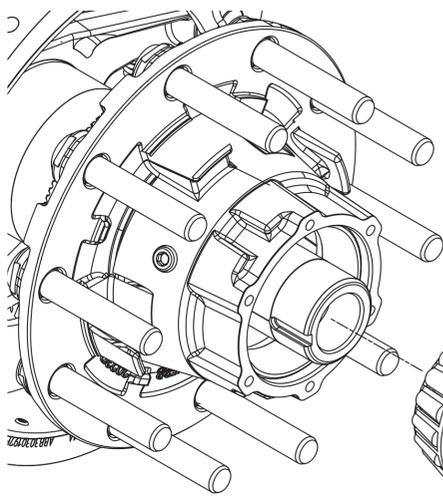


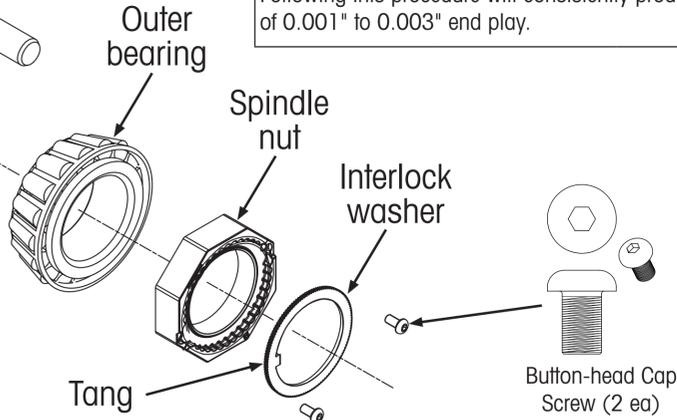
PRECISION240™, PRECISION320™ NUT SYSTEM Installation Procedures

T71005

March 2016 Revision C

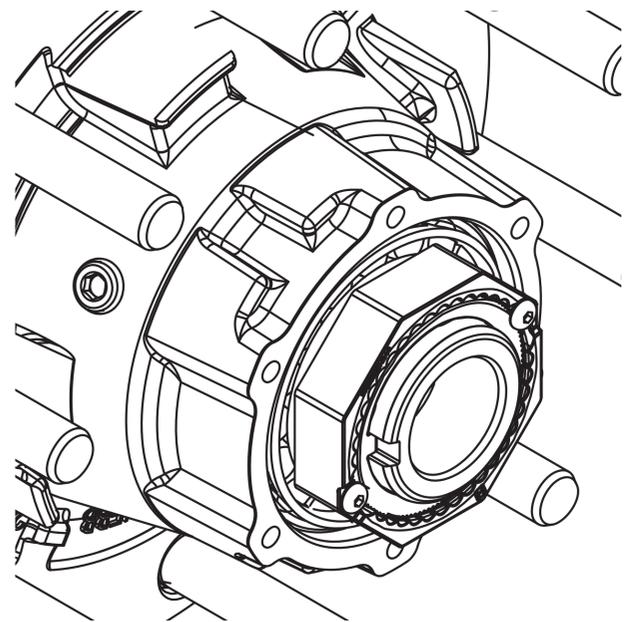


Precision Spindle Nut System Components



SPINDLE NUT	SOCKET	CAP SCREW HEX
PRECISION240™	3 13/16"	5/32"
PRECISION320™	4 7/8"	3/16"

Wheel bearings should be set within 0.001" to 0.005" end play. Following this procedure will consistently produce a bearing setting of 0.001" to 0.003" end play.



⚠ WARNING

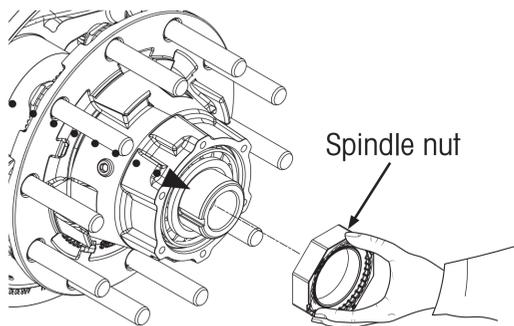
FAILURE TO FOLLOW THESE INSTRUCTIONS COULD CAUSE WHEEL TO COME OFF AND CAUSE BODILY INJURY. OVER-TIGHTENING NUT COULD CAUSE BEARINGS TO RUN HOT AND BE DAMAGED.

STEP 1

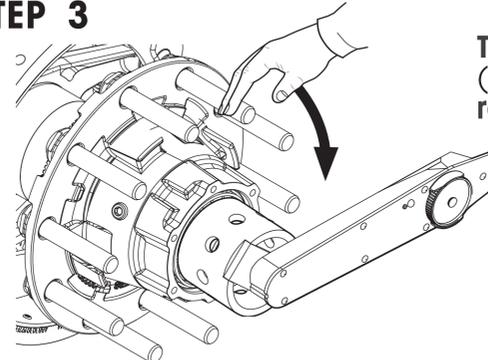


IMPORTANT
Inspect spindle to ensure threads are clean and free of damage and distortion. **Ensure** bearings are lubricated prior to installation.

STEP 2

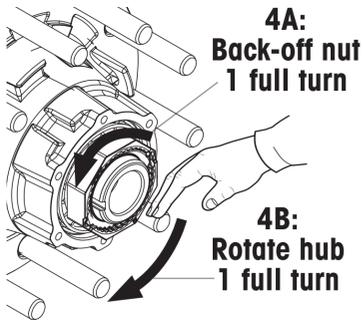


STEP 3



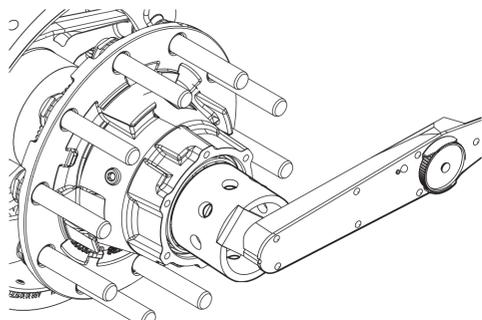
Torque to 200 ft. lbs. (271 Nm) while rotating hub 3 full turns

STEP 4



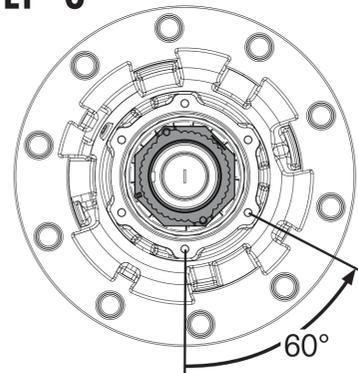
4A: Back-off nut 1 full turn
4B: Rotate hub 1 full turn

STEP 5



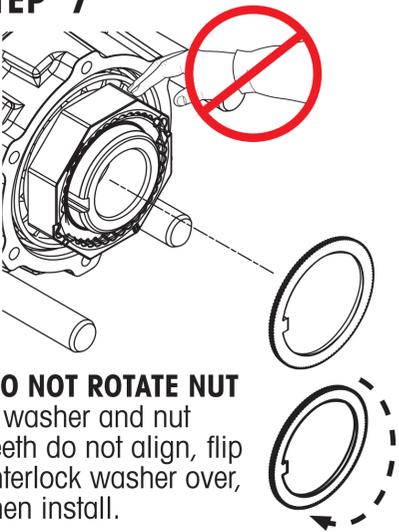
Torque to 50 ft. lbs. (68 Nm), then rotate hub 3 full turns. Repeat torque and rotations three more times. See note 1.

STEP 6



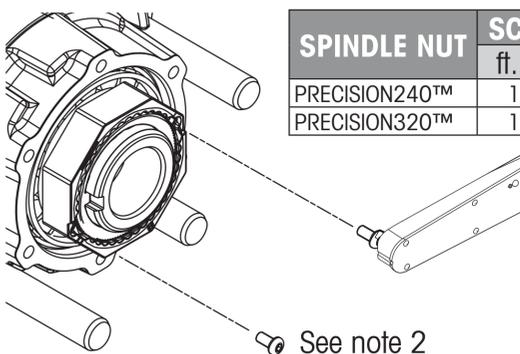
Back-off nut 1/6 turn (60°)

STEP 7



DO NOT ROTATE NUT
If washer and nut teeth do not align, flip interlock washer over, then install.

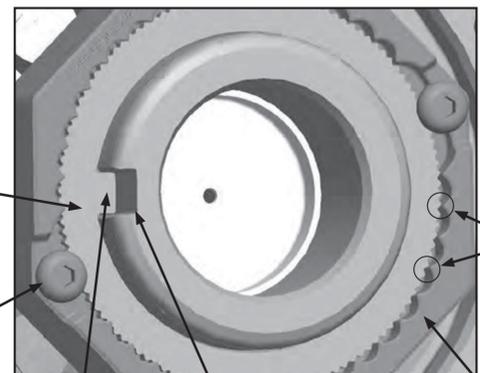
STEP 8



SPINDLE NUT	SCREW TORQUE	
	ft. lbs.	Nm
PRECISION240™	10±2	13.5±2
PRECISION320™	15±2	20±2

See note 2

STEP 9 Inspect



Properly seated Interlock Washer

Cap screw

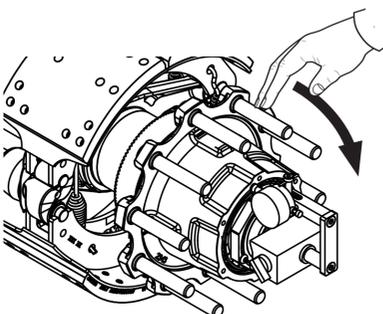
Tang

Spindle keyway slot

Fully engaged

Spindle nut

STEP 10 End Play



Rotate hub at least five revolutions. Use a dial indicator to verify end play is within 0.001" to 0.005". Adjust nut as necessary to achieve acceptable end play. If required, refer to applicable wheel-end maintenance procedures.

NOTES:

- These steps must be performed four times to ensure bearings are fully seated.
- If reusing existing screws, apply a small amount of Loctite® Threadlocker Blue to screw threads.