

Description of Revisions: *This bulletin replaces the previous version dated June 2009. Information has been added to clarify that this bulletin pertains only to AirLiner suspension crossmembers.*

General Information

Six-piece bolted service crossmembers are an improved, more durable service replacement for five-piece welded crossmembers, or bolted five-piece service crossmembers, to be used with steel frame rails.

This bulletin lists replacement crossmembers for the following.

- AirLiner Single Axle Suspension Six-Piece Main Crossmember (see **Fig. 1**).
- AirLiner Tandem Axle Suspension Six-Piece Forward Crossmember (see **Fig. 2**).
- AirLiner Tridem Axle Suspension Six-Piece Mid and Forward Crossmember (see **Fig. 3**).

IMPORTANT: This bulletin only applies to AirLiner suspension crossmembers. For replacement kits for 5-piece welded crossmembers that are not listed in this bulletin, refer to *Sterling Service Bulletin 31-2, Five-Piece Crossmember Replacement*.

Parts

Complete crossmember replacement kits are available from the PDCs. For replacement kit numbers, see **Table 1**.

5-Piece Crossmembers		Replacement 6-Piece Crossmember Part Number
Welded 5-Piece Crossmember Part Number	Bolted 5-Piece Crossmember Part Number	
A15-14814-000	A15-22498-000	A15-24632-000
A15-14814-001	A15-22498-001	A15-24632-000
A15-14814-002	A15-22498-002	A15-24632-001
A15-14814-003	A15-22498-003	A15-24632-001
680 310 22 37	A15-22497-000	A15-24632-000
680 310 23 37	A15-22497-001	A15-24632-001
680 310 32 37	A15-22497-006	A15-24632-000
A15-14814-016	A15-22498-016	A15-24632-000
680 310 33 37	A15-22497-007	A15-24632-001
A15-14814-017	A15-22498-017	A15-24632-000
680 310 34 37	A15-22497-008	A15-24632-000
680 310 35 37	A15-22497-009	A15-24632-001

Table 1, Replacement 6-Piece Crossmembers

Crossmember Replacement Procedure

1. Apply the parking brake, then chock the tires on both the front and rear axles.

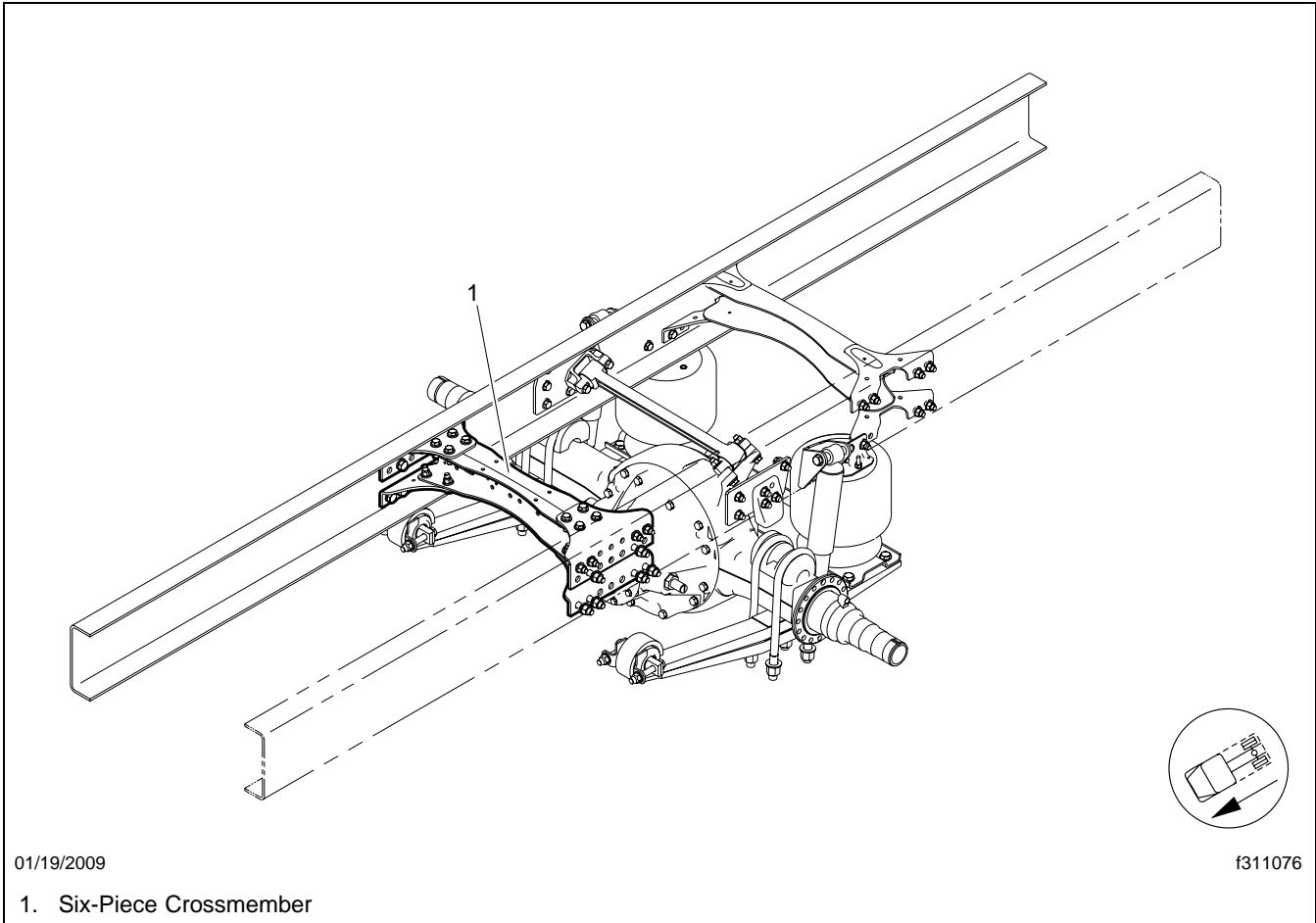
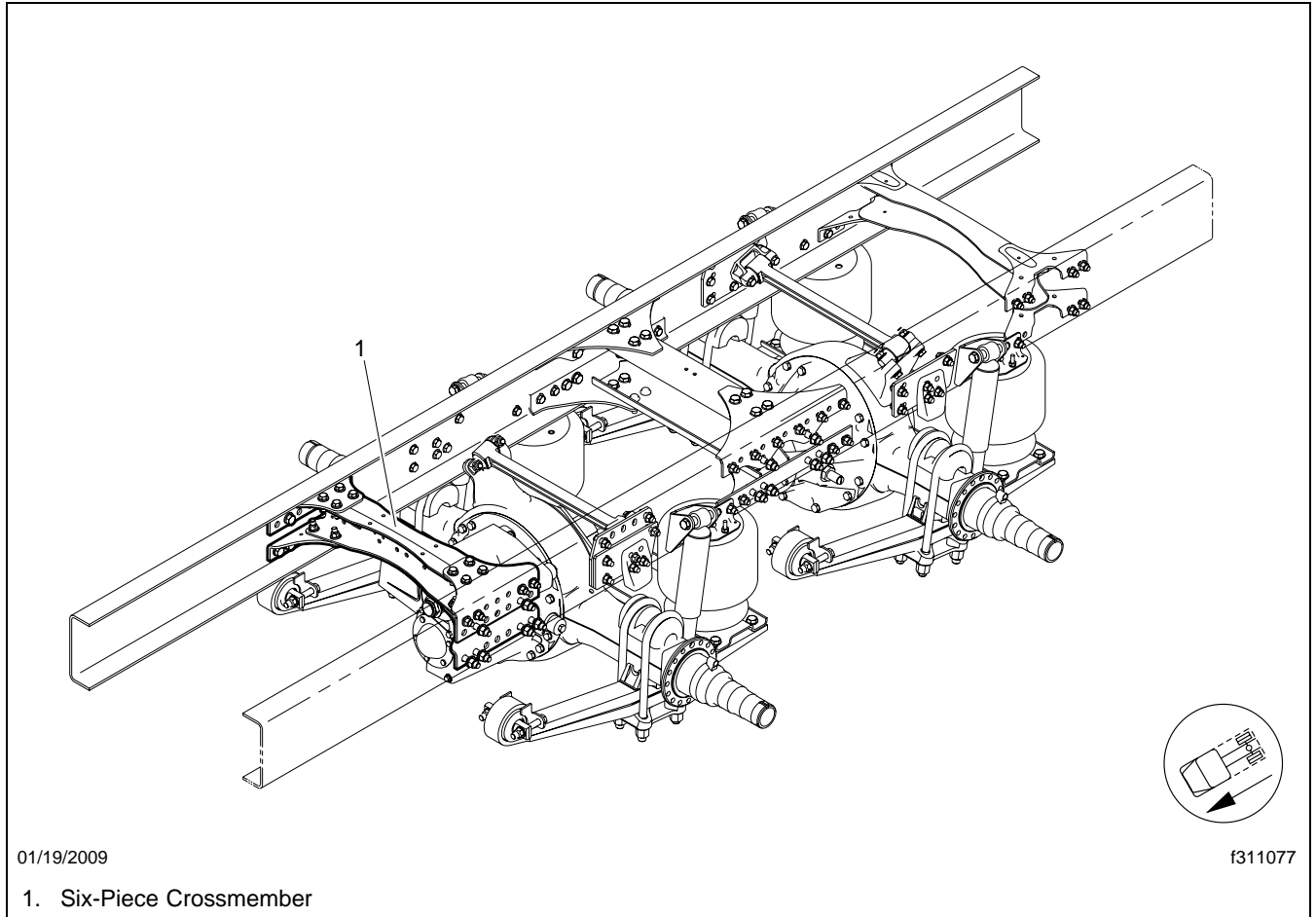


Fig. 1, Single Axle Installation

2. If any air-brake valve is attached to the crossmember, drain the air reservoirs, then remove the valve(s) from the crossmember. Remove any clamps that attach air lines or wiring to the crossmember. Secure the lines or wires away from the crossmember.
3. If rear suspension brackets are attached to the frame rails with the same fasteners that attach the crossmember, use safety stands to support the rear of the frame at its normal ride height.
4. Using a cutting torch, cut the crossmember channel in two at an angle.
5. Remove the fasteners that attach the crossmember halves to the frame rails, and remove the crossmember. If threaded fasteners are used, save them to use with the new crossmember. If huckbolts are used, refer to **Group 31** of the applicable service or workshop manual for instructions on removing and replacing them with threaded fasteners.
6. Attach one new upper gusset to the crossmember channels. Tighten the fasteners snugly, but not to their final torque value.
7. Position the crossmember so the channels are supported on the lower flanges of both frame rails.

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1. Six-Piece Crossmember

Fig. 2, Tandem Axle Installation

8. Slide the other upper gusset into position and attach it to the crossmember channels. Tighten the fasteners snugly, but not to their final torque value.
9. Using a deadblow hammer, tap the crossmember up into place. Align the mounting holes of the upper gussets with the holes in the frame rails. Install the fasteners, but do not tighten them.
10. Position the lower gussets on the crossmember channels. Install, but don't tighten, the fasteners that hold the lower gussets to the crossmember channels. Install the fasteners that attach the lower gussets to the frame rails. If threaded fasteners are used, save them to use with the new crossmember. If huckbolts are used, refer to **Group 31** of the applicable service or workshop manual for instructions on removing and replacing them with threaded fasteners..
11. Tighten the fasteners that attach the gussets to the frame rails 136 lbf-ft (184 N-m), then tighten the fasteners that attach the gussets to the crossmember channels 68 lbf-ft (92 N-m). If any air-brake valve was removed from the old crossmember, install the valve(s) on the new crossmember.
12. Install any clamps that attach air lines or wiring to the crossmember.

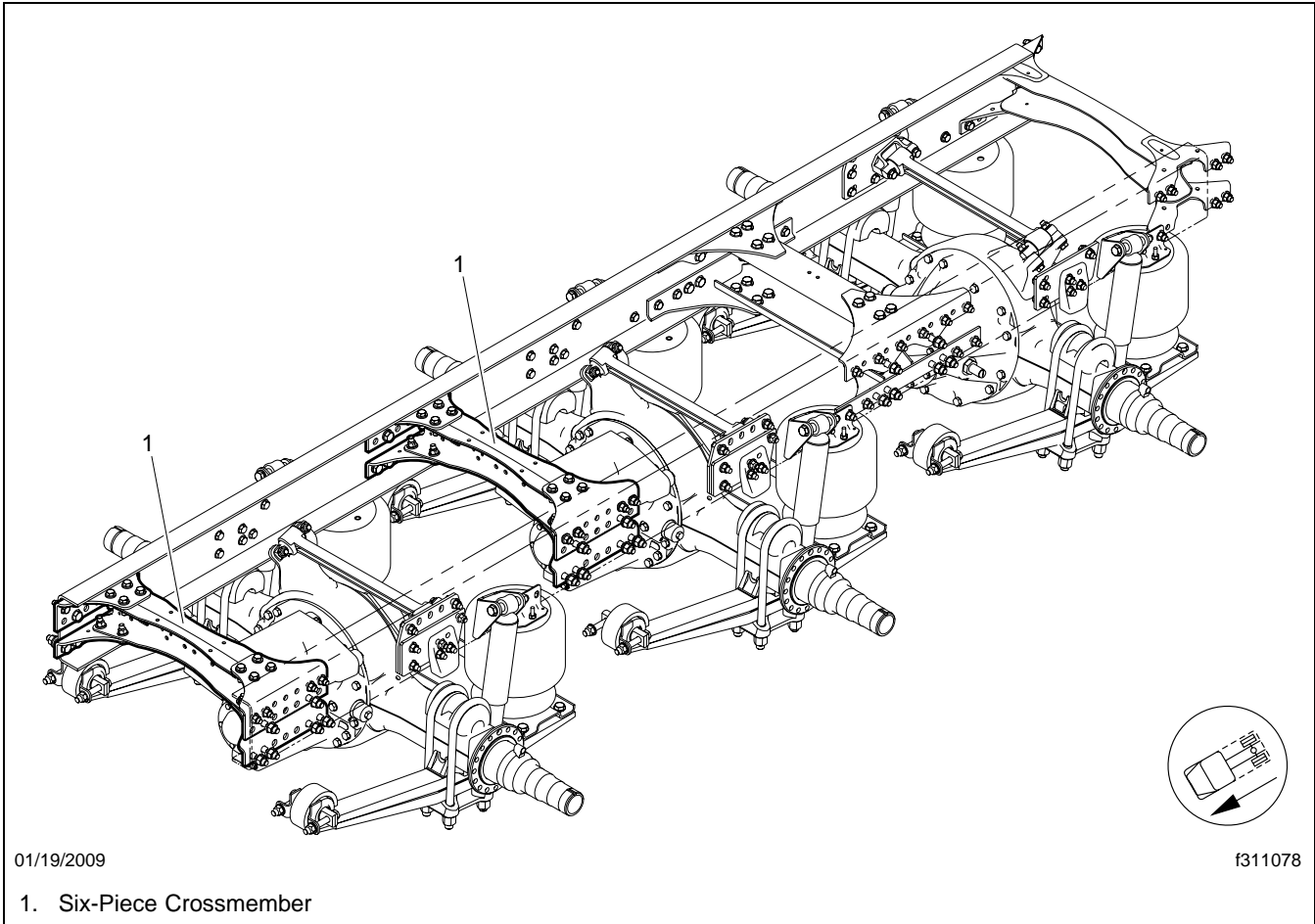


Fig. 3, Tridem Axle Installation

Warranty

This is an informational bulletin only. Warranty reimbursement is applicable nly in the event of an actual failure of the component.