

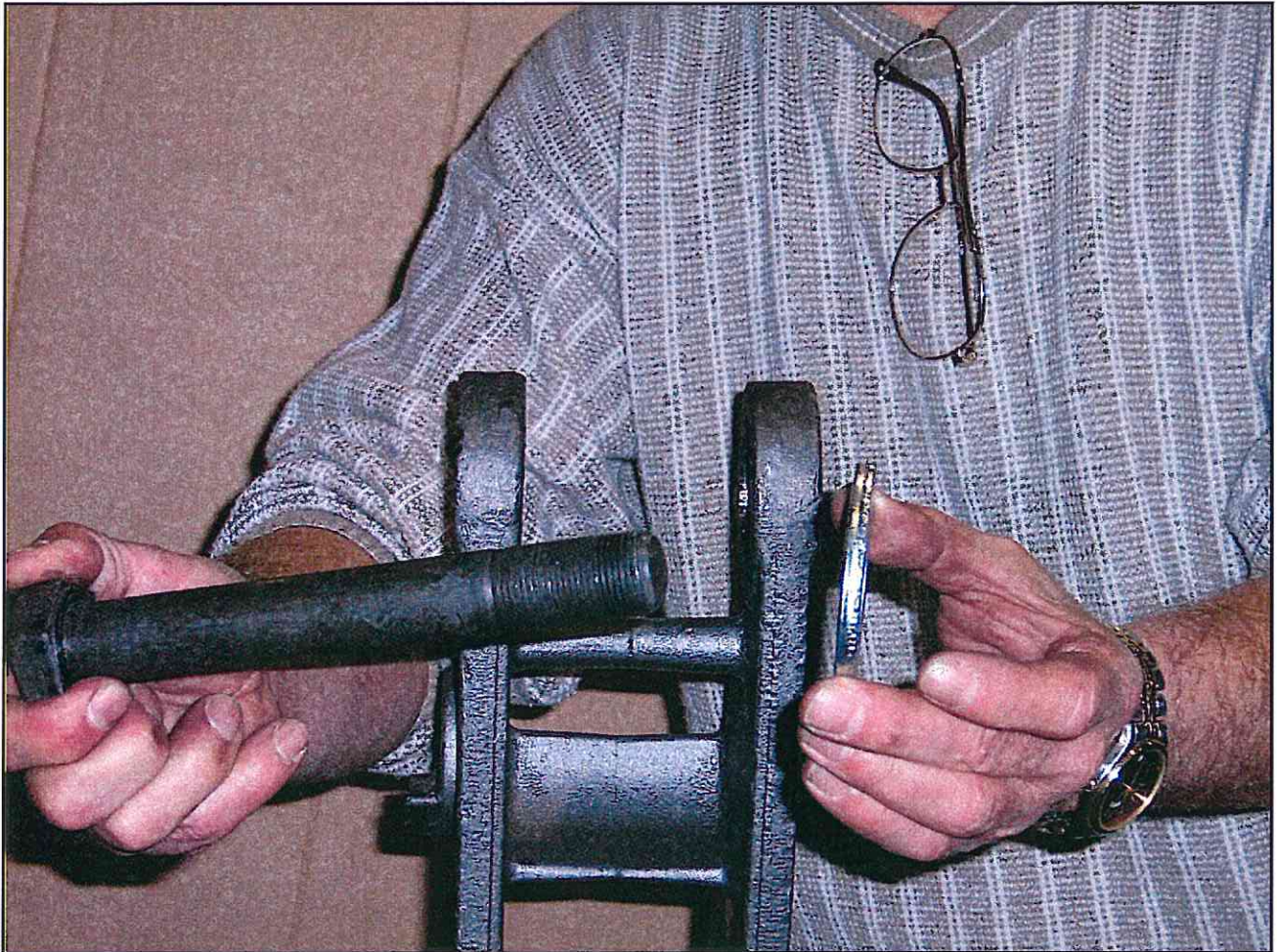
21B Bushing Installation for Rubber or Blue Urethane Bushings

**Pictures used are hanger side of
suspension, duplicate these
procedures on axle bracket**

Proper Torque



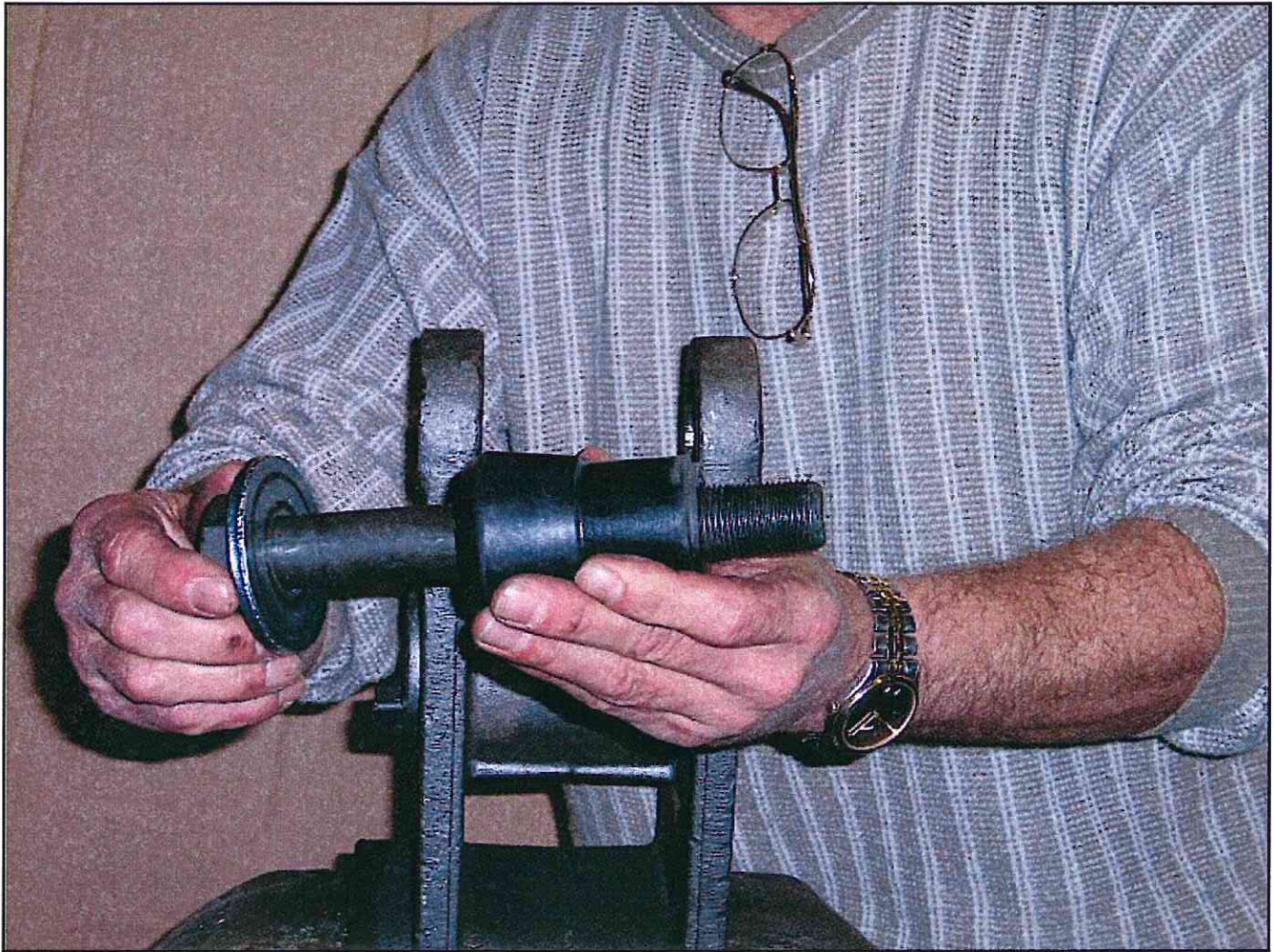
- 1 Inch Torque Arm Bolts 140 -160 FP when using Rubber or Blue Urethane Bushings
- When proper Bushing squeeze is attained STOP
- Do Not Retorque these fasteners after installation
- 1 Inch Equalizer Cap Screws are torqued to 400-450 FP



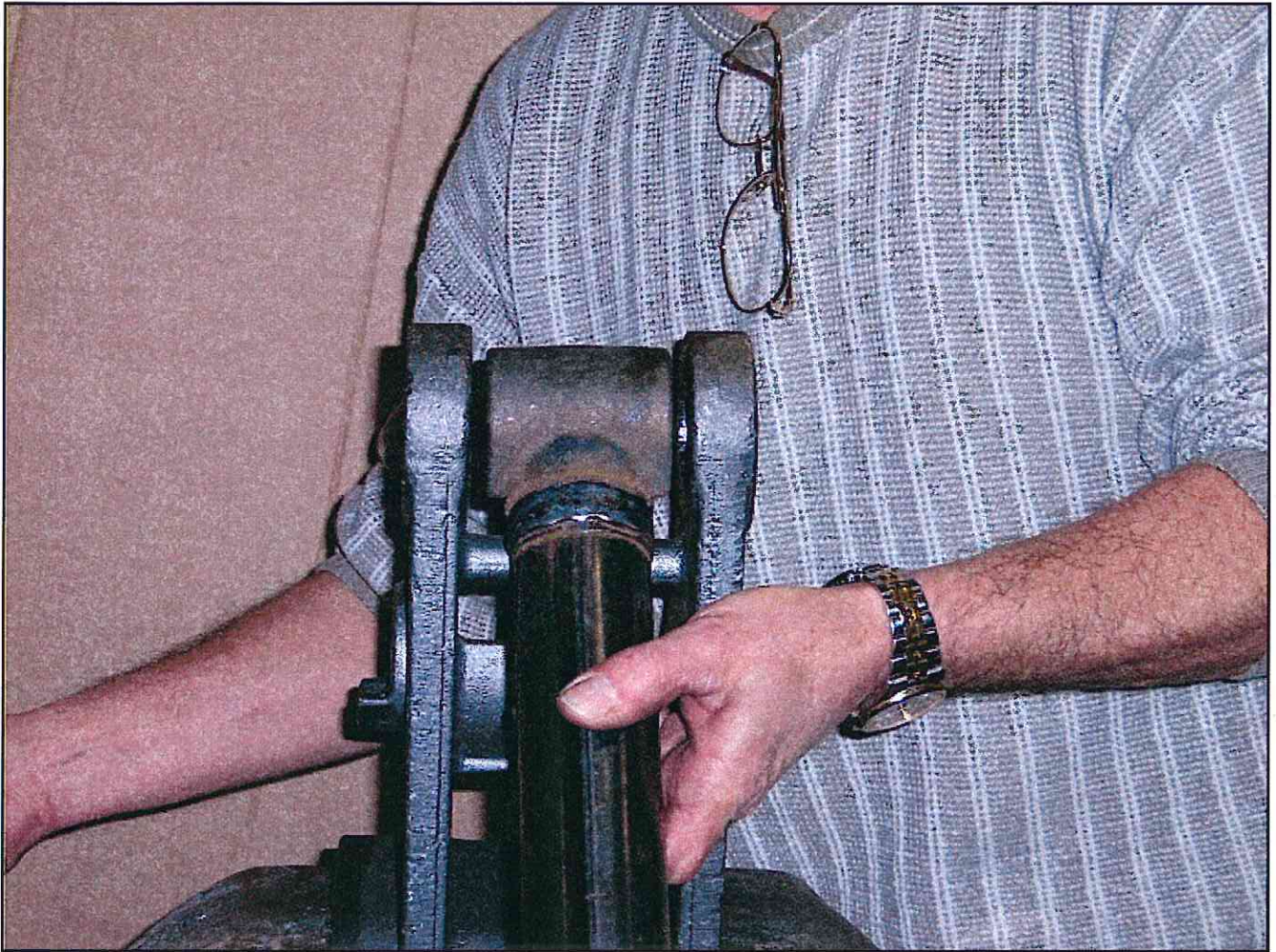
Always use a New Bolt, Nut, Washers, & Bushings. New Bolt should be dry and unlubricated.



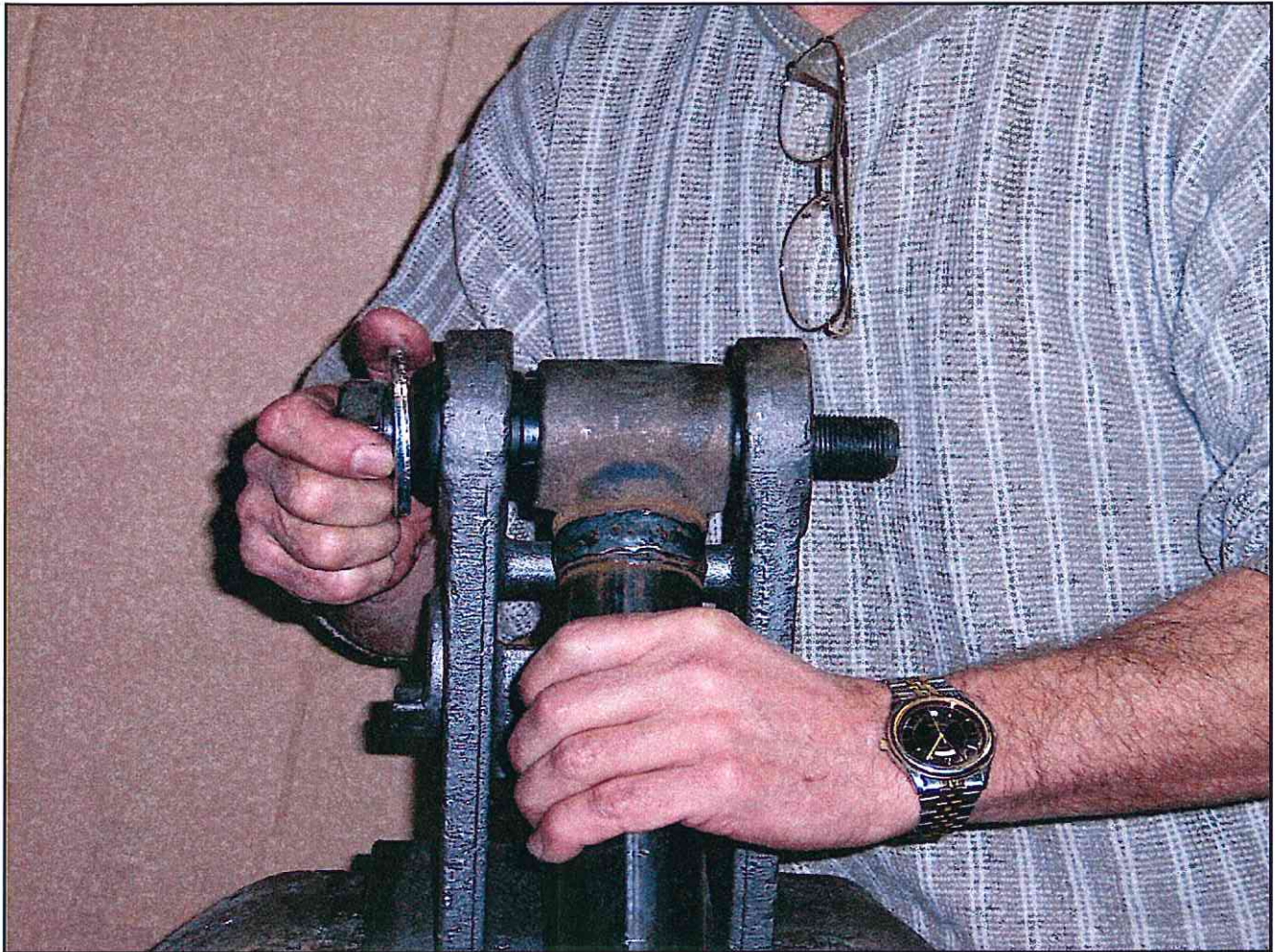
Inspect hanger to make sure the bushing surface is clean, smooth and free of any burr's, Install 1 washer on the new bolt. Bolt head will be to inside of the suspension.



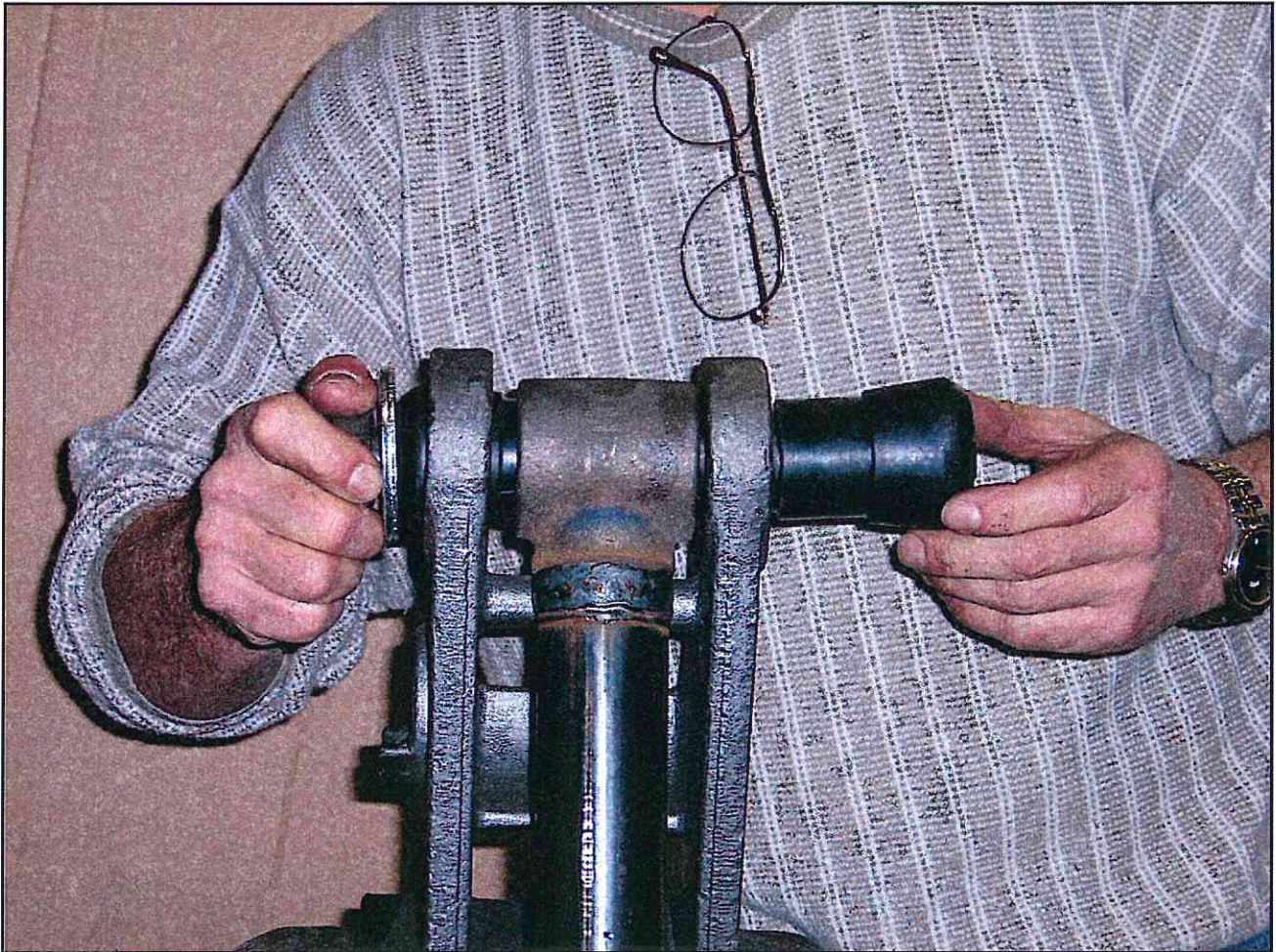
Install one bushing on the bolt, large side against the flat washer.



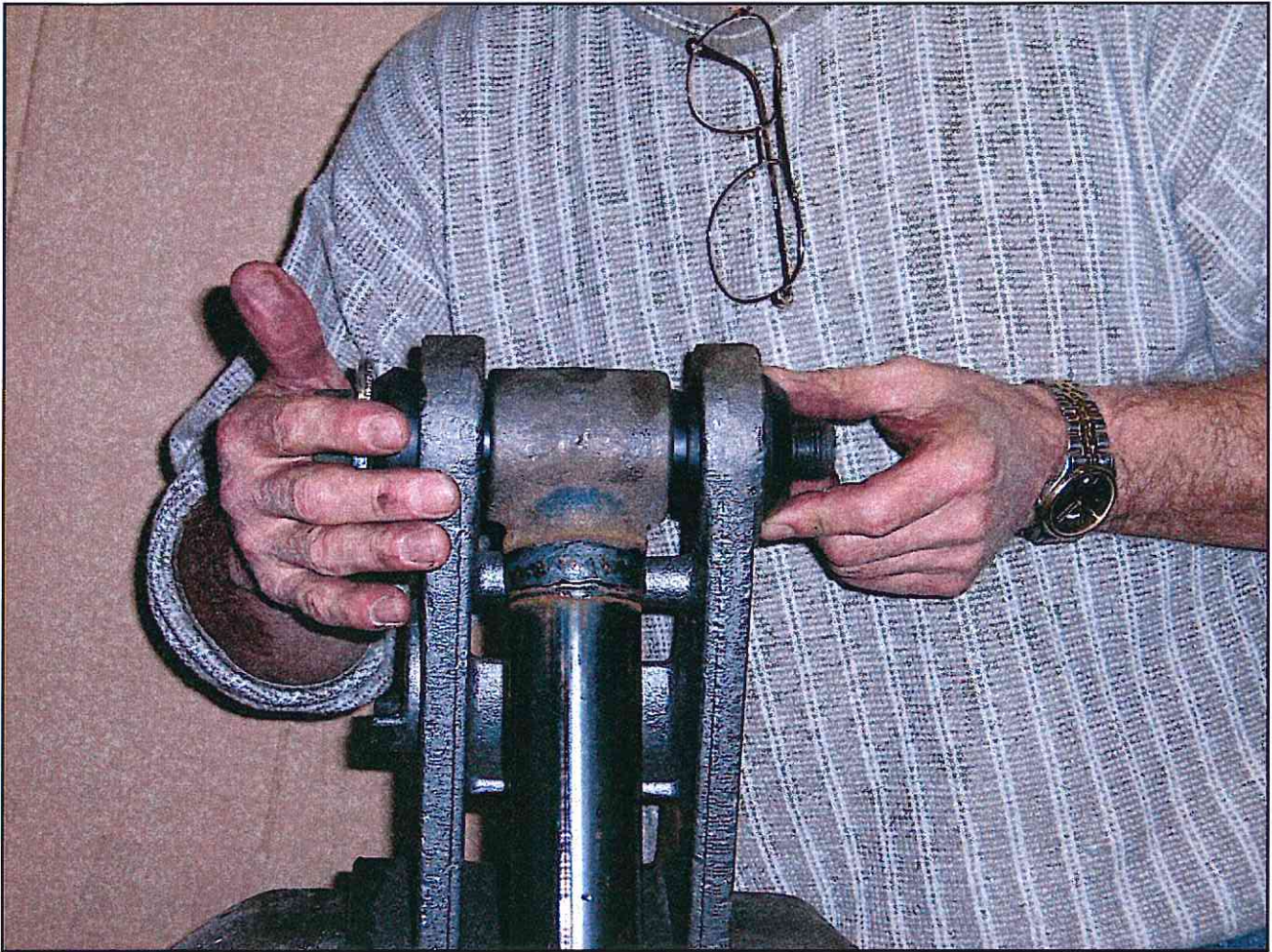
Center the torques arm between the ears of the suspension spring hanger.



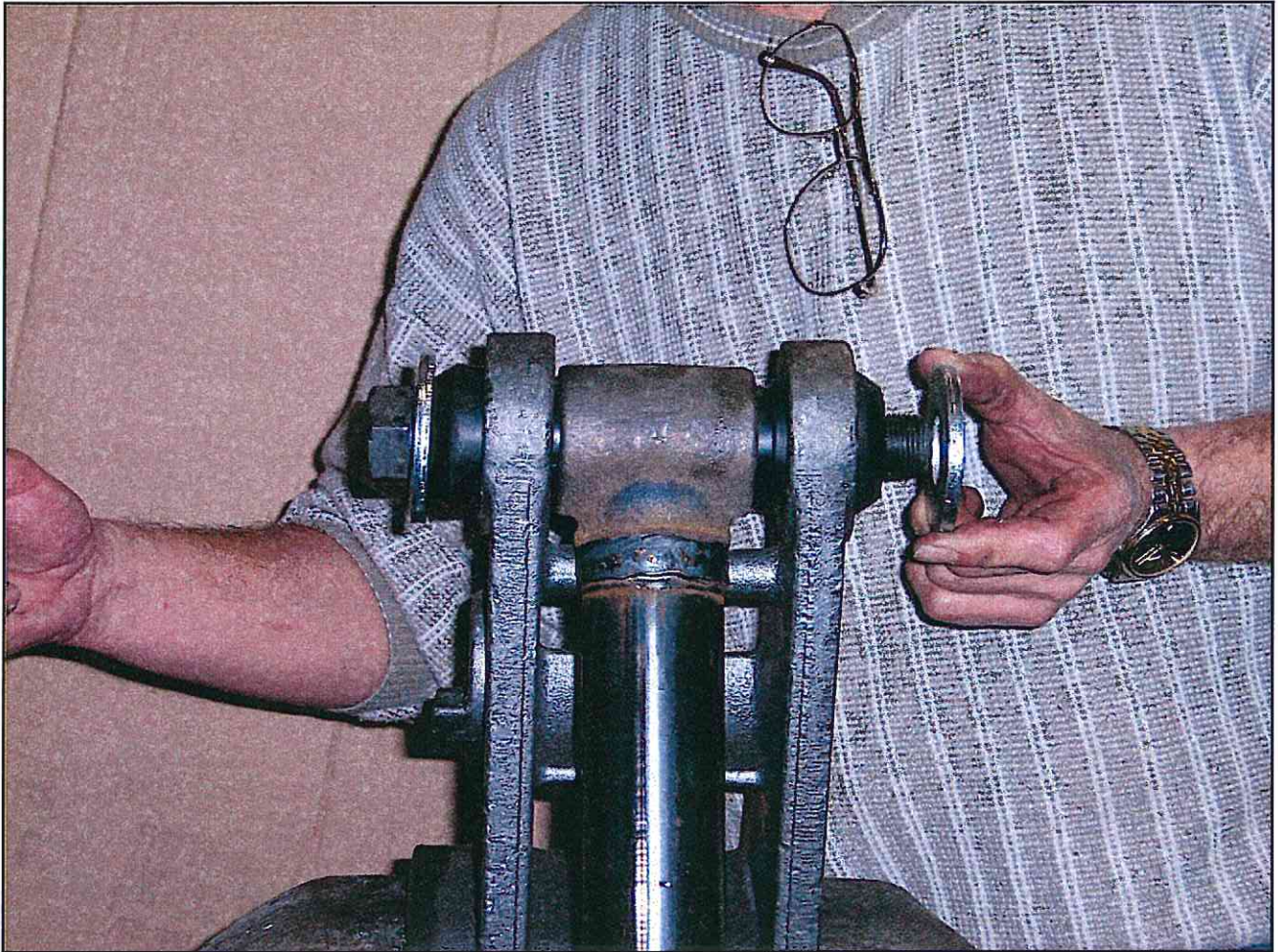
Install the bolt with washer and bushing through the hanger eye from the inside of the trailer (lubrication of the bushing is not required, but a non petroleum based lube may be used).



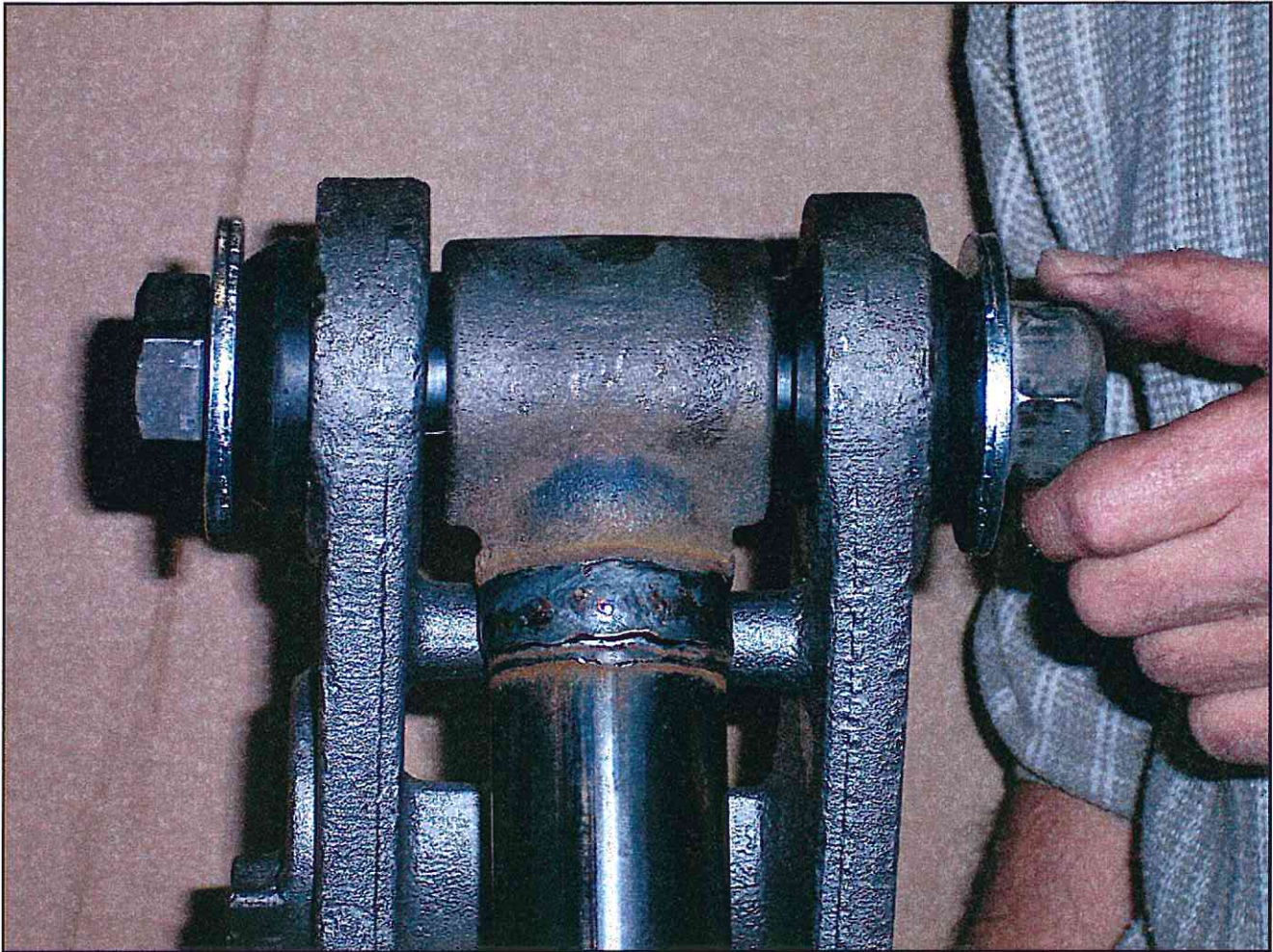
Install the second bushing through the other hanger eye, large end to the outside.



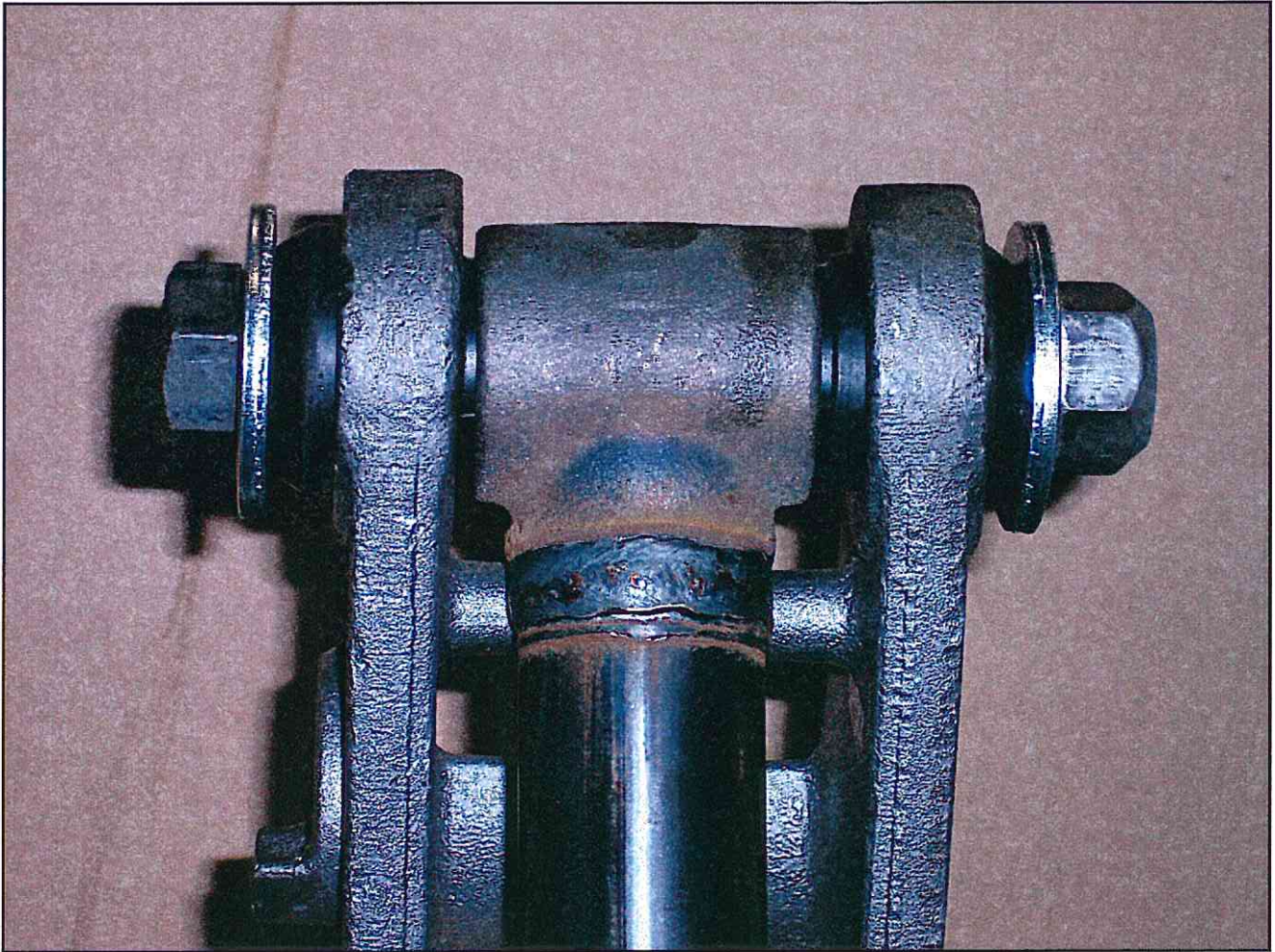
Push bushing through hanger eye into the torque arm end, keep torque arm centered in the hanger.



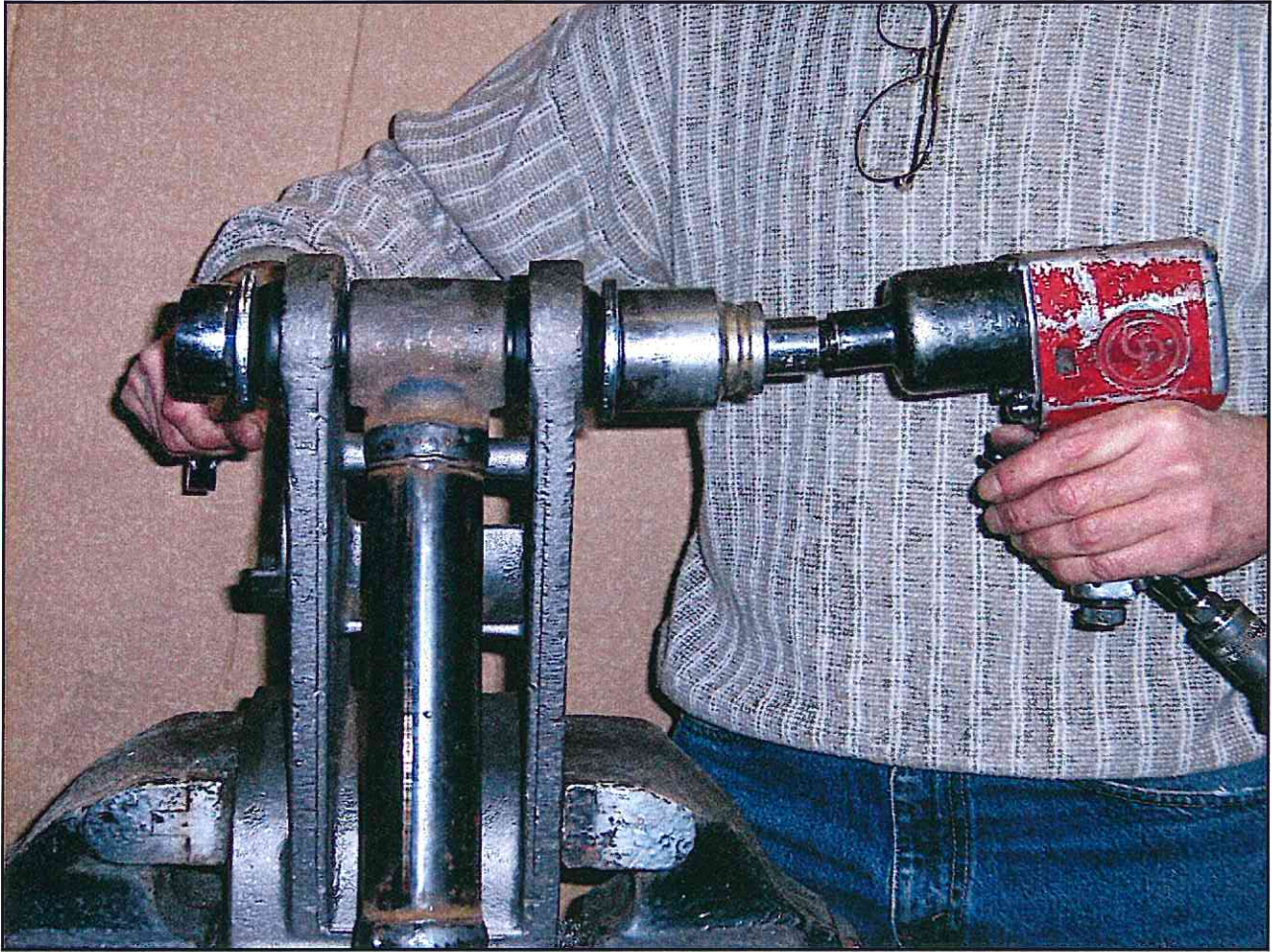
Install second washer on bolt and push against bushing, keep torque arm centered in hanger.



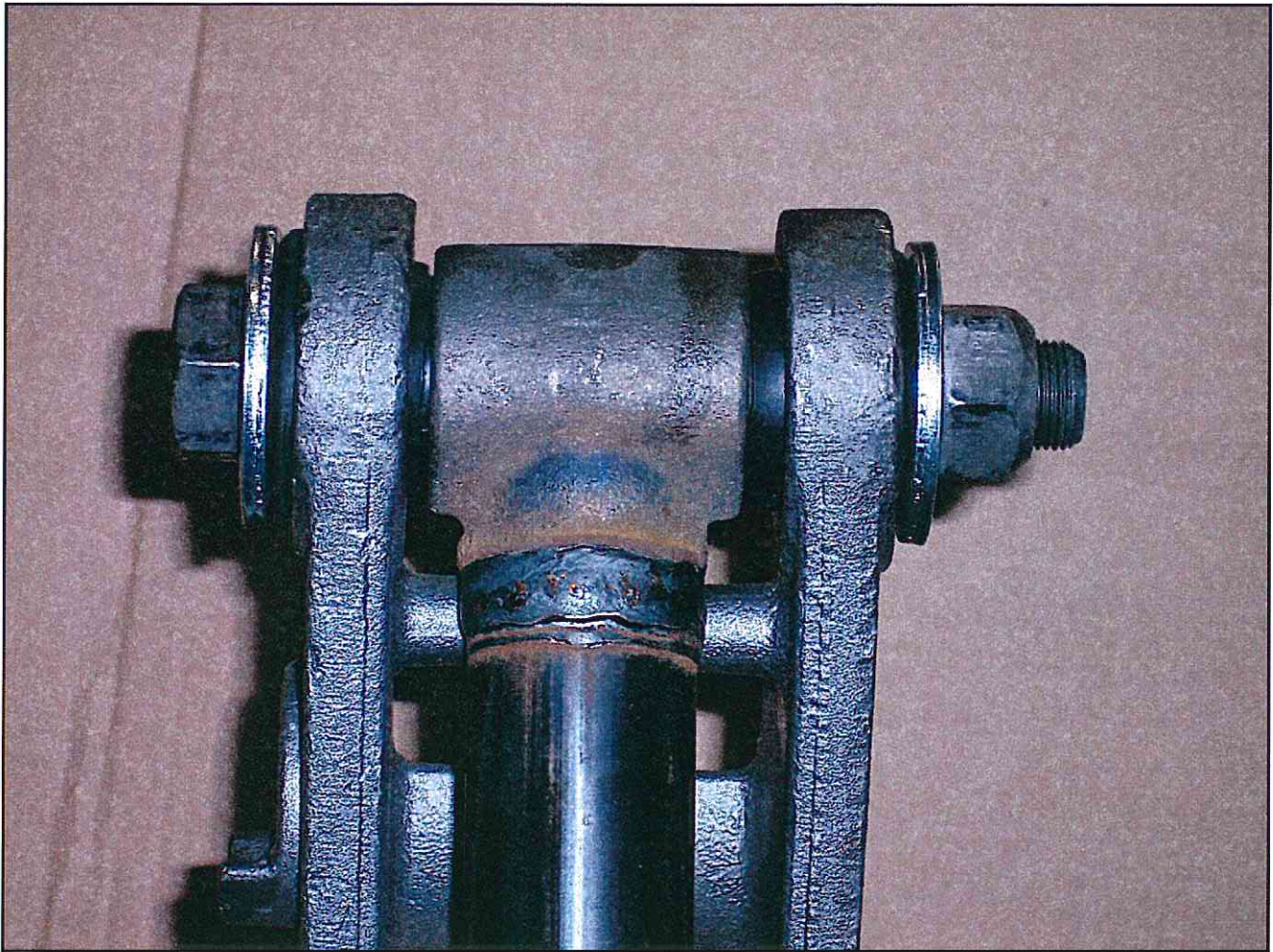
Install lock nut and tighten till contact is made with out side washer, making sure to keep torque arm centered and gaps are visible between washers and hanger side (both sides) and a visible gap between inside hanger sides and torque arm end casting.



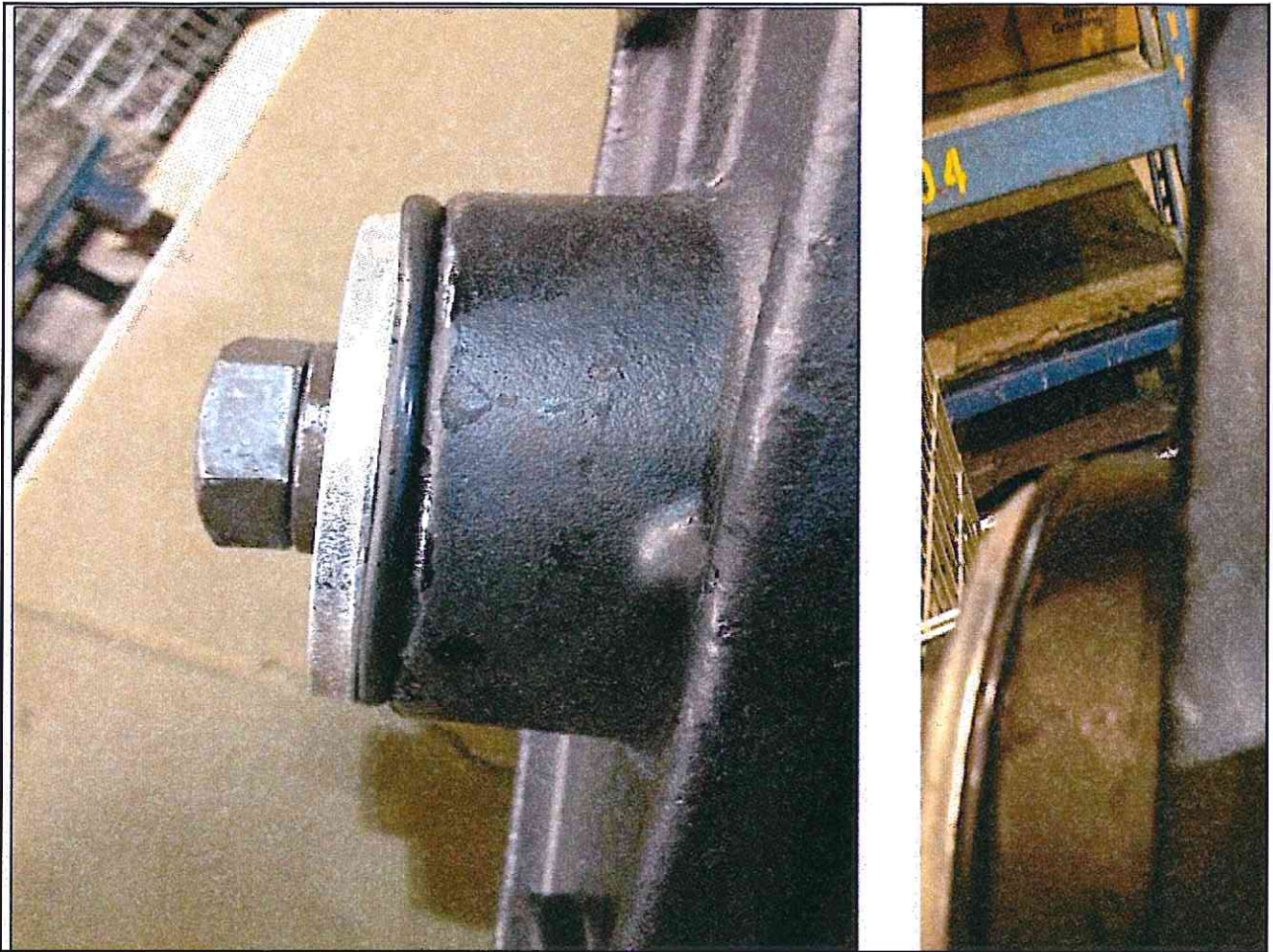
Your assembly should look similar to this picture. At times it may be necessary to tap the assembly several times with a shop hammer to properly center the bushing assembly.



Using an impact gun, to keep everything centered, slowly tighten the assembly. The bolt and nut assembly should be tightened to 140 to 160 ft pounds of torque.



The picture above shows what the completed assembly should look like. You will notice there is a cushion of rubber between the washers and hanger casting on the inside and outside, there is also a rubber cushion between the torque arm end and the inside of the casting on both sides. The initial torque value will decrease as the bushings take a “set”. It is not necessary to retorque after proper bushing squeeze is accomplished. Visually Check at each inspection for worn or damaged bushings.



Pictures shows proper bushing squeeze on the Equalizer. Tighten in a side to side motion to maintain equal amounts of bushing showing. The equalizer bushing goes metal-to-metal, so it is less temperamental. It can be re-torqued without pushing out more rubber.