

GARLOCK DX BUSHING SERVICE KIT INSTRUCTIONS

APPLICATION:

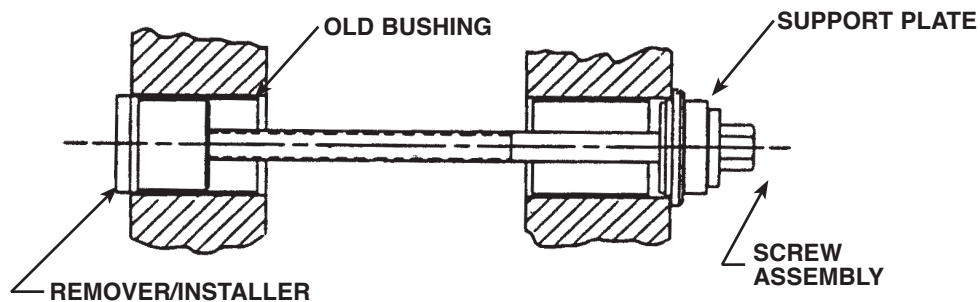
Meritor FF & FG Series (1.7950/1.7960 Bushing I.D.), FL Series (2.000/2.001 Bushing I.D.), (Dana 1.609/1.608 Bushing I.D.), Eaton 18F3 (1.875 Bushing I.D.), Eaton 12F4 Series (1.627 Bushing I.D.).

NOTE: See service kit consists of for proper details for axle model being serviced.

BUSHING REMOVAL

Assemble screw, support plate and remover as shown in Fig. 1. Tighten screw with wrench or impact wrench until bushing is removed from knuckle. Assemble tool from opposite end to

remove remaining bushing. **IMPORTANT:** Screw threads **MUST** be lubricated with high- pressure lubricant, J 23444-A or equivalent prior to being used.

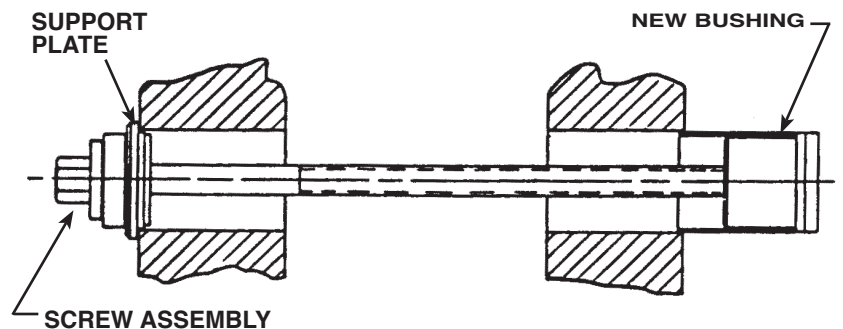


Bushing Removal

Figure 1

UPPER BUSHING INSTALLER

Assemble screw , support plate and installer with bushing as shown in Fig. 2. Bushing must be centered in bore, tighten screw until bushing is installed to manufacturer specifications.



Upper Bushing Installation

Figure 2

REAMING UPPER BUSHING

Reaming procedure **MUST** be performed in vertical position.

1. Install large pilot into lower knuckle bore.
2. Remove set screw from reamer dog, then position the dog on to shaft so the threaded hole is located over the notch closest to the square drive, reinstall set screw and tighten.
3. Assemble reamer onto shaft and engage dog tangs into notches on reamer.
4. Install assembly as shown in Fig. 3. Do not allow reamer to drop into I.D. of bushing.
5. Using tee handle wrench, turn the reamer in a clockwise direction **ONLY** when reaming or withdrawing the reamer.

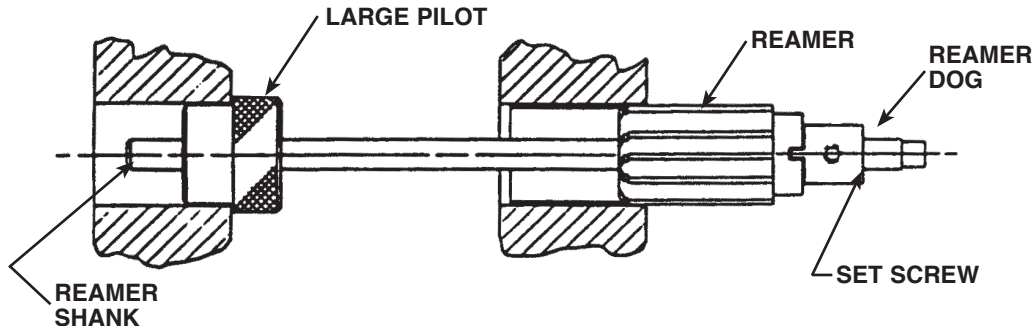
For best results, use light pressure on the reamer.

NOTE: Do not at any time turn the reamer counterclockwise as this will dull the cutting edges of the reamer.

When completing reaming use leather glove to support reamer when it passes thru bushing from bottom side.

INSTALLING LOWER BUSHING

Same as Upper Bushing, except the opposite side.



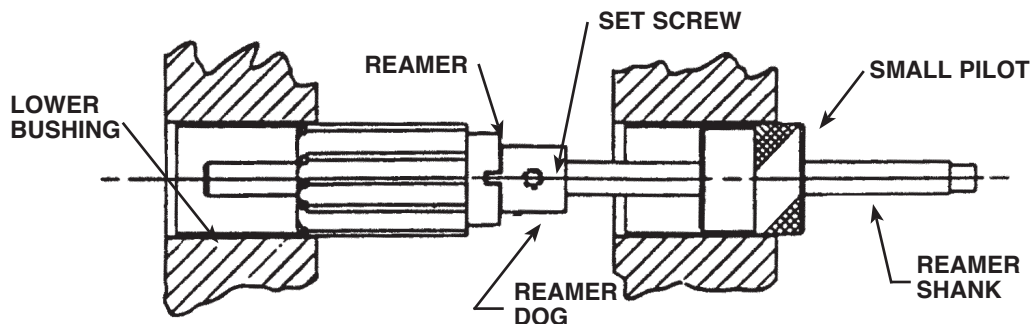
Reaming Upper Bushing

Figure 3

REAMING LOWER BUSHING

1. Install small pilot into upper reamed bushing. See Fig. 4.
2. Secure reamer dog with set screw to reamer shank, lowest notch on reamer shank. See Fig. 4.
3. Follow step 3 thru 5 from Reaming Upper Bushing to Ream Lower Bushing. Follow manufacturer procedure for final inspection.

NOTE: Should material remain partly attached to grease pocket walls finish clean with a brass brush.



Reaming Bottom Bushing

Figure 4

PT 4375-A Basic Kit

PT 4360-1	Reamer Shank	J-23444-A	Extreme Assembly
PT 4360-2	Driving Dog	PT 4360-9E	Instructions
PT 4370-45	Support Plate	PT 4360-11	Box Assembly
PT 4365-4A	Screw Assembly		

***PT 4370-10 Arvin Meritor 1.7935 FF, FG**

PT 4360-3	Small Pilot	PT 4360-5	Reamer
PT 4360-4	Large Pilot	PT 4365-1	Remover/Installer

***PT 4370-20 Arvin Meritor 1.9985 FL**

PT 4360-6	Small Pilot	PT 4360-8	Reamer
PT 4360-7	Large Pilot	PT 4365-2	Remover/Installer

PT 4360-30A 1.609 Senior Axle Service Kit

PT 4370-31	Small Pilot	PT 4370-33A	Reamer
PT 4370-32A	Large Pilot	PT 4370-34A	Remover/Installer

PT 4370-40 I-120 Service Kit (1989 Navistar)

PT 4370-42	Reamer	PT 4370-44	Pilot Guide
PT 4370-43	Large Pilot	PT 4370-46	Remover/Installer

PT 4370-50 I-160 Service Kit (1989 Navistar)

PT 4370-51	Reamer	PT 4370-53	Pilot Guide
PT 4370-52	Large Pilot	PT 4370-54	Remover/Installer

PT 4370-60A 1.359 Junior Axle Service Kit

PT 4370-61	Small Pilot	PT 4370-63A	Reamer
PT 4370-62A	Large Pilot	PT 4370-64A	Remover/Installer

PT 4370-70A 1.611 Senior Oversize (.002" O.S. King Pin)

Reamer Only

PT 4370-80A 1.361 Junior Oversize (.002" O.S. King Pin)

Reamer Only

PT 4370-90 1.625 Eaton 12F4

PT 4370-91	Reamer	PT 4370-93	Small Reamer Pilot
PT 4370-92	Large Reamer Pilot	PT 4370-94	Remover/Installer

PT 4370-95 1.873 Eaton 18F3

PT 4370-96	Reamer	PT 4370-98	Small Reamer Pilot
PT 4370-97	Large Reamer Pilot	PT 4370-99	Remover/Installer

PT 4370-110 Arvin Meritor 1.236 MFS6

PT 4370-112	Small Pilot	PT 4370-114	Reamer
PT 4370-113	Large Pilot	PT 4370-111	Remover/Installer
PT4370-115	Support Plate		

PT 4370-120 Arvin Meritor 1.501 MFS7 & 8, FC-941

PT 4370-122	Small Pilot	PT 4370-124	Reamer
PT 4370-123	Large Pilot	PT 4370-121	Remover/Installer

*Basic kit is for all sizes, used with proper axles size service kit.

For additional information see reverse.

For individual axle application, look across the top of the chart for the particular axle you wish to service. Then look down that column and order each of the items that are checked to give you a complete tool kit to service that axle. If ordering to service more than one axle, be sure not to duplicate PT 4375-A Basic Kit; only one is required.

AXLE MODEL NUMBER	ARVIN MERITOR				NAVISTAR				DANA				EATON								
	MFS 10, 12, 13, 14	MFS 16, 18, 20	MFS 7 & MFS 8	MFS 6	1989 Model Year	1989 Model Year	1989 Model Year	1989 Model Year	1989 Model Year	1989 Model Year	1989 Model Year	1989 Model Year	1989 Model Year	1989 Model Year	1989 Model Year						
KING PIN SIZE (INCHES)	1.7935	1.9985	1.501	1.236	1.921	2.046	1.359	1.361	1.609	1.611	1.7935	1.985	1.359	1.361	1.609	1.611	1.921	2.046	1.625	1.873	
PT 4375-A BASIC KIT	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
PT 4370-10 SERVICE KIT	X																				
PT 4370-20 SERVICE KIT		X																			
PT 4370-30A SERVICE KIT																					
PT 4370-40 SERVICE KIT																					
PT 4370-50 SERVICE KIT																					
PT 4370-60A SERVICE KIT																					
PT 4370-90 SERVICE KIT																					
PT 4370-95 SERVICE KIT																					
PT 4370-70A REAMER FOR .002" O.S. KING PIN																					
PT 4370-80A REAMER FOR .002" O.S. KING PIN																					
PT 4370-110 SERVICE KIT																					
PT 4370-120 SERVICE KIT																					

NOTE: * Used with PT 4370-30 Components; PT 4370-31 Small Pilot, PT 4370-32 Large Pilot, PT 4370-34 Remover/Installer
 NOTE: ** Used with PT 4370-60 Components; PT 4370-61 Small Pilot, PT 4370-62 Large Pilot, PT 4370-64 Remover/Installer