

Disassemble the Bushing Press Tool. Inventory parts. Read all removal and installation instructions before starting bushing removal/installation process.
Notice: Use *Never Seize* on threads at every use. DO NOT use impact wrench. Use sockets and ratchets ONLY. Always use protective hearing and eye gear.

Bushing Removal Instructions

1. Remove kingpin from housing.
2. Insert square end of Press Bolt (#S101) into housing hole. Usually from the top.
3. Choose correct size of Press Washer to fit inside bushing. These washers have square holes. Check washers for size by using the replacement bushings to measure. Washer must NOT be larger than the outside of the new bushing. Place the square holed washer over the square end of Press Bolt. Screw on half-inch nut (#S104). Snug down the nut, but do not over tighten. The Press Washer has to pass through the axle housing. The old bushing will be pulled from the bottom, through the axle, into the Receiver Cylinder (#S102).
4. Place Receiver Cylinder on top of axle with threads sticking up.
5. Place Receiver washer over bolt centering it so that the lower shoulder on washer fits into the Receiver Cylinder.
6. Place flat washer (#S110) on top of Receiver Washer. Screw on Press Bolt Nut by hand until everything gets snug, but can still move. Make sure everything is centered. The Press Nut (#S105) is a specially designed nut. One end has recessed threads and the other end has flush threads. Depending on the size of bushing, invert the Press Nut to fit the situation.
7. Use a ratchet and socket and start tightening the Press Nut. If the bushing seems to not be coming out, recheck the Press Washer at the bottom and make sure it is the proper size and it is centered.
8. At no time should the bolt turn when removing or installing bushings.

Bushing Installation Instructions

Notes:

****The Receiver Cylinder (#S102) will or will not be used according to bushing length and/or bushing housing length. A shorter bushing will require that the Receiver act as a spacer between the bushing housing and the press nut (#S105). The Receiver Cap Washer (#S103) will be utilized also at this time.**

****Washers are made with an inner shoulder so that the washers will fit inside the Receiver Cylinder to guard against slipping and damaging the Receiver Cylinder (#S102) or Press Bolt (#S101) threads. When assembling the Bushing Press on the vehicle, make sure all parts are centered.**

****Sometimes there are burrs and other rough spots in the housing where the old bushing came out. Use a solvent and a piece of Emery Cloth to clean the housing hole, removing rough areas. Using solvent, wash out any grit that might be left behind and coat the inside of the housing hole with *Never Seize* for smooth, straight, insertion of the new bushing.**

****The new bushings are pulled from the bottom up in most cases. Make sure the bushing is lined up straight in the housing hole.**

1. Place Press Bolt (#S101) through bushing housing hole, putting the small end with square shoulders in first. This step is usually done inserting the Press Bolt from the top. Check to make sure the Press Bolt is inserted deeply enough to place Press Washer with square hole on Press Bolt. Usually, if you used the receiver to remove the bushing, you will need it to install the new bushings. If you need a spacer, use the Receiver Cylinder (#S102) with a Receiver Cap on each end to act as a spacer. This should leave enough Press Bolt sticking out of the bottom. If not, remove the receiver.
2. Place the flat washer (not seen on diagram, but provided) over the top of the Press Bolt Screw. This will stop the galling between the Press Bolt and the Receiver Cylinder when you start tightening. Look at the Press Nut. On one end, the threads are inset deep inside. On the other end, the threads are flush. Use the appropriate end to turn the Press Nut on enough to hold in place against the flat washer.
3. Slip the new bushing up past the square shoulder end. There are four different Press Washers with square holes. The best way to see which press washer to use is to use the new bushing to see which washer shoulder fits the bushing best, without protruding over the outside of the bushing. Choose the correct size of Press Washer and place it over the square shoulder up against the new bushing. Start hand tightening the Press Nut.

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Bushing Tool Assembly View

Parts List

ITEM	ITEM #	QTY	Description
#S101	1	1	Press Bolt
#S105	2	1	Press Nut
#S104	3	1	1/2 inch Nut
#S109	4	1	Press Washer 1"
#S108	5	1	Press Washer 1 1/4"
#S107	6	1	Press Washer 1 1/2"
#S106	7	1	Press Washer 1 3/4"
#S103	8	2	Receiver Cap Washer
#S110	9	1	Flat Washer
#S102	10	1	Receiver Cylinder

