

**New Bushings for Tighter Fitting
Cleanout Doors on
Side Loader Refuse Vehicles
Installation Instructions**

Date: June 30, 2026
Bulletin Name: MISC-IB-085-A
Model: Zero Radius 48
AutoReach 49
M/MA 42, 44
Volterra® ZSL® 50

Purpose:

McNeilus Truck and Manufacturing provides these instructions for the installation of new bushings for the service cleanout door for all Side Loader refuse vehicles. The new bushings can help provide a tighter seal on the door.

Revision A includes additional checks for leaking after the installation of the new bushings.

Notice:

- This bulletin should be read and understood in its entirety before performing this procedure.
- All procedures outlined in these instructions must be performed by skilled service personnel.
- Parts can be purchased from your McNeilus Dealer network. Customer will supply own labor, tools and equipment.
- Confirm all parts are present before starting installation.

SAFETY NOTICE

Perform your company's Lockout/Tagout procedure. If your company does not have a Lockout/Tagout procedure, follow OSHA 1910.147 and 1910.146 Confined Space as appropriate.

SAFETY NOTICE

Use appropriate Personal Protective Equipment (PPE) as required by your company.

Parts, Tools, and Equipment Required:

Customer to supply:

- 3/4" wrench and/or socket
- 1/2" wrench and/or socket
- Machinist's marker or permanent marker
- Cutoff grinding wheel/grinder
- Deburring tool
- Steel hammer
- Scrap wood block
- Truck body matching touch-up paint
- Clean rags

Recommended tools:

- Loctite® 648 or 680 (follow package instructions for application)
- 1/2"-13 tap
- Full set of wrenches
- Flat edge ruler

Kit Part Number: 1698852

One kit updates two cleanout doors

Item	PN	Qty.	Description
1	1700023	4	BUSHING, HINGE, OFFSET

Before you start

1. Place the unit on a flat surface. Properly chock wheels and engage the service brake. Perform your company's Lockout/Tagout procedure. If your company does not have a Lockout/Tagout procedure, follow OSHA 1910.147 and 1910.146 Confined Space as appropriate.
2. Unlatch and lower the cleanout door on one side of the vehicle (Figure 1).

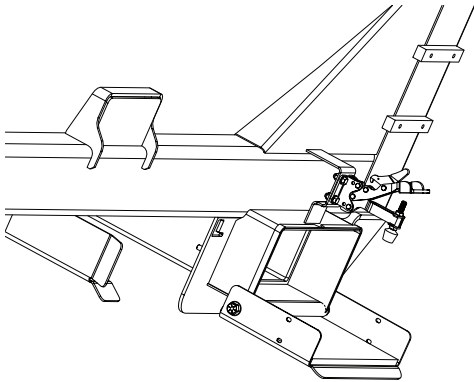


Figure 1

3. Check for gaps around the cleanout doors.

3.a Hold a flat edge ruler against each outside edge of the cleanout door chute to check for gaps (Figure 2, Item 1 and Item 2 shows a closer view).

TIP: It could be helpful to place a flashlight on the inside of the cleanout to identify potential leak paths.

3.b If gaps are more than 0.090", use a grinder to work the gap until it becomes less than 0.06" or 1/16 of an inch.

3.c Clean the surfaces of dust and debris using a clean rag.

3.d Apply touch-up paint to all areas affected by grinding and allow to fully air dry before continuing with this procedure.

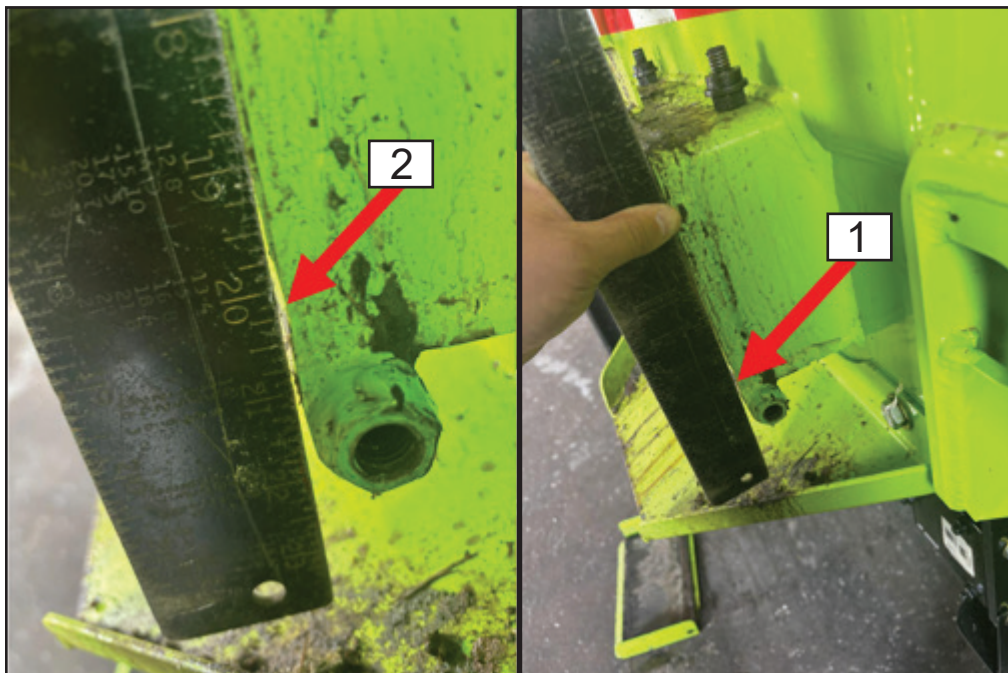


Figure 2

4. Repeat Step 3 to the cleanout door on the opposite side of the vehicle.

Procedure to remove existing parts, cut location, and install new parts

5. Remove and retain the existing hardware, spacers, and door from the cleanout chute using a 3/4" wrench (Figure 3).

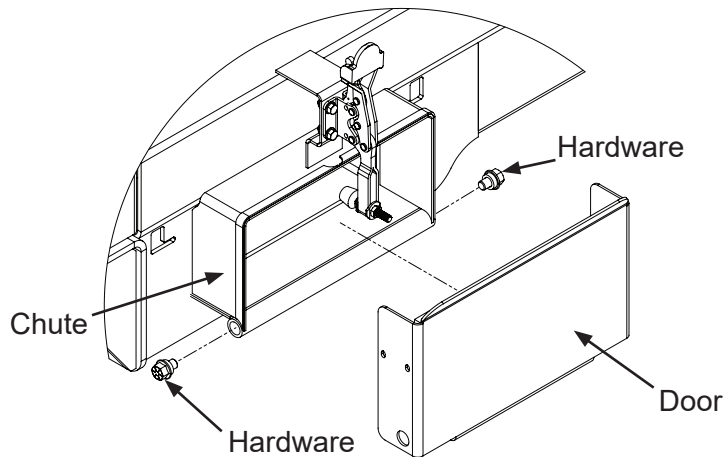


Figure 3

- **IMPORTANT:** If the vehicle is a Volterra® ZSL® side loader, then the drip tray must also be removed (Figure 4). Retain the drip tray and hardware for reinstallation during a later step.

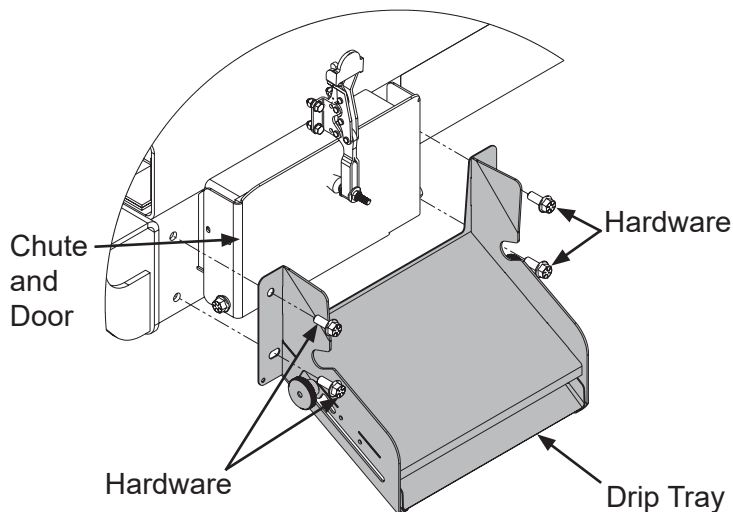


Figure 4

6. Using a permanent marker or machinist's marker, mark cutting lines on both chute side tubes to cut flush with the bottom plate of the chute. These tubes are where the door hardware secures the door to the chute. Figure 5 shows one side chute tube with cutting line; the other side chute tube is not as visible for clarity.
7. Confirm the tube length after cutting will be 14". If it will not be 14" in length, readjust the cut lines to ensure the tube length after cutting will be 14"

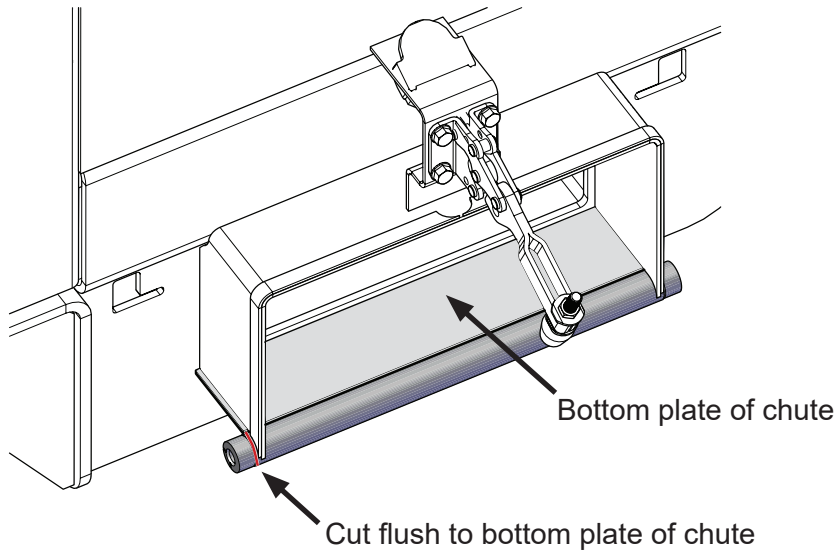


Figure 5

8. Use a grinding wheel to cut both tubes where marked.
9. Use the deburring tool to deburr inside both tubes.
10. Clean the tubes and surfaces of dust and debris using a clean rag.
11. If desired, apply Loctite® 648 or 680 (following package instructions) to each bushing before installing. Or, as an alternative, the bushings may be welded instead of using Loctite®.
12. Place one bushing against each tube opening, orienting the bushing so one machined mark faces down to the ground and the other faces toward the vehicle body (Figure 6).

Bushing orientation

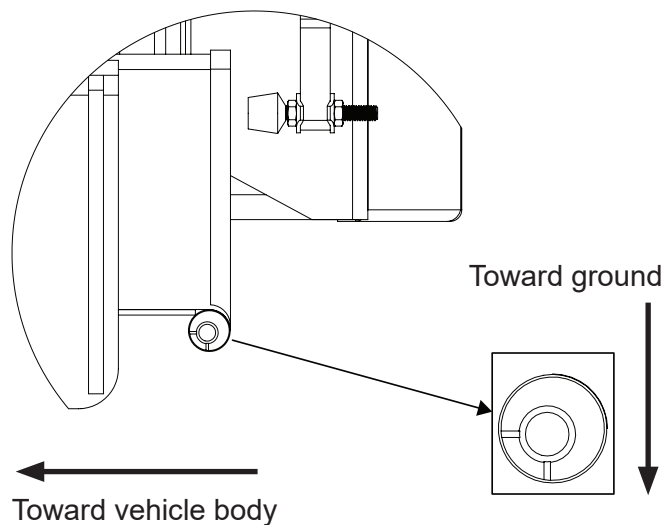


Figure 6

13. Gently tap in the bushing with the hammer until it stays in place in the tube opening. Repeat with the second bushing and other tube opening.
14. Place the wood block against the bushing and use the hammer against the wood to pound the bushing until it fully seats in the tube opening. Repeat this process with the second bushing and other tube opening.
15. Remove any debris and apply touch-up paint to both bushings to prevent rust. Wait for the paint to completely air dry.

16. Locate and line up the existing door between the new bushings.
17. Reinstall the existing spacers and bolts using the 3/4" wrench.
18. Use a torque wrench to torque to 85 ft.-lbs.

NOTE: Do not use power impact drivers because they could cause the bushings to spin.

- If the vehicle is a Volterra® ZSL® side loader, reinstall the drip tray and its hardware (Figure 7). Securely tighten all hardware.

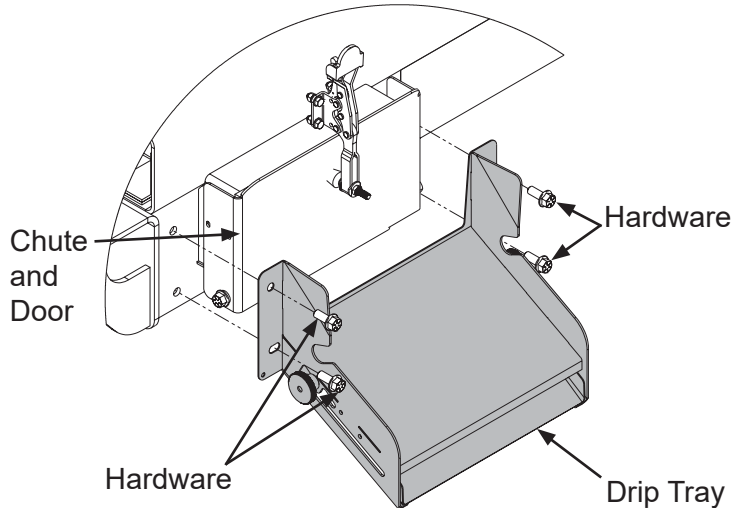


Figure 7

19. Repeat Steps 2 through 18 using the remaining two bushings to the other service cleanout door on the other side of the vehicle.

Leak Check Procedure

20. To both cleanout doors, conduct a leak test following these procedures to ensure the cleanout doors have a tight seal.
 - 20a. Close the cleanout doors.
 - 20b. Fill the cleanouts with water to the top of the troughs.
 - 20c. Drive one or two laps around a parking lot. Driving is critical because the movement of the water helps expose leaks that may not be visible when stationary.
 - 20d. Inspect the cleanout doors and chutes for evidence of leaking.
21. If leaks are detected, repeat the gap audit procedure (Step 3) and check the rubber seal for damage or cracking and replace as needed.
22. Adjust the cleanout door latch and clamping force using two 1/2" wrenches (Figure 8). The more clamping force, the tighter the door seals with these new bushings. The clamp should have a tight fit against the door.
23. Maneuver the cleanout doors open and close a few times to ensure each door rotates and the sealing is correct.

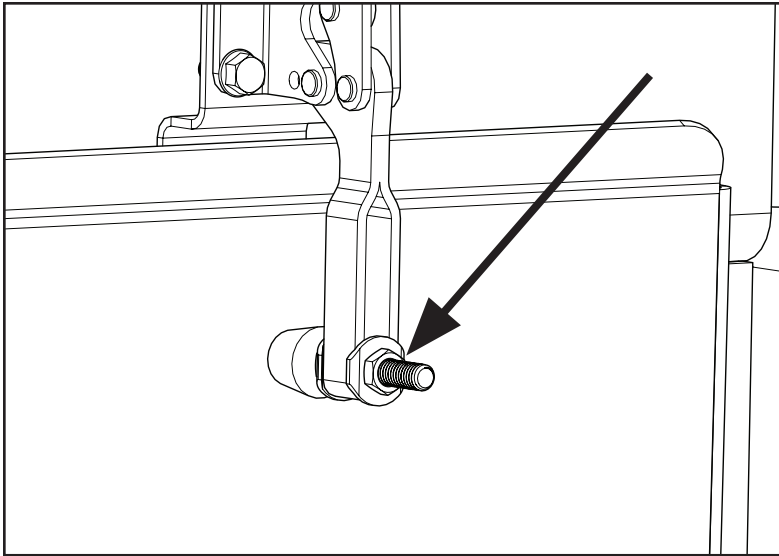


Figure 8

24. When all steps have been completed to both cleanout doors, the installation is complete and the vehicle can be returned to service.