



## Service Parts Instructions

# Installing Meritor ReadySet™ No-Ream King Pin Kits

Meritor Front Non-Drive Steer Axles

## Hazard Alert Messages

Read and observe all Warning 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 you perform 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 ReadySet No-Ream King Pin Kits

This publication provides instructions for installing Meritor ReadySet no-ream king pin kits. Each kit includes four bronze pre-sized bushings. These kits can be used to service Meritor front non-drive steer axles. Figure 1.

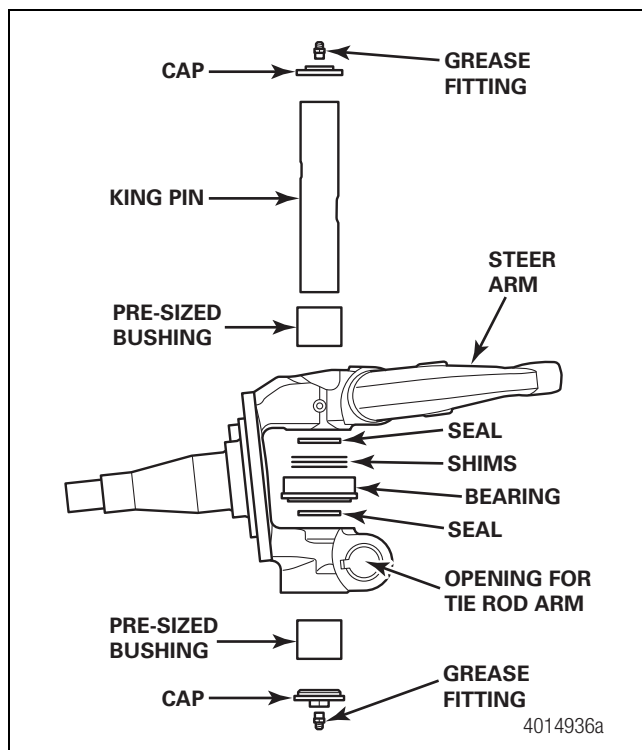


Figure 1

## 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. Inspect all disassembled parts for wear per Maintenance Manual 2.

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

1. Remove all grease and lightly hone the bushing bores to treat scratches and burrs.

- Using an appropriate driver, install the new pre-sized bronze bushings in from the top and bottom of the knuckle. Figure 2. Continue installation until the bushing is below the top of the bore. If the knuckle has a threaded cap, continue installation until the bushing is just below the threads.

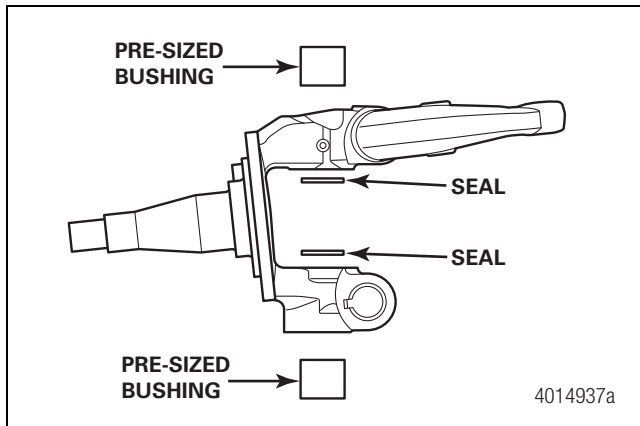


Figure 2

### ⚠ 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 and Figure 2.

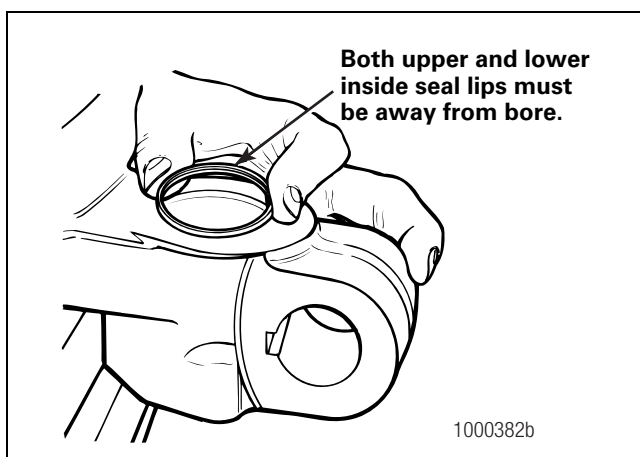


Figure 3

- Install the new king pin and check the fit. The king pin must fit freely and rotate.
- Pre-pack the thrust bearing with grease.

- Reinstall the knuckle assembly to the axle with the new king pin and thrust bearing. Add shims until the fit is snug and the thrust bearing requires a slight tap to align with the king pin. Figure 1 and Figure 4.

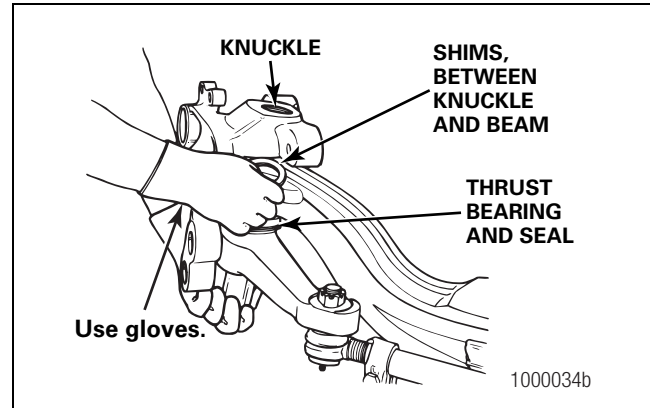


Figure 4

- 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 5.

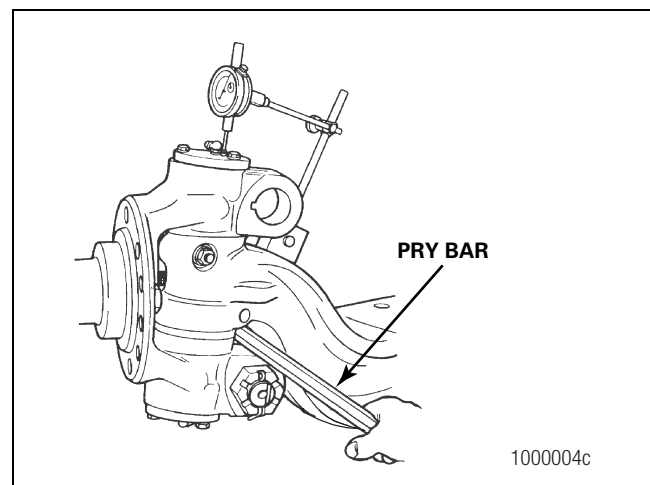


Figure 5

- Rotate the knuckle from side to side and check to ensure it rotates freely.
- 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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