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XXXX[.XX] = #.010[.25]
XXXX[.XXX] = BASIC

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ANGLES = 110

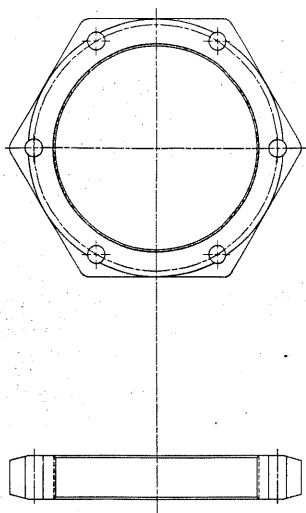
MUST BE FREE OF BURRS AND SHARP EDGES

AXLES

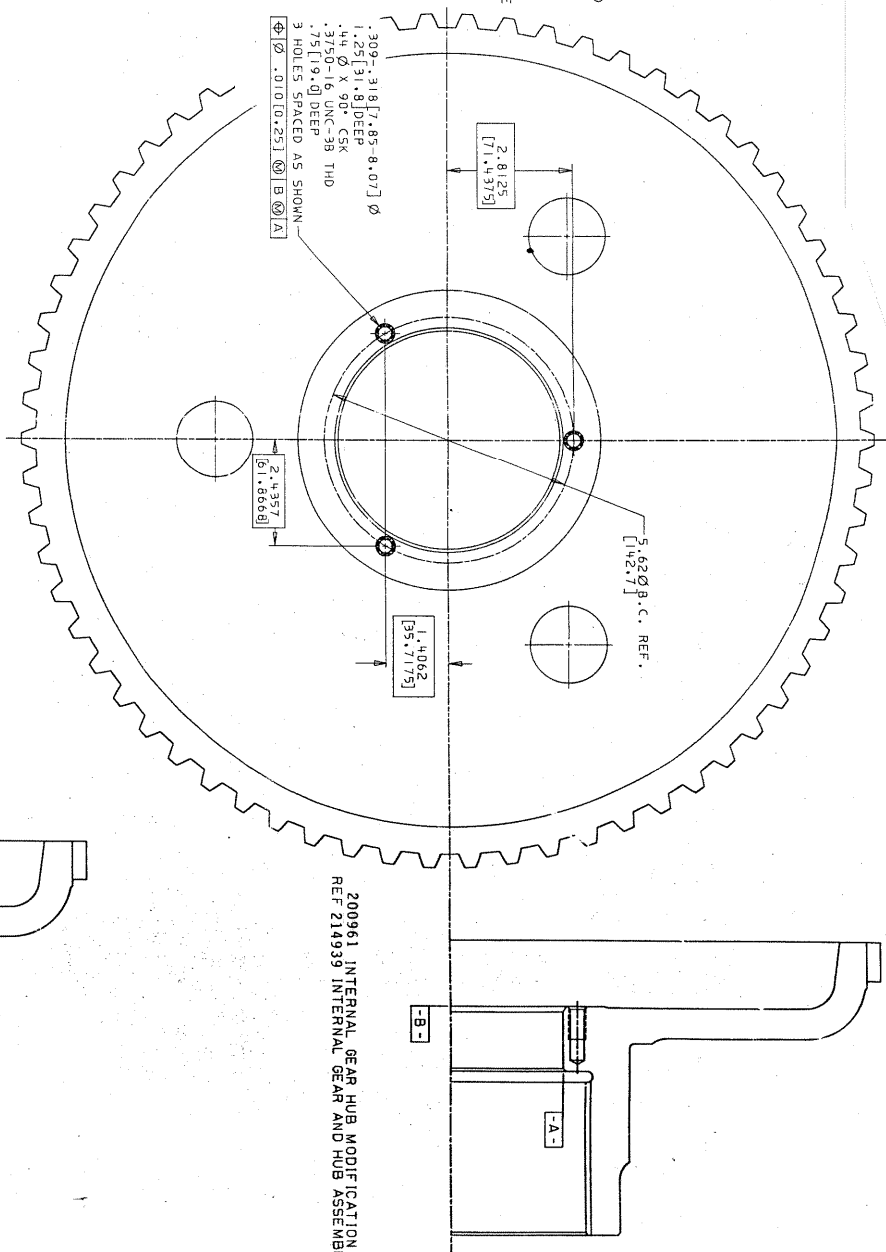
1. BEFORE WHEEL BEARING ADJUSTMENT IS MADE, IT IS IMPERATIVE ALL TAFFERED BEARING CONES AND CUPS BE PRESTRESSED TO FULLY SEATED POSITION DO NOT DEPEND ON THE WHEEL BEARING ADJUSTING NUT TO "SHOULDER" TAFFERED BEARINGS CUPS AND CONES.

2. COAT WASHER FACE OF NUT AND SPINDLE THREADS WITH BRUSH-APPLIED MS-260 LUBRICANT. (ANTI-SEIZE OR NEVER-SEIZ)

3. INSTALL TIGHT AND TIGHTEN TO 1000 LBF-FT [1355 N·M] TORQUE. SHOCK INTERNAL GEAR HUB WITH HEAVY BAR OR Mallet. ROTATE WHEEL HUB 2 TO 3 TIMES. REPEAT SHOCKING AND ROTATING. REPEAT CAUTION 2. IF WHEEL HUB DOES NOT ROTATE FREELY, STOP. REPEAT SHOCKING AND ROTATING AS ABOVE. CONTINUE UNTIL 1000 LBF-FT [1356 N·M] DOES NOT ADVANCE NUT.
4. LOOSEN NUT 1/4 TO 1/2 TURN. SHOCK TO LOOSEN AND MEASURE THE NO-LOAD ROLLING TORQUE (NORMALLY 25-100 LBF-FT [34-135 N·M]).
5. TORQUE TO 700 LBF-FT [949 N·M] THEN ADVANCE NUT UNTIL 3 HOLES IN NUT LINE UP WITH TAPPED HOLES IN INTERNAL GEAR HUB.
6. CHECK ROLLING TORQUE-MUST BE IN THE RANGE OF 5-13 LBF-FT [7-20 N·M] USED BEARINGS 20-80 LBF-FT [27-108 N·M] NEW BEARINGS. (17-20 N·M)
7. IF OVER THE MAXIMUM ROLLING TORQUE, REDUCE NUT TORQUE AS REQUIRED TO OBTAIN THE 5-15/20-80 LBF-FT [7-20/27-108 N·M] RANGE. BUT NOT LESS THAN 400 LBF-FT [542 N·M] ON NUT IF THIS OCCURS. REPEAT STEPS 4 THROUGH 6 UNTIL THE INTERNAL GEAR HUB 3-4 SLIGHTLY FEELS TO BE ROLLING NUT AND REASSEMBLE REPEAT BEARING PRELOAD PROCEDURE.
8. IF UNDER THE MINIMUM ROLLING TORQUE, INCREASE NUT TORQUE UNTIL THE PRELOAD RANGE WITH 3-10/20-80 LBF-FT [40-108/135 N·M] ROLLING RANGE WITH 3 HOLES ALIGNED, BUT NOT MORE THAN 1400 LBS-FT [1898 N·M].
9. LOCITE THE CAPSCREW THREADS WITH LOCITE NO. 262 AND INSTALL AT 35-40 LBF-FT [48-54 N·M]. TIGHTENING TORQUE



230705 NUT-BEARING ADJUSTING



200961 INTERNAL GEAR HUB MODIFICATION
REF 214939 INTERNAL GEAR AND HUB ASSEMBLY

17C-624H 3 PLACES PER WHEEL END
C.375-16 UNC-2B THD 1.50[38.1]L

230705
NUT-BEARING
ADJUSTING

MODIFIED 214939 INTERNAL
GEAR AND HUB
ASSEMBLY

SPINDLE

[illegible]