



**INSTALLATION INSTRUCTIONS  
LIFT AXLE FENDER BRACKET KIT  
For Meritor 4 Bolt Cam Flange Rear  
Kit# B6584SBA**

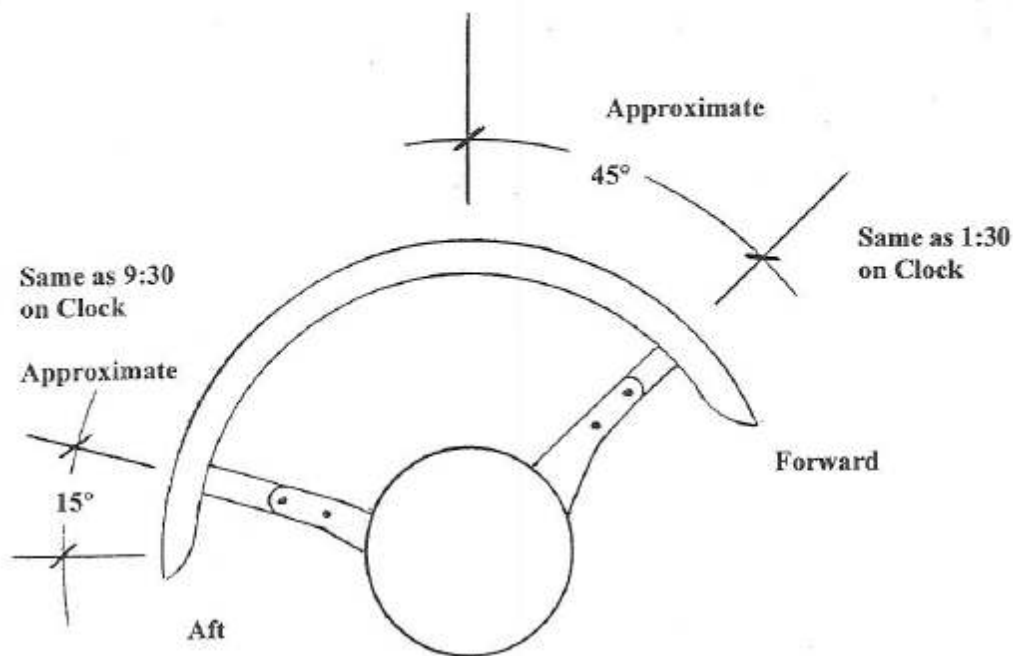


**\*\*BOLTS ARE ONLY PROVIDED FOR STEPS 8-9. BOLT SIZES VARY IN STEPS 1-7 DEPENDING ON THE APPLICATION AND ARE NOT PROVIDED.**

1. Remove the hub & drum assembly (with outboard hubs, you may only have to remove the drum).
2. Remove the low three backing plate to spindle bolts on the rear side of the spindle.
3. Install the B7842L/R mounting plate with longer grade 8 bolts and 2 to 4, SAE flat washers between the spindle and the offset mounting plate. (This is to get the plate away from the irregular surface).

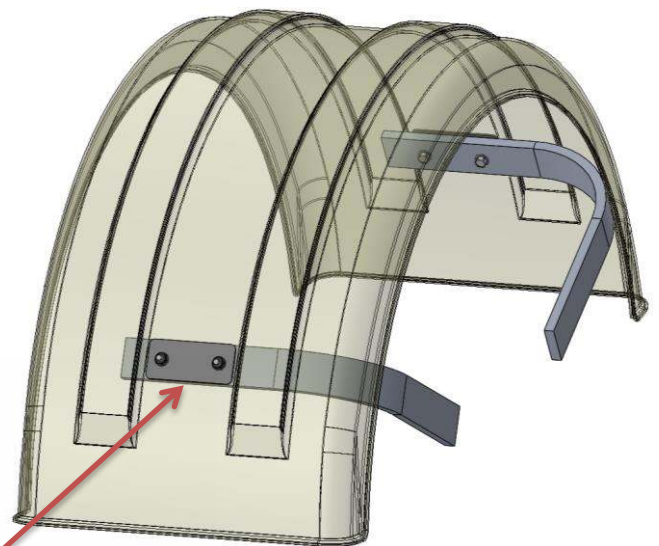
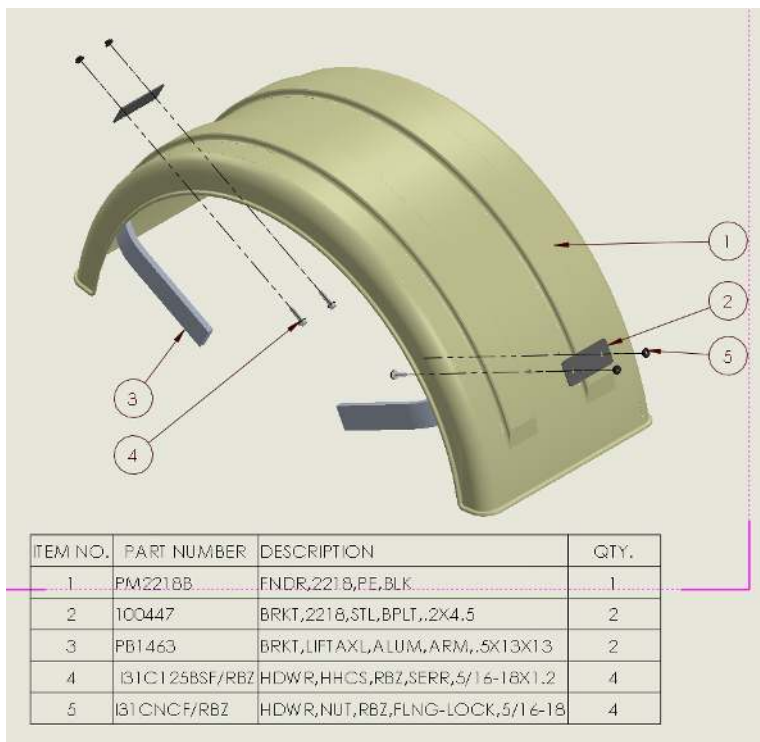
4. The other mounting plate B6542L/R is to be bolted to the cam tube-mounting flange. Use both top bolt holes and one lower bolt hole with 1/2" longer bolts.
5. Re-install the bug & drum assembly-Install tire & wheel
6. Cut 12 - 1/2" leg to 10" (out to out) - or to desired length on all four aluminum arms.
7. Hold arms in place with 10" leg over tire 1 1/2" from tire tread to inside of arm. Trim other leg to fit onto bracket (on inside, between bracket and truck frame).
8. Clamp in place with vise grip. (Make sure inside of arms point directly to center of spindle.) Mark & drill 1/2" holes in aluminum arms. Bolt aluminum arms to steel mounting brackets using 1/2" bolts with self-locking nuts (provided in kit).
9. Install poly fender on top of the aluminum arms. It should be approximately the same distance from the end of the fender to the 2" arm on both ends of the fender. Make sure the edge of the fender is parallel to the side of the tire. Drill two each 5/16" diameter holes into center of fender ribs to bolt the fender to the arm. Use 5/16" bolts with self-locking nuts (provided in kit).

### Recommended Placement of Brackets and Fenders for Correct Installation



## Instructions for use of MIN221800 fenders with Minimizer steerable lift axle brackets:

- Inside the Minimizer bracket kit locate four steel plates (Minimizer part number 100447)
- The steel plates are to be installed on the exterior surface of the fender.
  - Align the steel plate so it is even (top to bottom) with the aluminum arm. Use one plate for each aluminum arm.
  - Drill two 21/64" holes through the fender using the steel plate as a template
  - Drill two 21/64" holes in the aluminum arm using the fender and steel plate as a template.
  - Use the 5/16-18"x 1-1/4" hardware provided by Minimizer to fasten the fender in between the aluminum arm and the steel plate.
  - **Tighten the 5/16-18X1-1/4 bolts to a recommended torque of 5-7 ft-lbs. Do not exceed the recommended torque.**
- Failure to install the exterior steel plates at the time of installation will void the manufacturer's warranty on the MIN221800 fender component.
- If installing fender model MIN161200 or any model other than MIN221800, the steel plates are not necessary and may be discarded.



ALIGN STEEL PLATE WITH ALUM ARM