

Bushing replacement tool 6100044 is used to remove and replace pivot bushings in suspension models that use a narrow bushing (4 1/8"):

- RCA-215 (All models)  
Auxiliary axle suspension
- RUL-245 (All models)  
Auxiliary axle suspension
- RAR-266 (23K capacity)  
Hanger mount  
trailer suspension
- RAR-266 Low Mount  
(20K capacity)  
Hanger mount  
trailer suspension
- RAR-254 Single Point  
(50K Capacity)  
Hanger mount  
trailer suspension

## (Narrow) Bushing Replacement Tool - 6100044

### 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 equipped. Exhaust all air from the air system.

**CAUTION** Failure to properly chock wheels, exhaust the air system 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 from RAR-266, RAR-254 suspension models and from RCA-215 suspensions (if equipped). 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. Lubricate the threads of the hex nut-threaded rod assembly, the inside threads of the plunger, and the end cap bearing with grease.
2. 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.
  - 2.1 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.
  - 2.2 Insert the threaded rod through the bushing sleeve and center the tapered end of the cone on the beam eye.
  - 2.3 Thread the plunger onto the threaded rod. Rotate the plunger until the plate is seated snugly against the bushing.
3. 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.
4. Disassemble the bushing replacement tool. Remove old bushing from the cone and discard.

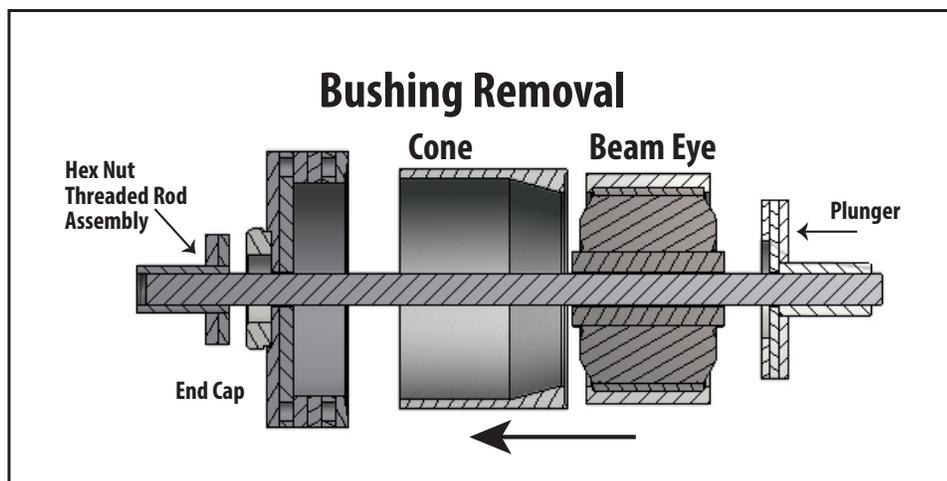


Figure 1.  
Tapered end of cone is placed against the beam eye for removal.

## Suspension models that use a narrow bushing (4 1/8"):

- **RCA-215 (All models)**  
Auxiliary axle suspension
- **RUL-245 (All models)**  
Auxiliary axle suspension
- **RAR-266 (23K capacity)**  
Hanger mount  
trailer suspension
- **RAR-266 Low Mount (20K capacity)**  
Hanger mount  
trailer suspension
- **RAR-254 Single Point (50K capacity)**  
Hanger mount  
trailer suspension

## New Bushing Installation

1. Use wire brush to clean foreign debris and corrosion out of the beam eye.
2. Liberally apply P80<sup>®</sup> lubricant or soap solution to the inside of the beam eye, the outside of the bushing and the inside of the cone.
3. The cone is tapered inside to a smaller opening on one end. Insert the new bushing into the larger opening of the cone.
4. Assemble bushing replacement tool and place on the beam eye (Figure 2).
  - 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.
  - 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 bushing placement to make sure it is centered in the eye of the beam.

## 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: Do not lubricate pivot bolt/nut. 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 the shock absorbers on RAR-266 suspensions and RCA-215 suspensions (if equipped). Connect height control valve linkage, if necessary. 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<sup>®</sup> socket (Ridewell tool 6100054) until the Torx<sup>®</sup> head is sheared off.

NOTE: If traditional pivot hardware is used with RUL-245 suspension models, torque to 500 ft-lb (678 N-m).

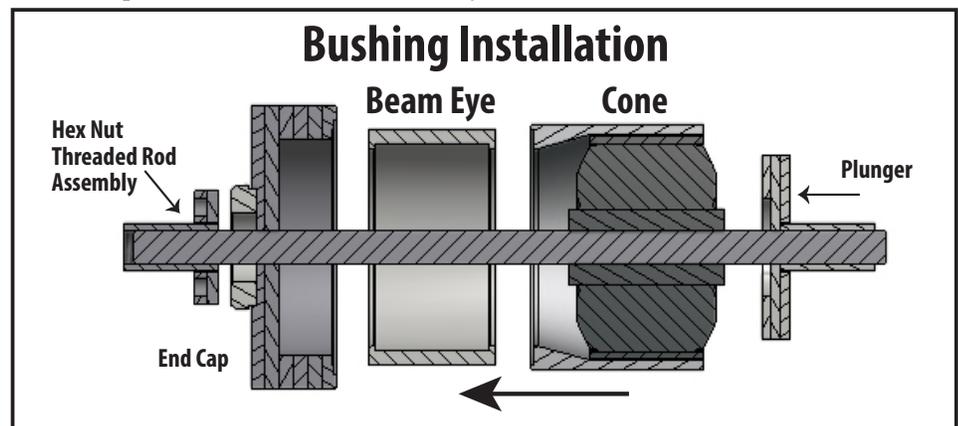
**CAUTION** Failure to torque pivot hardware to specifications can result in failure of the suspension and void the warranty.

### 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 2.**

**The tapered end of cone compresses the bushing for installation.**