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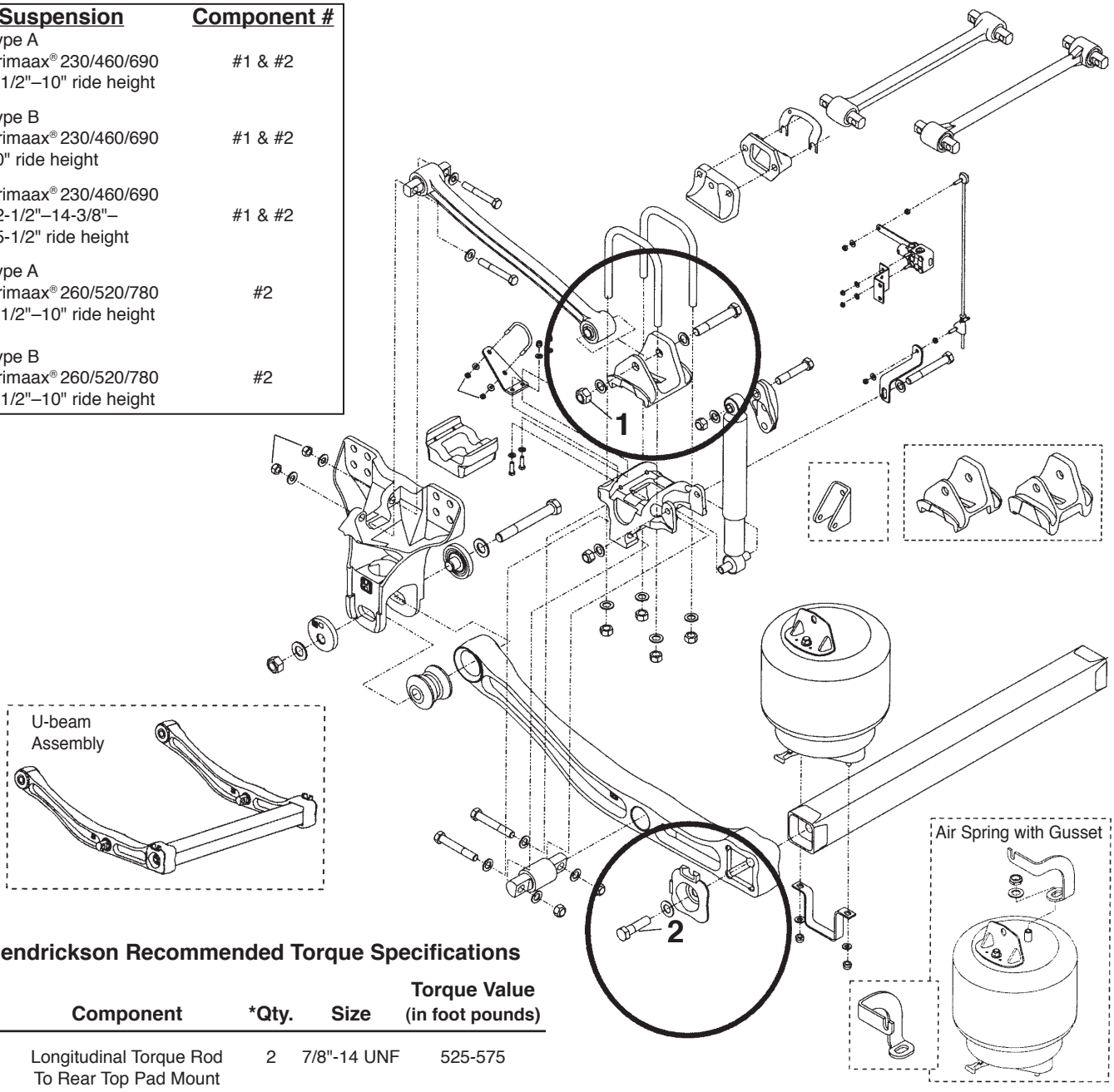
Form No. 551719

Operating Instructions for: **1768**

Hendrickson PRIMAAX® Quick Wrench

For use on the following Hendrickson suspensions and which component(s):

Suspension	Component #
Type A Primaax® 230/460/690 8-1/2"–10" ride height	#1 & #2
Type B Primaax® 230/460/690 10" ride height	#1 & #2
Primaax® 230/460/690 12-1/2"–14-3/8"– 15-1/2" ride height	#1 & #2
Type A Primaax® 260/520/780 8-1/2"–10" ride height	#2
Type B Primaax® 260/520/780 8-1/2"–10" ride height	#2



Hendrickson Recommended Torque Specifications

Item No.	Component	*Qty.	Size	Torque Value (in foot pounds)
1	Longitudinal Torque Rod To Rear Top Pad Mount	2	7/8"-14 UNF	525-575
2	Beam Assembly To Cross Brace End Cap	2	7/8"-9 UNC	525-575

NOTE: Quantities shown are per axle. Double for tandem or triple for tridem.

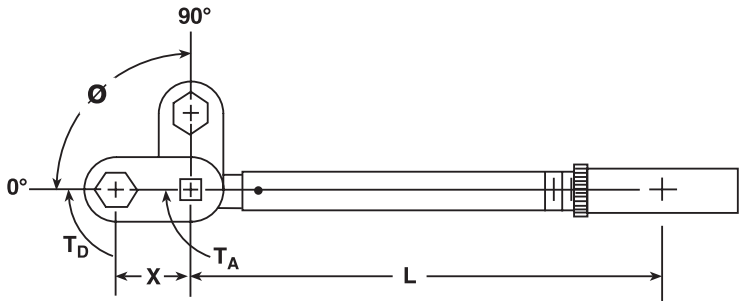
Issue Date: Rev. C, June 6, 2014

Safety Precautions

Caution: Failure to follow these warnings could cause damage to equipment, and / or failure of equipment, which may result in personal injury or property damage.

- **Read and understand all safety precautions and operating instructions before using this tool.**
- **Wear eye protection that meets ANSI Z87.1 and OSHA standards.**

Torque Wrench Adapter Calculations



This tool is designed to be used perpendicular (90°) to the torque wrench. If its used in an application that is not perpendicular, the torque wrench setting must be calculated to adjust for the tool offset and prevent torque multiplication.

Use the following guidelines when calculating:

- Zero degrees is parallel to the torque wrench with the adapter pointing away from the handle and 180° is parallel to the torque wrench with the adapter pointing towards the handle.
- Offset 'X' and length 'L' can be in inches or a metric measure as long as the same unit of measure is used for both.
- Torque can be any unit of torque as the same torque wrench setting will be returned.

Formula: $$T_A = \frac{T_D \times L}{L + X}$$

T_A = Unknown (new torque wrench setting to be applied.

T_D = Desired torque value to be applied.

L = Distance from center of torque wrench square drive to center of wrench handle.

X = 5 in./12.7 cm (Distance from center of drive extension to center of torque wrench square drive)

NOTE: If an obstruction creates the need to have an angle between the two axis, follow the modified formula below.

$$T_A = \frac{T_D \times L}{X \cos \text{ø} + L}$$