Form No. 102497

Parts List and
Operating Instructions for: 1744

Bronze Center Bushing Removal Set

Application: Hendrickson 340, 380, 440, and 460 Suspensions

Some 34,000 lb., 38,000 lb., 44,000 lb., and 46,000 lb. Hendrickson Truck Equalizing Beam suspensions are equipped with bronze center bushings. This No. 1744 service set is designed to remove and install the bronze center bushings and grease seals used with the bushings. This service set must be used with No. 1740, 1741, or 1742 OTC Tooling Set as shown in Figures 1 and 2.

1 2 3 4

Parts List

Item No.	Part No.	No. Req'd	Description
1	**28536**	1	Installing Adapter (5-3/4 in. O.D.)
2	**28538**	1	Installing Adapter (4-5/8 in. O.D.)
3	**302024**	1	Removing/ Installing Adapter (4-23/32 in. O.D.)
4	**302025**	1	Removing/ Installing Adapter (3-19/32 in. O.D.)

Safety Precautions

WARNING: To prevent personal injury,

- **Read and understand all safety precautions and operating instructions before using these tools. If the operator cannot read these instructions, operating instructions and safety precautions must be read and discussed in the operator's native language.**
- **Wear eye protection that meets ANSI Z87.1 and OSHA standards.**
- **Block the front tires of the vehicle with wheel chocks to prevent movement of the vehicle during bushing removal and installation.**
- **Never stand directly in front of the pulling screw or other components while applying hydraulic pressure.**
- **Do not alter the tooling or use hydraulic components not designed for this application.**

Bronze Center Bushing Removal

1. Remove the saddle caps that hold the center bushing and beam to the spring assembly. *Note: Bronze center bushing removal and installation can be accomplished with the wheels left on the vehicle and the beam in place, eliminating the need for wheel and beam disassembly.*
2. Raise the rear of the vehicle until the saddle studs clear the equalizing beam. Use a hole saw to cut out the retaining disc in the center of the bushing. **CAUTION: Do not use a torch to burn out the disc, which could permanently damage the equalizing beam.**
3. Remove the cross tube. *Note: RU340-series cross tubes must be removed by using OTC No. 1743 End Bushing Hanger Tube / RU Series Center Bushing Service Set.*
4. Refer to Figure 1. Assemble the tooling as shown using a removing / installing adapter from this No. 1744 set, plus the following tools from the No. 1740 Basic Tooling Set:

Item numbers refer to callouts in Figure 1.

Item No. 1 – 302029 Speed Nut
Item No. 2 – 302023 Ram Screw
Item No. 3 – 302021 Receiving Adapter (34,000 lb. suspensions only)
Item No. 4 – 302028 Hex Nut

34,000 lb. Suspension Tooling Setup
Assemble the tooling as shown in Figure 1 using No. 302025 Removing / Installing Adapter.

38,000 lb., 44,000 lb., or 46,000 lb. Suspension Tooling Setup
Assemble the tooling as shown in Figure 1 using No. 302024 Removing / Installing Adapter, but do not use No. 302021 (Item No. 3) from the 1740 Basic Tooling Set.

WARNING: To prevent personal injury, the threads on Item Nos. 1 and 4 must be fully engaged before hydraulic pressure is applied.

5. Slowly and carefully activate the hydraulics to pull the bushing out of the beam.

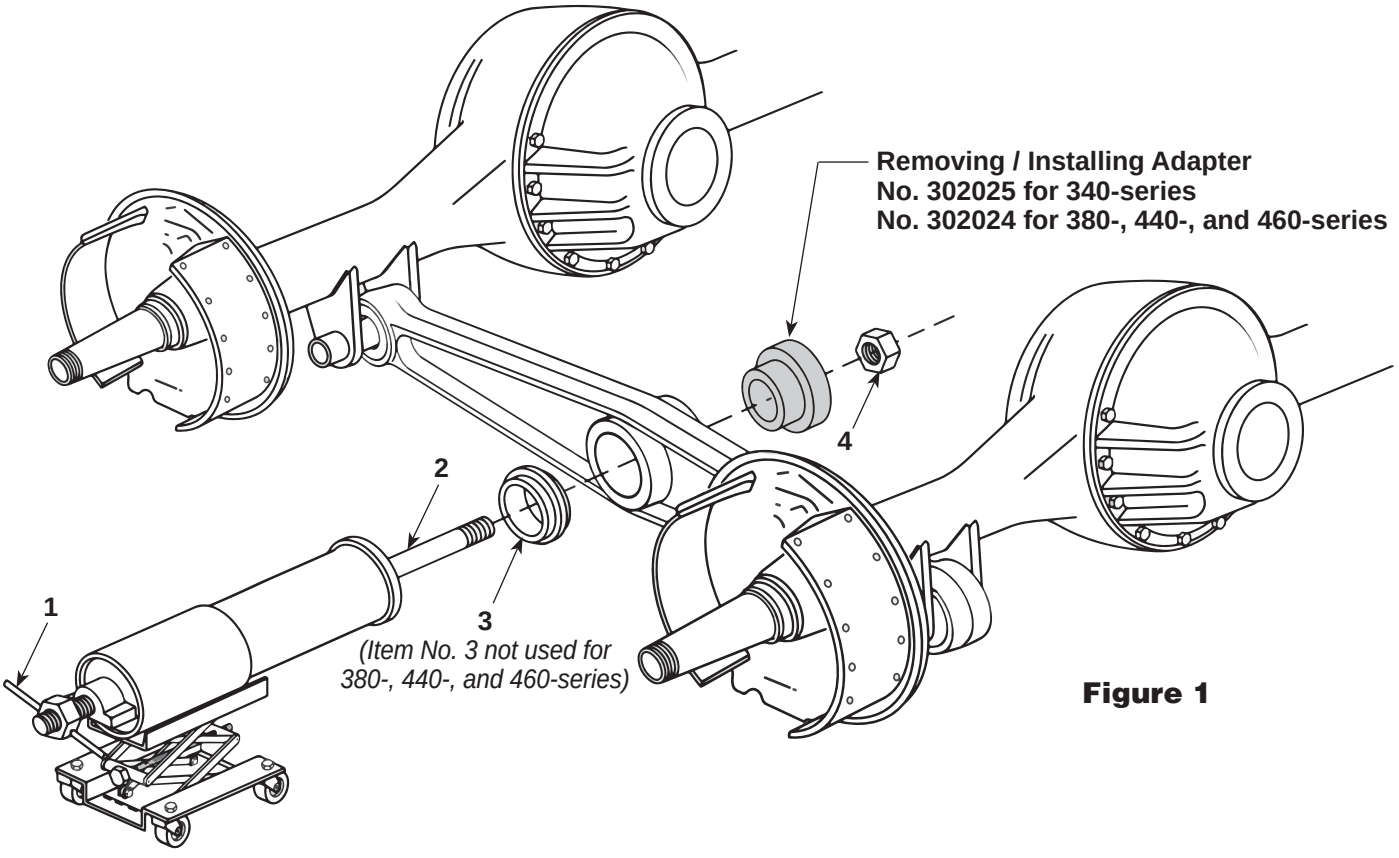


Figure 1

Bronze Center Bushing Installation

1. Clean and lubricate the equalizing beam bore, following Hendrickson-approved procedures.
2. Assemble the tooling components as shown in Figure 2 and Inset A. Position the deep ridge of the installing adapter (No. 28536 or 28538) against the bronze bushing as shown in Inset A. Slowly and carefully activate the hydraulics to pull the new bronze center bushing into place.

WARNING: To prevent personal injury, the threads on the speed nut and hex nut must be fully engaged before hydraulic pressure is applied.

3. Flip the installing adapter to position the shallow ridge against the grease seal as shown in Inset B. Tap the seal in place by striking the adapter assembly with a hammer. Grease seals are installed at the correct depth when the adapter makes contact at all points on the face of the beam.

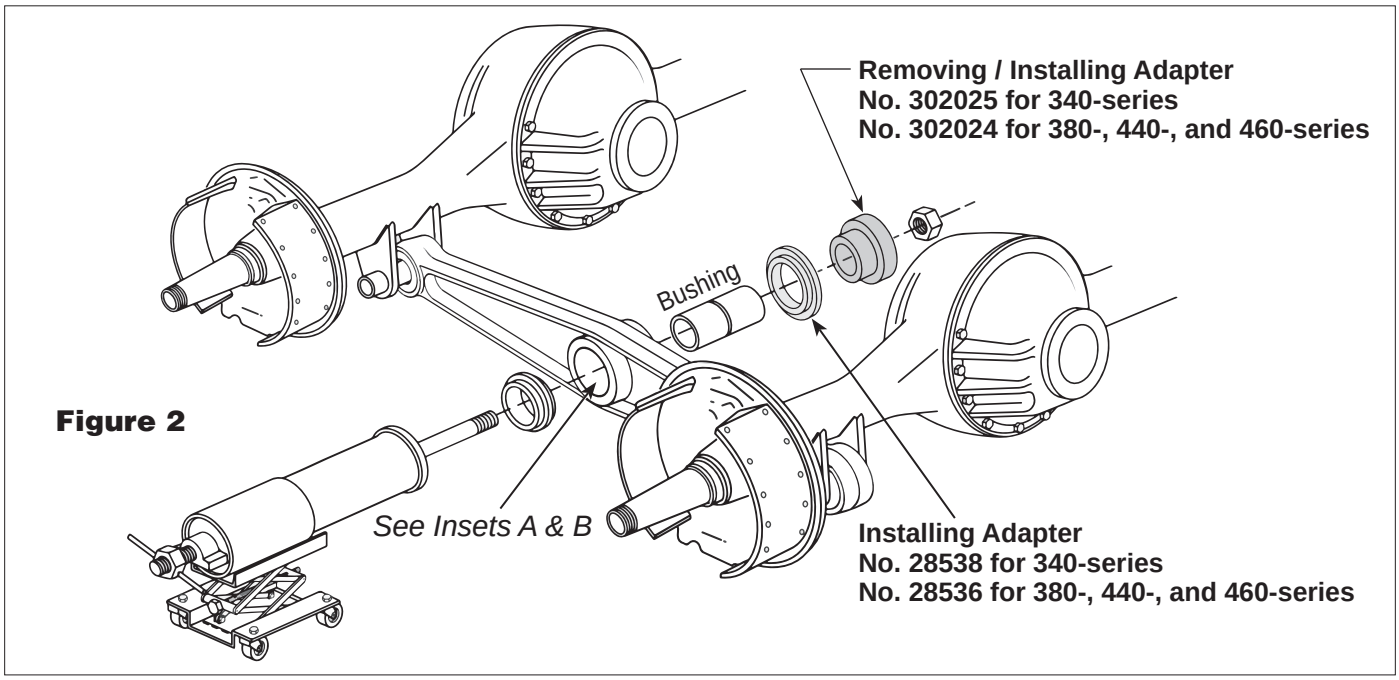
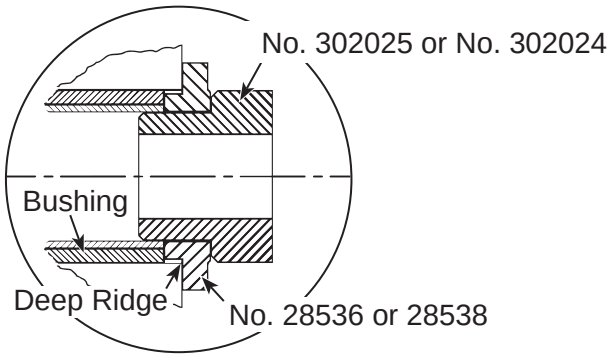
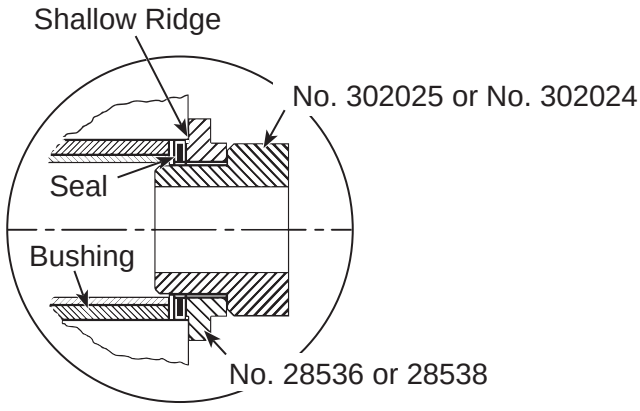


Figure 2



Inset A
Installing
Bronze Center Bushing



Inset B
Installing
Grease Seals