

PLUS KIT™

STEMCO KAISER PLUS KIT **Better Fit, Less Down Time & Better Quality**

STEMCO Kaiser has been offering a “no-ream” bi-metal king pin kit for over ten years, yet many customers were asking for a better fit than the product provided. That was until now! With improvements to our PLUS Kit, we now offer pre-sized bi-metal bronze bushings with the fit of a tightly reamed king pin installation.

When you compare our manufactured parts, notice the difference in quality compared to other kits. The ease of installation and the improved fit of pin & bushing shows that the STEMCO Kaiser PLUS Kit is the most economical way to do your king pin job. Now there is no reason to spend thousands on reamers and all the costs associated with reaming. You will get a great fit every time you use a PLUS Kit.

STEMCO Kaiser PLUS KIT™ **For No Ream Installation & Perfect Fit**

- Pre-sized Bronze Bushings
- No Need to buy Reamers
- Fit as Good as “Reamed”
- Install Faster than Reaming
- Least Expensive King Pin Installation



REMOVAL

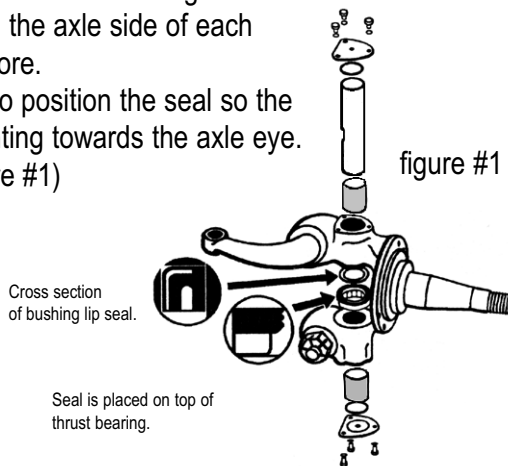
- Use established procedures for teardown.

STEERING KNUCKLE AND AXLE PREPARATION

- Clean spindle and axle eyes and wipe dry.
- Remove any burrs from spindle bores and axle eyes using brake hone or similar device.

INSTALLING BUSHING LIP SEALS

- Handle with care, lip seals are easily damaged.
- Using a bushing driver or similar device, drive the seals into the bore leaving the seal flush with the axle side of each spindle bore.
- Be sure to position the seal so the lip is pointing towards the axle eye. (see figure #1)



SPECIAL INSTRUCTIONS FOR INSTALLING PRESIZED BRONZE BUSHINGS

- Using the Kaiser Plus bushing driver specifically designed for your kit, drive both bushings into bores.

CHECK BEFORE ASSEMBLY

- Wipe bushings clean.
- Using king pin check for fit, first insert pin into each bushing individually then insert pin into both bushings, king pin should slide through both bushings simultaneously.
- If pin fits through bushings individually but not

simultaneously the spindle has spread and may need replacement.

BEARING INSTALLATION

- Prepack bearings with grease.
- For proper bearing orientation please refer to figure #1.
- Place needed shims under upper spindle bore.
- Position king pin through upper spindle bore and through needed shims, be sure TOP of pin is parallel to axle for proper lock flat alignment.
- Place spindle, shims and pin onto axle, allow pin to drop into axle bore about 2".
- Tap bearing into place, a properly fit bearing will require a slight tap fit without damaging the bearing case.
- If bearing is too tight or too loose, adjust the number of shims being used.

COMPLETE PIN INSTALLATION

- Once the bearing fit is correct, allow pin to slip into lower bushing.
- Position lock pin flats on pin so they line up with lock holes.
- Pound lock pins into place, lock pins with threads apply 25-30 ft. lbs of torque.

END PLATE OR END PLUG INSTALLATION

- Install end plates or end plugs, using the proper seal under plates.
- Install grease fitting into end plate or end plug.

GREASING

- Apply grease until it can be seen between axle and spindle.

CHECK INSTALLATION

- Once greased the spindle should turn easily from side to side.
- There should be very little up and down movement.
- If unit seems loose or too tight we recommend calling our tech line for assistance.

STEMCO

KAISER™

GETTING HELP

USE THE STEMCO Kaiser TECHNICAL SERVICE LINE

888-854-6474

WARNING: STRIKING STEEL PARTS WITH HAMMERS CAN RESULT IN CHIP PROJECTILES, ALWAYS WEAR SAFETY GLASSES TO PROTECT YOURSELF AGAINST INJURY. STEMCO Kaiser IS NOT RESPONSIBLE FOR ANY INJURY THAT MAY OCCUR DURING THIS PROCESS.

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