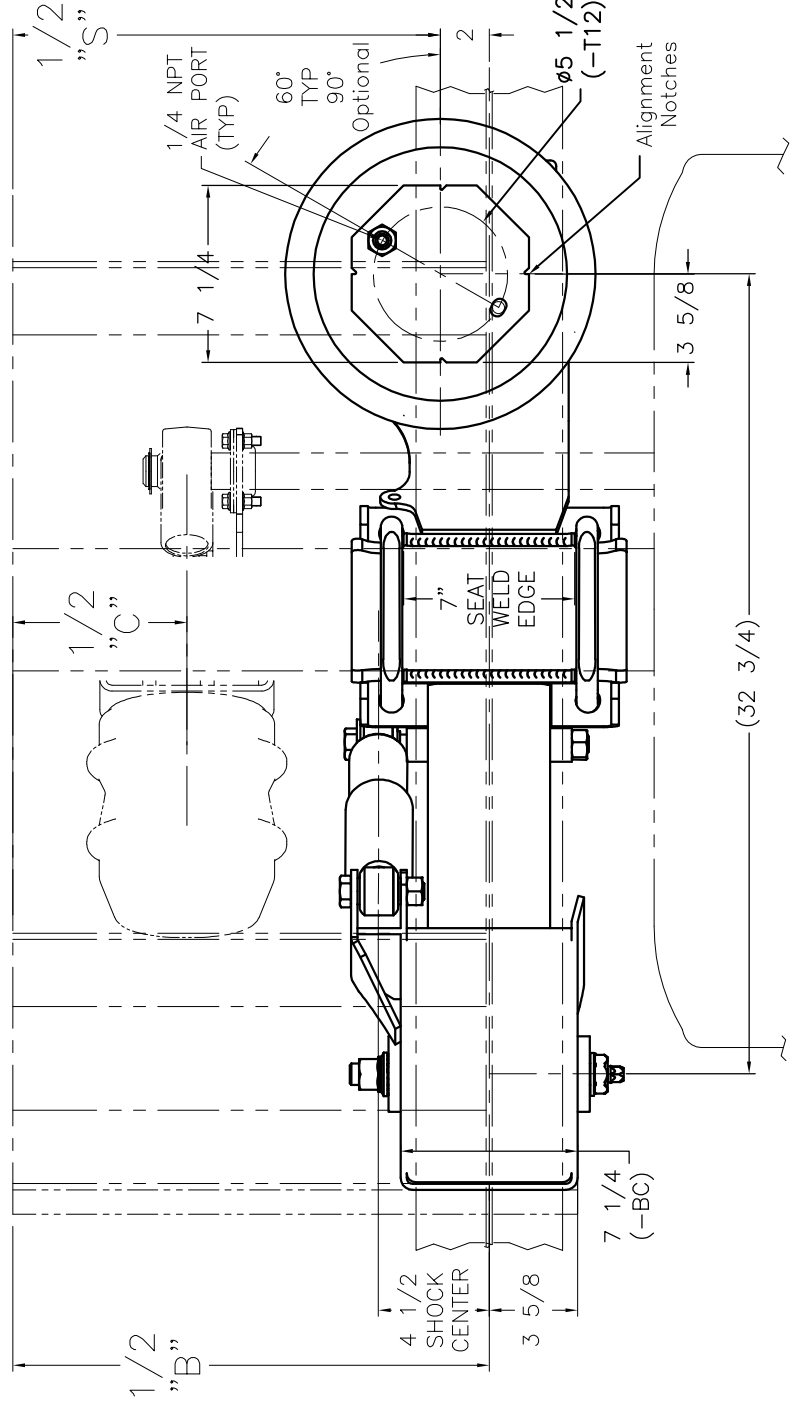
NOTE: Failure to follow the procedures in the CUSH Service and Installation manual and/or properly torque the pivot fasteners at this time can result in a failed pivot connection and a loss of warranty coverage!
 10) Install air springs and shocks per suspension installation manual and drawing sheets.

General Application Dimension Variables - Installation Clearance Notes: Supersede all Common Variables Shown

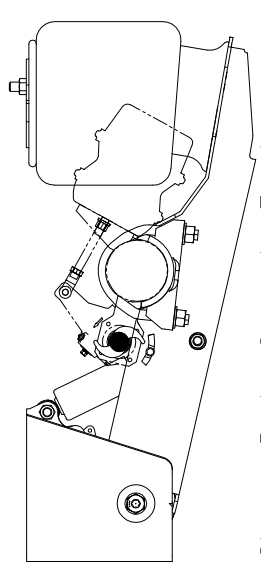
Ref. Suspension Mounting Centers	34	35	40	41	40	39
Ref. Air Spring Centers (2" insert side)	30	31	36	37	36	35
Ref. Axle Track	71.5"	71.5"	76.5"	77.5"	77.5"	77.5"
Approx. Chamber Centers for 16.5" x 7" Brake	9.75	9.75	14.75	15.75	15.75	15.75
Ref. Inside of Tires (Hanger Style)	46.5	46.5	51.5	52.5	52.5	52.5
Ref. Inside of Tires (Yoke Style)	48	48	53	54	54	54

Installation Clearance Notes

- 0.75" minimum clearance must be maintained around air spring when it is at maximum diameter.
- It is the responsibility of the installer to ensure that proper clearances exist at the tires: 1" minimum clearance required between top of tire and bottom of trailer structure when axle is at full jounce, 2" minimum clearance required between inside of tire and trailer frame structure for lateral movement, and there should be ample fore and aft clearances: 0.25" clearance is recommended between suspension beam and brake s-cam shaft.



SECTION F-F

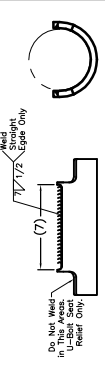


Shown: Brake Cams to Front

AXLE WELDING NOTES, See CUSH Procedure A0001-3:

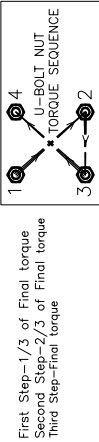
- Suspension components and their mating parts must be at a minimum temperature of 60°F(15.5°C) and free from moisture, dirt, scale, paint, grease, and other contaminants.
- For the best axle to beam weld joint use the following wire. Axle Weld Wire: AWS ER70S-6
- Create the root pass to connect the axle to the trailing arm beam on the straight edge weld. Hit the axle seat tabs down to the axle to give you parent metal for pass 2 and 3. Finished axle weld should be a multi-pass 1/2" weld.

Axle Seat Weld Notes:



U-BOLT INSTALLATION NOTES:

- WARNING:** Do not apply any lubricants to the u-bolts
- U-Bolts should only be installed and torqued after completion of axle welding. Allow sufficient axle cooling time before applying torque to u-bolts.
 - Snug u-bolts evenly before applying torque. Check that u-bolts are spaced and square to the axle.
 - Apply the step process to avoid an improperly clamped axle and resulting damage. Torque the u-bolts in an "x" pattern with each torque step (1-2-3-4). This allows the u-bolt to stretch/relax and hold torque. Proper tightening will allow equal amount of tread above each nut.



First Step-1/3 of Final torque
 Second Step-2/3 of Final torque
 Third Step-Final torque

APPLICATION INSTALLATION SHEET
 Cush Performance 25,000lbs. UnderMount
 5" Round Axle U-Bolted & Weld Seat
 7"-10.5" Ride Height (9" Sit)
 Add-On Features Available

DATE	REV	BY	CHK

SCALE: A-SIZE 1/8
 B-SIZE 1/4
 D-SIZE 1/4

Part/Drawing No: **CP25US9**

Options: -

