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Hub, Hub & Drum and Hub & Rotor Assembly

- ◆ With the exception of the backing plate and caliper-mounting bracket (**12” rotor only**), the assembly process between the hub, hub and drum and the hub and rotor are the same.
- ◆ Mount the backing plate or caliper mounting bracket (**12” rotor only**) with the bolts specified on drawings.
- ◆ **In greased applications inner bearing must be packed with grease prior to placing bearing.**
- ◆ Place inner bearing in the back of hub, hub and drum or hub and rotor.
- ◆ Press the rear seal in to the rear of the hub, hub and drum or hub and rotor until seated.
- ◆ Mount the hub, hub and drum or hub and rotor on the spindle.
- ◆ **In greased applications fill the hub, hub and drum or hub and rotor cavity with grease prior to installing the outer bearing. Outer bearing must be packed with grease prior to installing.**
- ◆ Install the outer bearing on the spindle.
- ◆ Install washer.
- ◆ Install nut and pre-load to 30 foot pounds while turning hub, hub and drum or hub and rotor. Back the hub nut off. While backing off, do not disturb the hub, hub and drum or hub and rotor. Then retighten the hub nut to finger tight.
- ◆ While installing the retainer take note to line up the hole in the spindle with a hole in the retainer. Install the cotter pin to secure the retainer.

OIL BATH ONLY

- ◆ Screw on oil bath cap and torque cap to 25-30 ft lbs.
- ◆ After the hub, hub and drum, or hub and rotor are assembled; add Chevron Clarity 150 Machine oil per specifications listed below. Use SAE 80W-90 gear oil for repairs if Clarity 150 is unavailable. Install oil plug into hub, hub & drum, hub & rotor using a 3/16” T-handle Allen wrench and turning oil plug clockwise. Tighten until it is snug, and then tighten ¼ turn more. **(take care not to cross-thread or over tighten)**
- ◆ Oil quantities are as follows:
 - ◆ HRM hubs 4 oz. (5500# and 6000# axles)
 - ◆ UHI hubs 2 3/8 oz. (Most 3000# and up axles)
 - ◆ BT hubs 2 1/8oz. (Most axles 2700# and under)
- ◆ You should check the oil level before towing your vehicle down the road.

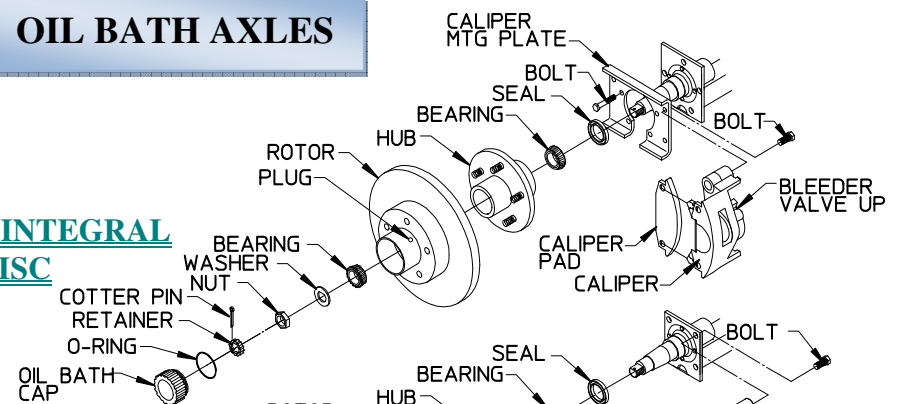
GREASE ONLY

- ◆ Fill bearing protector about 1/4 full, making sure that bearing protector is concentric with hub, hub and drum, or hub and rotor, drive on bearing protector.

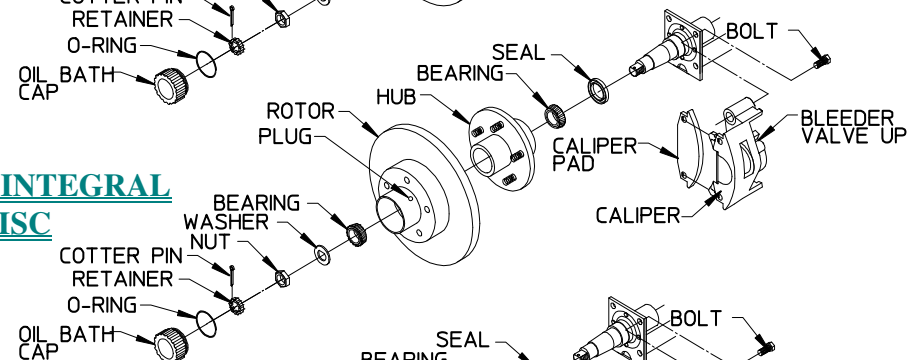
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OIL BATH AXLES

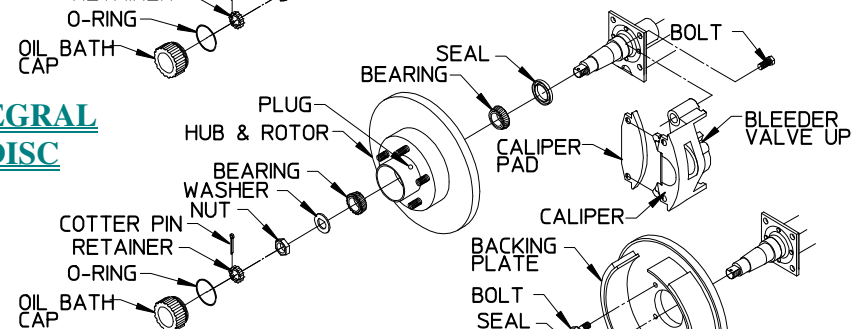
NON-INTEGRAL 12" DISC



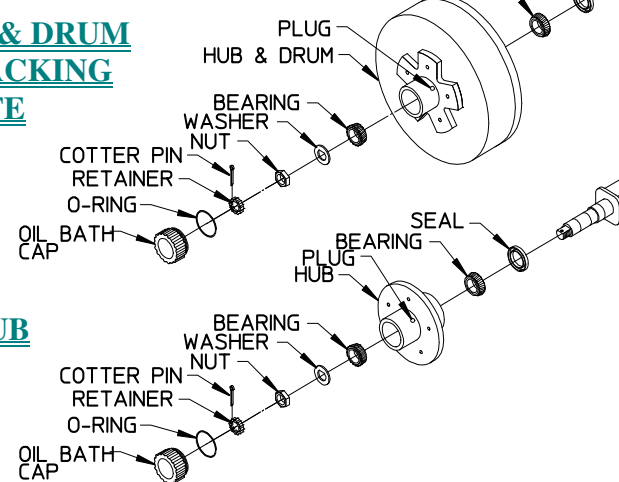
NON-INTEGRAL 10" DISC



INTEGRAL 10" DISC



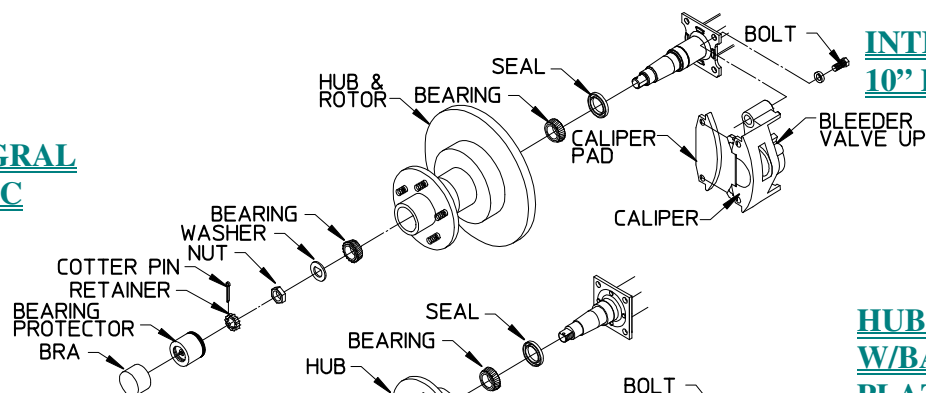
HUB & DRUM W/BACKING PLATE



HUB

GREASE AXLES

INTEGRAL 8" DISC



HUB

INTEGRAL 13" DISC

