

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)
- RAR-266 Low Mount  
(20K capacity)
- RAR-254 Single Point  
(50K Capacity)

### Bushing Replacement Procedure

Park the vehicle on a level surface. Chock wheels to keep vehicle from moving. Raise vehicle to a height that removes the load from the suspension. 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.

#### 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.



Part No.: 9710016

## (Narrow) Bushing Replacement Tool - 6100044

### 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 the 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.

### Tool Assembly

Make sure that the thrust washer is firmly seated in the flat (outside) edge of the end cap. Examine both the tool cone tapered insert and larger open end for any damage/out-of-round. Repair or replace if necessary.

### Bushing Removal

1. Lubricate the hex-head bolt threads and the thrust washer bearings with Extreme Pressure Lube (#1980014).  
NOTE: Failure to apply lubricant could result in decreased tool performance and reduced life of the tool.
2. Place the flat washer onto the hex-head bolt, followed by the bearing collar, then the end cap assembly. The bushing tool cone tapers to a smaller opening on one end. Place the larger opening of the cone onto the end cap. NOTE: Always place the tapered end of the cone against the eye of the beam (Figure 1).
3. Insert the end of the hex bolt through the bushing sleeve into the center opening of the plunger. Make sure the cone is centered on the beam eye and tighten the hex bolt until the plunger is firmly against the bushing.
4. Use a 1 1/4" socket on a 3/4" drive impact wrench (1" recommended) to rotate the hex bolt and press the bushing out of the beam eye into the cone. NOTE: It may require a small amount of heat 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 the old bushing from the bushing tool cone and discard.

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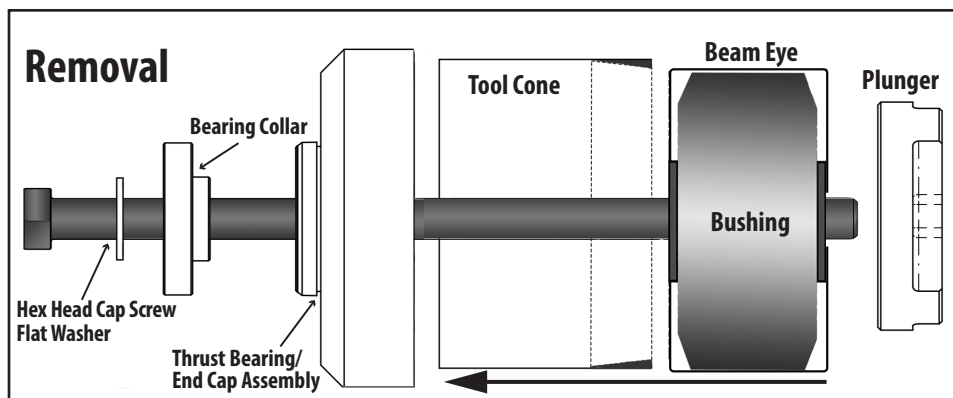
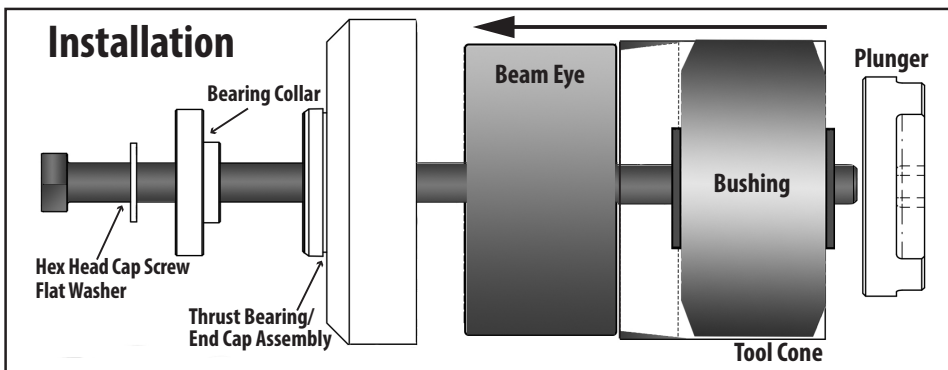


Figure 1.  
Tapered end of cone is placed against the beam eye for removal.



**Figure 2.**  
Lubricate outside of bushing, inside the beam eye and the inside of the tool cone before installation.

### Tool Assembly

Place the flat washer, the bearing collar, and the end-cap assembly on the hex-head bolt.

### Bushing Installation

1. Use a wire brush to clean any debris and corrosion out of the beam eye.
2. Liberally apply P80® lubricant or soap solution to the inside of the beam eye, the outside of the bushing and inside the tool cone.
3. Insert the new bushing into the large end of the tool cone.
4. Place the plunger/cone/bushing assembly on the beam eye.
5. Insert the hex-head bolt assembly through the beam eye. Thread the hex bolt into the plunger until the end-cap rests against the beam.
6. Center the bushing tool cone on the beam eye. Use a 1 1/4" socket on a 3/4" drive impact wrench (a 1" impact wrench is recommended) to rotate the hex bolt and press the bushing into the beam eye.
7. Disassemble and remove the bushing replacement tool. Check placement to make sure bushing is centered in 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 the pivot bolt/pivot nut.

Tighten flanged locknut until the adjuster plate pin is engaged and the 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 the pivot bolt with an E-20 Torx® socket (Ride-well tool #6100054) on a 1" drive impact wrench and until the Torx® head shears off.

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

