

Bolt Tightening Sequence

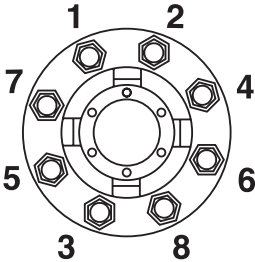


Figure 1

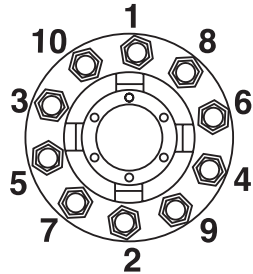


Figure 2

WARNING:

Always tighten the top nut first to fully seat the brake drum on the drum pilot and against the hub face. See the adjacent diagram for bolt tightening sequence, and tighten in order from 1 through 8 or 10, depending on the bolt pattern (see Figures 1 & 2).

Wheel Mounting System

Hub Pilot Wheel Mounting

The hub Pilot wheel mounting system makes use of a single two-piece flange nut on each wheel stud for both single and dual wheel applications (see figure 3). The hub pilot wheel mounting system is also known as the Uni-Mount-10™ (10 stud), WHD-10™ (10 stud), WHD-8™ (8 stud), and ISO system.

Ball Seat Wheel Mounting System

The ball seat wheel mounting system makes use of the spherical contact area between the nut and wheel to both locate the wheel and hold the wheel tight against the brake drum (see figure 4). The ball seat wheel mounting system is also known as the stud piloted, ball seat cap nut (BCN) and double cap nut (DCN) system.

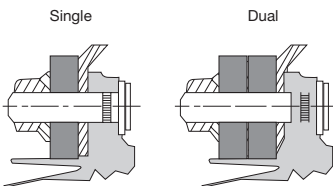


Figure 3

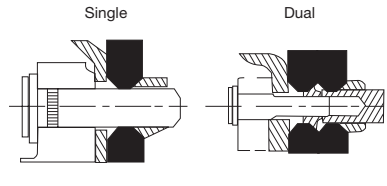


Figure 4

Wheel End Torque Specifications

Item	Measurement	Torque (ft-lbs)	Notes
Ball Seat	3/4-16	450-500	Always tighten the top nut first. If lubricant is used, apply sparingly on threads only. Do not lubricate the faces of the hub, drum, wheel or on the ball seats of the wheel nuts.
Wheel Nut	1 1/8- 16		
Hub Pilot	22 mm x 1.5 mm	450-500	Always tighten the top nut first. Apply two drops of oil between the nut and nut flange, and two or three drops to the outermost 2 or 3 thread of the wheel studs. Lightly lubricate the wheel pilots on the hub.
Wheel Nut			
Drive Studs, Installation Torque	3/4-16	40-90	
	5/8-18		
	1/2-20		
Hub Cap	5/16-18	12-18	Minimum SAE Grade 5 fasteners, flat washers only.
Oil Fill Plug	1/4 NPT	20-25	O- Ring Style
	3/8 NPT		
	9/16-18		
Disk Brake Rotor			See Brake Manufacturer
Drive Axle Flange Nuts			See axle manufacturer's recommendations for proper drive axle nut torque.
ConMet PreSet 2-Piece Nut		300 Inner 200 outer	NO BACK OFF
ConMet PreSet 1-Piece Nut		250	NO BACK OFF