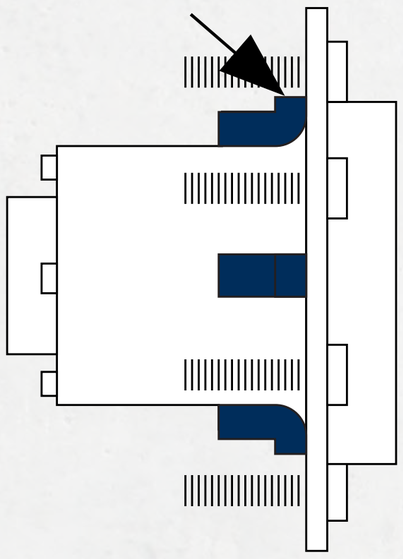
STEMCO®

BRAKE PRODUCTS

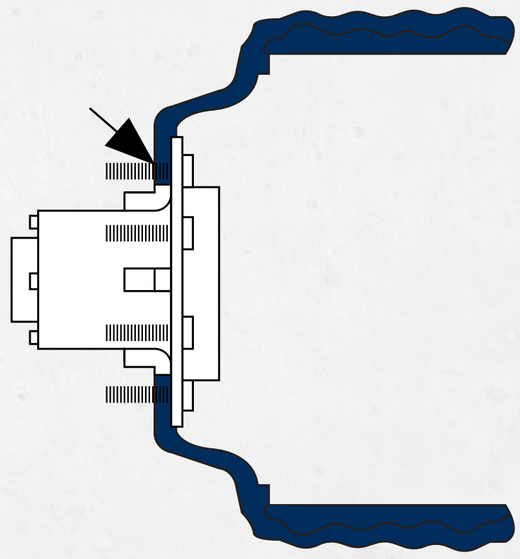
BRAKE DRUM INSTALLATION PROCEDURES

FOR HUB PILOTED 8 AND 10 HOLE WHEEL END SYSTEMS



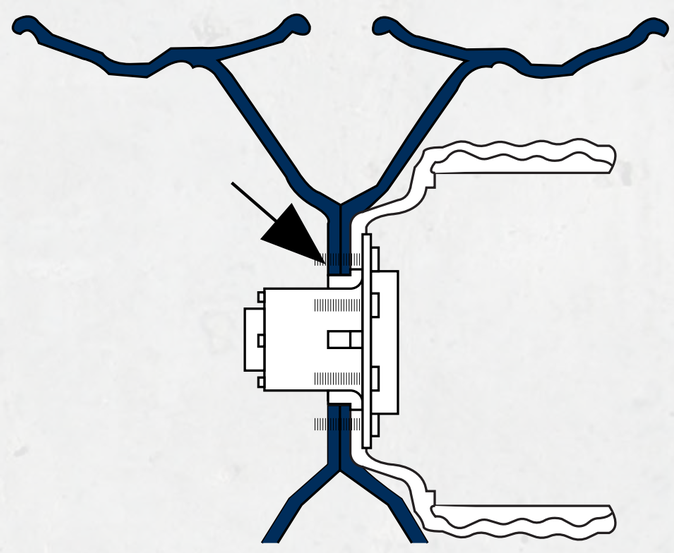
STEP 1

Locate one hub pilot pad at twelve o'clock position.



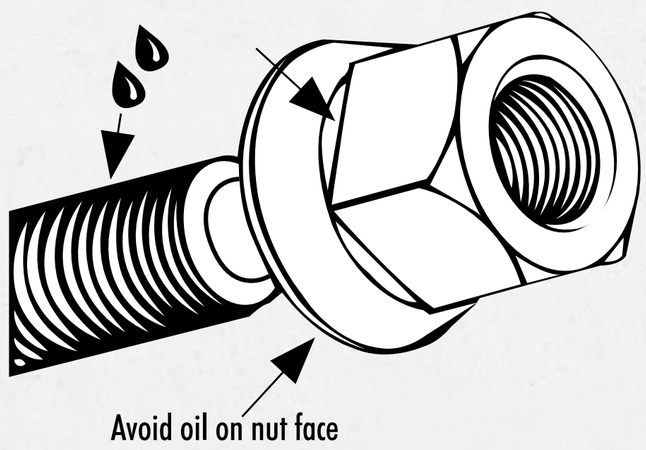
STEP 2

Before mounting wheels, be sure drum is properly positioned on raised step of pilot pad.



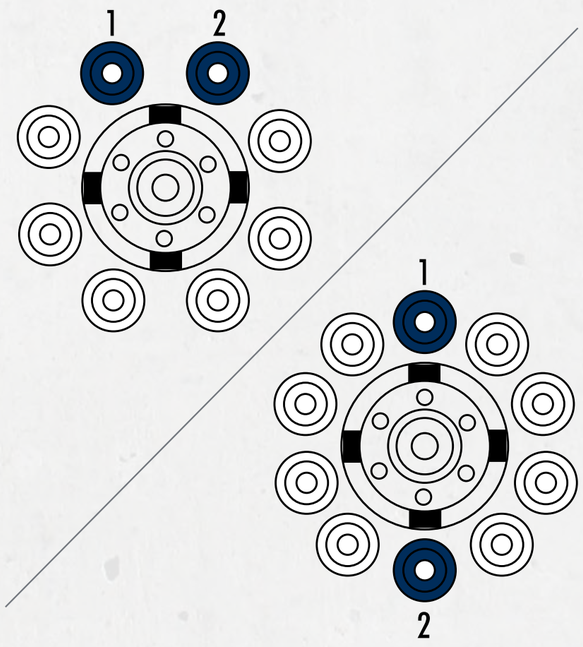
STEP 3

With wheels square to hub, mount inner and outer wheels as far back on the pilot pad as possible. Be sure both tire valve stems are accessible.



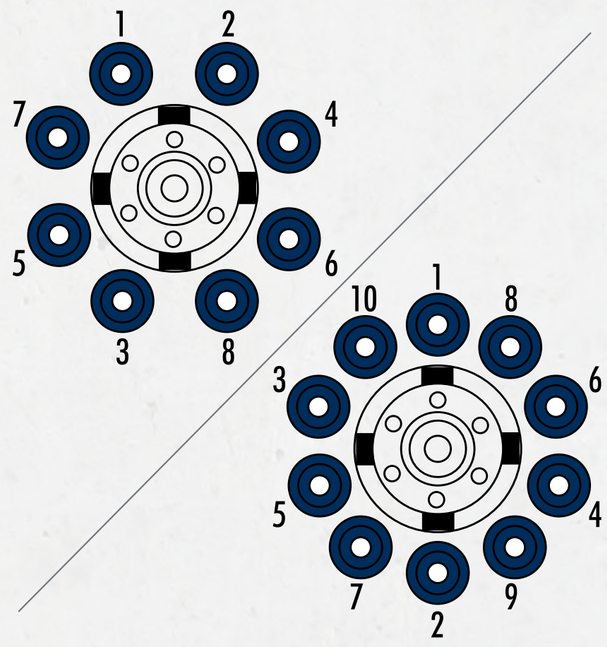
STEP 4

Apply two drops of oil on leading threads of studs and between nut body and flange. Avoid getting oil on face of nut, wheels, or brake drum.



STEP 5

Finger tighten nuts on top two positions on an 8 hole wheel; top and bottom positions on a 10 hole wheel. Apply remaining nuts finger-tight. Then snug all nuts to 50 ft.-lbs. following the sequence shown in step 6.



STEP 6

Complete procedure by tightening all the nuts in the sequence shown to the recommended 450–500 ft.-lb. After installation, rotate wheels to be sure that the drum remains fully seated against the hub face.

IMPORTANT:

Axle end parts "seat in" during normal vehicle operation. Therefore, it is recommended to repeat torquing procedure after 5–100 miles of operation, and after each tire change, or whenever nuts are removed. Torque to 450–500 ft.-lbs. Check torque output of impact wrenches frequently. Torque wrenches should be calibrated periodically. Record calibration rates.

STEMCO®

A Higher Standard of Performance.℠