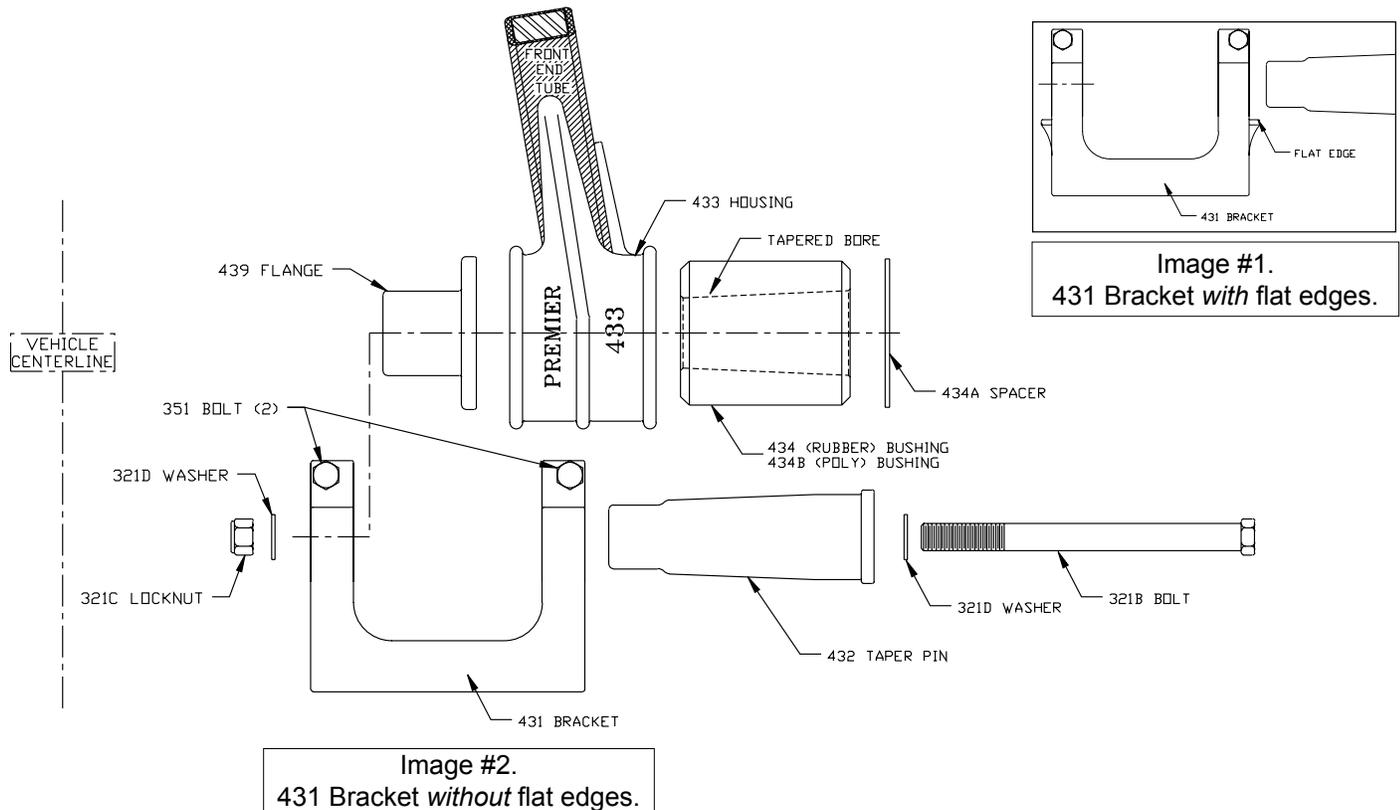




PREMIER MANUFACTURING COMPANY

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430/430A HINGE ASSEMBLY - SERVICE GUIDE



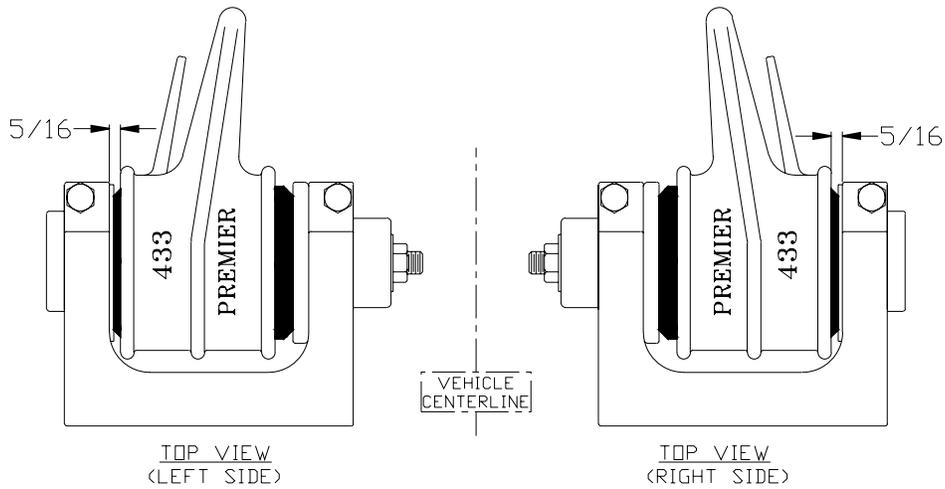
This document is to assist in the replacement of the 430/430A Hinge Assembly components that had previously been installed. **Because the 430/430A Hinge Assemblies operate in pairs, the service instructions below are to be followed simultaneously, for each hinge.**

For new hinge assembly installation instructions, please contact us.

ASSEMBLY:

1. Place the 439 Flange into the bore hole, on the vehicle centerline side of the 431 Bracket. Make certain that the slit in the flange lines up with the slit in the bracket.
 2. Slide the 434/434B Bushing into the 433 Housing, making sure that the smaller diameter end of the tapered bore in the bushing is towards the 439 Flange. Place the housing into the 431 Bracket aligning the bores as much as possible.
 3. At the opposite end that the 439 Flange resides, insert the 434A Spacer between 434/434B Bushing and the inside surface of the 431 Bracket. Push the spacer in far enough so the hole is centered with the bracket bore hole.
 4. Slide the 432 Taper Pin into the 431 Bracket bore hole from the opposite end of the 439 Flange. IF there are Flats on each side of the 431 Bracket (see Image #1), then make certain the flat on the taper pin is aligned with the flat edge on the bracket. If there are *not* Flats on the bracket (see Image #2), then continue reading.
 5. Using a rubber mallet only, tap the taper pin into the bracket until the head of the taper pin is flush against the bracket.
 6. Place one 321D Washer onto the 321B Bolt and slide it through the 432 Taper Pin, as shown in diagram. Place the second 321D Washer and 321C Locknut onto the end of the 321B Bolt. Prior to tightening, check to make sure that there is a 5/16" gap between the outside face of the 433 Housing and 431 Bracket (see Image #3).
 7. Torque the 321C Locknut to 60 ft-lbs. Test each hinge assembly for desired rotational stiffness. If a stiffer hinge is desired, tighten the 321C Locknut in 10-20 ft-lb increments. **DO NOT EXCEED 200 ft-lbs of TORQUE.**
 8. Tighten the 351 Bolts to 80 ft-lbs of torque. These bolts compress the 431 Bracket, clamping both the 439 Flange and 432 Taper Pin.
- IMPORTANT NOTE:** Both 351 Bolts must first be loosened, prior to any future adjustment of the 321B Bolt for hinge stiffness. After adjustment, the 351 Bolts must be re-torqued to 80 ft-lbs.

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Centerline Setup
Finished configuration

Image #3



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