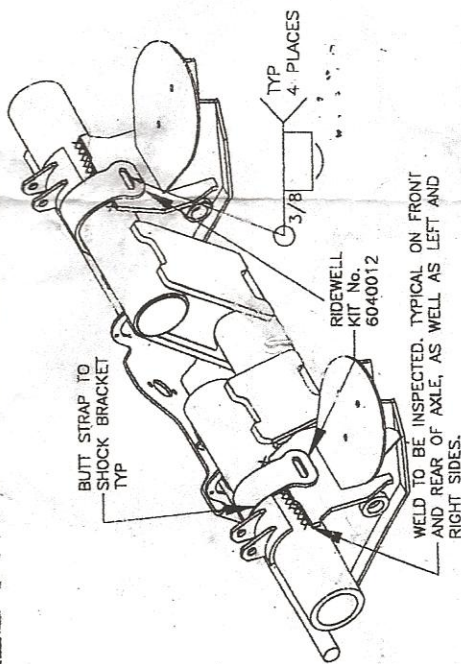


AXLE STRAP INSTALLATION KIT: 3-25-99 REV. 1



INTERIM INSPECTION AND INSTALLATION PROCEDURES (approx. time of completion: 2 - 2 1/2 hours):

WARNING: Coach equipped with air suspension must be supported under main frame rails at engine before working under coach.

- STEP 1: Raise and block tag axle. Remove tag axle tires and wheels.
- STEP 2: Remove tag axle air spring pressure via "tag dump" switch on dash. Disconnect battery "Ground" cables at batteries. Remove tag axle air springs.
- STEP 3: Clean all welds connecting lower beam to axle using either mechanical or chemical means. Be certain to clean around ends as far as possible. See illustration for locations.
- STEP 4: Visually inspect welds for any signs of cracking. If cracking is found on either the face or ends of the weld, contact Ridewell Corporation immediately. Do not continue with this process or operate bus without approval from Ridewell Corporation.
- STEP 5: Assuming no cracks were observed, install straps (service kit P/N 6040012 includes 2 of these) per illustration. Straps must fit snug to the top of the axle and minor adjustment may be required. Paint must be removed from all weld areas to ensure proper fit. Position and clamp straps as indicated and plug weld using a 7018 low hydrogen electrode for stick or E70T (or S) 1 for MIG or equal. Repaint area as needed.
- STEP 6: Return air springs to original position and reinstall fasteners. Torque all 1/2" fasteners to 23ft/lbs and all 3/4" fasteners to 50ft/lbs.
- STEP 7: Install tag axle tires and wheels. Remove axle blocking. Reconnect battery "Ground" cables at batteries.
- STEP 8: Pressurize tag axle air springs by reversing tag axle dump switch on dash. Adjust tag axle pressure regulator (using allen wrench) to indicate 40 psi on dash gage. Regulator located on frame crossmember aft of tag axle.
- STEP 9: Interim work is now completed. Replacement of specific components will be required in the future. Ridewell Corporation will contact you to make arrangements for this phase as parts become available.
- STEP 10: Owners and/or operators are required to visually inspect the welds at 3,000 mile intervals until the final phase is completed. Should cracking be observed, DO NOT operate the vehicle. contact Ridewell Corporation immediately for instructions.

Primary contact at Ridewell Corporation will be Dave Carney, our National Service Manager. Alternate contacts are Steve Bilyeu (Quality Control Manager) or Bill Mattocks (Sr. Project Engineer). All may be reached at 1-800-641-4122 or 1-417-833-4565.

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DRWN	CHECKED	RELEASED	Yr.