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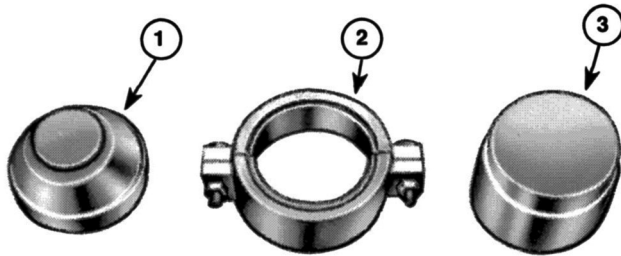
Form No. 102501

Parts List &
Operating Instructions for: **1763**
Y-840-A

Center & End Bushings Service Set

Application: Heavy Duty R500 & R700 Series Hendrickson Suspensions

PARTS LIST



Item No.	Part No.	No. Req'd	Description
1	35855, Y-844-A	1	End Bushing Removal/Replacement Adapter
2	42050, Y-843-A	1	Clamp
3	28541, Y-842-A	1	Center Bushing Removal/Replacement Adapter

NOTE: The heavy duty center and end bushing service set requires a shop press with a minimum capacity rating of 100 tons.

CENTER BUSHING REMOVAL

1. To remove the bushings on the R500 and R700 heavy-duty series suspensions (50,000 and 70,000 lb.), the equalizing beams must first be removed from the vehicle and placed in a shop press.
2. Position the equalizing beam in the shop press and align the Center Bushing Removal/Replacement Adapter (Item No. 3) as shown in Figure 1.

WARNING

Check to insure proper alignment of tooling adapters with truck equalizing beam components before applying full hydraulic pressure with a shop press.

3. Apply hydraulic force and remove bushing.

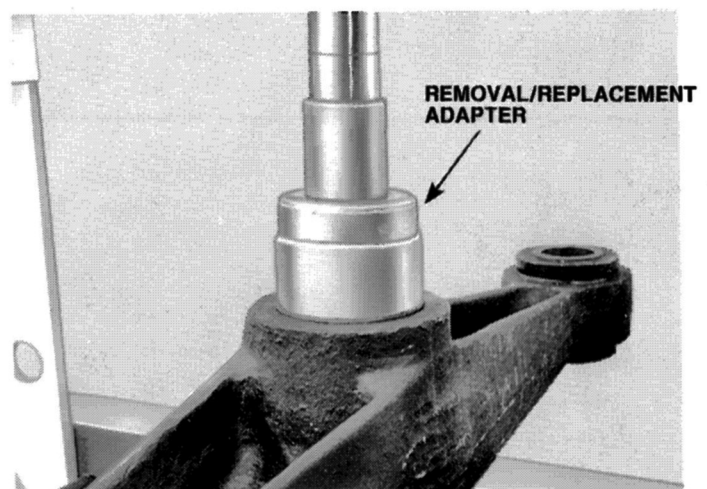


FIGURE 1

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Issue Date: Rev. B, January 11, 2018

CENTER BUSHING INSTALLATION

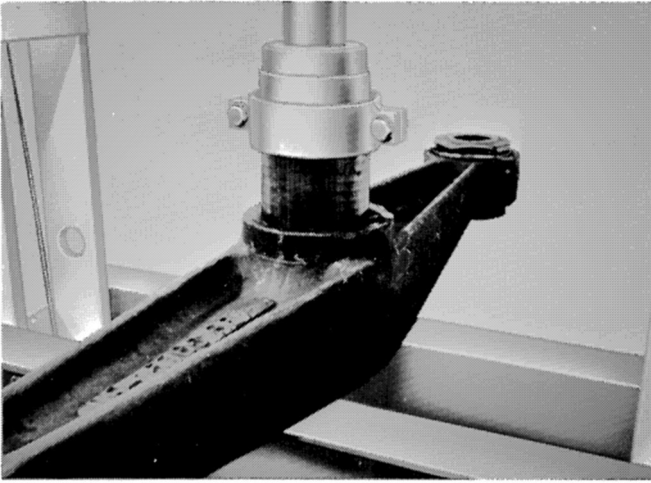


FIGURE 2

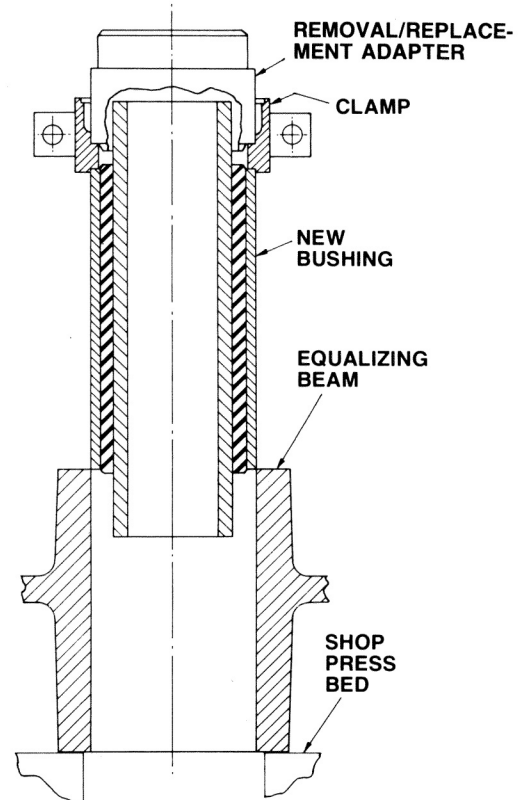


FIGURE 3

1. Polish the center bore of the equalizing beams with a cylinder hone or emery paper. Clean out and apply a suitable lubricant to the center bore and to the new bushings.
2. Position the removal/replacement adapter onto the new bushing. Assemble and wrench tighten the Clamp (Item No. 2) onto the bushing and the removal/replacement adapter as shown in Figure 2 and 3.

⚠ WARNING

Check to insure proper alignment of tooling adapters with truck equalizing beam components before applying full hydraulic pressure with a shop press.

3. Apply hydraulic force and press new bearing into the equalizing beam.

END BUSHING REMOVAL

1. Position the equalizing beam in the shop press and align the End Bushing Removal/Replacement Adapter (Item No. 1) with the tapered end facing the bushing to be removed (see Figure 4).

⚠ WARNING

Check to insure proper alignment of tooling adapters with truck equalizing beam components before applying full hydraulic pressure with a shop press.

2. Apply hydraulic force and remove the old bushing.

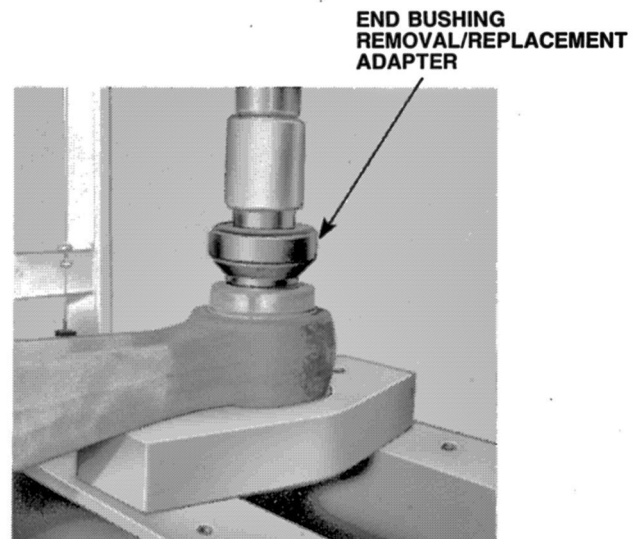


FIGURE 4

END BUSHING REPLACEMENT

1. Polish the end bushing bore with a cylinder hone or emery paper. Clean out and apply a suitable lubricant to the end bores and to the new bushings.
2. Position the end bushing removal/replacement adapter, with the tapered end facing away from the new bushing, onto the new bushing. Assemble and wrench tighten the Clamp (Item No. 2) onto the bushing and the adapter as shown in Figure 5 and 6.

WARNING

Check to insure proper alignment of tooling adapters with truck equalizing beam components before applying full hydraulic pressure with a shop press.

3. Apply hydraulic force and press the new bearings into place. The bushing will be completely seated when the clamp makes contact with the beam face.

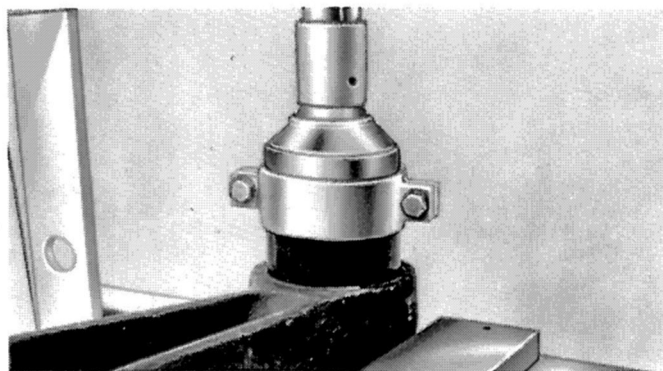


FIGURE 5

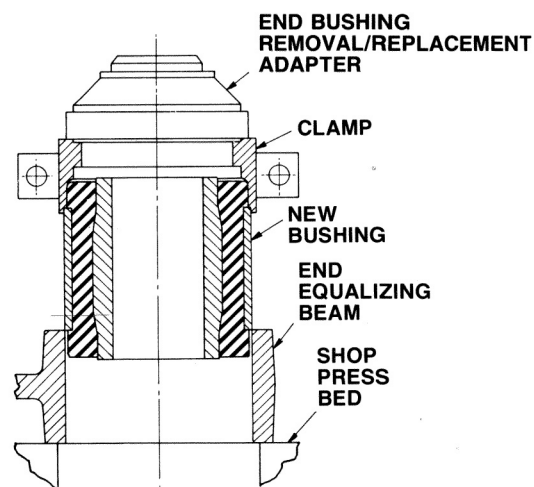


FIGURE 6