

NUT TIGHTENING PROCEDURE

A key to the Hub Piloted wheel, hub and drum mounting system is proper installation of the Cone Lock Nuts. IT IS IMPORTANT to follow the recommended installation instructions, paying particular attention to the order of nut tightening.

1. Before installing wheels, be sure that the drum is positioned on the raised step to the hub's drum pilot pad. One of the hub's wheel pilot pads should be at the top location, on the 8-hole system nuts 1 and 2 will be on the sides of the pilot pad and with the 10-hole system be sure the pilot pad is lined up with a nut at the twelve o'clock position. Adjustment of the brakes prior to installation of the wheels helps keep the drum in proper position.
2. Lubricate the Cone Lock Nuts and stud threads. Apply two drops of any common lubricant on the threads, and also in the crevice between the Cone Lock Nut Body and its attached flange. (See Tech Data #TD3 "Lubrication of Hub Piloted System Fasteners")
3. After positioning wheels on pilots pads, hand start Cone Lock Nuts (CLN). ALL nuts and studs have RIGHT HAND metric threads.
4. Using wrench with correct 33mm or 1.5" hex socket, snug up the nuts in the order shown to about 50-100 ft.-lb. of torque. Starting with nuts 1 and 2 on the 8-hole system and nut 1 on the 10 hole system will help insure that the drum and wheels will seat properly.
5. Check to be certain that the mating surface of the wheel(s) and drum are flush and seated fully against the hub face.
6. Again, starting with the top nut/nuts, tighten to 450-500 ft.-lbs. using the pattern shown for the particular system.
7. Inspect the finished installation for complete seating of the wheels and drum. Rotate the wheel to look for anything out of correct position.

