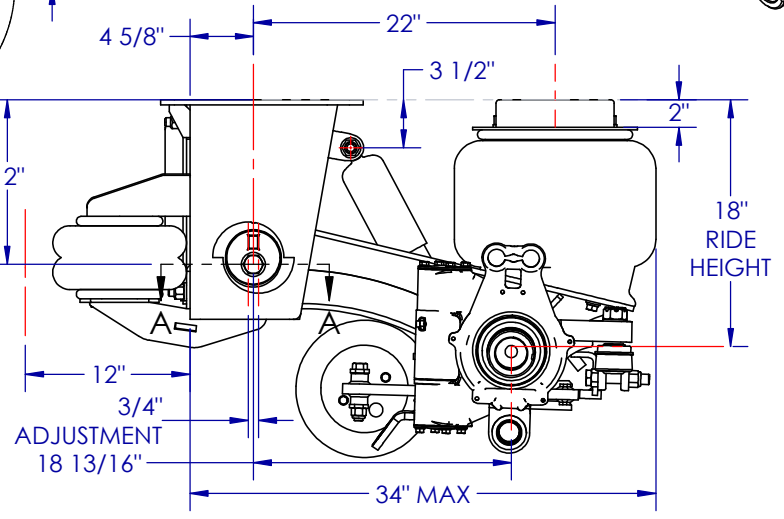
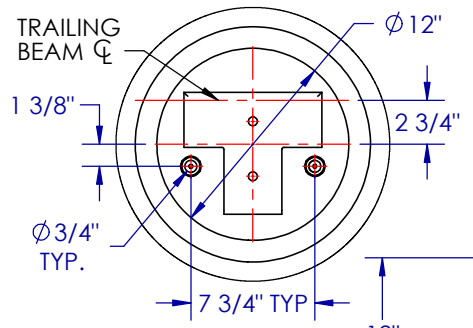


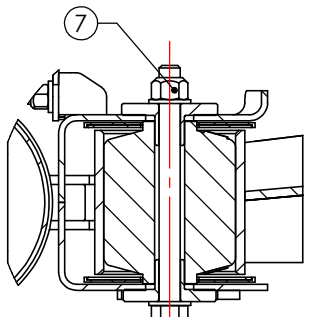
STAR650016-18L-840 BOM			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	651197-120-350-FHL	HANGER ASSEMBLY - BOLT-ON - LH	1
2	651198-120-350-FHL	HANGER ASSEMBLY - BOLT-ON - RH	1
3	652050-01-FHL	TRAILING BEAM/SSA ASSEMBLY	1
4	653018-2000	AIR SPRING TOP PLATE ASSY	2
5	653512-01	AIR SPRING	2
6	653511-01	SHOCK ABSORBER	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	651025-2969	BOLT-ON CROSS MEMBER	1
11	651026-1590	BOLT-ON DIAGONAL BRACE	2
12	653532-01	BOLT-ON CROSS MEMBER HARDWARE KIT	1
13	653514-01	AIR SPRING - LIFT	2
14	653521-01	LIFT HARDWARE KIT	2



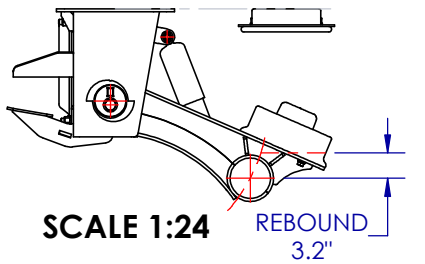
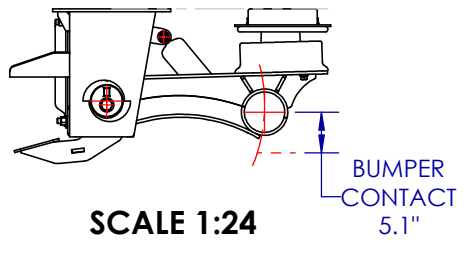
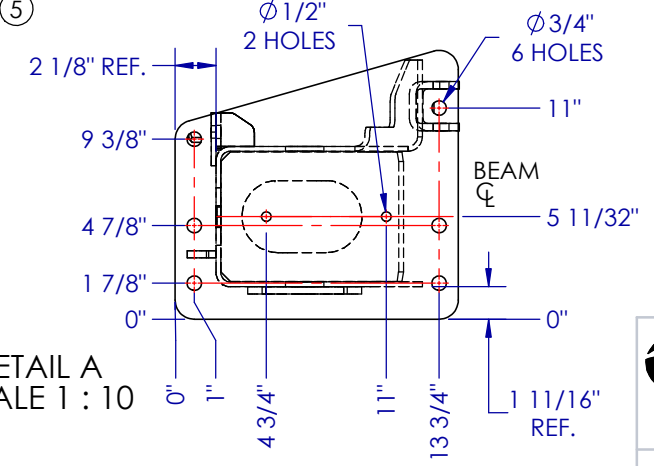
DETAIL B  
SCALE 1 : 12

DETAIL A  
SCALE 1 : 10

PIVOT CONNECTION NOT TORQUED AT FACTORY



SECTION A-A  
SCALE 1:8



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..

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

**INGERSOLL AXLES**  
AN IMT COMPANY™

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

**SUSPENSION ASSEMBLY**

**ISS-30K-18TLS-SSA-BE25-FHL**

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

UNLESS SPECIFIED, ALL DIM'S 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

REF: P-2740 (702528) REV LEVEL

DWG No. **STAR650016-18L-840**

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

REV	DESCRIPTION	DATE	REV'D BY
~	ECN2015-309, RELEASED FOR PRODUCTION	SEP 14/15	BF