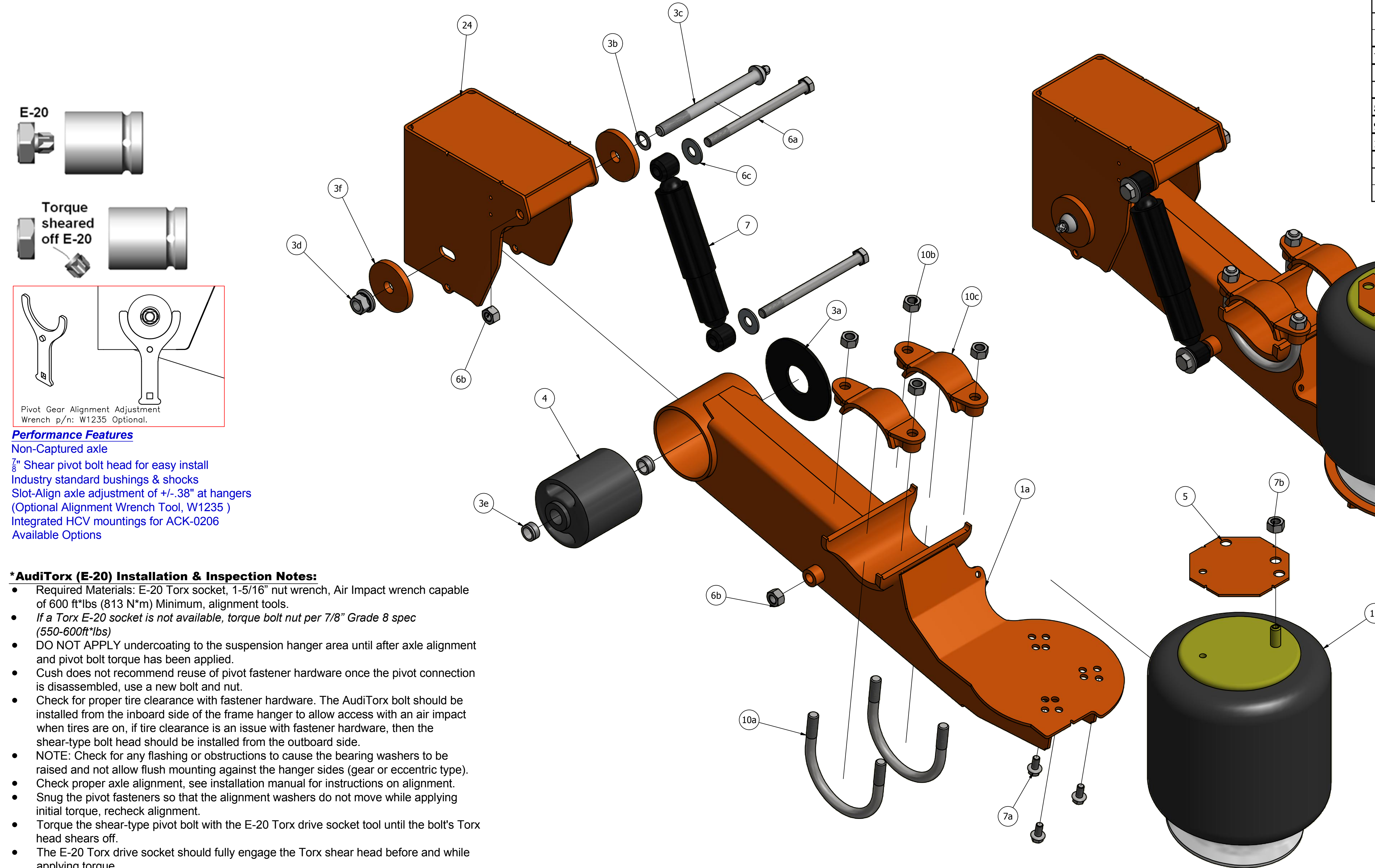


DCN#	REV	Description	DATE	BY	CHK	APP
DRAFTSMAN: DJW	3/19/2015	TITLE: Layout				
CHECKED: CHK		Cush Performance 25000lbs. UnderMount				
RELEASED: APP		5" Round Axle, Weld On U-Bolt				
WEIGHT: N/A		6.5"-10.5" Ride Height (9" STD)				
MATERIAL:						
All of the Information shown herein is the intellectual property of Cush Corp and is submitted only on a confidential basis. The recipient agrees that no disclosure of this information will be made to a third party without written consent of Cush Corp.		TOLERANCE UNLESS OTHERWISE STATED: XX = +/- .062 FRACTIONS = +/- 1/16 XXX = +/- .031 ANGLES = +/- 1°	PROJECT NO: 14208	SHEET: 1 OF 3	SCALE: A-SIZE: NTS B-SIZE: 1/X D-SIZE: 1/4	REV: -
		PART/DRAWING NO: CP25UC9-KU				



Nixa, MO, USA
PHONE: 417-724-1239
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Customer to torque all fasteners!				(Ft*Lbs)		(Nm)	
General Fastener Torque Specs	Size	Thread	Grade	Min.	Max.	Min	Max.
Air Spring Mount Bolt	3/8	16-UNC	5/B	25	35	34	47
Air Spring Bottom Mount Nut	1/2	13-UNC	5/B	25	35	34	47
Air Spring Bottom Mount Bolt	1/2	13-UNC	5/B	40	50	54	68
Air Spring Top Mount Nut	3/4	16-UNF	5/B	40	50	54	68
Shock Mount Nut/Bolt	3/4	10-UNC	5/B	210	235	285	319
U-Bolt Nut / Pivot Bolt	3/4	10-UNC	8/C	330	380	447	515
Pivot Nut (SecureLok/Securex)	7/8	9-UNC	8/C	550	600	746	813



Item	Performance Model Descriptions: CP25UC9-KU	Cush P/N:	Qty
1	Beam Assembly		
1a	Roadside (LH) Beam for U-Bolt & Weld-on axle mount	W0900-3	1
1b	Curbside (RH) Beam for U-Bolt & Weld-on axle mount	W0900-4	1
2	Frame Bracket, Wingless, Weld-on, Slot Align, P=9" Tall (4.75")	W1226	2
3	Pivot Bushing Hardware Kit (Per Hanger Side L/R)	K0623	2
3a	Wear Washer, 0.25" thk	C0061	1
3b	Washer 0.875" SAE Thru-Hard	H2101	1
3c	AudiTorx HHCS 0.875"-9 UNC x 10"lg grd8	H0124	1
3d	Nut, SecureLok Nut 0.875"-9 UNC	H1106	1
3e	Bushing Insert, Reducer from 1.25" OD to 0.9" ID	T0063	2
3f	Round Alignment Washer, Inner and Outer	F1184-50	2
4	Dual Rate Bushing, 6.75" Long 1.25" ID	C0052	2
5	0.19" Tall spacer Weld-on Plate, Octagon	F0790	2
6	Bolt Kit, Mounting for Shock Pair	K0025	1
6a	HHCS, 0.75-10unc x 10"lg, Grd 5	H0225	4
6b	Nut, locking, 0.75-10unc, grd C	H1201	4
6c	Washer 3/4" ID, USS	H2203	4
7	Bolt Kit, Air Spring Mounting (Top/Bottom)	K0054	1
7a	HHCS, Flangelock 0.5-13UNC x 1"	H0304	6
7b	L'Nut, Nylock 0.75-16UNF	H1202	2
8	Shock 16"Max/10.7"Min (Gabriel #85064)	C0226	2
9	Air Spring, (Firestone#9580/GY#1R12-467/Conti#1010-21P434)	C0060	2
10	Kit, U-Bolt w/ Nuts and Brackets	K0673	2
10a	U-Bolt 3/4"-10 x 6 1/8" Long, Grade 8	HU204	2
10b	L'Nut, 3/4-10 UNC, Top Lock, Grade C	H1201	4
10c	U-Bolt Bracket	W1300	2

Performance Features
Non-Captured axle
7/8" Shear pivot bolt head for easy install
Industry standard bushings & shocks
Slot-Align axle adjustment of +/- .38" at hangers
(Optional Alignment Wrench Tool, W1235)
Integrated HCV mountings for ACK-0206
Available Options

- *AudiTorx (E-20) Installation & Inspection Notes:**
- Required Materials: E-20 Torx socket, 1-5/16" nut wrench, Air Impact wrench capable of 600 ft*lbs (813 N*m) Minimum, alignment tools.
 - If a Torx E-20 socket is not available, torque bolt nut per 7/8" Grade 8 spec (550-600ft*lbs)
 - DO NOT APPLY undercoating to the suspension hanger area until after axle alignment and pivot bolt torque has been applied.
 - Cush does not recommend reuse of pivot fastener hardware once the pivot connection is disassembled, use a new bolt and nut.
 - Check for proper tire clearance with fastener hardware. The AudiTorx bolt should be installed from the inboard side of the frame hanger to allow access with an air impact when tires are on, if tire clearance is an issue with fastener hardware, then the shear-type bolt head should be installed from the outboard side.
 - NOTE: Check for any flashing or obstructions to cause the bearing washers to be raised and not allow flush mounting against the hanger sides (gear or eccentric type).
 - Check proper axle alignment, see installation manual for instructions on alignment.
 - Snug the pivot fasteners so that the alignment washers do not move while applying initial torque, recheck alignment.
 - Torque the shear-type pivot bolt with the E-20 Torx drive socket tool until the bolt's Torx head shears off.
 - The E-20 Torx drive socket should fully engage the Torx shear head before and while applying torque.
 - Apply paint to the sheared away Torx area as a rust preventative.

DCN#	REV	Description	DATE	BY	CHK	APP
DRAFTSMAN: DJJV	3/19/2015	TITLE: Part List Installation Sheet				
CHECKED: CHK		Cush Performance 25000lbs. UnderMount				
RELEASED: APP		5" Round Axle, Weld On U-Bolt				
WEIGHT: N/A		6.5"-10.5" Ride Height (9" STD)				
MATERIAL:						
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PROJECT NO:	14208	SHEET: 2 OF 3	SCALE: A-SIZE: NTS B-SIZE: 1/X D-SIZE: 1/4	REV: -	PART/DRAWING NO: CP25UC9-KU	

CUSH GENERAL INSTALLATION NOTES, SEE CUSH SERVICE/INSTALLATION MANUAL

INSTALLATION DISCLAIMER NOTES:

- 1) It is important that the proper Cush suspension is chosen for the trailer application. The following criteria must be considered when selecting a suspension: required suspension capacity, loaded frame-to-ground measurement, ride height, axle travel, axle spacing, and axle GAWR.
- 2) It is the responsibility of the installer to determine the correct location of the suspension in order to provide the proper trailer load distribution. The gross axle weight rating (GAWR) of each axle must not exceed the rated capacity of any of the components involved. The suspension capacity ratings are for suspension components and axle beam only.
- 3) Required cross member locations maybe shown. Actual size and shape may vary per trailer design. It is the responsibility of the suspension installer to ensure structural adequacy of the trailer frame and related cross members. Verify that the actual trailer cross member locations correspond with those specified on the suspension drawing.
- 4) It is the responsibility of the suspension installer to read the instructions on all the drawing sheets thoroughly before proceeding with a suspension installation.

CUSTOMER TORQUE INSTRUCTIONS:

- 1) *DUAL RATE PIVOT BUSHING JOINT SNUG FROM FACTORY. CUSTOMER TO TORQUE THIS JOINT TO SPECIFICATION AFTER AXLE ALIGNMENT.
- 2) It is the customer's responsibility to check and tighten fasteners to specified torque at installation, after the suspension has been in operation for 3000 miles, and at suspension inspection cycles. Failure to do so can result in loss of warranty.
- 3) Torque values given are specified for the fasteners in the condition supplied by Cush Corporation. DO NOT APPLY ANY ADDITIONAL LUBRICANTS.
- 4) CAUTION: Fasteners should never be reused if removed or loss of clamp load occurs. For proper joint clamping contact Cush for replacement fasteners.
- 5) CAUTION: Over-torquing fasteners could result in material failure.

Customer to torque all fasteners!				(Ft*Lbs)		(Nm)	
General Fastener Torque Specs	Size	Thread	Grade	Min.	Max.	Min	Max.
Air Spring Mount Bolt	3/8	16-UNC	5/B	25	35	34	47
Air Spring Bottom Mount Nut	1/2	13-UNC	5/B	25	35	34	47
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Shock Mount Nut/Bolt	3/4	10-UNC	5/B	210	235	285	319
U-Bolt Nut / Pivot Bolt	3/4	10-UNC	8/C	330	380	447	515
Pivot Nut (SecureLok/Securex)	7/8	9-UNC	8/C	550	600	746	813

INSTALLATION OF "SLOT-ALIGN" NOTES:

- OVERVIEW: The "SLOT-Align" pivot joint features outside eccentric cam gear washer that cover the alignment slo and gives the user a economical way to get axle alignment feature.
- CAUTION: DO NOT APPLY undercoating to the area until after alignment and torque of the pivot bolt.
- With the pivot bolt loose.
 - For adjustment, use a breaker bar or other to move the axle forward/rearward.
 - The Slot gives you 3/8" pivot movement fore and aft per hanger side.
 - To align the axle, move one side of the suspension to get the axle aligned. If needed, go to the other side of the suspension and move in the opposite direction to fully align the axle.
 - After alignment, clamp the joint per Cush torque specifications. After alignment, the suspension installer can weld the outside washer to the hanger side with 1/2" welds two opposite places to prevent tampering & for off-road applications.

ORIGINAL-INSTALLATION INSPECTION NOTES, verify that:

- The installation clearance requirements have been met.
 - The axles have been aligned properly.
 - The suspension frame bracketry and air spring plate welds have been properly completed per specifications.
 - All suspension bolt torques are to Cush specifications.
 - The suspension ride height is set properly.
 - The suspension can articulate freely through its entire travel and adequate component clearances have been provided.
- INSPECTION:** 30-DAY, 90-DAY, & at every brake lining change.
- Check installation clearance requirements.
 - Check for any signs of wear or component interferences.
 - Check suspension attachment welds for signs of problems.
 - Check that all bolts are in place and securely torqued.
 - Check pivot bushings & clamping connections for problems.
 - Check that the trailer is level.
 - Check tire wear that might indicate an alignment problem.

INSTALLATION NOTES:

- Measure trailing arm centers and track to verify your requirements.
 - DO NOT APPLY undercoating to the suspension until after completing the alignment. Undercoating will effect clamp load of the pivot connection fastener and can damage the hardware.
 - Mount hangers onto trailer frame per suspension drawing sheets.
 - Place plastic washers on both sides of bush inner metal and insert spacer collars into bush inner sleeve.
 - Measure for fitup then mount Cushride trailing arm/axle assembly into suspension hangers.
- NOTE: If the assembly fits tightly, it may be necessary to spread the mounting. DO NOT GRIND material from suspension components.
- Place"-Align" gear washer, with indicator in neutral position, and insert pivot bolt/washer
 - Mount pivot washer/nut and torque joint for a snug fit.
 - Adjust "-Align" for proper axle track alignment.
 - Torque bushing pivot bolts per Cush torque instructions.
- NOTE: Failure to follow the procedures in the Cush Service and Installation manual and/or properly torque the pivot fasteners at this time can result in a failed pivot connection and a loss of warranty coverage!
- Install air springs and shocks per suspension installation manual and drawing sheets.

AXLE WELDING NOTES, See Cush Procedure A0001:

- WARNING: Review Cush Recommended Steel Welding Procedures
- Suspension components and their mating parts must be at a minimum temperature of 60°F(15.5°C) and free from moisture, dirt, scale, paint, grease, and other contaminates.
 - For the best axle to beam weld joint use the following wire.

Axle Weld Wire: AWS ER70S-6

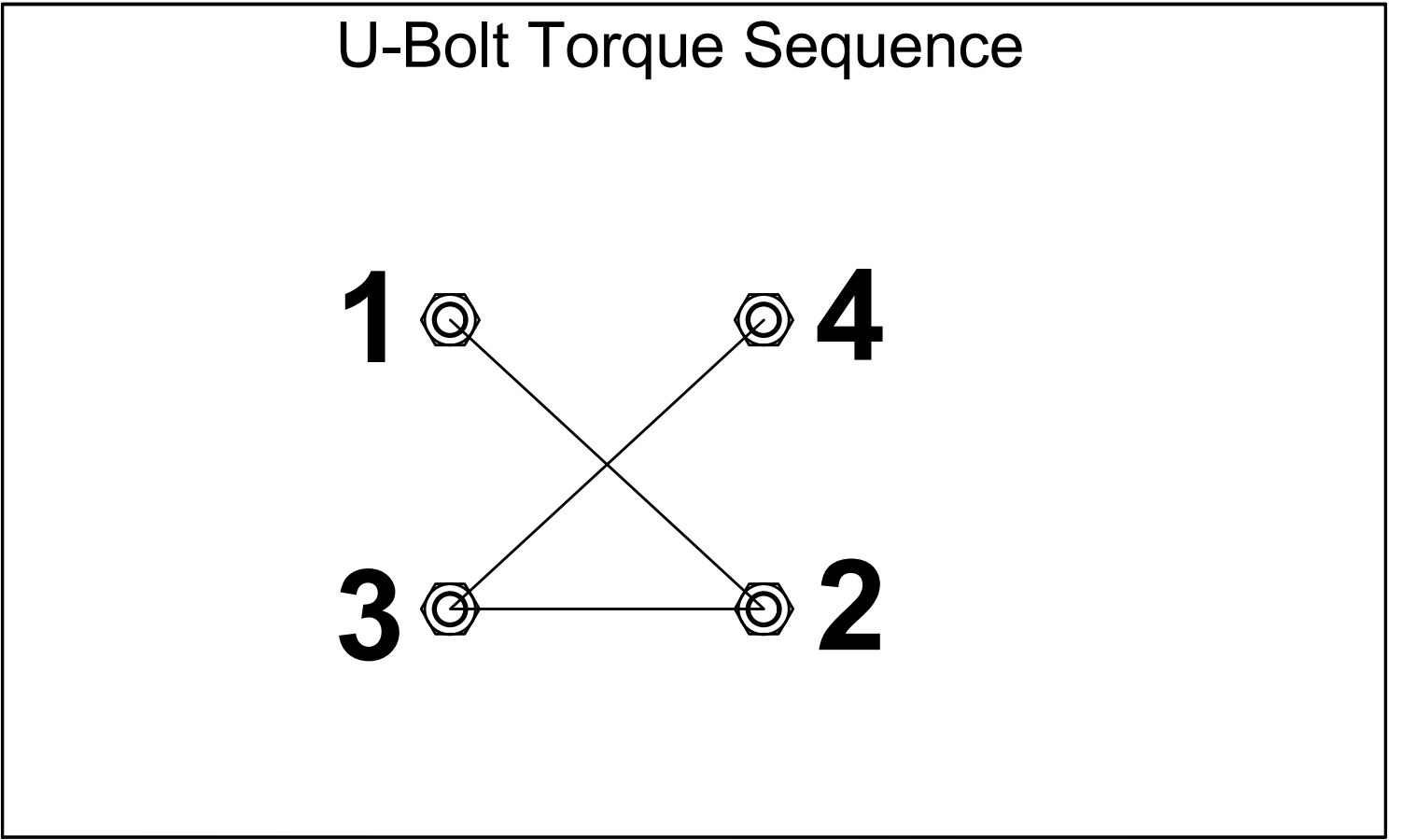
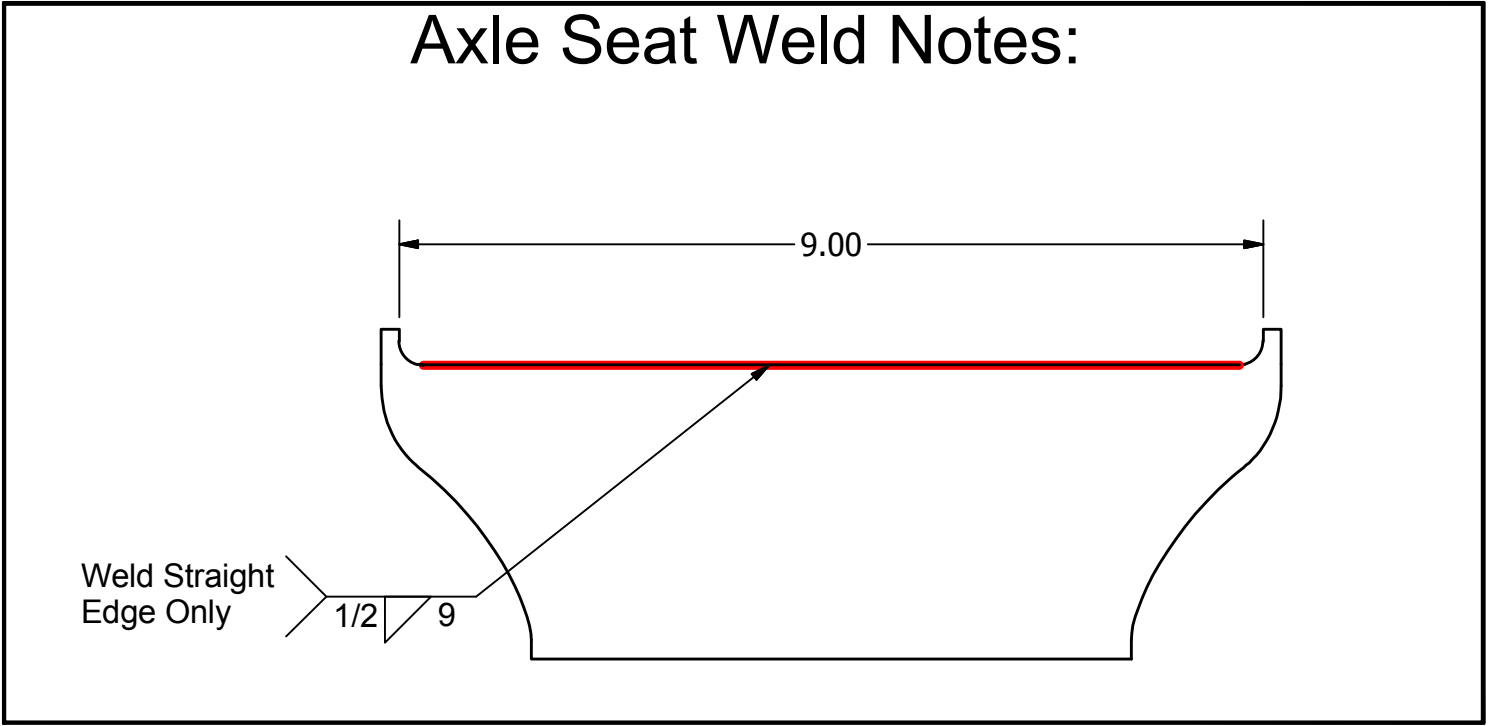
- Create the root pass to connect the axle to the trailing arm beam. Hit the axle seat tabs down to the axle to give you parent metal for pass 2 and 3. Finnished axle weld should be a multi-pass 1/2" weld.

U-BOLT INSTALLATION NOTES:

- WARNING: Do not apply any lubricants to the u-bolts
- U-Bolts should only be installed and torqued after completion of axle welding. Allow sufficient axle cooling time before applying torque to u-bolts.
 - Snug u-bolts evenly before applying torque. Check that u-bolts are parallel and square to axle.
 - Torque u-bolts in a three step process to avoid an improperly clamped axle and resulting damage. This allows the u-bolt to strech/relax and hold torque. Proper tightening will allow equal amount of tread above each nut.
First Step-1/3 of Final torque
Second Step-2/3 of Final torque
Third Step-Final torque

	Max	Bumper		Min	Full
Ride	Jounce	Contact	Rebound	Jounce	Rebound
Height	"UP"	"UP"	"DOWN"	Height	Height
6.5	2.3	2.0	7.0	4.2	13.5
7.0	2.8	2.5	6.5	4.2	13.5
7.5	3.3	3.0	6.0	4.2	13.5
8.0	3.8	3.5	5.5	4.2	13.5
8.5	4.3	4.0	5.0	4.2	13.5
9.0	4.8	4.5	4.5	4.2	13.5
9.5	5.3	5.0	4.0	4.2	13.5
10.0	5.8	5.5	3.5	4.2	13.5
10.5	6.3	6.0	3.0	4.2	13.5

General Application Dimension Variables - Installation Clearance Notes Supersede all Common Variables Shown							
B" Ref. Suspension Beam(Hanger) Centers	34	35	40	41	40	39	
S" Ref. Air Spring Centers (2" inset/side)	30	31	36	37	36	35	
T" Ref. Axle Track	71.5"	71.5"	76.5"	77.5"	77.5"	77.5"	
C" Approx. Chamber Centers for 16.5" x 7" Brake	9.75	9.75	14.75	15.75	15.75	15.75	
T" Ref. Inside of Tires Min (Hanger Style)	46.5	46.5	51.5	52.5	52.5	52.5	
T" Ref. Inside of Tires Min (Yoke Style)	48	48	53	54	54	54	
Installation Clearance Notes							
1. 0.75" minimum clearance must be maintained around air spring when it is at maximum diameter.							
2. It is the responsibility of the installer to ensure that proper clearances exist at the tires: 1" minimum clearance required between top of tire and bottom of trailer structure when axle is at full jounce, 2" minimum clearance required between inside of tire and trailer frame structure for lateral movement, and there should be ample fore and aft clearances. 0.25" clearance is recommended between suspension beam and brake s-cam shaft.							



DCN#	REV	Description	DATE	BY	CHK	APP
DRAFTSMAN: DJW	3/19/2015	TITLE: Installtion Notes				
CHECKED: CHK		Cush Performance 25000lbs. UnderMount				
RELEASED: APP		5" Round Axle, Weld On U-Bolt				
WEIGHT: 9.199 lbmass		6.5"-10.5" Ride Height (9" STD)				
MATERIAL: Steel						
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PROJECT NO:	SHEET: 3 OF 3	SCALE: A-SIZE: NTS B-SIZE: 1/X D-SIZE: 1/4	REV:	-	PART/DRAWING NO: CP25UC9-KU	



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