

## SAF Intra Suspension

### Hanger bracket pivot mount repair procedure

**Note:** The style of hanger shown on page 5 cannot be repaired and must be replaced.

- Remove trailing arm from hanger bracket by lowering the suspension
- Make a repair template (refer to template diagram on page 4)
- Place repair template over the damaged hole using the alignment brace to locate template. Align the bottom of the repair template to the lower edge of the hanger as per (Fig 1)



Figure 1

- Clamp template to hanger and scribe around the 66mm diameter hole.(Fig 2)

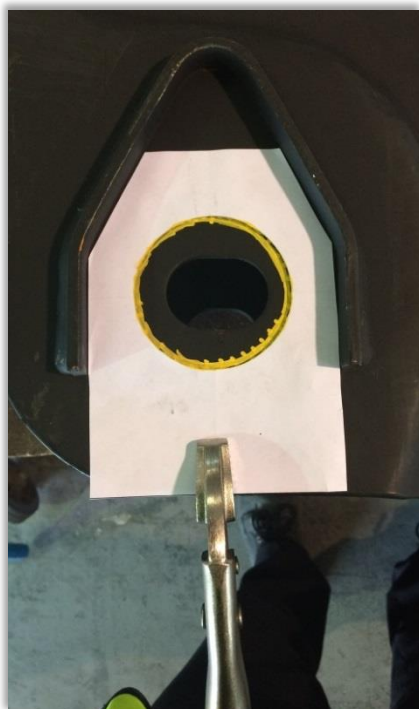


Figure 2

- Once circle has been scribed, remove template and center punch the line of the 65mm diameter mark before cutting out. (Fig 3)



Figure 3

- Cut along center punch line using oxy/fuel cutting equipment (Fig 4)

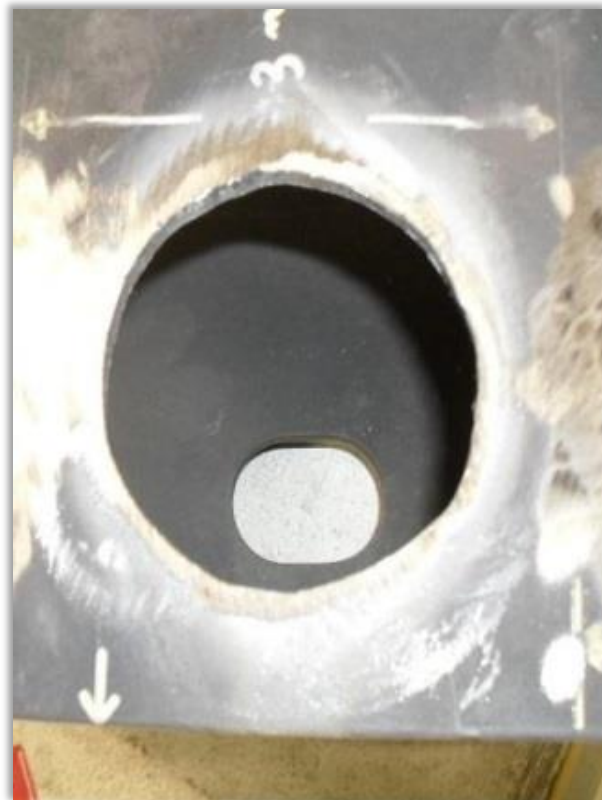


Figure 4

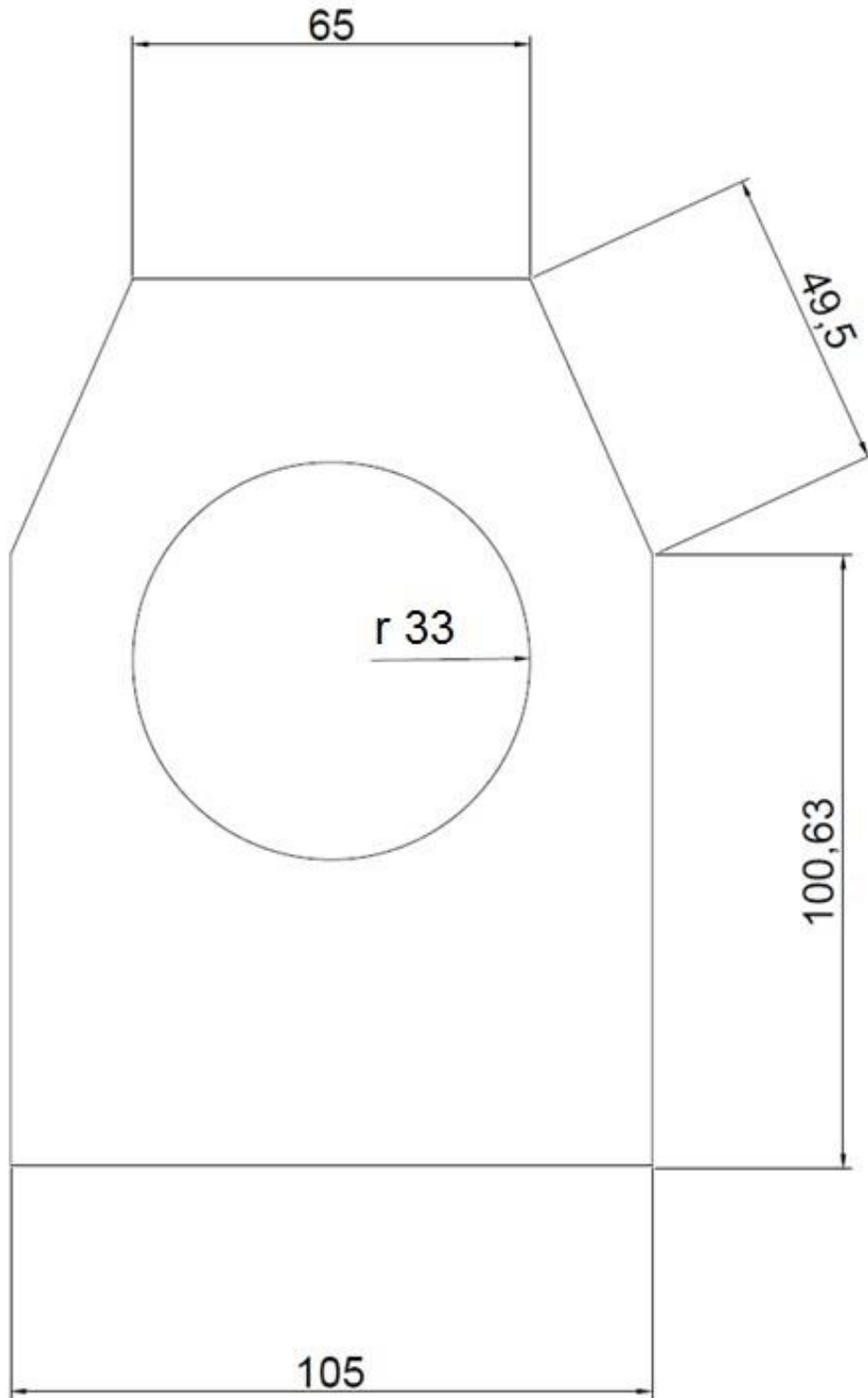
- Clean area and ensure the new bush can be neatly inserted into hole
- Ensure all burs and slag has been removed from the inside and outside of the hanger
- Place new bush sleeve in position ensuring bush is flat and in full contact with hanger
- Tack weld in 4 places (Fig 5).



Figure 5

- Fully weld the outer edge of bush to hanger with a 6mm fillet weld. Ensure that full and complete penetration has been achieved to all welds
- Follow the above procedures for the opposite side of the hanger bracket.

TEMPLATE: NOT TO SCALE



**The below hanger style can not be repaired and must be replaced if damaged**



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