Bushing Assembly and Replacement Instructions for:
- RSS-233 – 13K Truck (13K Capacity)
- RSS-233T – 13K Trailer (13K Capacity)

Notes and Cautions
This instruction uses two types of service notes:
“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.

233-13K Truck – Bushing Replacement Kit

<table>
<thead>
<tr>
<th>Replacement Kit - Part No.</th>
<th>Pivot Hardware</th>
<th>Torque Values</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>foot-pound</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Newton-meter</td>
</tr>
<tr>
<td>6040133</td>
<td>Bushing kit w/o hardware</td>
<td>310 ft-lb</td>
</tr>
<tr>
<td>6040134</td>
<td>Pivot Bolt (HHCS) Pivot Nut (Lock Nut)</td>
<td>310 ft-lb</td>
</tr>
</tbody>
</table>

⚠️ CAUTION Failure to install and maintain fasteners at torque specifications could result in suspension failure and void the warranty.

Park the vehicle on a level surface. Chock wheels to keep vehicle from moving. Exhaust all air from the air system. Disassemble suspension, if necessary, to reach pivot connections.

⚠️ CAUTION Failure to properly chock wheels and exhaust air system could allow vehicle/suspension movement that could result in serious injury.

Bushing Replacement Procedure – 233-13K Truck

Bushing should be replaced in the eight pivot connections at the same time (Figure 1).

1. Remove the pivot hardware by cutting/grinding away the Huck® Collar. Discard pivot hardware.
2. Remove the bushing assembly from the rod eye. Clean the rod eye of foreign debris/corrosion.
3. Apply Energy Suspensions® Formula 5 Prelube to the bore (inside) of each bushing half. NOTE: Do not substitute - urethane bushing lubricant is included with all bushing replacement kits.
4. Press bushing halves into the eye of the torque rod until halves are snug against the eye. NOTE: Mallet may be needed to install the bushing.
5. Press the bushing inner sleeve into the center opening of the installed bushing. NOTE: Mallet or bushing press will be needed to insert sleeve into installed bushing.
6. Check that installed bushing inner sleeve is flush with both sides of new bushing.
7. Install pivot hardware and torque to specifications.
8. Reassemble suspension, if necessary. Torque to specifications.
9. Check wheel toe-in setting (between 1/32” and 3/32”) and adjust, if necessary.

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

Figure 1.
The bushing replacement kit with hardware includes traditional hardware to replace the Huck® Fasteners used for initial assembly.
233T-13K Trailer – Bushing Replacement Kit

<table>
<thead>
<tr>
<th>Bushing Replacement Kit Part Number</th>
<th>Pivot Hardware</th>
<th>Torque Values</th>
<th>Foot-Pound</th>
<th>Newton-meter</th>
</tr>
</thead>
<tbody>
<tr>
<td>6040187</td>
<td>Bushing kit w/o hardware</td>
<td></td>
<td>310</td>
<td>420</td>
</tr>
<tr>
<td>6040188</td>
<td>Pivot Bolt (HHCS) - Pivot Nut (Locknut)</td>
<td></td>
<td>310</td>
<td>420</td>
</tr>
</tbody>
</table>

**CAUTION** Failure to install and maintain fasteners at torque specifications could result in suspension failure and void the warranty. Refer to the engineering drawing of each model for torque specifications.

Park the vehicle on a level surface. Chock wheels to keep vehicle from moving. Exhaust all air from the air system. Disassemble suspension, if necessary, to reach pivot connections.

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

**Bushing Replacement Procedure – 233T-13K Trailer**
Replace eight pivot connection bushings at the same time (Fig. 2).


2. Remove bushing assembly from the rod eye and discard. NOTE: Bushing assembly before October 2018 consists of two bushing halves and inner sleeve.

3. Clean the torque rod eye of foreign debris/corrosion with a wire brush before installing new bushing assembly.

4. Apply Energy Suspensions® Formula 5 Prelube to the bore (inside) of the replacement bushing. NOTE: Do not substitute - urethane bushing lubricant is included with all bushing replacement kits.

5. Install (press) bushing into the eye of the torque rod. NOTE: Mallet/press needed to install bushing.

6. Press inner sleeve into the installed bushing. Center the sleeve inside the bushing so that the sleeve ends extend slightly past the bushing sides.

7. Assemble the pivot connection with one wear washer on each side of the bushing. The inner sleeve of the bushing must be flush with or extend slightly past the outside of the wear washers after assembly. NOTE: Bushing replacement kit (6040188) includes traditional pivot hardware. Wear washers included in all replacement kits.

8. Torque pivot hardware to specifications (see chart).

9. Reassemble suspension, if necessary. Torque to specifications (see engineering drawing).

10. Check wheel toe-in setting (between 1/32” and 3/32”) and adjust, if necessary.

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

Figure 2. The bushing replacement kit with hardware includes traditional hardware to replace the Huck® Fasteners used for initial assembly.