NO REAM INSTALLATION
USING BUSHING ASSEMBLIES FOR KING PIN STEERING KNUCKLE REPAIRS

REMOVAL
• Use established procedures for teardown.

STEERING KNUCKLE AND AXLE PREPARATION
• Clean spindle and axle eyes, wipe dry.
• Remove any burrs from spindle bores and axle eyes using brake hone or similar device.

INSTALLING BUSHING LIP SEALS
• Handle with care, lip seals are easily damaged.
• Using a bushing driver or similar device, drive the seals into the bore leaving the seal flush with the axle side of each spindle bore.
• Be sure to position the seal so the lip is pointing towards the axle eye. (see figure #1)

SPECIAL INSTRUCTIONS FOR INSTALLING SPIRAL BUSHING ASSEMBLY
• Using the STEMCO Kaiser™ bushing driver specifically designed for the kit, drive both bushings into bores.

CHECK BEFORE ASSEMBLY
• Wipe bushings clean.
• Using king pin check for fit, first insert pin into each bushing individually then insert pin into both bushings, king pin should slide through both bushings simultaneously.
• If pin fits through bushings individually but not simultaneously the spindle has spread and may need replacement.

BEARING INSTALLATION
• Prepack bearings with grease.
• For proper bearing orientation refer to figure #1.
• Place needed shims under upper spindle bore.
• Position king pin through upper spindle bore and through needed shims, be sure TOP of pin is parallel to axle for proper lock fl at alignment.
• Place spindle, shims and pin into axle, allow pin to drop into axle bore about 2”.
• Tap bearing into place, a properly fit bearing will require a slight tap fit without damaging the bearing case.
• If bearing is too tight or too loose, adjust the number of shims being used.
• When working on an application where the bearing has a shoulder, the bearing must be installed before the shims.

COMPLETE PIN INSTALLATION
• Once the bearing fit is correct, allow pin to slip into lower bushing.
• Position lock pin flats on pin so they line up with lock holes.
• Pound lock pins into place, lock pins with threads apply 25-30 ft. lbs of torque.

END PLATE OR END PLUG INSTALLATION
• Install end plates or end plugs, using the proper seal under plates.
• Install grease fitting into end plate or end plug.

GREASING
• Apply grease until it can be seen between axle and spindle.

CHECK INSTALLATION
• Once greased the spindle should turn easily from side to side.
• There should be very little up and down movement.
• If unit seems loose or too tight we recommend calling our tech line for assistance.