



Service Parts Instructions

Installing Meritor FastSet™ No-Ream King Pin Kits

Special Instructions for Kit R202035 for Mack and Volvo FXL Axles

Hazard Alert Messages

Read and observe all warnings and caution hazard alert messages in this publication. They provide information that can help prevent serious personal injury, damage to components, or both.

WARNING

To prevent serious eye injury, always wear safe eye protection when performing vehicle maintenance or service.

Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Support the vehicle with safety stands. Do not work under a vehicle supported only by jacks. Jacks can slip and fall over. Serious personal injury and damage to components can result.

How to Obtain Additional Maintenance, Service and Product Information

Refer to Maintenance Manual 2, Front Non-Drive Steer Axles/All Meritor Conventional, Easy Steer Plus™ and MFS Series. To obtain this publication, visit Literature on Demand at meritor.com.

How to Obtain Kits and Tools

Call Meritor's Commercial Vehicle Aftermarket at 888-725-9355 in Florence, Kentucky.

Meritor FastSet No-Ream King Pin Kits

This publication provides instructions for installing Meritor FastSet no-ream king pin kits. Each kit includes four spiral bushings.

Procedures

Remove the Knuckle Assembly and Bushings

Refer to Maintenance Manual 2 for the correct procedures to remove the steering knuckle assembly and old bushings.

NOTE: Use optional King Pin Removal Tool, part number R212137, to "break" the king pin loose from the axle. Then use an appropriate brass drift to drive the pin out of the axle and knuckle.

IMPORTANT: Measure the thickness of the bearing cup seat in four places.

- If the thickness is not within 0.392-0.394-inch (9.96-10.0 mm): Replace the knuckle.

Install the Meritor FastSet No-Ream King Pin Kit and Knuckle Assembly

1. Remove all grease and lightly hone the knuckle bores to treat scratches and burrs.
2. Twist in the new spiral bushings clockwise from the bottom of the knuckle. Start by hand at a slight angle, then use the spiral bushing T-handle installation tool, part number R212087, to continue installation until the bushing is below the top of the bore.

CAUTION

When installing the lower grease seals, the nylon insert inside the seal must face down against the knuckle. If the seal is installed incorrectly, grease will not purge from the knuckle. Damage to components may result.

3. Install the lower grease seal with the nylon insert inside the seal facing down against the knuckle.
4. Install the king pin from the bottom of the knuckle, using the force needed to seat the king pin into the axle eye.
5. Pre-pack the thrust bearing with grease.
6. Reinstall the bearing assembly using a suitable bearing driver.
7. Install the king pin nut and tighten to 200 lb-ft (271 N•m). Check for free movement of the knuckle. If the knuckle turns freely, tighten the king pin nut to a final torque of 600 lb-ft (813 N•m).
8. Reinstall the caps and tighten to 120 lb-ft (163 N•m).

⚠ CAUTION

If the knuckle locks up during greasing, stop greasing immediately or damage to components may result. Remove one end cap bolt to relieve trapped air, re-install the bolt, then resume greasing.

9. Add grease slowly at the fitting and rotate the knuckle to spread the grease. Repeat this process for the top and bottom until grease purges between the axle and knuckle.



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