












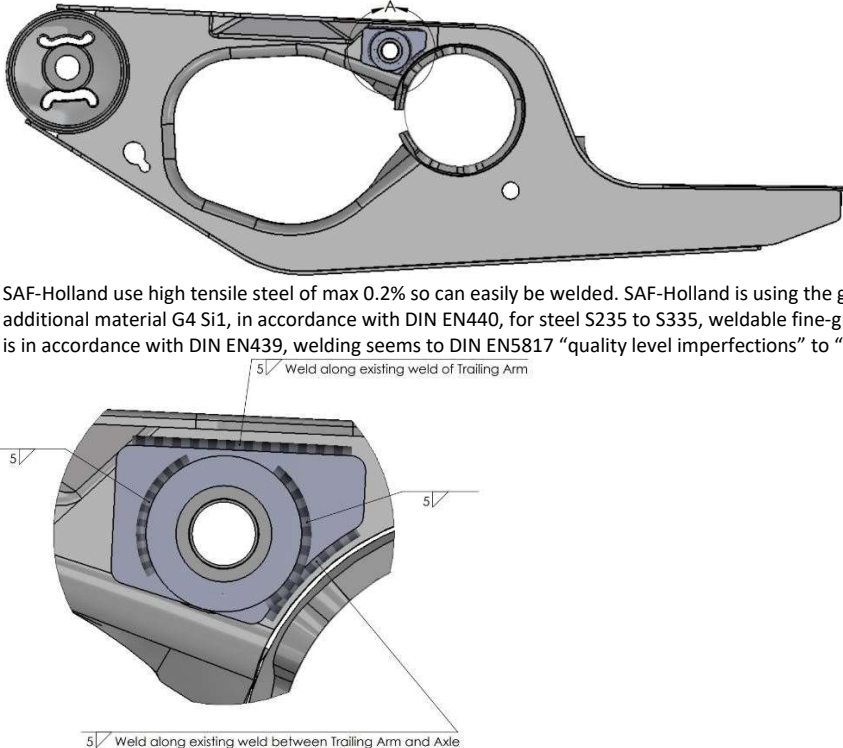
## SAF Intra Suspension Shock mount repair procedure

### Material required

RK2376 kit Lwr Shock Mount Repair Kit to suit Intra

1	Remove shock absorber from trailing arm.
2	<p>Cut and remove side reinforcement plate as shown if fitted.</p>  
3	<p>Use side reinforcement plate as a template to scribe and cut out larger hole.</p>  
4	<p>Barrel grind hole to the scribed diameter, or use oxy acetylene equipment to remove the majority of the material then finish extending the hole with barrel grinder.</p>   <p>Clean area to remove any steel oxide, swarf or chips.</p>
5	Complete steps 3 & 4 to opposite side of trailing arm.

6	<p>Insert boss into side plates and weld as shown. Welds should be 5mm fillet ensuring no craters or cracks are present. Back fill all weld eyes.</p> 
7	<p>Install smaller bushes in the above assembly and in trailing arm on both sides.</p> 
8	<p>Reinstall shock absorber using new bolt and nut. Ensure bolt is at least 100Nm tight.</p> 
9	<p>Tack weld side plates ensuring shock absorber is centrally located.</p> 

11	<p>Undo and remove bolt, nut and shock absorber.</p> <p>Tack weld keys in position as shown, ensuring they locate in the machine slots of the inner bush to clamp on shock bush.</p> 
12	<p>Weld replacement shock mount assembly mounting plate to the axle adapter (lower) and the trailing arm top plate (upper) using 5mm fillets.</p> <p>Ensure there are no cracks or crater and back fill all weld eyes.</p>  <p>SAF-Holland use high tensile steel of max 0.2% so can easily be welded. SAF-Holland is using the gas metal arc welding procedure with the additional material G4 Si1, in accordance with DIN EN440, for steel S235 to S335, weldable fine-grained structural steel to S460. Shielding gas is in accordance with DIN EN439, welding seems to DIN EN5817 "quality level imperfections" to "group C"</p>
13	<p>Once cool, paint with rust inhibiting paint and reassemble with shock absorber.</p>
14	<p>Ensure suspension is set to ride height before final torquing shock absorber bolt and nut to 600Nm.</p>

Please direct all queries to SAF-HOLLAND Technical Service team on (03) 9971 7900, or via e-mail at [service@safholland.com.au](mailto:service@safholland.com.au)

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