



FITTING INSTRUCTIONS

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**Chassis reinforcement
VB-SA NCV3 3,5t**

VB-SemiAir 1552350016

Revision table

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1. If the vehicle isn't equipped with a VB-SemiAir, remove the bump stops.

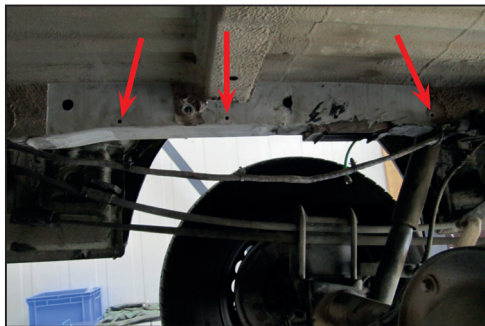
If the vehicle is equipped with a VB-SemiAir, remove the air springs (with the brackets). Don't remove the air tubes, filling valves, compressor or control panel.



2. Disconnect the wiring harness from the chassis, at the indicated places.

Remove the bolt of the stabiliser (at the chassis).

Remove the protective coating.



Hold the chassis reinforcement bracket to the chassis, to determine the area where the protective coating needs to be removed.

3. Apply some glue to the chassis, in the area where the (bump stop bracket) plate will be placed.



Slide the plate in to the bracket of the bump stop to determine the area where the glue needs to be applied.



Use glue that is supplied by VB-Airsuspension. VB-A article number 5400700002.



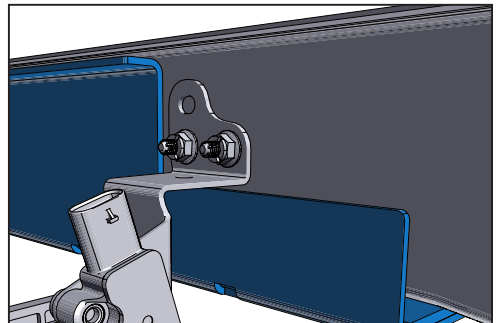
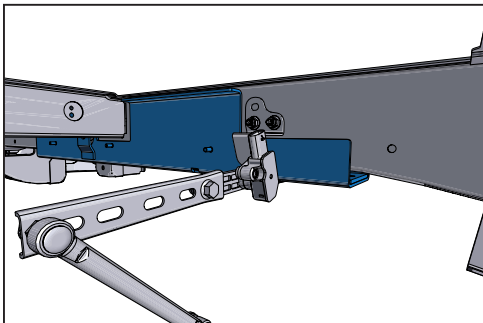
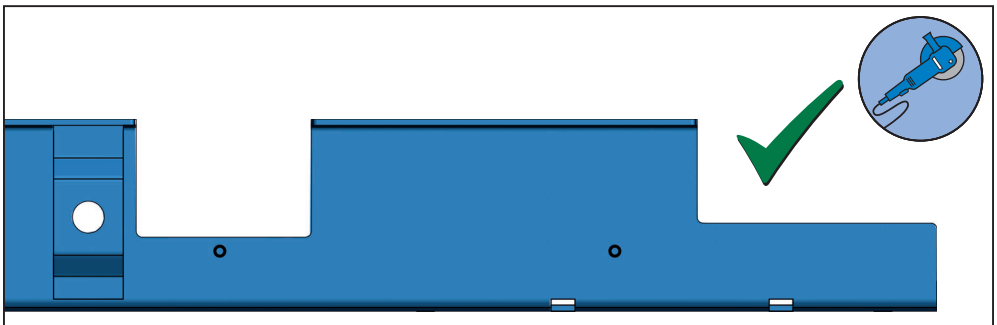
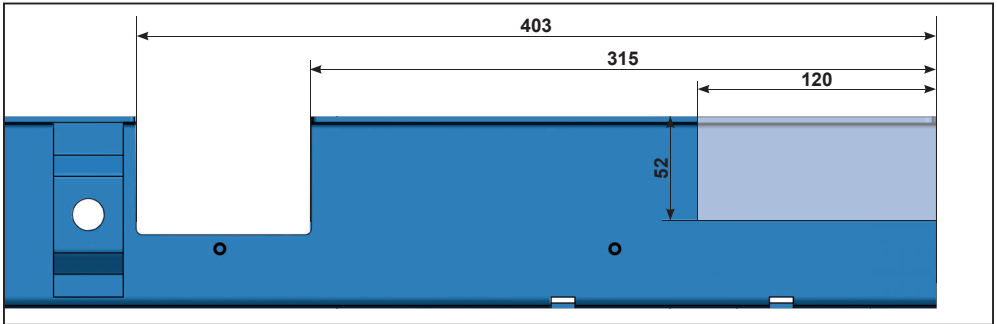
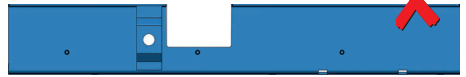
Before applying the glue, make sure that the surface is properly cleaned and grease-proof!

4. Slide the plate in to the bracket of the bump stop.



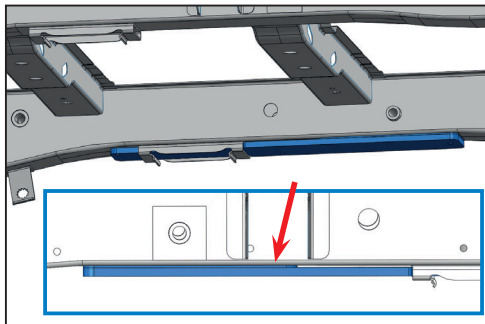


If you have Xenon headlights you need to make the following adjustment to the left (green dot) reinforcement bracket (105 235 0114), before you go to step 5.





Mount the plate as shown in the image. The thin plate must be between the chassis and the (thick) plate.



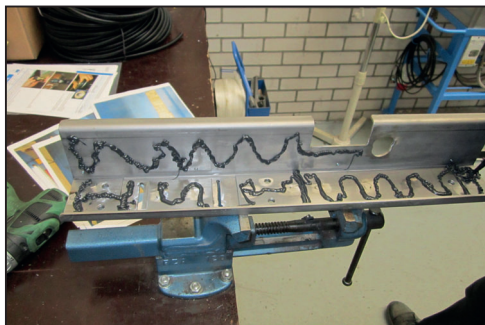
5. Apply some glue to the inside of the chassis reinforcement bracket.



Use glue that is supplied by VB-Airsuspension. VB-A article number 5400700002.



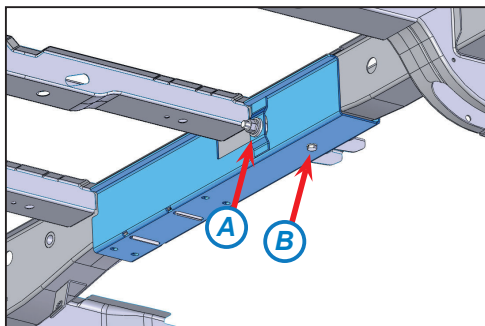
Before applying the glue, make sure that the surface is properly cleaned and grease-proof!



6. Mount the chassis reinforcement bracket to the chassis.



Notice the colour marks on the separate parts. This is to define the position on the car. A black dot is the for right-side and a green dot for the left-side.



**2x Original bolt and nut (A)
2x Washer M12 Ø30 (A)
2x Bolt M12x120 **
2x Washer M12 **
2x Lock nut M12 ****

104 Nm

**** If the vehicle isn't equipped with a roll stabiliser, use these bolts, nuts and washers. Always use washer M12 Ø30 on the inside of the chassis.**



**2x Bolt M8x16 (B)
2x Washer M8 (B)**

20 Nm

7. Mount the air spring assembly to the chassis reinforcement bracket.



**8x Bolt M8x20
8x Washer M8**

20 Nm



If the vehicle isn't equipped with VB-SemiAir, assemble the air spring assembly according to the fitting instruction in the VB-SemiAir kit.

8. Use a tyre valve to pump some air-pressure into the air springs and a jack on the rear end of the chassis reinforcement bracket. This is to press the chassis reinforcement properly against the chassis until the glue has hardened.



The glue should harden for at least 5 hours, before the pressure of the air-springs and jack can be released!



9. Seal all edges of the chassis reinforcement bracket, so moisture and dirt can't get between the chassis and bracket. Use the glue to seal the edges.



Use glue that is supplied by VB-Airsuspension. VB-A article number 5400700002.



10. Spray the area, where the protective coating was removed, with an anti-corrosive protection



11. Press the fixing ties on the weld studs. Fasten the wiring harness to the chassis reinforcement bracket using the fixing ties.

	3x Fixing ties



If the vehicle wasn't equipped with VB-SemiAir, finish the assembly of the VB-SemiAir kit according to that fitting instruction.





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