

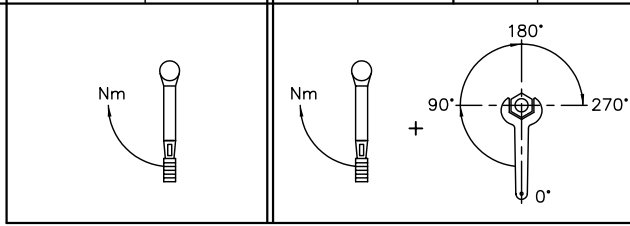










TIGHTENING INSTRUCTION

FASTENER	Dim.	TIGHTENING METHOD				for auditing only		
		TORQUE		ANGLE <sup>④</sup>				
		torque [Nm]	tolerance [Nm]	step 1 torque [Nm]	step 2 angle [degrees]		checking torque after assembly [Nm]	
 ① pivot bolt (nut) ③	M27x2 M30x2			250	+25/-0	270	+27/-13	process control
 ② pivot bolt (nut) ③	M27x2 M30x3,5	800	+50/-0	250	+25/-0	270	+27/-13	process control
shock absorber bolt (nut) ③	M20x2			200	+20/-0	180	+18/-9	process control
shock absorber bolt (head) ③	M20x2			200	+20/-0	180	+18/-9	process control
u-bolt M22 ⑤	M22x1,5	600	+25/-0					450
u-bolt M24 ⑤ ⑥	M24x2	800	+50/-0					650
air spring	M12	66	+0/-16					50
option: offsetplate	M12	66	+0/-16					50
option: splitter/axle-lift	M16	200	±20					150



- ①    Suspension system with axle alignment device in the hangerbracket.
- ②    Suspension system without axle alignment device in the hangerbracket.
- ③ Tighten at ride height.
- ④ During angle tightening of the nut/bolt it is essential to secure the counterside.
- ⑤ Tighten U-bolts evenly and crosswise.
- ⑥ If a BPW axle with BPW axle clamping parts is used, the instructions of the Bergischen Achsenfabrik for these parts have to be followed.

IM-052-GB-B



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