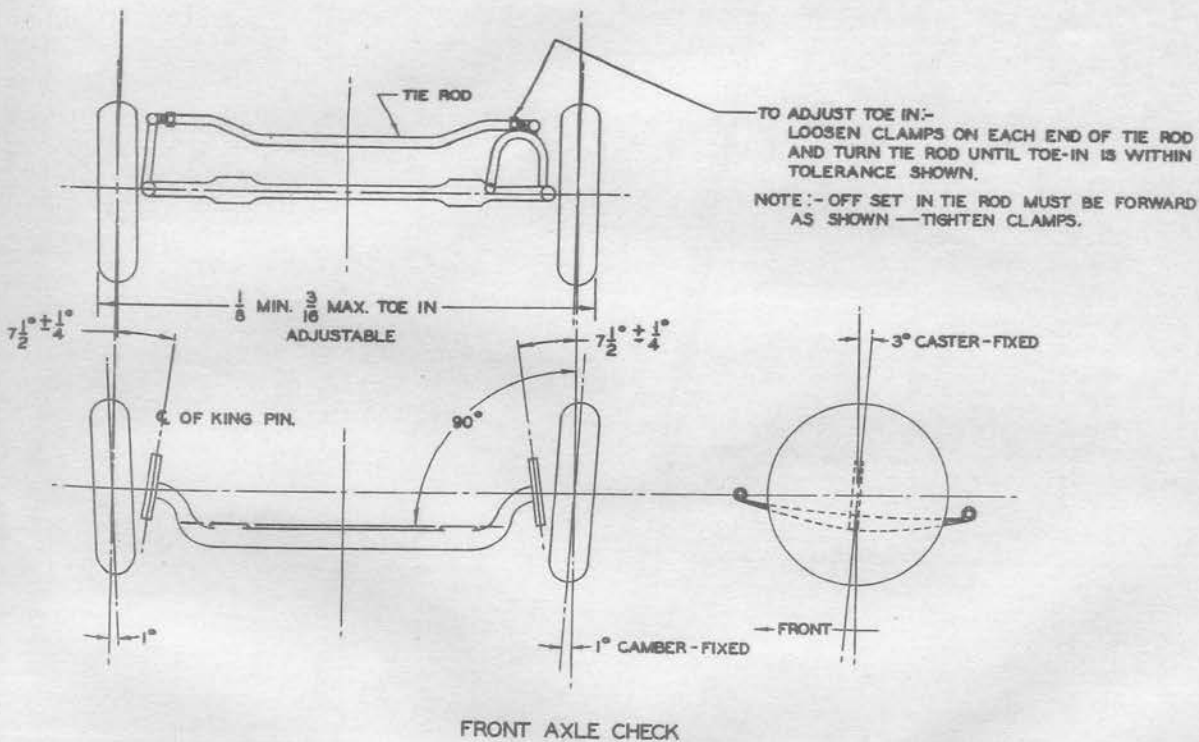


FRONT AXLE

GROUP II

SPECIFICATIONS

Type	I-Beam Section 2-3/8" High
	1-1/2" Wide
Spring Seat Centers	32-1/8"
Spring Seat Width	3-3/4"
King Pin Centers	53-1/8"
King Pin Angle	7-1/2°
Drop of I-Beam From	
Spindle Center to Spring Seat	3-1/2"
Cross Tie Rod	Thompson Adjustable
Steering Angle (Maximum Ahead of Center)	30°
Steering Angle (Maximum Back of Center)	40°
Tread	59-15/16"

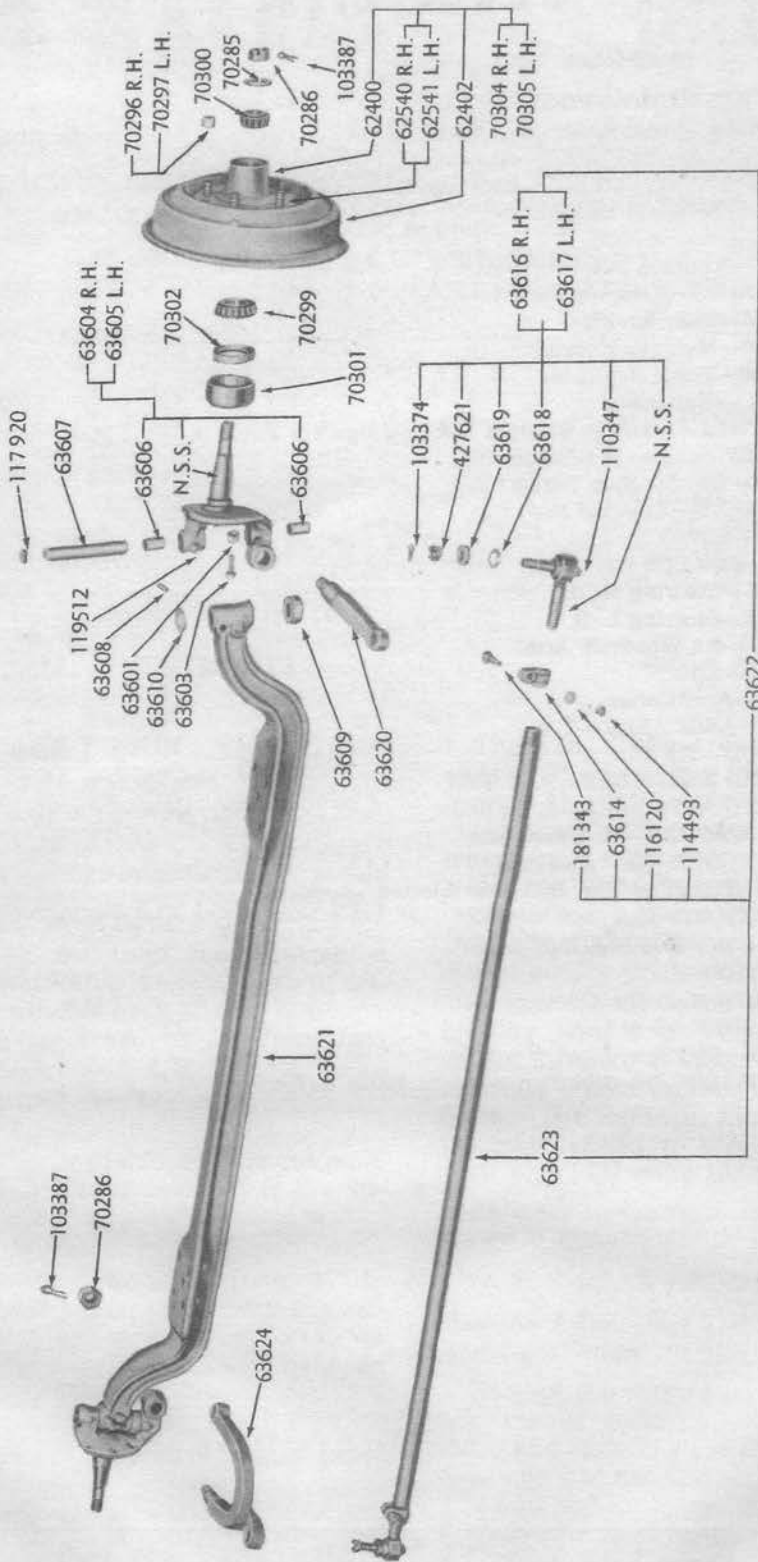


DISASSEMBLY

- A. After removal from vehicle:
 - 1. Clean exterior of assembly thoroughly.
- B. Remove cotters from tie rod ball bolts and with proper wrench remove tie rod ball bolt nuts.
- C. Insert forked wedge between steering arm and tie rod end, and driving on wedge remove tie rod from steering arms.
- D. Remove nut from steering knuckle pin draw key and drive draw key from axle.
- E. Remove expansion plug from top of steering knuckle pin and drive pin from knuckle and axle center. The lower expansion plug will be removed from the knuckle during this operation.
- F. Remove knuckle from axle center, being careful not to drop thrust bearing so that dirt is introduced.
- G. Using proper driver, drive bushings from steering knuckle.

REASSEMBLY

- A. Using proper driver, drive bushings into steering knuckle, being certain the lubricating holes in bushings are in line with fittings in knuckle.
- B. Check fit of pin in bushings. (This should be a "thumb push" fit.)
- C. Holding thrust bearing in position on knuckle install knuckle on axle center and install pin, being certain the slot in pin aligns with hole in axle center so that draw key may be installed without trouble.
- D. Install draw key and secure in place with nut and lockwasher.
- E. Install new expansion plugs over ends of steering knuckle pins.
- F. Install tie rod on steering arms and secure in place with nut, then install and spread cotter key.



FRONT AXLE ASSEMBLY COMPLETE

FRONT AXLE**GROUP 2****PARTS LIST**

No. Req'd.	Part Number	Description
1	80020	AXLE ASSEMBLY—Front
1	63621	CENTER—Front Axle
1	63604	KNUCKLE ASSEMBLY—Steering R. H.
1	63605	KNUCKLE ASSEMBLY—Steering L. H.
4	63606	BUSHING—King Pin
2	63607	PIN—Knuckle King
2	63608	KEY—Knuckle Draw
2	63609	BEARING—Knuckle Thrust
As Req.	63610	SHIM—Thin Knuckle
As Req.	63611	SHIM—Medium Knuckle
As Req.	63612	SHIM—Thick Knuckle
4	117920	PLUG—Expansion
4	119512	FITTING—1/8 I. P. Straight Lubricating (Not Furn. in 80020 Assembly)
2	63603	SCREW—Special Knuckle Stop
2	63601	NUT—Special Stop Screw
2	70285	WASHER—Knuckle Nut
2	70286	NUT—Knuckle
2	103387	PIN—Knuckle Nut Cotter
1	63620	ARM—Steering R. H.
1	63624	ARM—Steering L. H.
2	9125	KEY—#9 Woodruff Arm
2	70286	NUT—Arm
2	103387	PIN—Arm Cotter
1	63622	ROD ASSEMBLY—Tie
1	63623	ROD—Tie
1	63618	END ASSEMBLY—R. H. Rod
1	63617	END ASSEMBLY—L. H. Rod
2	63619	WASHER—Rod End Ball
2	63618	COVER—Rod End Ball
2	427621	NUT—Rod End Ball Bolt Slotted
2	110347	FITTING—1/4-28 Straight 1/2" Long Lubricating (Not Furn. in 80020)
2	103374	PIN—Rod End Ball Cotter
2	63614	CLAMP—Rod
2	181343	BOLT—Hex. Hd. Clamp
2	116120	WASHER—Bolt Lock
2	114493	NUT—Bolt Jam
2	70301	SLINGER—Oil (Not Furnished in 80020 Assembly)