



Service Parts Instructions

Installing Meritor FastSet™ No-Ream King Pin Kits

Kits R202036, R202037 and R202038 for
Meritor Front Non-Drive Steer Axles

Hazard Alert Messages

Read and observe all hazard alert messages in this publication.

⚠ DANGER

Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Support the vehicle with safety stands. NEVER work under a vehicle supported only by jacks. Jacks can slip and fall over. Failure to use a jack stand can result in serious personal injury and damage to components.

⚠ WARNING

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

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. These kits can be used to service Meritor front non-drive steer axles. Figure 1.

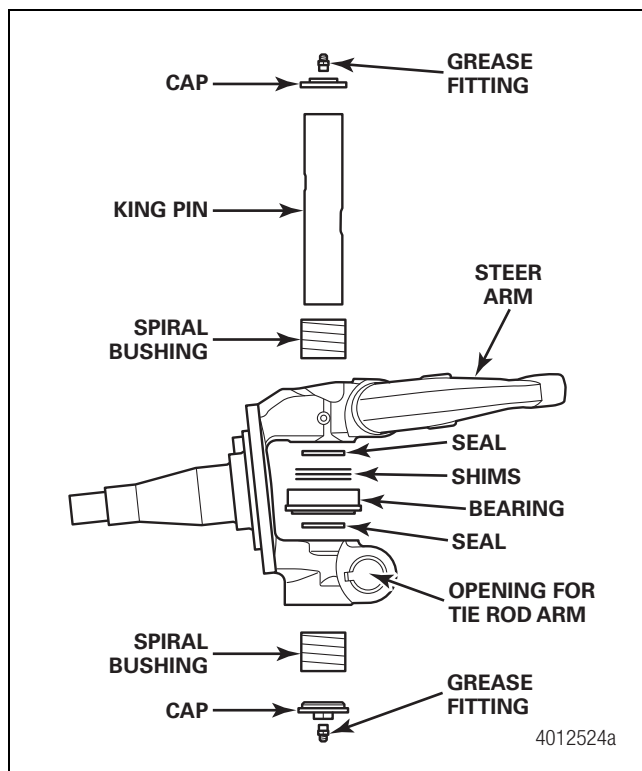


Figure 1

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.

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.

- Using the Meritor bushing driver tool specifically designed for the kit, drive both bushings into the knuckle. Figure 2.
 - For kit R202036, use bushing driver R212135.
 - For kit R202037, use bushing driver R212135.
 - For kit R202038, use bushing driver R212136.

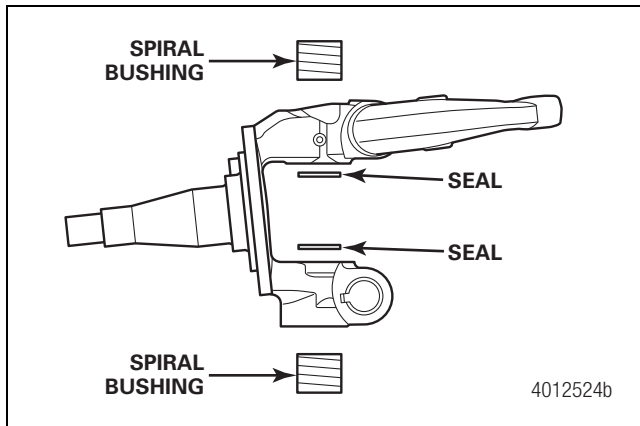


Figure 2

⚠ CAUTION

When installing the upper and lower grease seals, both seal lips must face away from the bores. If the seals are installed incorrectly, grease will not purge from the knuckle. Damage to components may result.

- Install the upper and lower grease seals so that the seal lip “V”s all open away from the bores. Seals must be even with the machined surface of the knuckle bores. Figure 3.

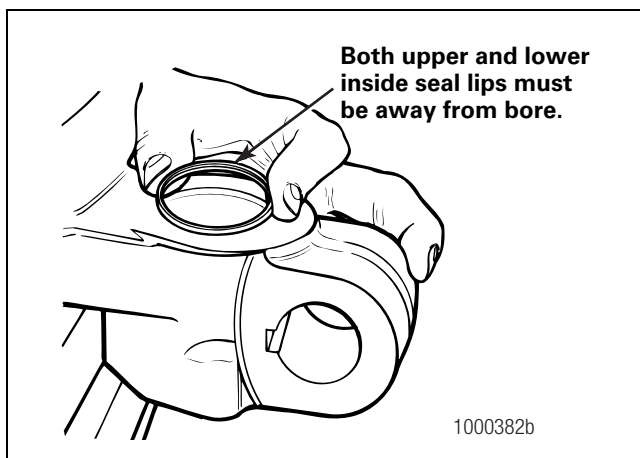


Figure 3

- Install the new king pin and check the fit. The king pin must fit freely and rotate.
 - If the king pin is tight:** Remove the king pin and bushing. Re-hone and clean the bushing bore, and reinstall the bushing and king pin.

- Pre-pack the thrust bearing with grease.
- Reinstall the knuckle assembly to the axle with the new king pin and thrust bearing. Each kit includes two types of thrust bearings. Install the friction-type bearing on the driver side and the standard cylindrical roller-type bearing on the passenger side. Add shims until the fit is snug and the thrust bearing requires a slight tap to align with the king pin. Figure 1, Figure 4 and Figure 5.

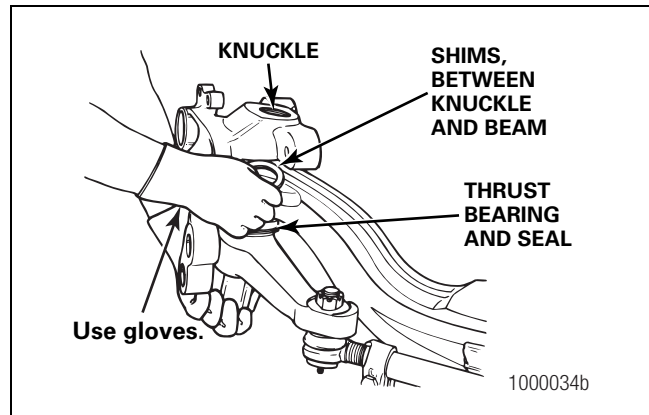


Figure 4

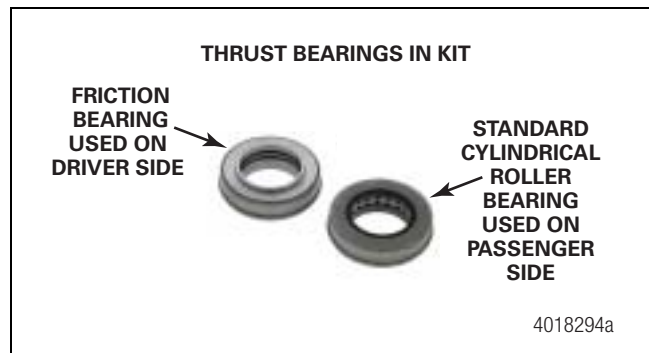


Figure 5

- Align the king pin with the lock pin flats. Install the lock pins and tighten to the torque specified in Maintenance Manual 2 for your application.
- Measure the vertical end play. Add or remove shims until the end play is within specification for your application. Refer to Maintenance Manual 2 for complete end play check procedures and specifications. Figure 6.

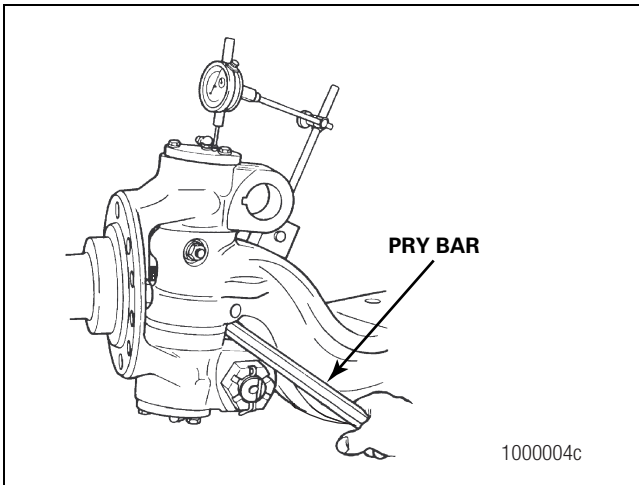


Figure 6

9. Rotate the knuckle from side to side and check to ensure it rotates freely.
 - **If the knuckle is tight:** Re-hone the bores.
10. Install the end caps, bolts and grease fittings.

⚠ 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.

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



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