



**INSTALLATION INSTRUCTIONS
STEERABLE AXLE BRACKET KIT
FOR MERITOR FWD CAM on HENDRICKSON "ST" SUSPENSION/AXLE
(Kit#: B845SBA)**



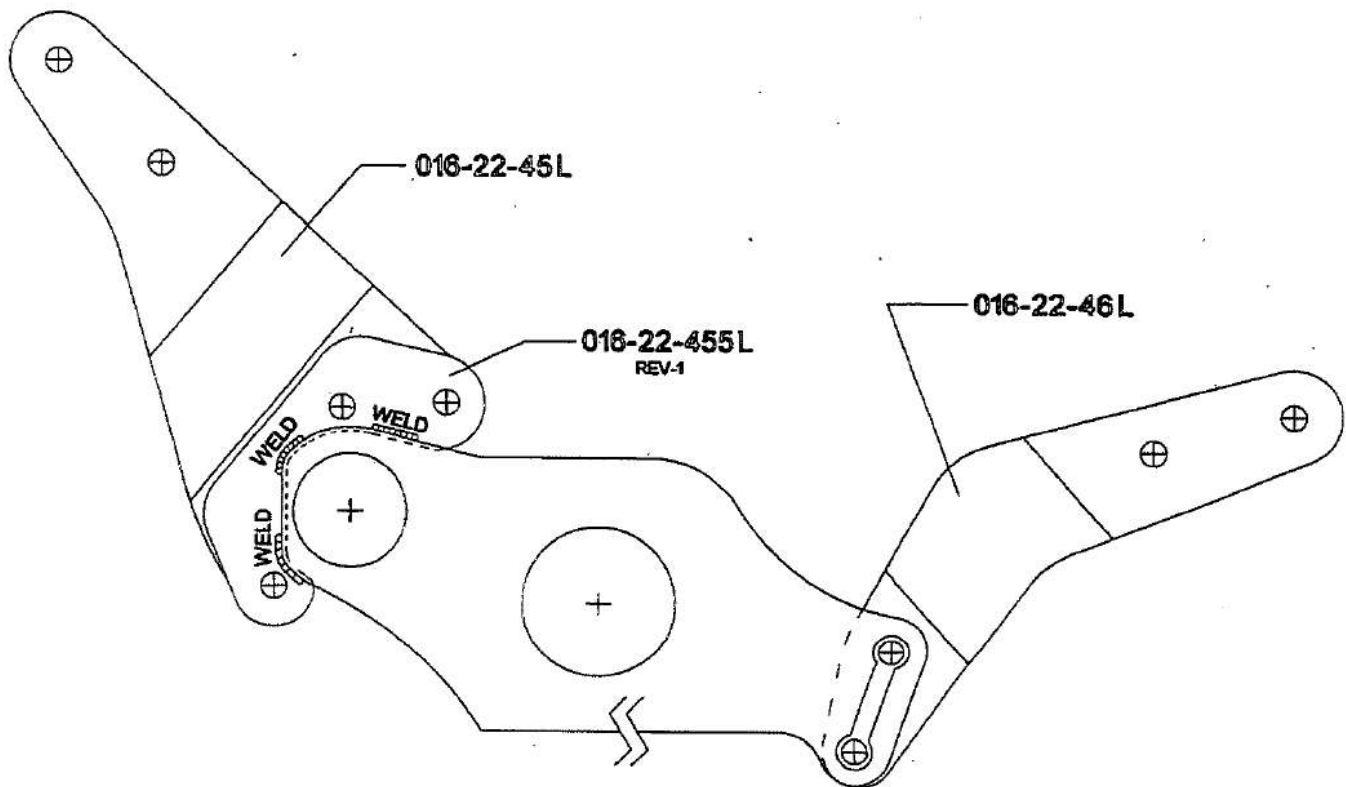
****BOLTS ARE ONLY PROVIDED FOR STEPS 9 & 10. BOLT SIZES VARY IN STEPS 1-8 DEPENDING ON THE APPLICATION AND ARE NOT PROVIDED.**

1. Remove brake drums and brake shoes
2. Position the B455L on left hand spider and 455R on right hand spider as shown in the drawing on page 2. The 455L and 455R have a machined step to fit onto the spider. Three weld beads $\frac{1}{4}$ " x $\frac{3}{4}$ " are required on the



outboard side. Weld with an E7018 electrode or E70XX flux core wire. The camshaft washer can be rotated for ease of welding then rotated back to original position.

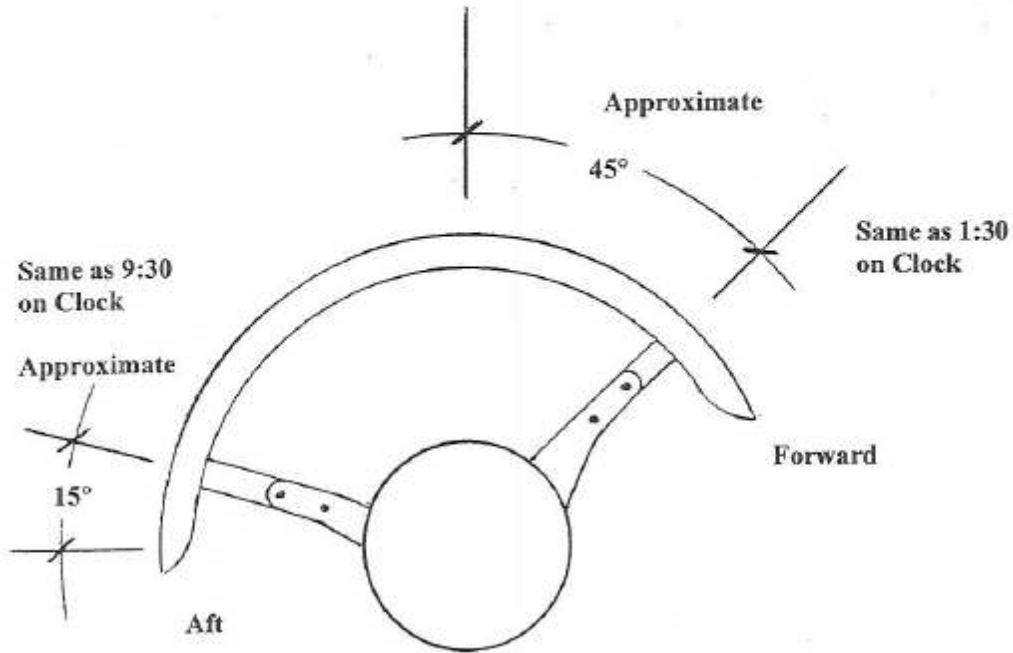
3. Install part 45L on the left (drivers) side and 45R on the right (passenger) side with 1/2-13 X 1 1/4" Grade 8 cap screws and SAE washers.
4. Remove the anchor pin bolts on the left and right rear sides of the spider and install part 46L on the left side and 46R on the right side. Fasten with 5/8-11 X 5 1/2" Grade 8 cap screws. Torque 5/8" bolts to 210-225 FT-LBS.
5. Install brake shoes and drums.
6. Install wheels.
7. Cut the 12-1/2" leg to 10" (out to out) on all 4 aluminum arms (for 12" wide Fenders. NOTE – MAY HAVE TO CUT ARMS ACCORDINGLY – MEASURE CORRECTLY FIRST BEFORE CUTTING.
8. Hold rear 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.)
9. Clamp in place with vise grip (make sure inside of arm points directly to center of spindle.) Mark and drill 1/2" holes in aluminum arms. Bolt aluminum arm to steel mounting bracket using 1/2" bolts with self-locking nuts (provided in kit).
10. Install the fender on top of the aluminum arms. Roll fender until it is approximately the same distance from end of the fender to the 2" arm on both ends of the fender. Make sure fender is parallel to tire. Drill 2 each 5/16" diameter holes on 6" centers (approximately 3" left and right of center) to bolt the fender to the arm. Use 5/16" bolts w/self-locking nuts (provided in kit).



LEFT HAND (DRIVERS) SIDE DRAWN WITHOUT
WHEEL, TIRE, HUB, DRUM AND BRAKE SHOES

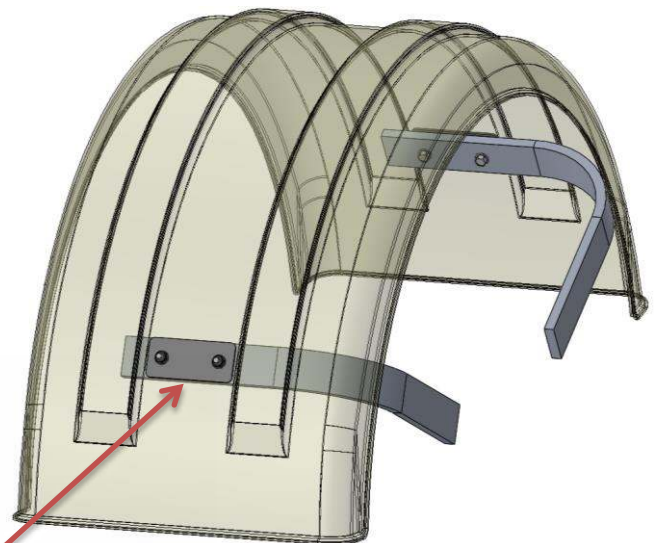
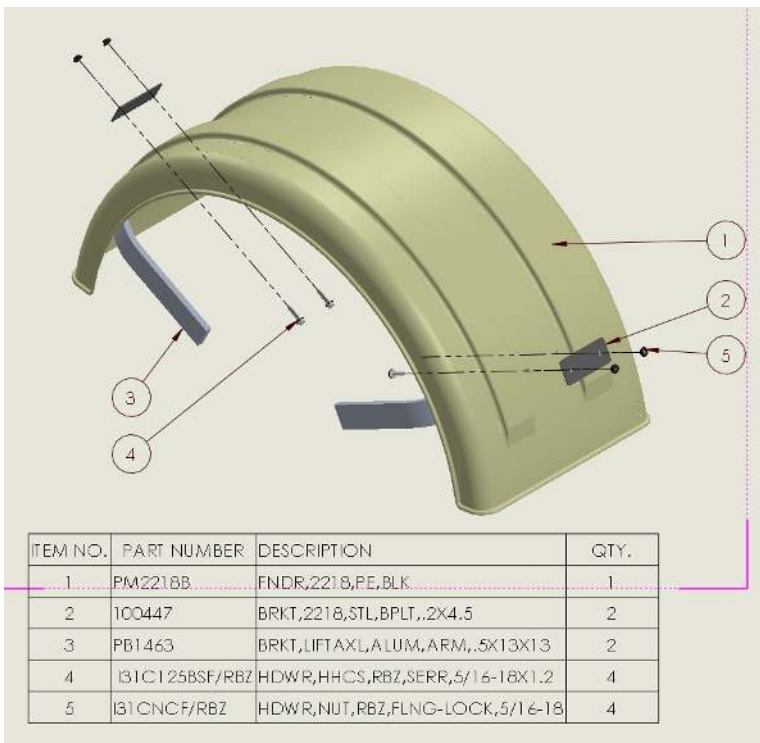


Recommended Placement of Brackets and Fenders for Correct Installation



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

