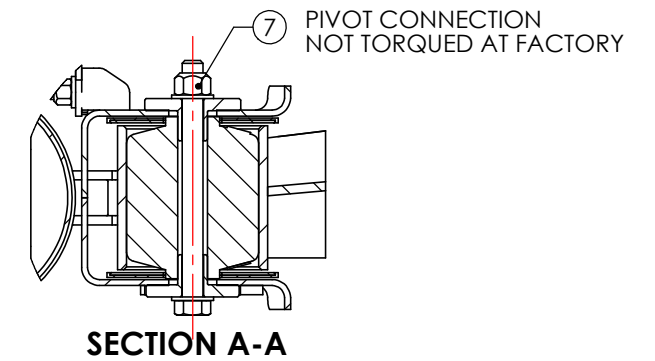


STAR650006-19L-775 BOM			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	651208-130-450-FHL	HANGER ASSEMBLY - LH	1
2	651209-130-450-FHL	HANGER ASSEMBLY - RH	1
3	652050-01-FHL	TRAILING BEAM/SSA ASSEMBLY	1
4	653018-3000	AIR SPRING TOP PLATE ASSY	2
5	653512-01	AIR SPRING	2
6	653511-01	SHOCK ABSORBER	2
7	653525-01	7/8" ECCENTRIC PIVOT HARDWARE KIT	2
8	653519-01	AIR SPRING HARDWARE KIT	2
9	653518-01	SHOCK HARDWARE KIT	2
10	653514-01	AIR SPRING - LIFT	2
11	653521-01	LIFT HARDWARE KIT	2
12	651025-2319	BOLT-ON CROSS MEMBER	1
13	653593-01	BOLT-ON CROSS MEMBER HARDWARE	1



IF THIS CONFIGURATION SUITS YOUR APPLICATION, PLEASE SIGN AND EMAIL NEIL AT nhaslam@ingersollaxles.com OR FAX TO 519-485-6336

APPROVED	DATE

- NOTES:
- 1-READ INSTALLATION MANUAL BEFORE INSTALLING YOUR SUSPENSION.
 - 2-ALL WELDING PROCEDURES SHOULD BE DONE IN ACCORDANCE WITH IMT STANDARDS - REFER TO THE MANUAL.
 - 3-ANCILLARY COMPONENTS SHOULD CLEAR SUSPENSION BY MINIMUM OF 2" (51mm) TO ALLOW FOR LATERAL MOVEMENT.
 - 4-IT IS THE INSTALLER'S RESPONSIBILITY TO ENSURE THE ADEQUACY OF ANY CROSS BRACES, CROSS MEMBERS OR REINFORCING BARS ACCORDING TO THE TRAILER'S FRAME DESIGN, APPLICATION, ETC..

INGERSOLL AXLES
AN IMT COMPANY™

IMT
347 KING STREET WEST
INGERSOLL, ONTARIO,
N5C 3K6
TEL: (519) 485-2210

SUSPENSION ASSEMBLY

ISS-30K-19TLS-SSA-WE-FHL

DWN BY: BF
DATE: AUG 31/15
SCALE: B = 1:14
SHEET: 1 of 1

TORQUE REQUIREMENTS		
ITEM	ft-lbs	N-m
1-1/8" - PIVOT BOLT LOCK NUT	900-920	1220-1290
7/8" - PIVOT BOLT LOCK NUT	425-440	575-595
3/4" - SHOCK ABSORBER NUT	150-175	205-240
1/2" - LOWER AIR SPRING BOLT	25-30	28-40
3/4" - UPPER AIR SPRING NUT	40-45	55-60
1/4" - AIR VALVE & LINKAGE NUT	5	7
3/8" - LOWER AIR SPRING BOLTS - LIFT BAG	15-20	20-25

UNLESS SPECIFIED, ALL DIMS ARE IN INCHES
UNSPECIFIED TOLERANCES

X.X = +/- 0.03 FRACTIONS = +/- 1/16
X.XX = +/- 0.01 ANGLES = +/- 1 DEG
X.XXX = +/- 0.005 SURFACE FINISH: 125
X.XXXX = +/- 0.0010 (XXX) CRITICAL DIMENSIONS

** WELDING PROCESS **
** WELD AS REQUIRED TO IMT DOCEN002 **
** BREAK SHARP CORNERS **

REF: P-2739 (702323)
STARG069 - SQ#12746

DWG No. **STAR650006-19L-775**

REV LEVEL **A**

REV	DESCRIPTION	DATE	REV'D BY
A	ECN2015-334, IT #1 WAS 651014, IT #2 WAS 651015, ADD IT #12&13	SEP 28/15	BF
~	ECN2015-309, RELEASED FOR PRODUCTION	SEP 14/15	BF

REVISIONS