

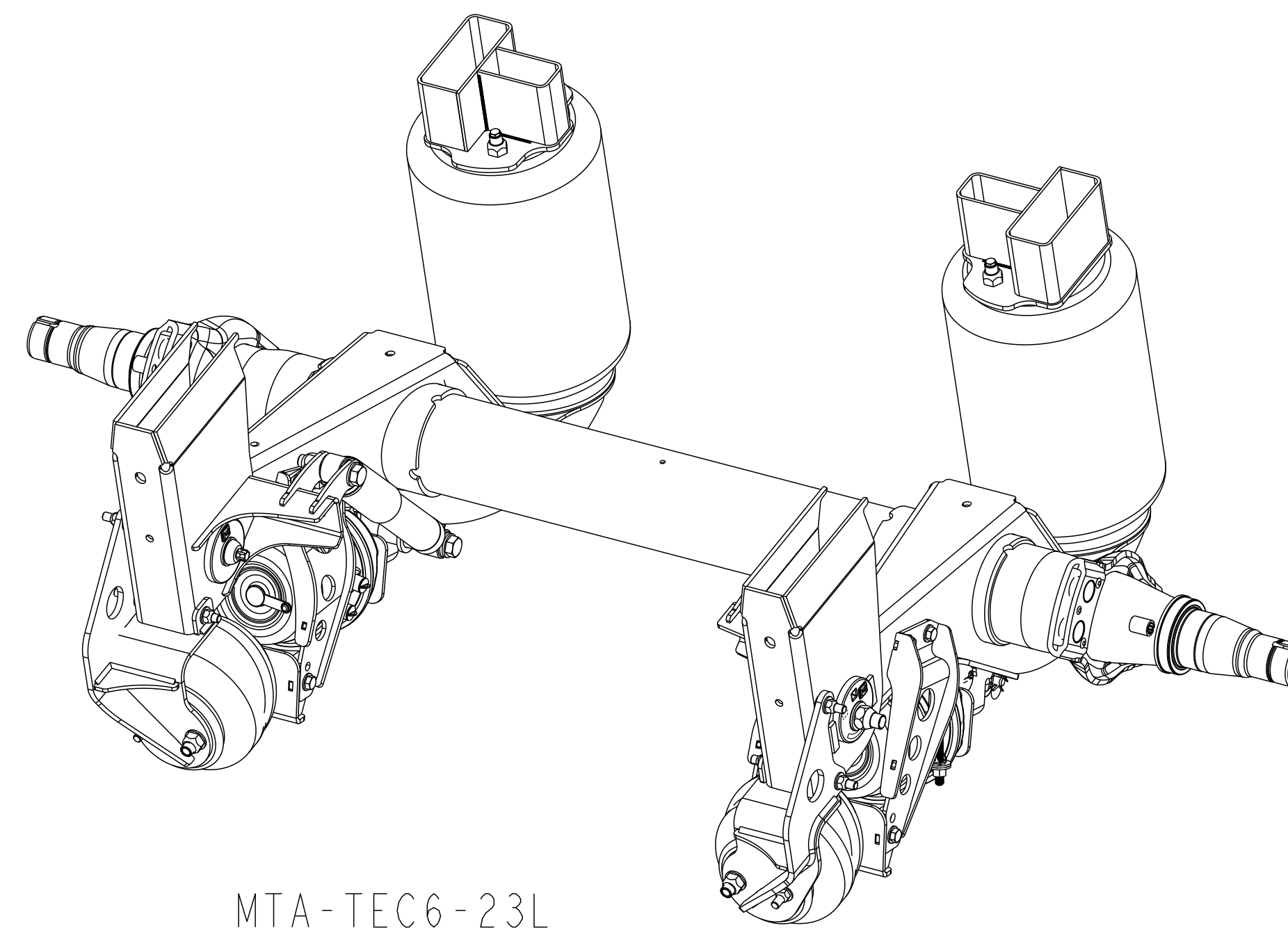
NOTES:

1. DRUM BRAKE AIR CHAMBERS:

- 23T - E61-3276D30 (STANDARD 2.5" STROKE) (RECOMMENDED)
- 23T - E50-3276D30 (LONG STROKE (3.0"))
- 23L - G56-3276D30 (STANDARD 2.5" STROKE) (RECOMMENDED)
- 23L - G53-3276D30 (LONG STROKE (3.0"))

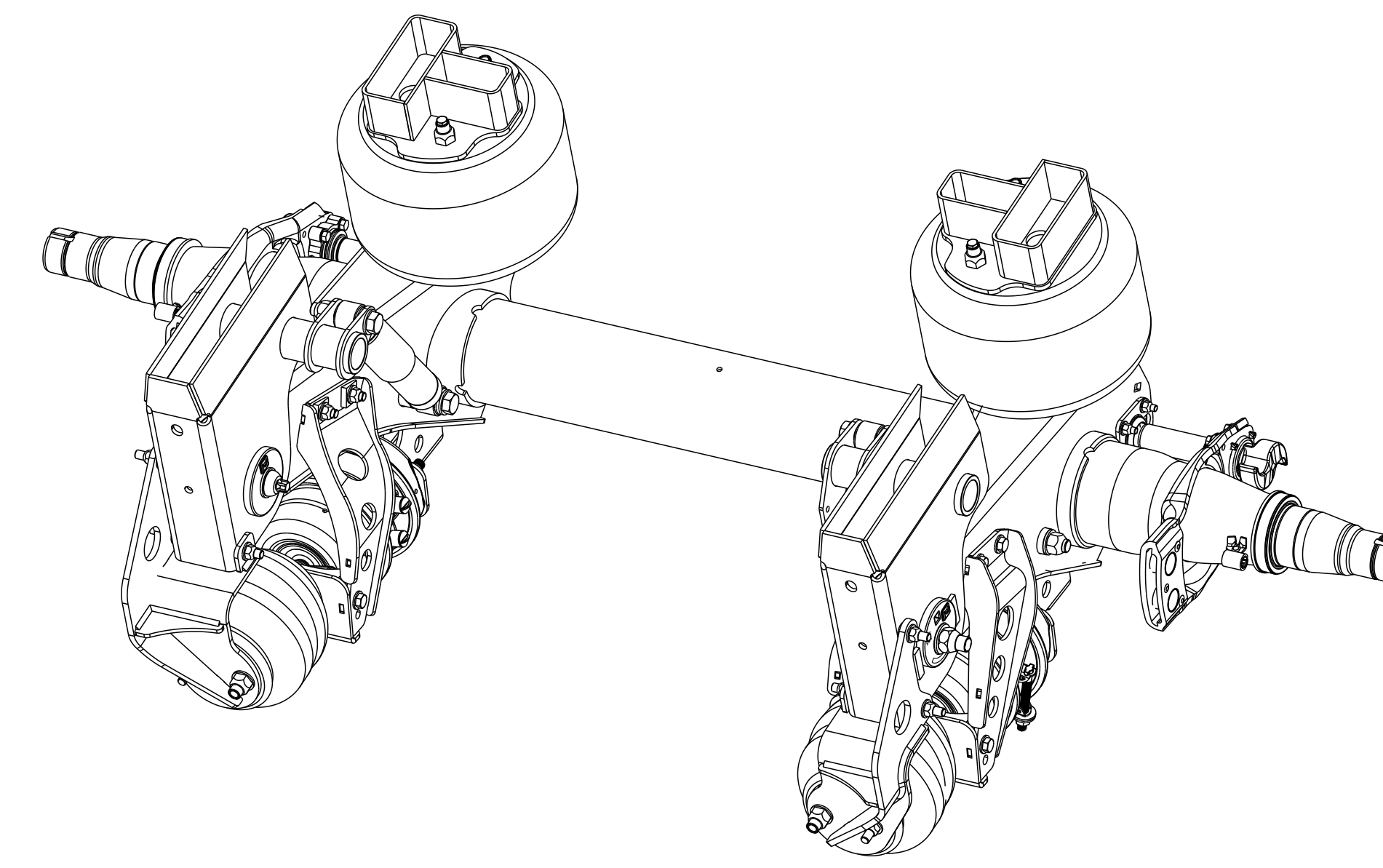
- 2. 17" RIDE HEIGHT SHOWN. INSTALLATION IS THE SAME FOR ALL RIDE HEIGHTS.
- 3. FRONT LIFT BRACKET TO HANGER PROCEDURE SHOWN ON SHEET 2.
- 4. THE LIFT KIT BRACKET PARTS LIST AND EXPLODED VIEW SHOWN ON SHEET 3.
- 5. DISC BRAKE VIEWS SHOWN ON SHEET 4.

*** LIFT KIT FITS BOTH 23T AND 23L TEC6 SUSPENSIONS.
 TOP MOUNT SUSPENSIONS USE TOP HOLE POSITION.
 LOW MOUNT SUSPENSIONS USE BOTTOM HOLE POSITION.



MTA-TEC6-23L

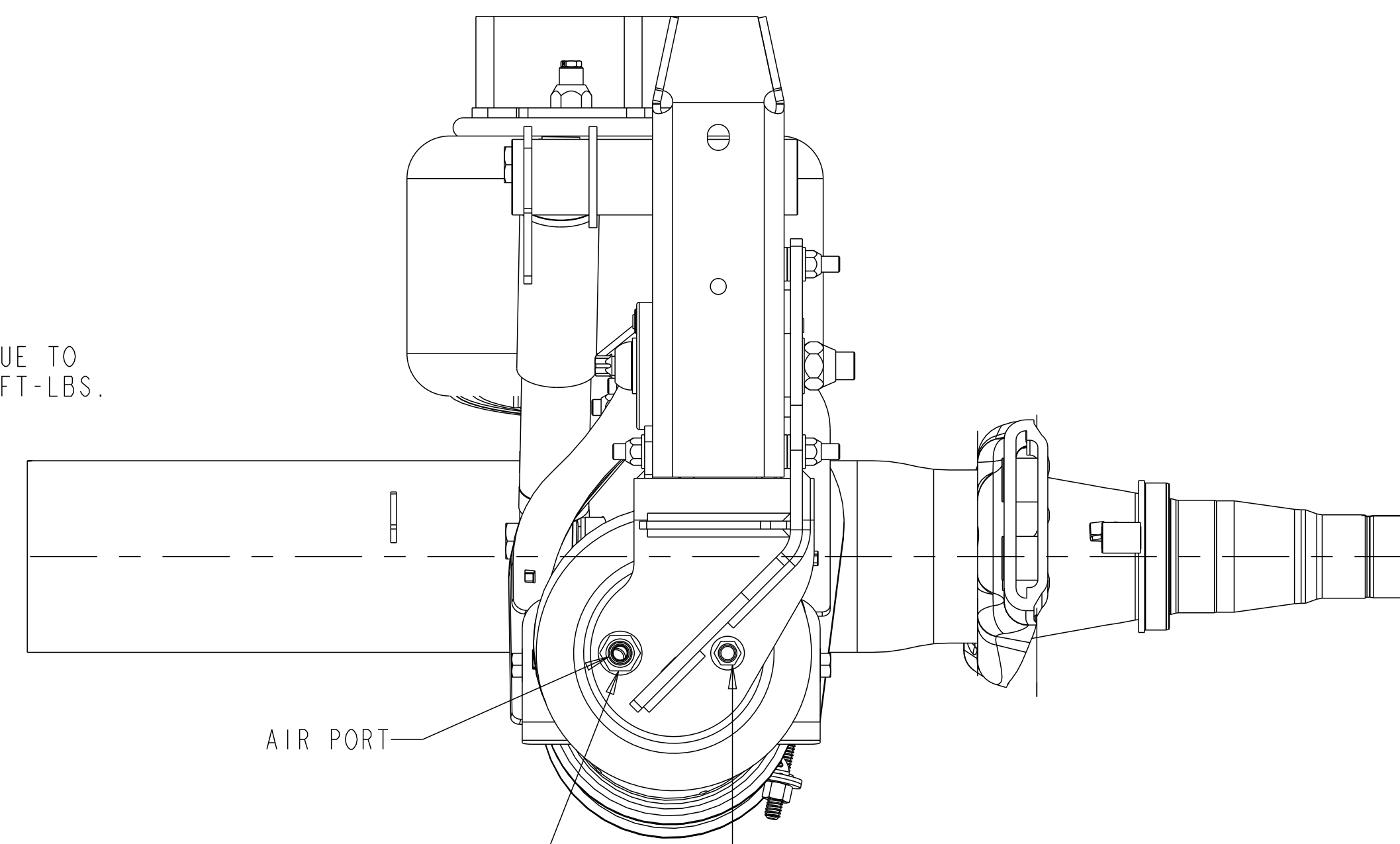
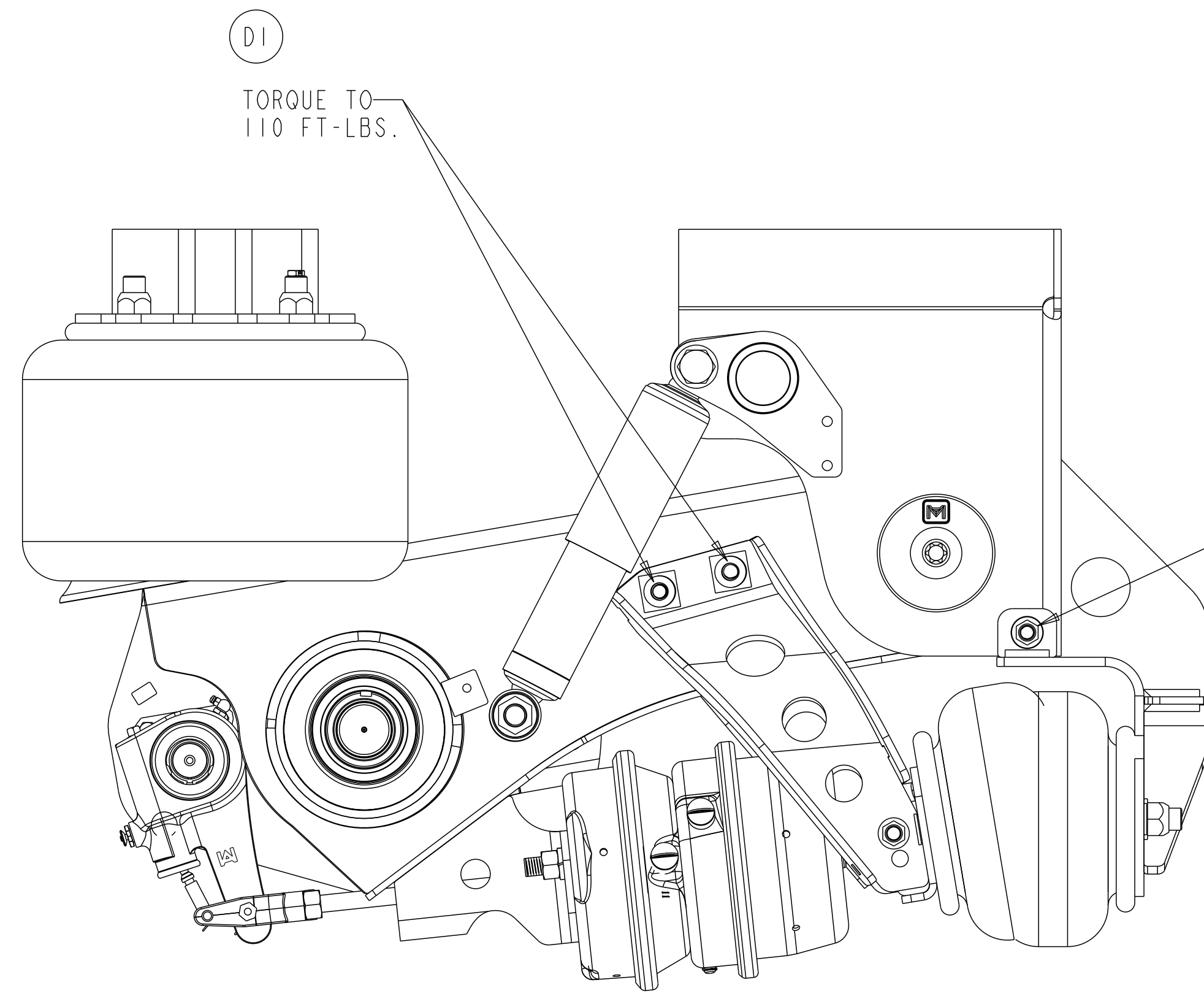
SCALE 0.125



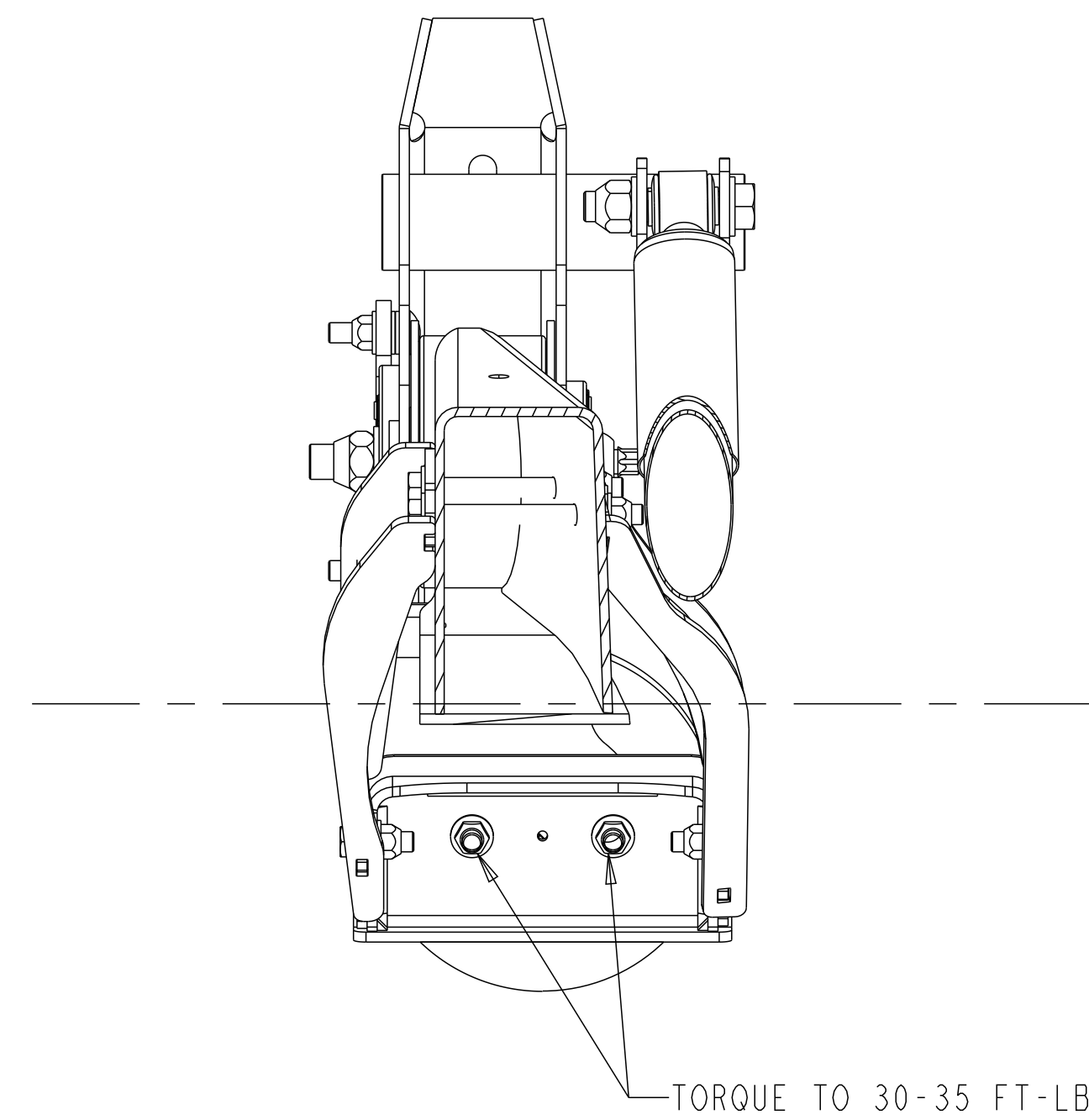
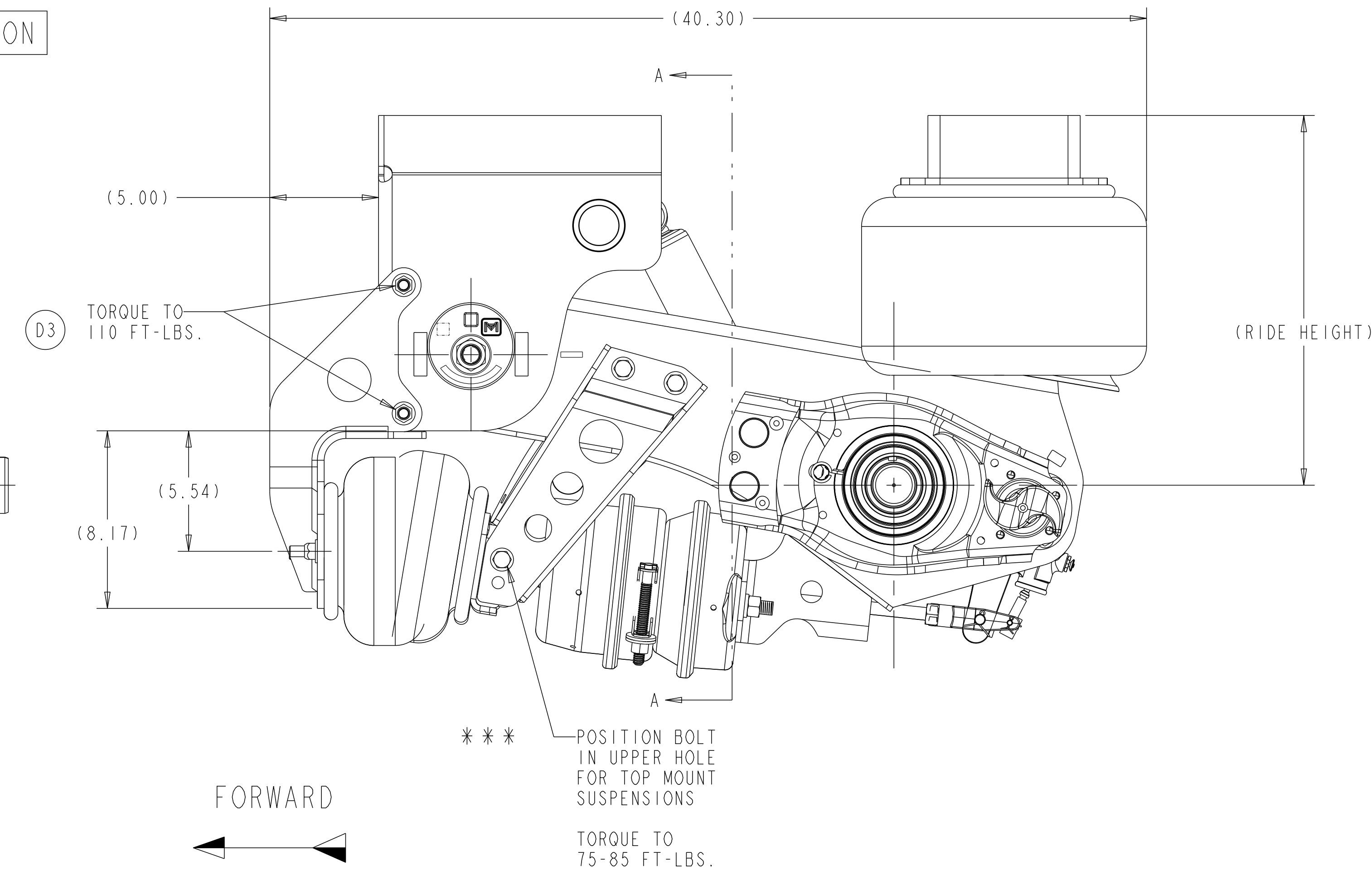
MTA-TEC6-23T

SCALE 0.125

SIM. PARTS		REVISIONS	
A	INITIAL RELEASE OF 5-68942C (SEE SHEET 3)	ECN-166078 27-MAY-20	CH SS
B	NO CHANGE THIS SHEET	ECN-168988 02-JUN-20	CH SS
C	ADDED DISC BRAKE INFO. TO SHT. 4 1) UPDATED NOTE (SHT. 2) 2-4) UPDATED HARDWARE (SHT. 3)	ECN-169690 16-JUL-20	CH SS
D	ALL VIEWS UPDATED TO SHOW ADDITIONAL WASHERS ADDED 1) TORQUE WAS 65 FT-LBS. 2-3) TORQUE WAS 75-85 FT-LBS. 4-7) SEE SHEET 2 8-12) SEE SHEET 3	ECN-171320 21-OCT-20	CH SS

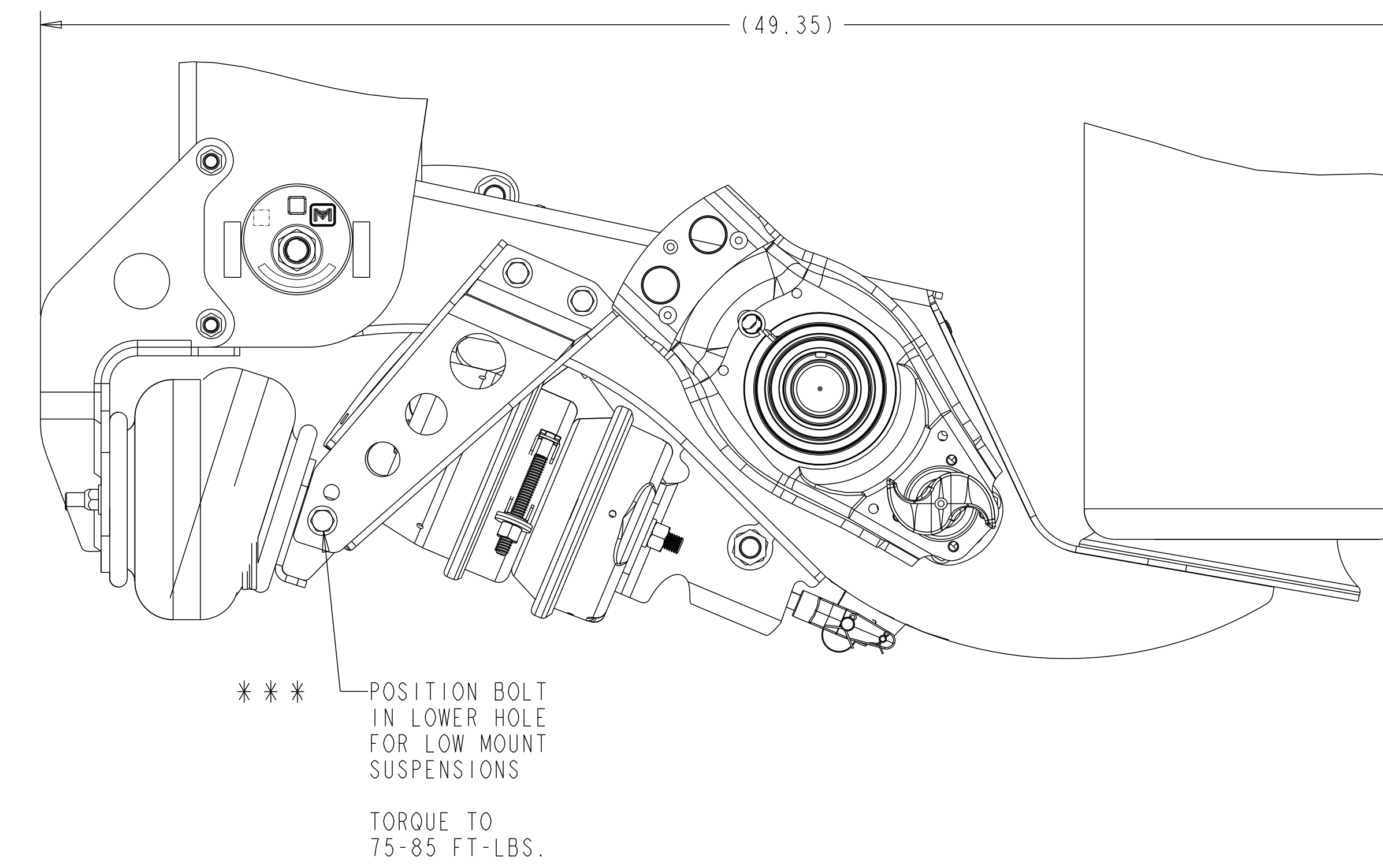


TOP MOUNT SUSPENSION



SECTION A-A

LOW MOUNT SUSPENSION



MTA-TEC6-23T & 23L SUSPENSION

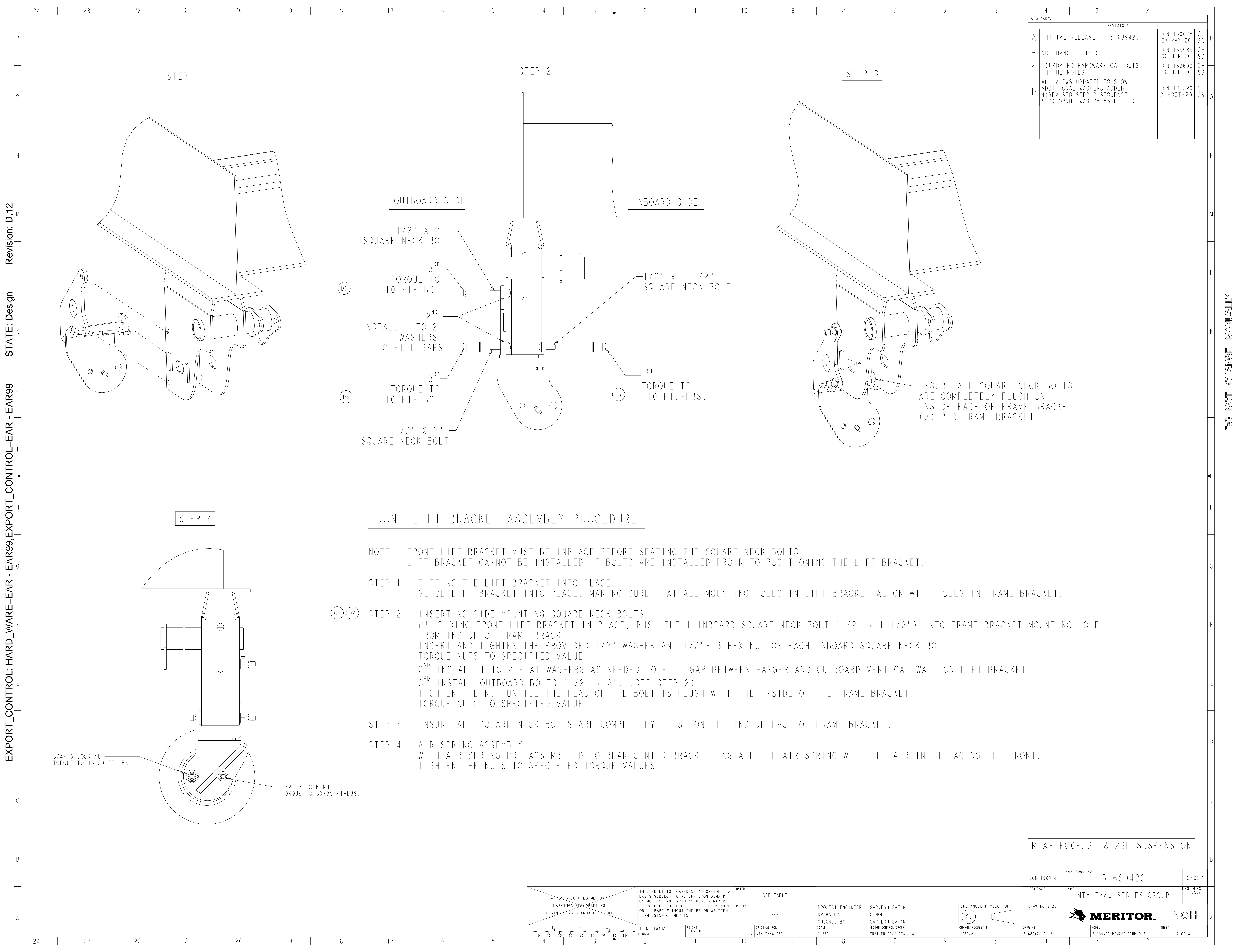
APPLY SPECIFIED MERITOR MARKINGS PER DRAFTING ENGINEERING STANDARDS D-604		THIS PRINT IS LOANED ON A CONFIDENTIAL BASIS SUBJECT TO RETURN UPON DEMAND BY MERITOR AND NOTHING HEREON MAY BE REPRODUCED, USED OR DISCLOSED IN WHOLE OR IN PART WITHOUT THE PRIOR WRITTEN PERMISSION OF MERITOR.		MATERIAL SEE TABLE		PROCESS ---		PROJECT ENGINEER SARVESH SATAM		3RD ANGLE PROJECTION		DRAWING SIZE E		RELEASE ECN-166078		PART/DWG NO. 5-68942C		04627	
4 IN. 10THS. 1:100MM		WEIGHT RGR./FIN.		ORIGINAL FOR LBS MTA-Tec6-23T		SCALE 0.250		DRAWN BY C.HOLT		TRAILER PRODUCTS N.A.		CHANGE REQUEST # 128162		DRAWING 5-68942C_PTC_MM_VERSION		MODEL 5-68942C_MTM23T_DRUM D.T		SHEET 1 OF 4	



INCH

Revision: D.12 STATE: Design EXPORT_CONTROL: HARD_WARE=EAR - EAR99.EXPORT_CONTROL=EAR - EAR99

DO NOT CHANGE MANUALLY



SIM. PARTS		REVISIONS	
A	INITIAL RELEASE OF 5-68942C	ECN-166078 27-MAY-20	CH SS
B	NO CHANGE THIS SHEET	ECN-168988 02-JUN-20	CH SS
C	1) UPDATED HARDWARE CALLOUTS IN THE NOTES	ECN-169690 16-JUL-20	CH SS
D	ALL VIEWS UPDATED TO SHOW ADDITIONAL WASHERS ADDED 4) REVISED STEP 2 SEQUENCE 5-7) TORQUE WAS 75-85 FT-LBS.	ECN-171320 21-OCT-20	CH SS

STEP 1

STEP 2

STEP 3

OUTBOARD SIDE

INBOARD SIDE

1/2" X 2" SQUARE NECK BOLT

3RD TORQUE TO 110 FT-LBS.

INSTALL 1 TO 2 WASHERS TO FILL GAPS

2ND

3RD TORQUE TO 110 FT-LBS.

1/2" X 2" SQUARE NECK BOLT

1/2" X 1 1/2" SQUARE NECK BOLT

1ST TORQUE TO 110 FT.-LBS.

ENSURE ALL SQUARE NECK BOLTS ARE COMPLETELY FLUSH ON INSIDE FACE OF FRAME BRACKET (3) PER FRAME BRACKET

STEP 4

FRONT LIFT BRACKET ASSEMBLY PROCEDURE

NOTE: FRONT LIFT BRACKET MUST BE IN PLACE BEFORE SEATING THE SQUARE NECK BOLTS. LIFT BRACKET CANNOT BE INSTALLED IF BOLTS ARE INSTALLED PRIOR TO POSITIONING THE LIFT BRACKET.

STEP 1: FITTING THE LIFT BRACKET INTO PLACE. SLIDE LIFT BRACKET INTO PLACE, MAKING SURE THAT ALL MOUNTING HOLES IN LIFT BRACKET ALIGN WITH HOLES IN FRAME BRACKET.

(C1) (D4) STEP 2: INSERTING SIDE MOUNTING SQUARE NECK BOLTS. 1ST HOLDING FRONT LIFT BRACKET IN PLACE, PUSH THE 1 INBOARD SQUARE NECK BOLT (1/2" X 1 1/2") INTO FRAME BRACKET MOUNTING HOLE FROM INSIDE OF FRAME BRACKET. INSERT AND TIGHTEN THE PROVIDED 1/2" WASHER AND 1/2"-13 HEX NUT ON EACH INBOARD SQUARE NECK BOLT. TORQUE NUTS TO SPECIFIED VALUE. 2ND INSTALL 1 TO 2 FLAT WASHERS AS NEEDED TO FILL GAP BETWEEN HANGER AND OUTBOARD VERTICAL WALL ON LIFT BRACKET. 3RD INSTALL OUTBOARD BOLTS (1/2" X 2") (SEE STEP 2). TIGHTEN THE NUT UNTILL THE HEAD OF THE BOLT IS FLUSH WITH THE INSIDE OF THE FRAME BRACKET. TORQUE NUTS TO SPECIFIED VALUE.

STEP 3: ENSURE ALL SQUARE NECK BOLTS ARE COMPLETELY FLUSH ON THE INSIDE FACE OF FRAME BRACKET.

STEP 4: AIR SPRING ASSEMBLY. WITH AIR SPRING PRE-ASSEMBLED TO REAR CENTER BRACKET INSTALL THE AIR SPRING WITH THE AIR INLET FACING THE FRONT. TIGHTEN THE NUTS TO SPECIFIED TORQUE VALUES.

3/4-16 LOCK NUT
TORQUE TO 45-50 FT-LBS

1/2-13 LOCK NUT
TORQUE TO 30-35 FT-LBS.

MTA-TEC6-23T & 23L SUSPENSION

APPLY SPECIFIED MERITOR MARKINGS PER DRAFTING ENGINEERING STANDARDS D-004	THIS PRINT IS LOANED ON A CONFIDENTIAL BASIS SUBJECT TO RETURN UPON DEMAND BY MERITOR AND NOTHING HEREON MAY BE REPRODUCED, USED OR DISCLOSED IN WHOLE OR IN PART WITHOUT THE PRIOR WRITTEN PERMISSION OF MERITOR.	MATERIAL	SEE TABLE	3RD ANGLE PROJECTION 	DRAWING SIZE	E		INCH	
		PROCESS	---		PROJECT ENGINEER	SARVESH SATAM			CHANGE REQUEST #
		DRAWN BY	C. HOLT	SCALE	0.250	DRAWING	5-68942C D.12	MODEL	5-68942C_MTM23T_DRUM D.T
		CHECKED BY	SARVESH SATAM	DESIGN CONTROL GROUP	TRAILER PRODUCTS N.A.	SHEET	2 OF 4		

Revision: D.12
STATE: Design
EXPORT_CONTROL=EAR-EAR99.EXPORT_CONTROL=EAR-EAR99

DO NOT CHANGE MANUALLY

BOLT-ON LIFT KIT PARTS LIST			
ITEM #	PART NAME	PART NUMBER	QTY
1	BRACKET-LIFTING, RS	A-3155S1917	1
2	BRACKET-LIFTING, CS	A-3155T1918	1
3	1/2" x 1 1/2" SQUARE NECK BOLT	41X2073	2
4	BRACKET-LIFTING, RS	A-3155W1921	1
5	BRACKET-LIFTING	A-3155U1919	2
6	BRACKET-LIFTING, RS	A-3155Y1923	1
7	BRACKET-LIFTING, CS	A-3155X1922	1
8	BRACKET-LIFTING, CS	A-3155Z1924	1
9	SPRING-AIR	A-2258M1755	2
10	1/2" WASHER-FLAT	I229Y1507-Z	36
11	1/2" x 5" SCREW-CAP	S-2840-M-2	2
12	1/2" x 5 1/2" SCREW-CAP	S-2844-M-2	2
13	1/2" WEDGE WASHER	I229J5652	4
14	1/2" NUT-LOCK, FIN.	I227B1614	20
15	1/2" X 1 1/2" SCREW-CAP	S-2812-M-2	4
16	3/4" NUT-LOCK, FIN.	I227M1573	2
17	3/4" WASHER-FLAT	I229V1556-Z	2
18	1/2" X 2.00" SQUARE NECK BOLT	41X2094	4

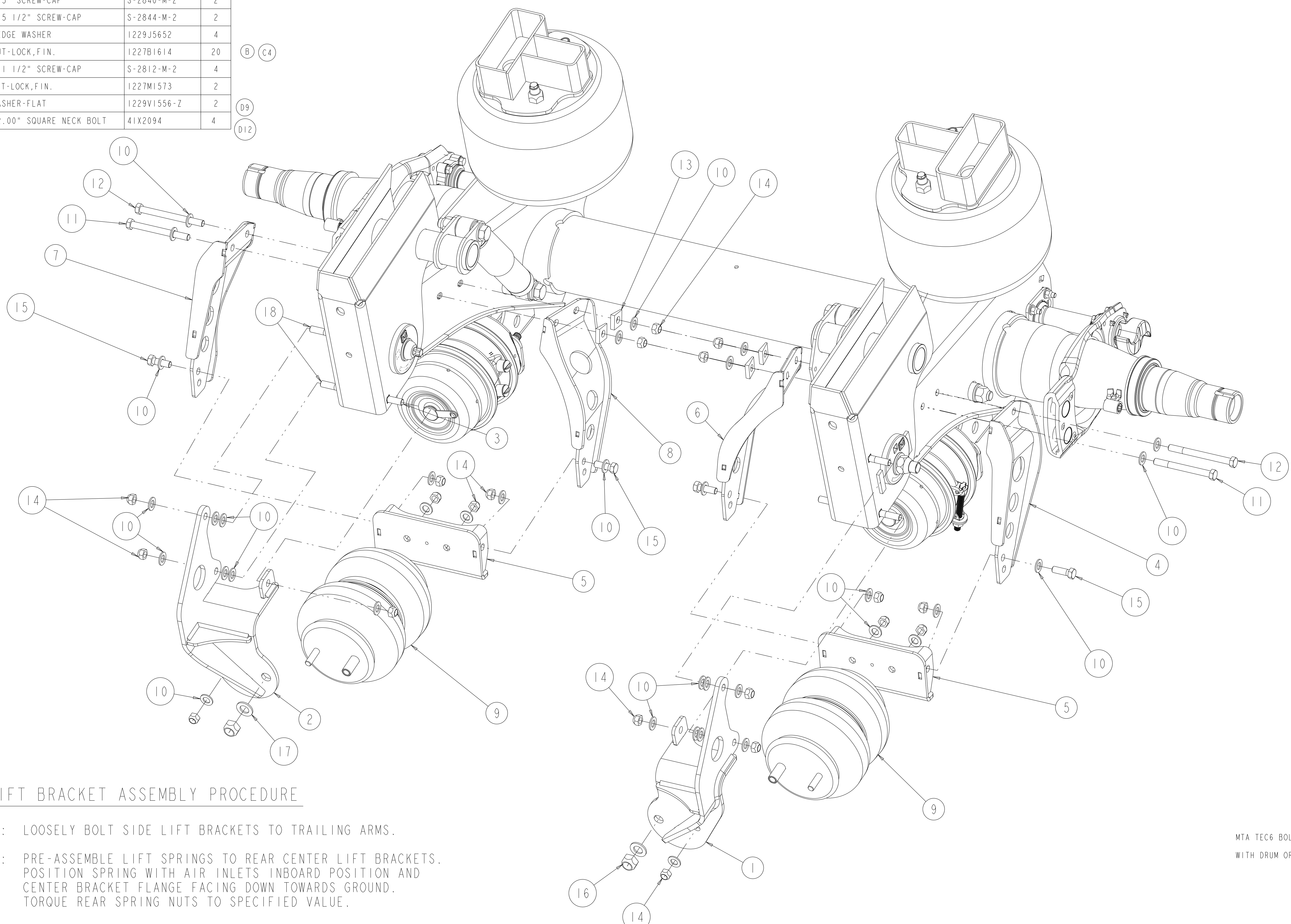
SIM. PARTS			
REVISIONS			
A	INITIAL RELEASE OF 5-68942C	ECN-166078 27-MAY-20	CH SS
B	S-2844-M-2 WAS S-2848-M-2	ECN-168988 02-JUN-20	CH SS
C	2)REMOVED WA-48-K & N-38-M-1 & RENUMBERED TABLE & VIEW BALLOONS 3)QTY. WAS 16, 4)QTY. WAS 14	ECN-169690 16-JUL-20	CH SS
D	8)QTY WAS 22 9)ADDED WASHERS, 10)ADDED NOTE 11)QTY WAS 6, 12)ADDED 41X2094	ECN-171320 21-OCT-20	CH SS

Revision: D.12

STATE: Design

EXPORT_CONTROL: HARD_WARE=EAR - EAR99.EXPORT_CONTROL=EAR - EAR99

DO NOT CHANGE MANUALLY



ARM LIFT BRACKET ASSEMBLY PROCEDURE

- STEP 1: LOOSELY BOLT SIDE LIFT BRACKETS TO TRAILING ARMS.
- STEP 2: PRE-ASSEMBLE LIFT SPRINGS TO REAR CENTER LIFT BRACKETS. POSITION SPRING WITH AIR INLETS INBOARD POSITION AND CENTER BRACKET FLANGE FACING DOWN TOWARDS GROUND. TORQUE REAR SPRING NUTS TO SPECIFIED VALUE.
- STEP 3: LOOSELY BOLT CENTER BRACKET TO SIDE BRACKETS. (FOR MTA23T USE UPPER HOLE IN SIDE BRACKETS) (FOR MTA23L USE LOWER HOLE IN SIDE BRACKETS)
- STEP 4: TORQUE ALL MOUNTING HARDWARE TO SPECIFIED VALUE.

OPTIONAL BOLT DIRECTION:

MOUNTING BOLTS 11 & 12 CAN BE INSTALLED FROM OTHER DIRECTION IF REQUIRED.

MTA-TEC6-23L:
REMOVE UPPER SHOCK BOLT AND ROTATE SHOCK OUT OF THE WAY TO INSTALL MOUNTING BOLTS FROM INBOARD DIRECTION. RE-INSTALL SHOCK AND TORQUE SHOCK BOLT TO 270-300 FT.-LBS.

MTA TEC6 BOLT-ON LIFT KIT FITS BOTH 23T & 23L SUSPENSIONS WITH DRUM OR DISC BRAKES (TEC6 23T DRUM BRAKE SUSPENSION SHOWN)

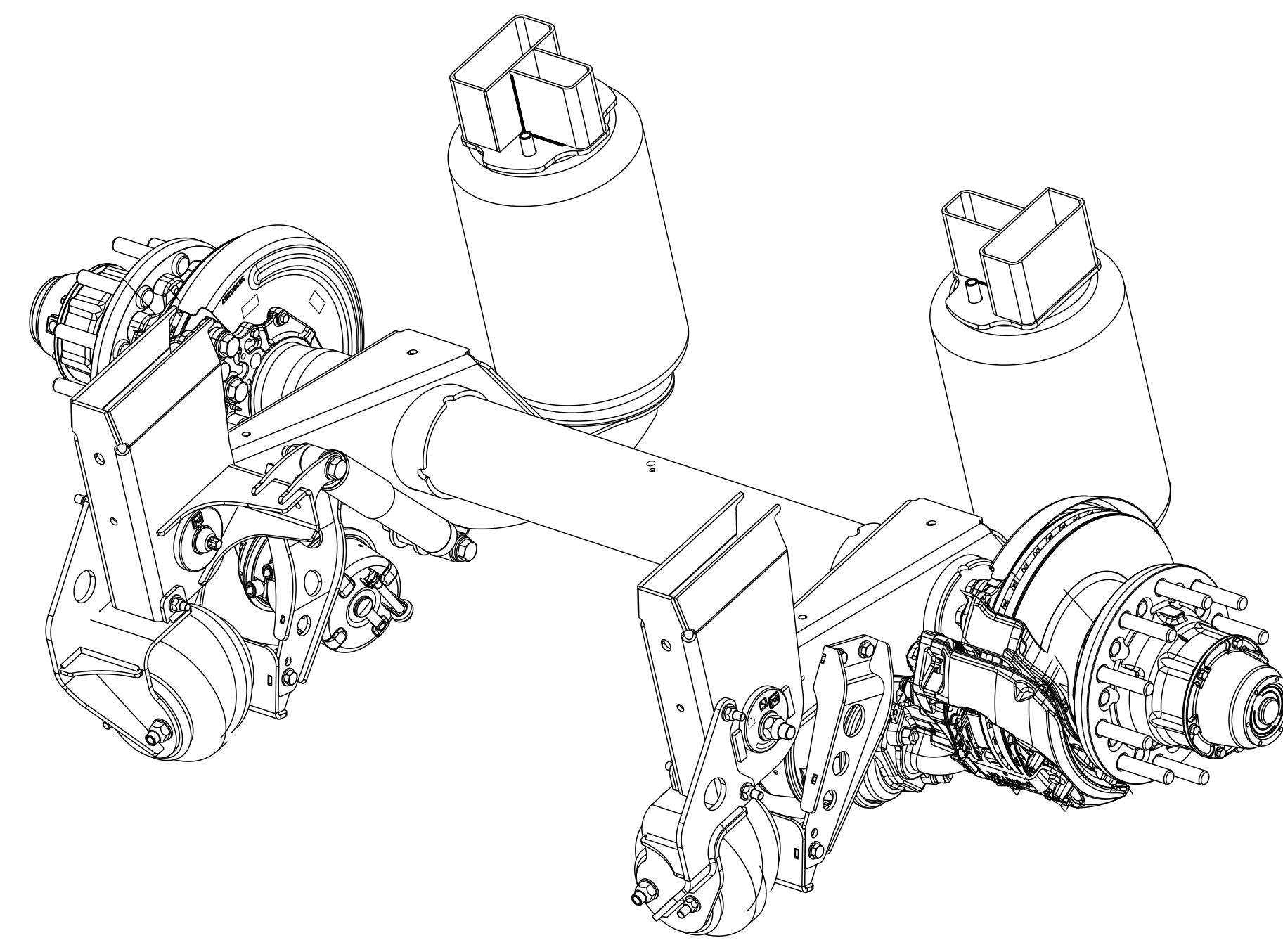
MTA-TEC6-23T & 23L SUSPENSION

APPLY SPECIFIED MERITOR MARKINGS PER DRAFTING ENGINEERING STANDARDS D-004		THIS PRINT IS LOANED ON A CONFIDENTIAL BASIS SUBJECT TO RETURN UPON DEMAND BY MERITOR AND NOTHING HEREON MAY BE REPRODUCED, USED OR DISCLOSED IN WHOLE OR IN PART WITHOUT THE PRIOR WRITTEN PERMISSION OF MERITOR.		MATERIAL: SEE TABLE		PROCESS: ---		PROJECT ENGINEER: SARVESH SATAM		3RD ANGLE PROJECTION		DRAWING SIZE: E		DRAWING: 5-68942C D.12	
4 IN. 10THS. 100MM		WEIGHT RGR./FIN.		ORIGINAL FOR LBS MTA-Tec6-23T		SCALE: 0.333		DESIGN CONTROL GROUP: TRAILER PRODUCTS N.A.		CHANGE REQUEST #: 128162		MODEL: 5-68942C_MTM23T_DRUM D.T		SHEET 3 OF 4	
ECN-166078		PART/DWG NO. 5-68942C		RELEASE		NAME: MTA-Tec6 SERIES GROUP		ENG. DESG. CODE: 04627				INCH			

NOTES:

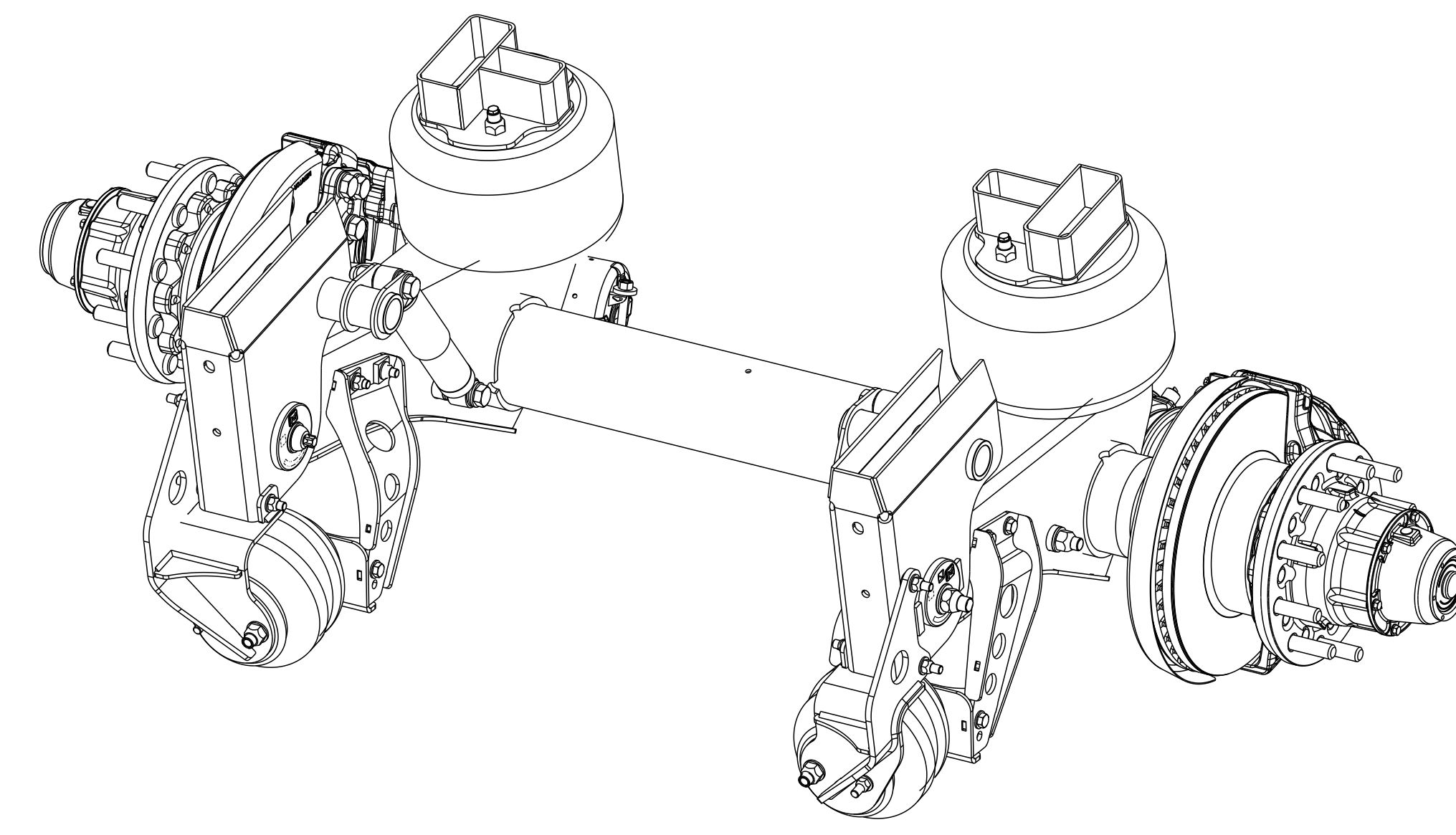
1. DISC BRAKE AIR CHAMBERS:
23T - D2-3376T20 & D4-3276T20
23L - D2-3376T20 & D4-3276T20
2. 17" RIDE HEIGHT SHOWN. INSTALLATION IS THE SAME FOR ALL RIDE HEIGHTS.
3. FRONT LIFT BRACKET TO HANGER PROCEDURE SHOWN ON SHEET 2.
4. THE LIFT KIT BRACKET PARTS LIST AND EXPLODED VIEW SHOWN ON SHEET 3.
5. ALL TORQUE INFO. ON SHEET 1 APPLIES TO THIS SHEET.

*** LIFT KIT FITS BOTH 23T AND 23L TEC6 SUSPENSIONS.
TOP MOUNT SUSPENSIONS USE TOP HOLE POSITION.
LOW MOUNT SUSPENSIONS USE BOTTOM HOLE POSITION.



MTA-TEC6-23L

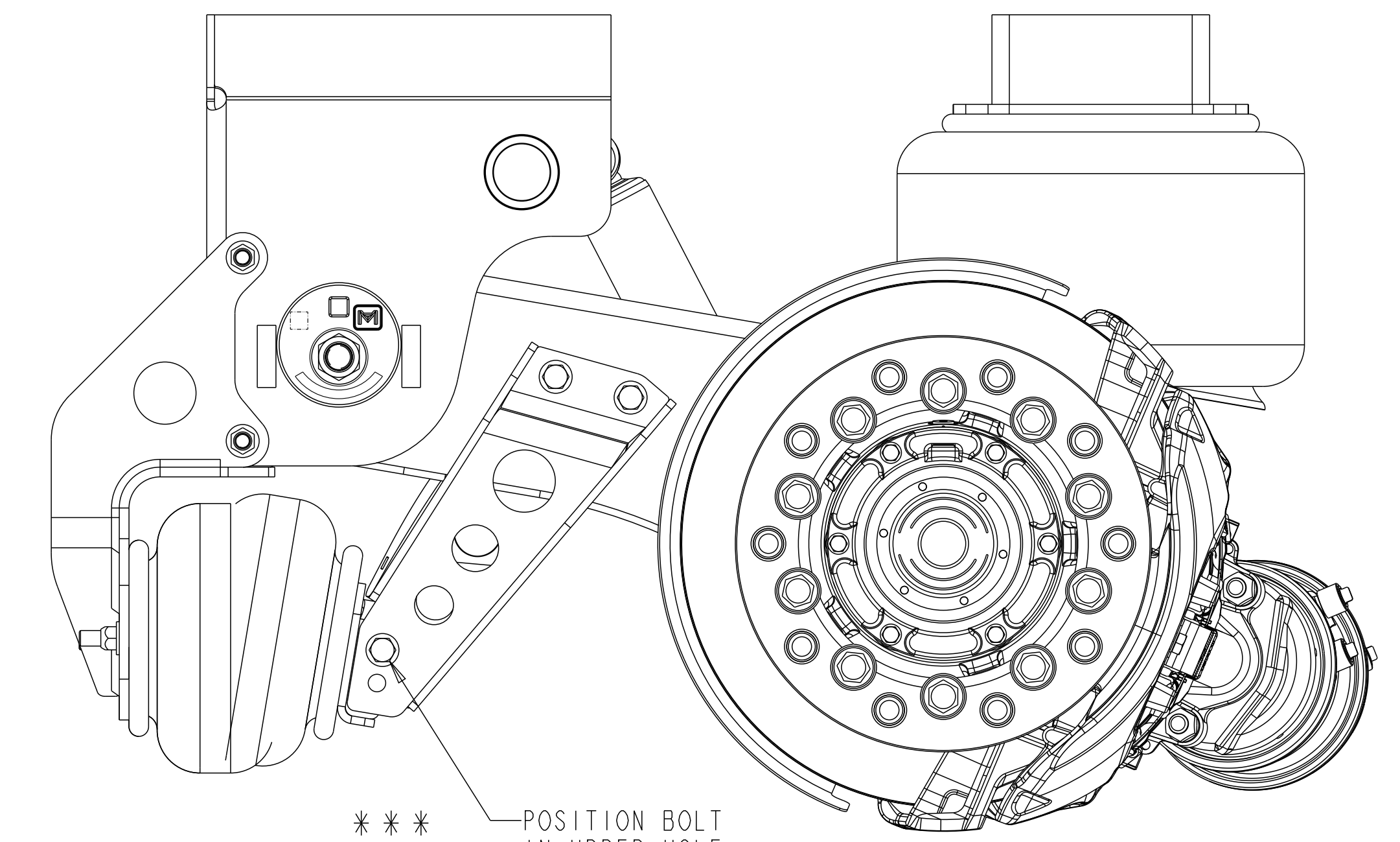
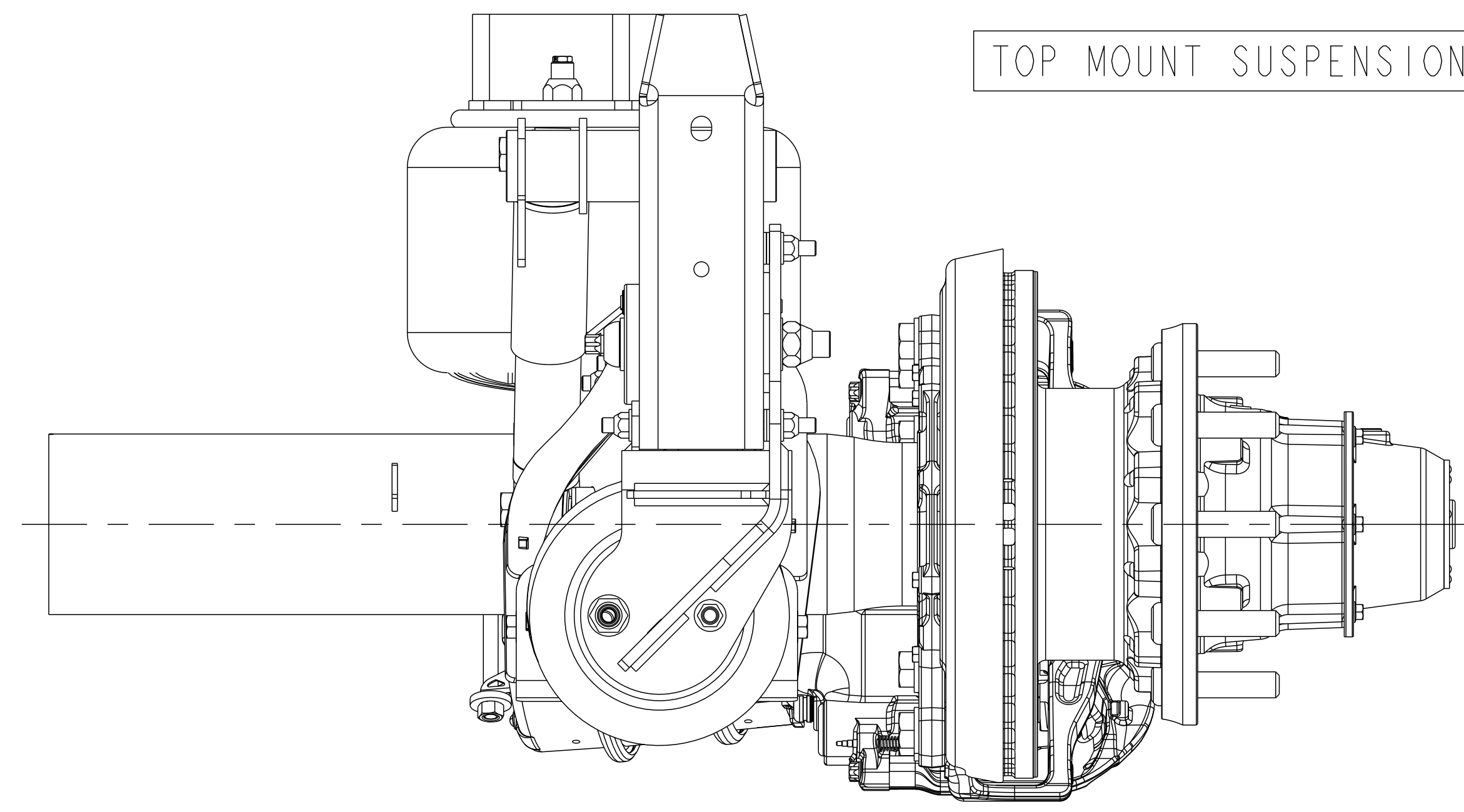
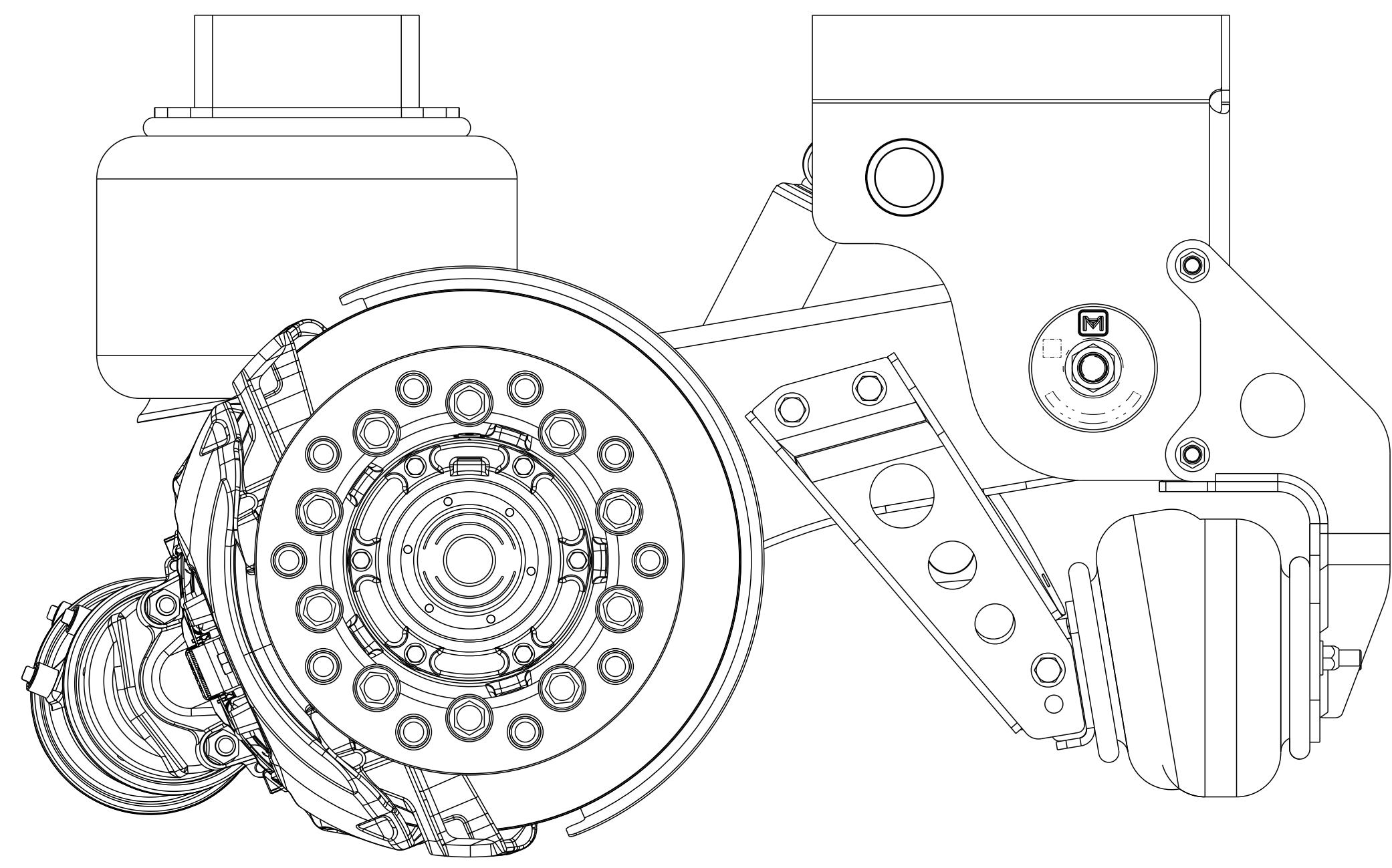
SCALE 0.125



MTA-TEC6-23T

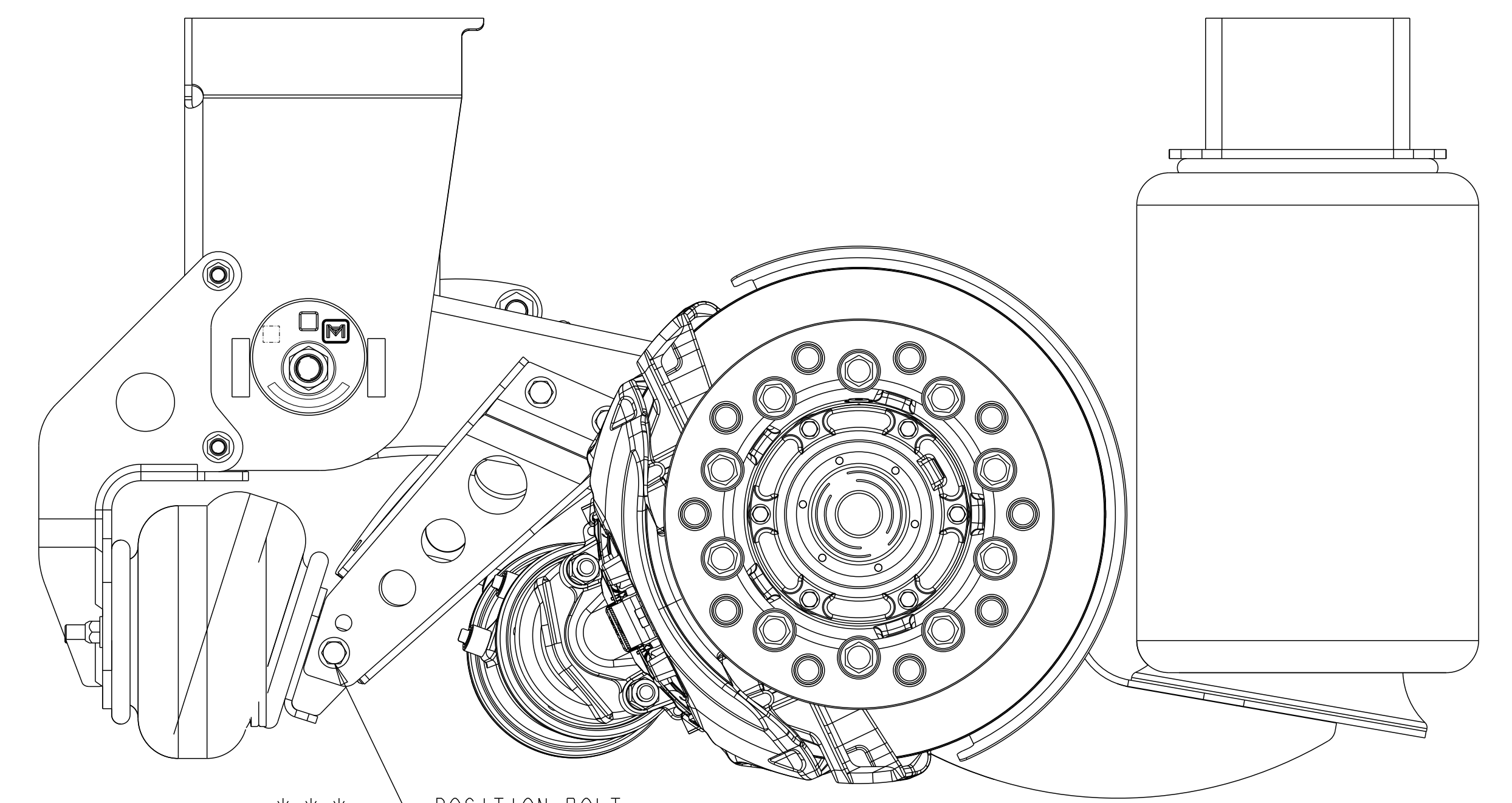
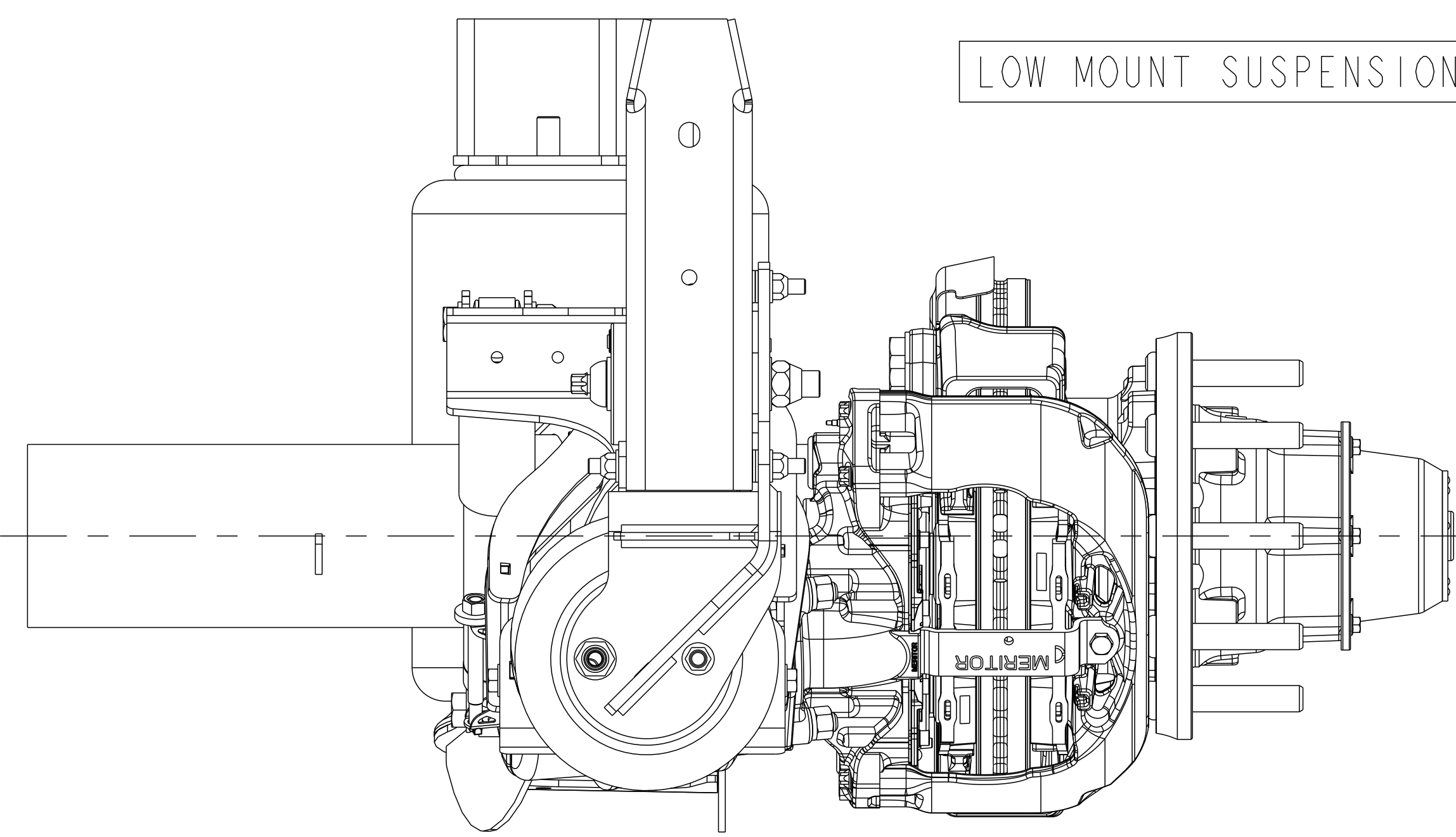
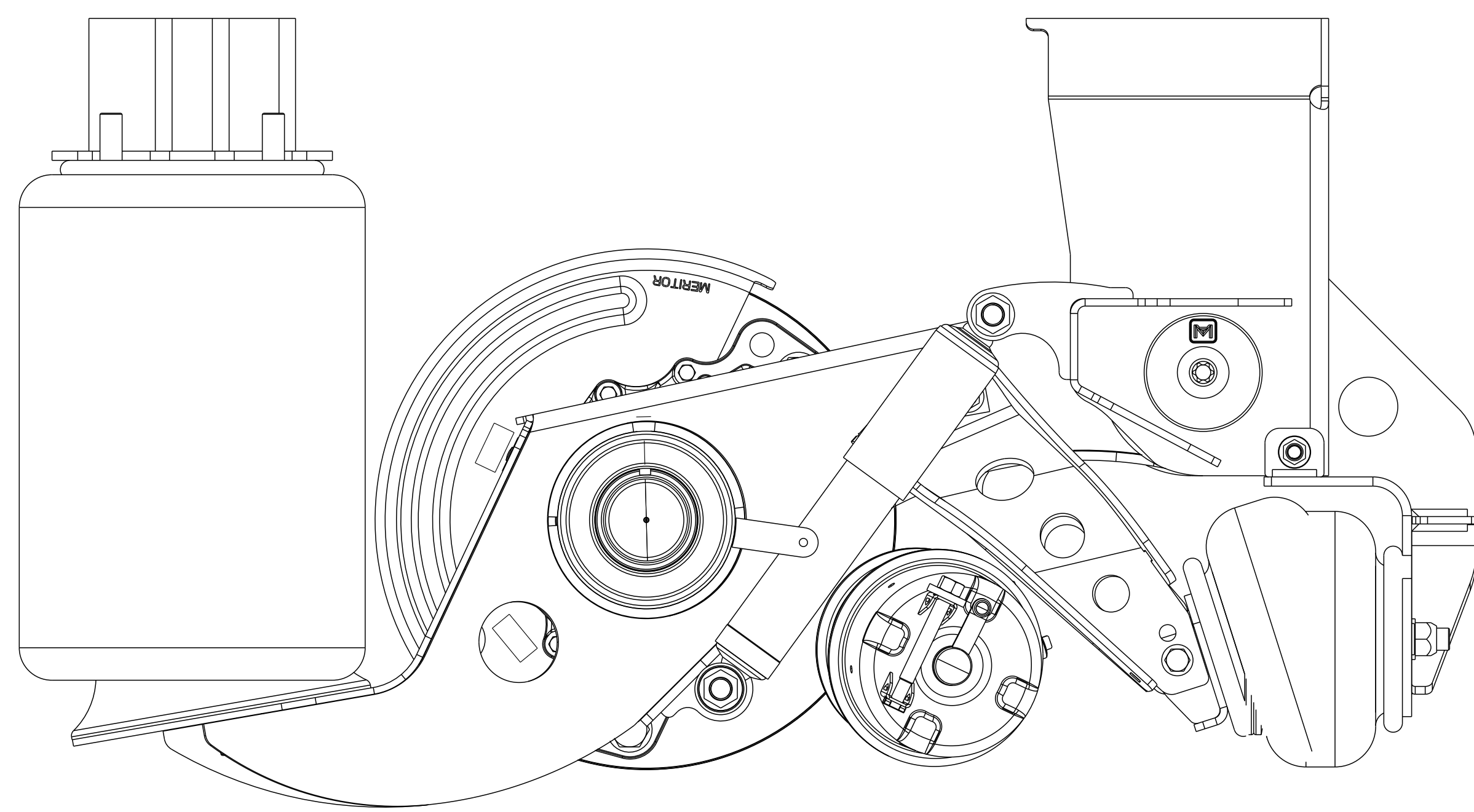
SCALE 0.125

SIM. PARTS		REVISIONS	
C	ADDED SHEET 3 SHOWING DISC BRAKE APPLICATIONS	ECN-169690 16-JUL-20	CH SS
D	VIEWS UPDATED TO SHOW ADDITIONAL WASHERS	ECN-171320 21-OCT-20	CH SS



*** POSITION BOLT IN UPPER HOLE FOR TOP MOUNT SUSPENSIONS

FORWARD



*** POSITION BOLT IN LOWER HOLE FOR LOW MOUNT SUSPENSIONS

MTA-TEC6-23T & 23L SUSPENSION

APPLY SPECIFIED MERITOR MARKINGS PER DRAFTING ENGINEERING STANDARDS D-604	THIS PRINT IS LOANED ON A CONFIDENTIAL BASIS SUBJECT TO RETURN UPON DEMAND BY MERITOR AND NOTHING HEREON MAY BE REPRODUCED, USED OR DISCLOSED IN WHOLE OR IN PART WITHOUT THE PRIOR WRITTEN PERMISSION OF MERITOR.	MATERIAL SEE TABLE	PROCESS ...	PROJECT ENGINEER SARVESH SATAM DRAWN BY C. HOLT CHECKED BY SARVESH SATAM	3RD ANGLE PROJECTION	RELEASE ECN-166078	PART/DWG NO. 5-68942C	ENG. DESG. CODE 04627
						DRAWING 5-68942C D.12	MODEL 5-68942C_MTM23T_DRUM D.T	SHEET 4 OF 4

Revision: D.12
STATE: Design
EXPORT_CONTROL: HARD_WARE=EAR - EAR99, EXPORT_CONTROL=EAR - EAR99

DO NOT CHANGE MANUALLY