

TufTrac M12 Bolts

TSB-32-020-WST

Creation Date: 2025-10-17

Engine or Vehicle Affected:

- ▶ 47X
- ▶ 49X
- ▶ 57X
- ▶ 4700
- ▶ 4900
- ▶ 5700
- ▶ 6900

This is an informational bulletin only. The described condition is a product improvement and is not warrantable.

Described Condition

The 1/2-inch center bolts and weld nuts provided on TrufTrac® suspension systems are being replaced with M12 center bolts and weld nuts when the center bearing is replaced. This service bulletin provides instructions on how to replace TufTrac suspension 1/2-inch center bolts and weld nuts with M12 center bolts and weld nuts.

Parts List

Table [1](#) and Table [2](#) lists the parts for TufTrac center bolt and weld nut replacement.

Table 1, TufTrac Center Bearing Replacement Parts List

Old Part Number	Description	New Part Number	Description	Quantity
16-20219-000	BRNG-CTR, LOW PRO, TUFTRAC,.5 INCH	16-21992-00	BRNG-CTR,LOW PRO,TUFTRAC,M12	1
23-14567-100	SCREW-CAP 1/2-13X1.00	23-14611-025	BOLT-HEXFLGH,10.9,PCHLK,M12X25	2
—	—	49-00312-426	TRQ-BOLT, 85NM, 63FTLB	—

Table 1, TufTrac Center Bearing Replacement Parts List

Table 2, TufTrac Center Bearing LOW PRO Replacement Parts List

Old Part Number	Description	New Part Number	Description	Quantity
16-20218-000	BRNG-CTR,LOW PRO,TUFTRAC,.5 INCH	16-20218-001	BRNG-CTR,LOW PRO,TUFTRAC,M12	1
23-14567-100	SCREW-CAP 1/2-13X1.00	23-14611-025	BOLT-HEXFLGH,10.9,PCHLK,M12X25	2

Old Part Number	Description	New Part Number	Description	Quantity
—	—	49-00312-426	TRQ-BOLT, 85NM, 63FTLB	—

Table 2, TufTrac Center Bearing LOW PRO Replacement Parts List

Installation of the TufTrac Center Bearing

- Park the vehicle on a level surface, shut down the engine, and set the parking brake. Chock the tires.

- Remove the rebound stop from the suspension. See Fig. 1.

- Remove the nut and bolt that secure the rebound stop to the mounting bracket.

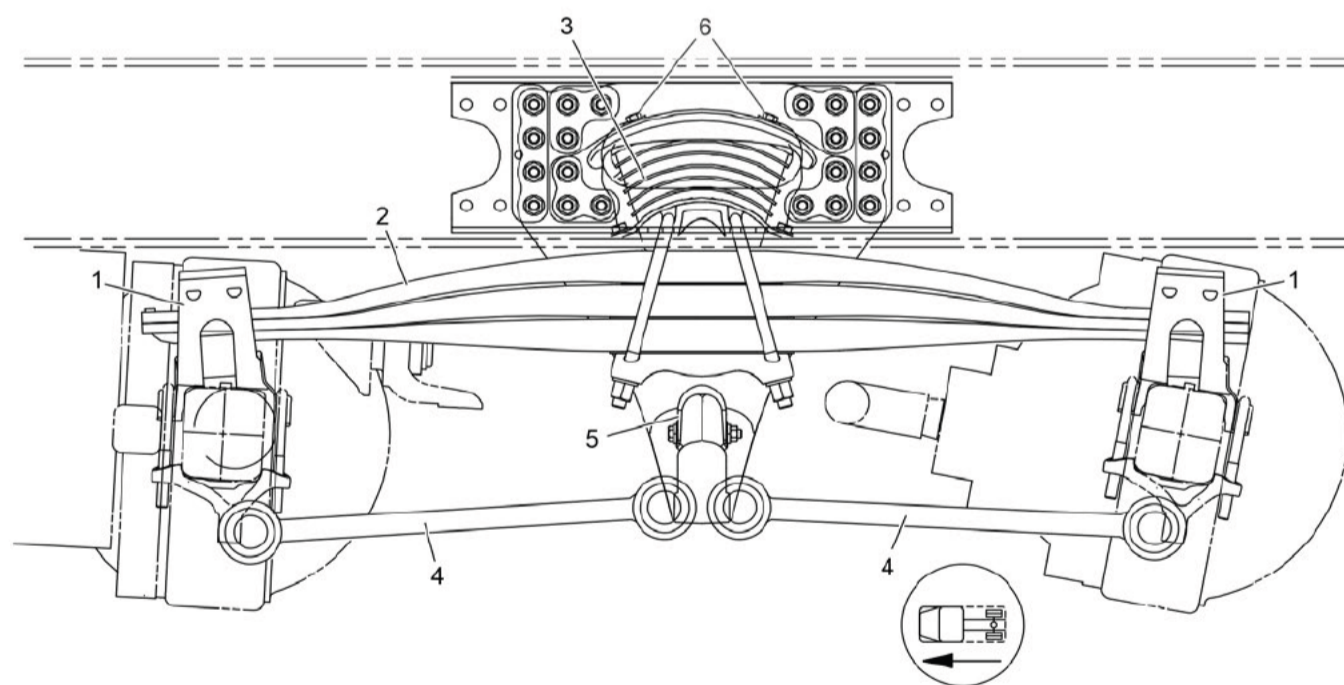
- Slide the rebound stop from the mounting bracket.

- Remove the two upper fasteners from the center bearing.

- Place a jack under the rear axle and raise the vehicle.

⚠ Warning: Do not place jack stands under any of the suspension components. Jack stands can be placed at any point below the axle, including the differential area. Always use floor jacks. Bottle jacks can slip, allowing the vehicle to fall, which could result in damage to the axle, serious injury or death.

- Support the rear frame rails with jack stands, then lower the jack. This clears the center bearing from the top of the mounting bracket. See Fig. 2.



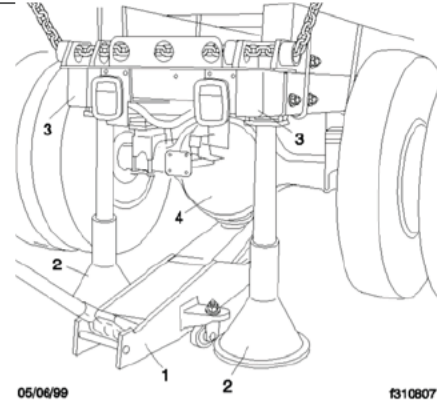
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1. Axle Clamps
2. Leaf Springs
3. Center Bearing

4. Lower Control Rods
5. Rebound Stop
6. Fasteners

Fig. 1, TufTrac Suspension (46,000-pound [20 865-kilogram] version shown)



- 1. Jack
- 2. Jack Stand
- 3. Frame Rail
- 4. Rear Axle

Fig. 2, Jack and Jack Stand Placement

6. Remove the lower center bearing bolts attached to the spring assembly casting. Discard the bolts.

7. Remove the center bearing. See Fig. 3.

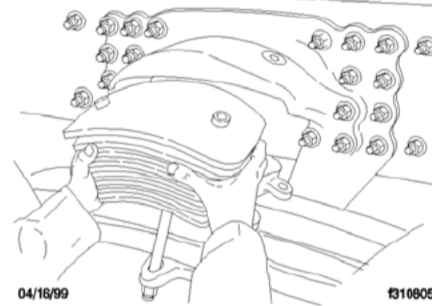


Fig. 3, Center Bearing Removal

8. Position the new center bearing in the mounting bracket.

9. Install the upper mounting M12 bolts (23-14611-025) and tighten 63 lbf·ft (85 N·m).

10. Use the jack to raise the rear axle until the bottom of the center bearing meets the mounting bracket on the leaf springs.

ⓘ Important: Be sure to use new bolts with Loctite® (23-12576-125) when attaching the center bearing to the leaf spring casting.

11. Install the new lower mounting bracket bolts (23-12576-125). Tighten the bolts 155 lbf·ft (210 N·m).

12. Return the vehicle to its normal operating position.

13. Install the rebound stop and tighten 63 lbf·ft (85 N·m).

Warranty

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Note:

- W12
- W14
- W17
- W16
- W15
- W01
- W02

W04

W05

W06

W07

W10

W11

INSTALL

REMOVE

016-005-158

053-007-006

053-007-005

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