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Form No. 102498

**Parts List &
 Operating Instructions**

for:

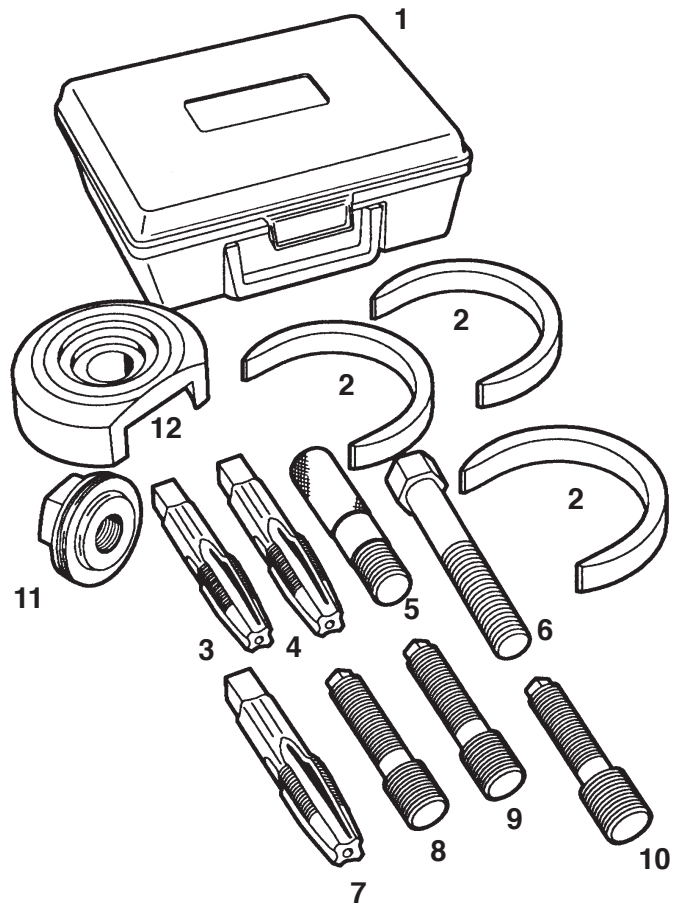
**1745
 1748
 Y-815**

End Bushing Adapter Plug Removal Set

Application: Hendrickson Suspensions

The #1745 and Y-815 sets are designed to remove the end bushing adapter plugs on 340 - 440 series suspensions; the #1748 set removes the end bushing adapter plugs on 460 - 520 series suspensions. (The plugs must be removed before the end bushing can be replaced.) These removal sets are designed to be used with the #1740 basic service set.

Item No.	Part No.	No. Req'd	Description
1	61415	1	Plastic Box
2	207025	3	Spacer Ring
3	207030	1	Special Hand Tap (7/8-14 UNF)
4	207031	1	Special Hand Tap (15/16-12 UN)
5	207026	1	Plug Gauge
6	207027	1	Screw
7	221378	1*	Special Hand Tap (M30 x 2)
8	302592	1	Screw (7/8-14 UNF)
9	302593	1	Screw (15/16-12 UN)
10	313342	1*	Screw (M30 x 2)
11	207039	1	Nut Assembly (consists of 204237 Retaining Ring, 207038 Thrust Bearing Washer, 207042 Thrust Bearing Roller, & 302596 Nut)
12	302595	1	Receiving Cup



* Not included in 1745 or Y-815 Set

Note: An extra 207038 Thrust Bearing Washer and an extra 207042 Thrust Bearing Roller have been provided for the nut assembly.

Safety Precautions



Caution: To prevent personal injury,



- **Wear eye protection that meets the requirements of ANSI Z87.1 and OSHA.**



- **Block the truck's front tires, or whatever is necessary, to prevent movement of the truck while removing the end bushing adapter plugs.**

Sheet No. 1 of 2

Issue Date: Rev. C July 21, 2014

Adapter Plug Removal

1. Remove the saddle caps that hold the center bushing and beam to the spring assembly.
2. Raise the rear of the truck frame until the saddle studs clear the equalizing beam.
3. Remove the tires to provide access to the end bushing area.
4. Remove the bolt and nut that secure the adapter plugs to the axle hanger.
5. Determine which special hand tap fits the hole in the adapter plug closest to the differential:
 - Use the M30 tap (#7) on the larger suspensions (460 - 520 series).
 - On the 340 - 440 series suspensions, insert the plug gauge (Item #5) into the hole. If the gauge easily passes through the hole, use the 15/16" tap (#4); if it does not, use the 7/8" tap (#3).
6. Using cutting oil, tap the hole as straight as possible to a depth of about 1-1/2". See Figure 1.
7. Thread the screw of similar size (#8, #9, or #10) into the newly tapped hole.
8. Install the receiving cup (#12) and nut assembly (#11) onto the screw. See Figure 2.
9. Turn the nut until the adapter plug breaks loose and bottoms on the inside of the receiving cup as shown in Figure 3.
10. Add spacer rings as needed to finish removing the adapter plug from the axle hanger. See Figure 4

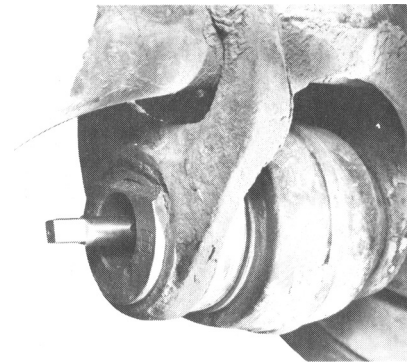


Figure 1

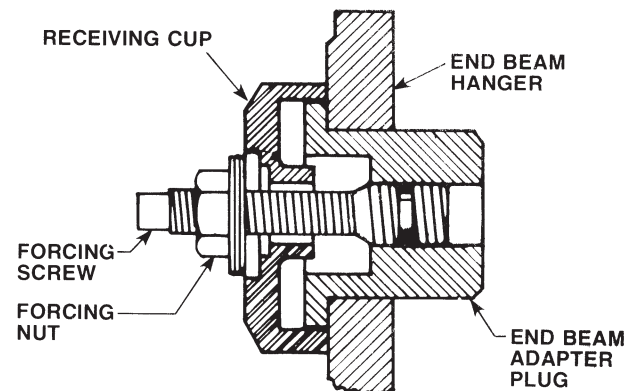


Figure 2



Figure 3

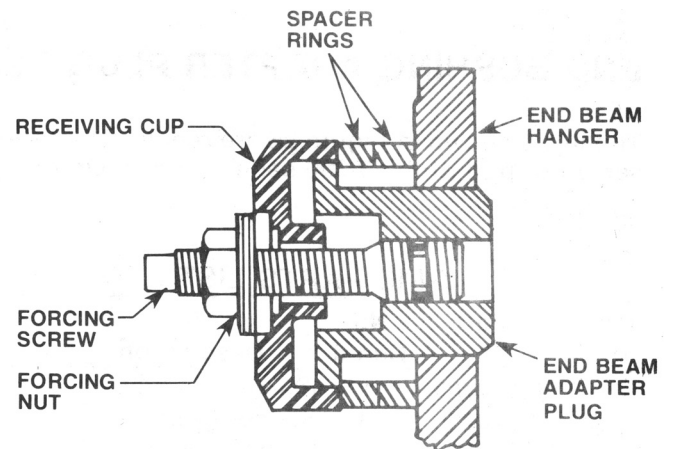


Figure 4

Removing the Second Adapter Plug

Removing the second adapter plug does not require using special hand taps.

1. Position the receiving cup over the adapter plug on the backing plate side.
2. Insert the screw (#6) from the differential side through the receiving cup, and secure the nut assembly. See Figure 5.
3. **Hold the bolt** and use a 1-1/2" open end or box wrench to **turn the nut**. See Figure 6.
4. Pull the adapter plug from the axle hanger until it bottoms on the inside of the receiving cup.

Note: It may not be possible to completely remove the adapter plug because of the clearance between the axle hanger and the brake backing plate. If this occurs, disassemble the tool from the hanger, and use a chipping hammer or similar tool to finish removing the adapter plug. See Figure 7.

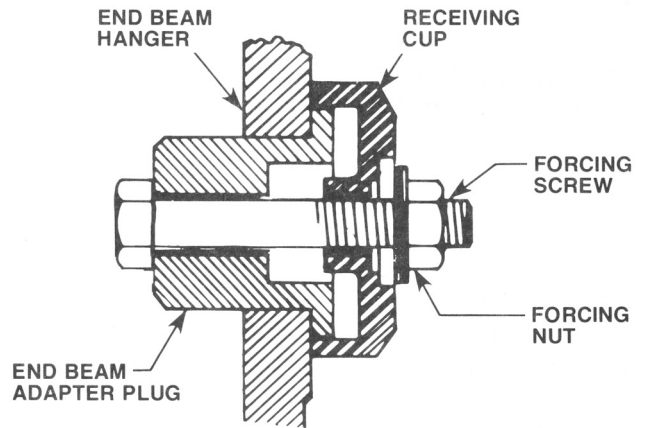


Figure 5

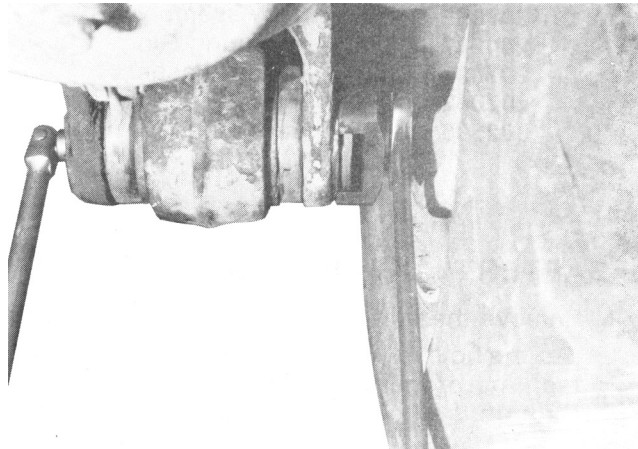


Figure 6

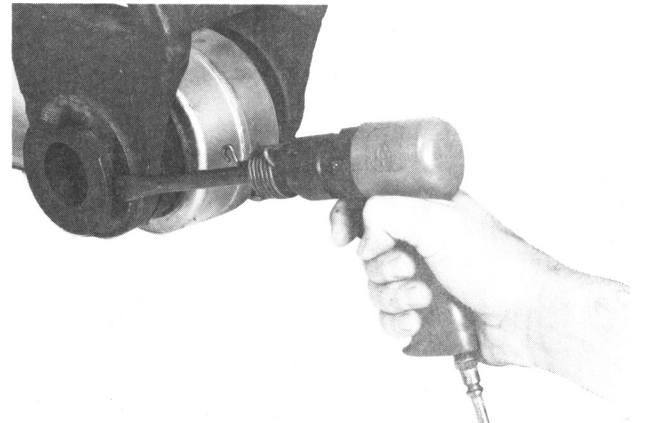


Figure 7