

Bushing replacement tool 6100051 is used to remove and install pivot bushings in suspension models that use a wide rubber bushing (6 3/4"):

- RAR-260 (All models)  
Hanger mount  
trailer suspension
- RAR-266 (23K/25K capacity)  
Hanger mount  
trailer suspension
- RAR-266 Low Mount  
(25K capacity)  
Hanger mount  
trailer suspension

## (Wide) Bushing Replacement Tool - 6100051

### Bushing Replacement Procedure

Park the vehicle on a level surface. Chock wheels to keep vehicle from moving. Raise vehicle to height that removes load from suspension and support with jack stands. Disconnect the linkage from the height control valve(s), if necessary, and exhaust all air from the air system.

**CAUTION** Failure to properly chock wheels, exhaust the air system and raise and safely support the vehicle could allow vehicle/suspension movement that could result in serious injury.

### Disassemble suspension

Remove wheels and tires, if necessary. Remove the shock absorbers. Disassemble the pivot connections. Remove and inspect adjuster plate and alignment washer(s). Replace, if necessary. Discard pivot hardware (new pivot hardware and wear washers included in bushing replacement kit).

Rotate trailing arm beams out of the hangers. Inspect pivot bolt holes and hanger surfaces for unusual wear or damage. Repair/replace components, as needed.

### Bushing Removal

1. Using the locator mark on the old bushing as a reference, draw a line on the trailing arm beam (Figure 2). The line on the beam will be used to orient the new bushing during installation.
2. Lubricate the threads of the hex nut-threaded rod assembly, the inside threads of the plunger, and the end cap bearing with grease.
3. Assemble the bushing replacement tool and place on the eye of the beam (Figure 1). NOTE: Cone is tapered inside to a smaller opening on one end.
  - 3.1 Place the end cap on the hex nut-threaded rod assembly. The end cap should be seated on the flange of the hex nut. Place the larger opening of the cone against the end cap.
  - 3.2 Insert the threaded rod through the bushing sleeve and center the tapered end of the cone on the beam eye.
  - 3.3 Thread the plunger onto the threaded rod. Rotate the plunger until the plate is seated snugly against the bushing.
4. Use a 3/4" drive impact wrench on the hex nut to rotate the threaded rod and press the bushing out of the beam eye into the cone. NOTE: A small amount of heat may be required to break the bond between the bushing and the beam eye. Do not overheat. Allow beam to cool before installing the new bushing.
5. Disassemble the bushing replacement tool. Remove old bushing from the cone and discard.

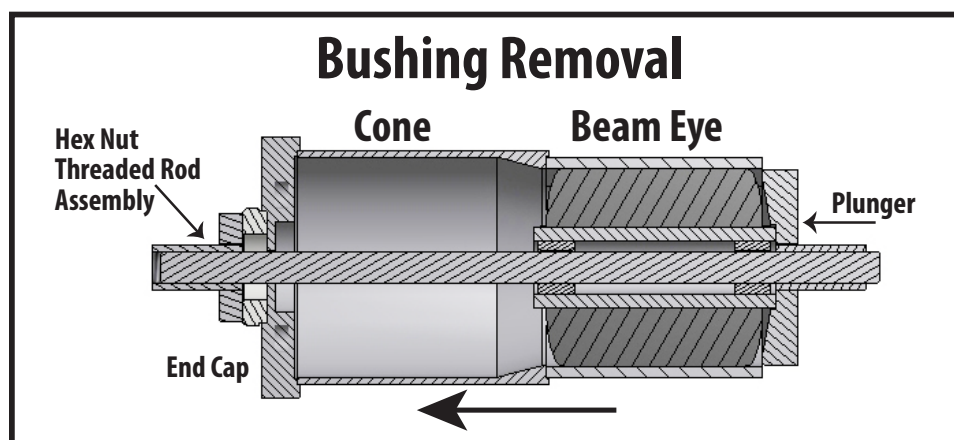


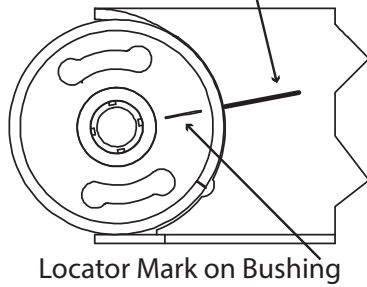
Figure 1. Tapered end of cone is placed against beam eye for removal.



Part No.: 9710015

## (Wide) Bushing Orientation

Draw Reference Line on Beam Before Removing Bushing



**Figure 2.**  
**Line up the locator mark on the bushing inside the cone to the line drawn on the beam before installing the new bushing.**

## New Bushing Installation

1. Use wire brush to clean foreign debris and corrosion out of the beam eye.
2. Coat the inside of the beam eye, the outside of the bushing and the inside of the cone with S.G. Type "M" Rubber Assembly Oil. NOTE: Do not substitute (S.G. Type "M" Rubber Assembly Oil included in bushing replacement kit).
3. The cone is tapered inside to a smaller opening on one end. Insert the new bushing into the larger end of the cone with the locator mark of the new bushing on the outside (Figure 2).
4. Assemble bushing replacement tool and place on beam eye (Figure 3).
  - 4.1 Place the end cap on the hex nut-threaded rod assembly. The end cap should rest on the flange of the hex nut.
  - 4.2 Insert the threaded rod/end cap assembly through the beam eye. Place the tapered end of the cone onto the threaded rod and center the cone on the beam eye. Line up locator mark on new bushing with line drawn on beam during bushing removal (Figure 2).
  - 4.3 Thread the plunger onto the threaded rod. Rotate the plunger until the plate is seated snugly against the bushing.
5. Use a 3/4" drive impact wrench on the hex nut to rotate the threaded rod and press the bushing into the beam eye. NOTE: Hold the plunger with an open end wrench to prevent the cone from rotating.
6. Disassemble and remove the bushing replacement tool. Check the placement of the bushing to make sure it is centered in the beam eye.

## Reassemble suspension

Rotate trailing arm beams into hangers. Install pivot connection hardware – alignment washers, adjuster plates, wear washers, shear-type pivot bolt, flat washer and flanged lock nut.

NOTE: Tighten flanged lock nut until adjuster plate pin is engaged and pivot hardware is snug against hanger. Do not apply final torque until axle alignment has been checked.

Install shock absorbers. Connect height control valve linkage (if disconnected) and inflate air springs. Install wheels and tires (if removed). Raise vehicle and remove support stands. Lower vehicle to ground.

Check axle alignment and realign, if necessary. Tighten pivot bolt with a 1" drive impact wrench and E-20 Torx® socket (Ridewell tool #6100054) until the Torx® head is sheared off.

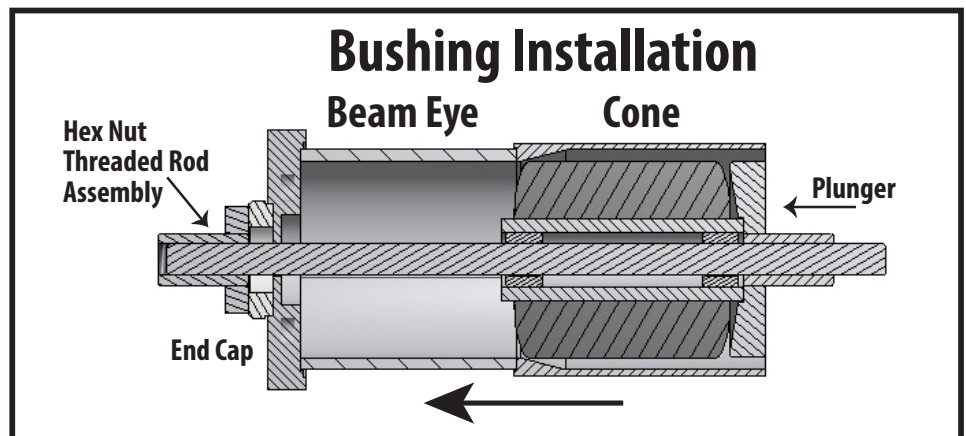
**CAUTION** Failure to torque pivot hardware to specifications can result in failure of the suspension and void the warranty.

### Notes and Cautions

The tool instructions uses two types of service notes, defined as:

"NOTE": Provides additional instructions or procedures to complete tasks and make sure that the suspension functions properly.

**CAUTION** Indicates a hazardous situation or unsafe practice that, if not avoided, could result in equipment damage and serious injury.



**Figure 3.**  
**Tapered end of cone compresses the bushing during installation.**