



## WHEEL ASSEMBLY PROCEDURE

This vehicle is equipped with hub-piloted disc wheels, flange nuts and M22 x 1.5 studs.

1. **Clean** all mating surfaces on hub, drum, wheels and nuts.
2. **Rotate** hub so a pilot boss is at the top (12 o'clock) position.
3. **Mount** brake drum on hub so it seats on drum pilot and against hub face.
4. **Mount** wheel(s) on hub. Wheel nuts can be started in order to hold wheel and drum into position.

5. **Snug** top (12 o'clock) and bottom (6 o'clock) wheel nuts and apply 50 ft. lbs. (68 N•m) of torque to draw wheel and brake drum fully against the hub.
6. **Inspect** to ensure proper assembly with wheel and brake drum positioned on pilot bosses before installing remaining wheel nuts.
7. Using sequence shown, **tighten** all wheel nuts to 50 ft. lbs. (68 N•m) of torque.
8. Repeating sequence shown, **retighten** all wheel nuts to a **final torque of 475 ±25 ft. lbs. (680 ±30 N•m)**.
9. **Check** seating of wheel and brake drum at the pilot bosses. Rotate wheel and check for any rotational irregularity.

### **WARNING**

Read and follow the outlined instructions when installing or servicing the hub, improper installation could result in property damage, injury, or death.

### **CAUTION**

Re-torque all wheel nuts after 50 to 100 miles of service on the initial "in-service" following any installation of wheels to hub assembly.