

TECHNICAL BULLETIN - #A608  
SUBJECT: **INTERNATIONAL CE INTEGRATED  
CROSSING ARM INSTALLATION INSTRUCTIONS**  
Effective Date: 08/01/06

The following procedures should be followed for installing integrated crossing arms on International CE chassis.

**AIR UNITS** (For installation at bumper subassembly station)

1. Install crossing arm box assembly to rear of bumper.
2. Torque the in-board mounting bolts 10 – 15 ftlbs of torque.
3. Torque the out-board mounting bolts (10mm) 10 – 15 ftlbs of torque.
4. Install yellow polycarbonate rod using hardware provided. Align rod with magnet rest. Torque mounting bolts 10 – 15 ftlbs.
5. Temporarily install plastic cover onto back of crossing arm assembly. Snug attaching nuts only.

After the bumper is installed and the bumper attaching bolts are torqued, the following final adjustment assembly should be completed, preferably at final air door adjustment station.

1. Loosen out board mounting bolts of crossing arm box. Re-torque to 20 ftlbs.
2. Verify alignment of yellow rod to magnet rest. If not aligned, realign by adjusting the yellow rod using it's mounting bolts. Torque mounting bolts 10 – 15 ftlbs.
3. Remove rear cover.
4. Connect air line, chassis harness, and magnet harness to crossing arm box.
5. Activate crossing arm.
6. Using yellow knob on crossing arm box, adjust air pressure so that crossing arm opens in 3 – 5 seconds. Turning clockwise increases air pressure. Required pressure for operation is approximately 90 psi. After adjusting, lock air regulator by pushing down on outer ring of yellow knob. Unit should operate smoothly without “slamming” open.
7. De-activate crossing arm.
8. Using white knob, adjust closing speed so that the arm closes in 5 – 7 seconds. Turning the white knob clockwise increases the closing time. After adjusting, lock regulator by tightening the thumb nut under the white knob.
9. After adjustment is complete, re-install rear plastic cover, torque nuts to 10 ftlbs.
10. Check magnet for correct operation.

**ELECTRIC UNITS**

1. Install crossing arm box assembly to rear of bumper.
2. Torque in-board mounting bolts 10 – 15 ftlbs of torque.
3. Torque the out-board mounting bolts (10mm) 10 – 15 ftlbs of torque.
4. Install yellow polycarbonate rod using hardware provided. Align rod with magnet rest. Torque mounting bolts 10 – 15 ftlbs.
5. Install plastic cover onto back of crossing arm assembly. Torque attaching nuts to 10 ftlbs torque.

After the bumper is installed and the bumper attaching bolts are torqued, the following final adjustment assembly should be completed.

1. Loosen outboard mounting bolts of crossing arm box. Retorque to 20 ftlbs.
2. Verify alignment of yellow rod to magnet rest. If not aligned, realign by adjusting the yellow rod using it's mounting bolts. Torque mounting bolts 10 – 15 ftlbs.
3. Connect chassis harness.
4. Activate crossing arm and check for magnet operation.