

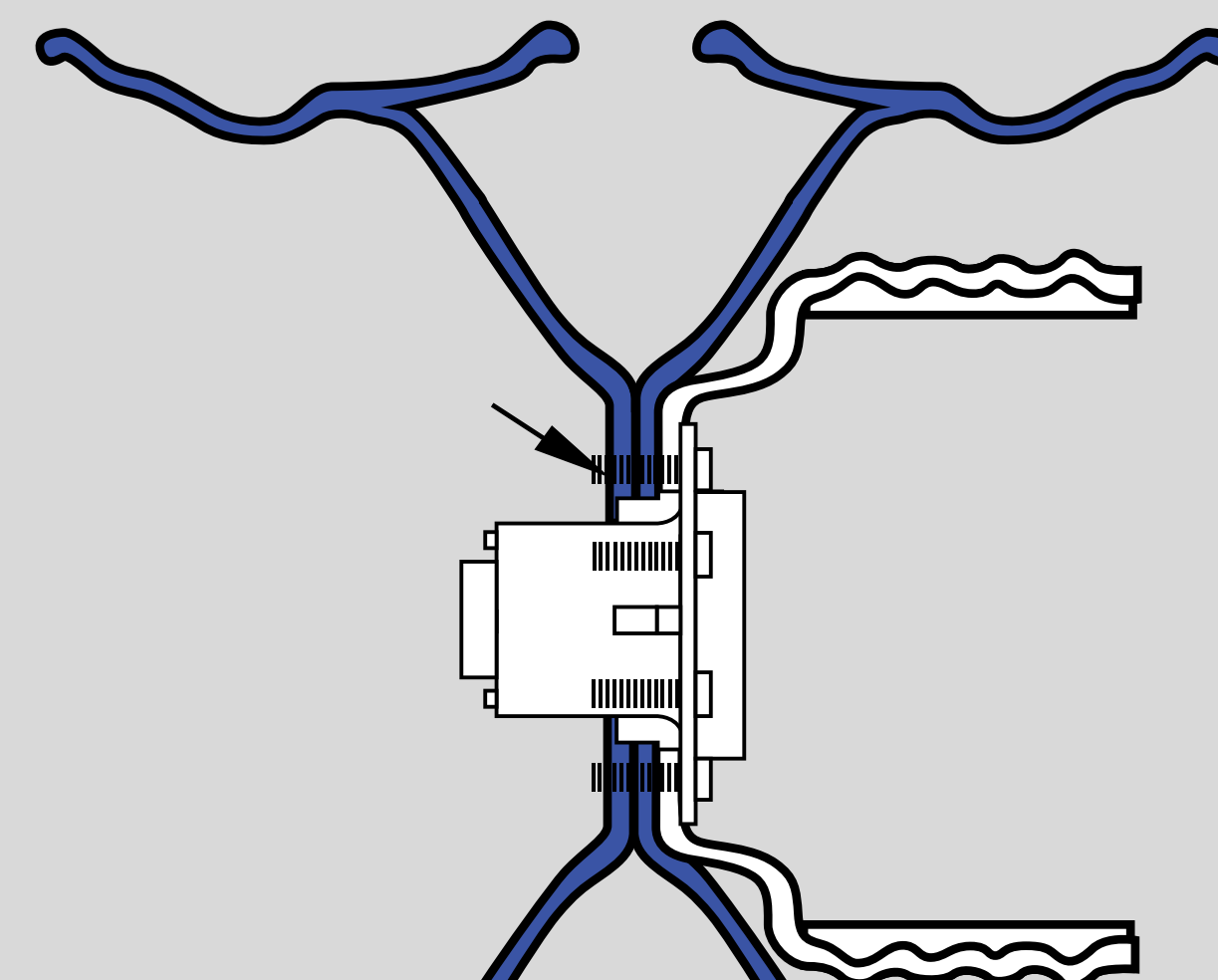
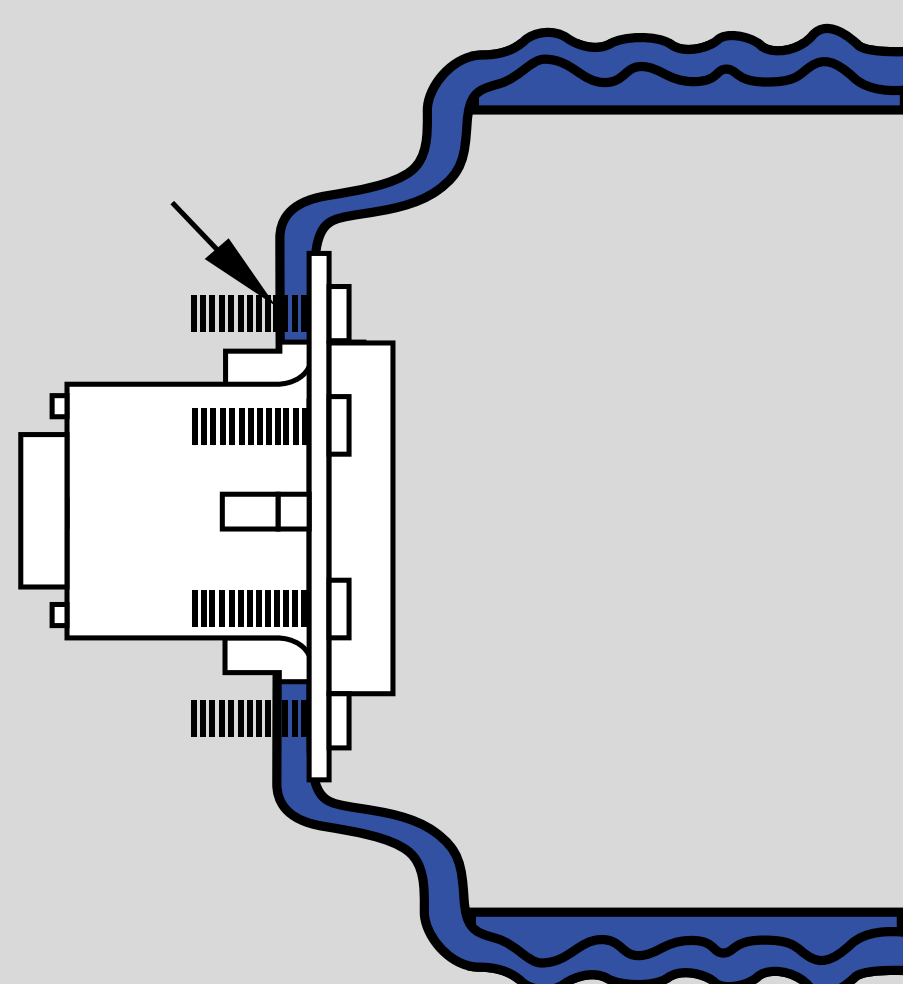
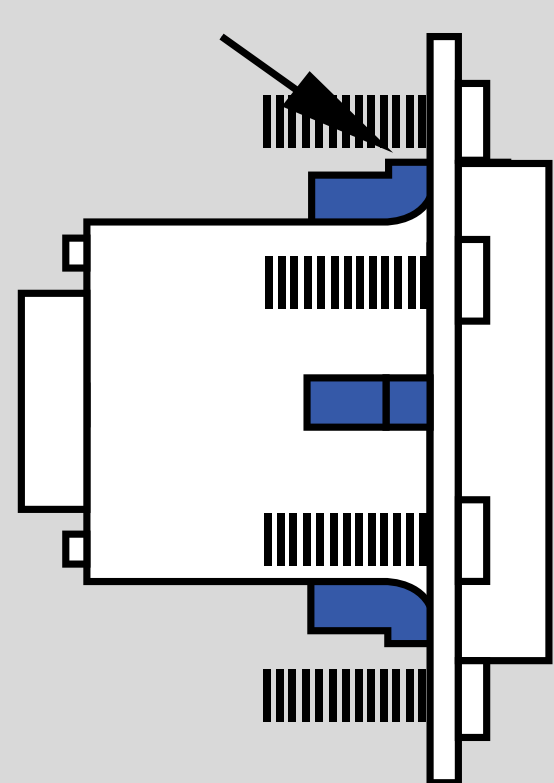


## BRAKE DRUM INSTALLATION PROCEDURES

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

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

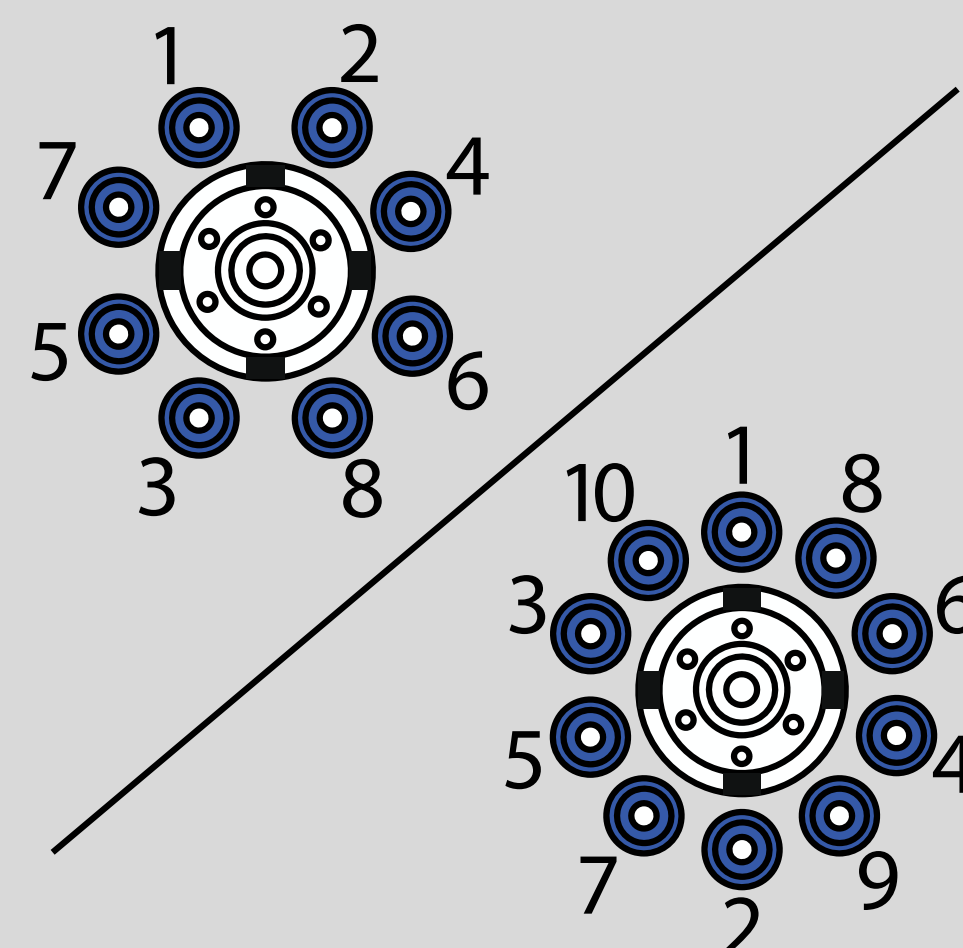
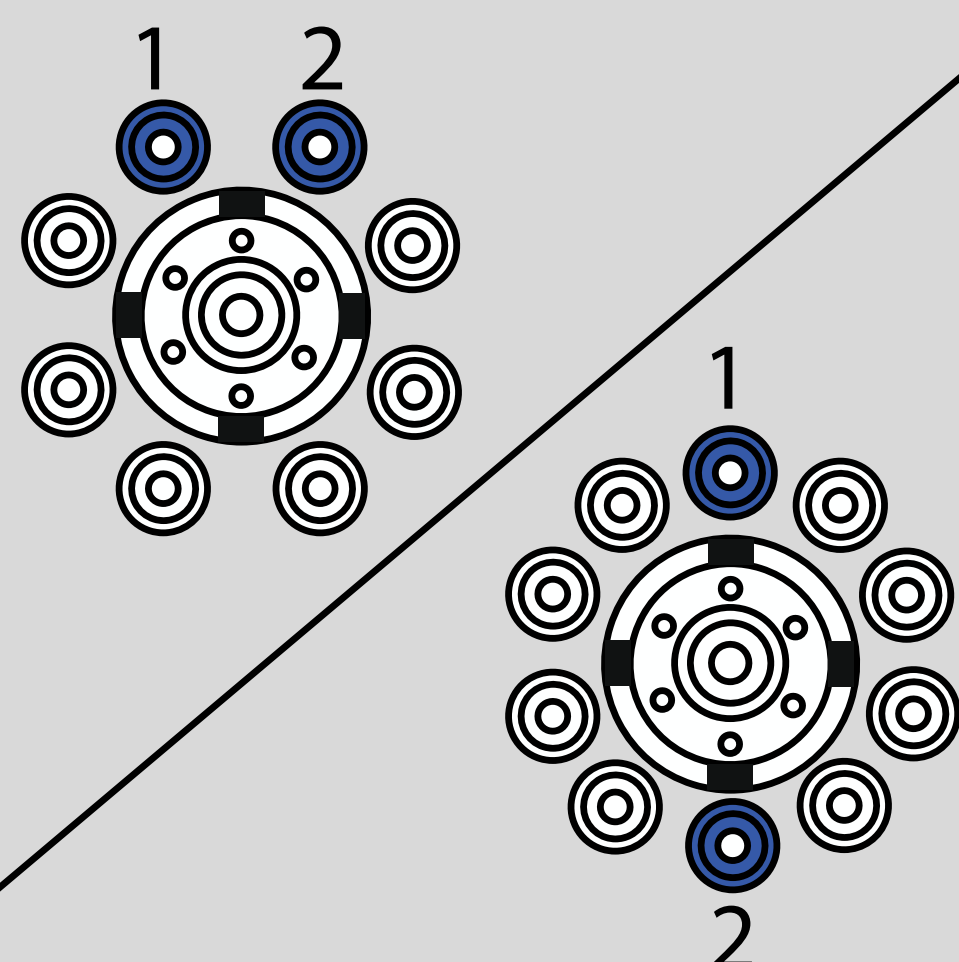
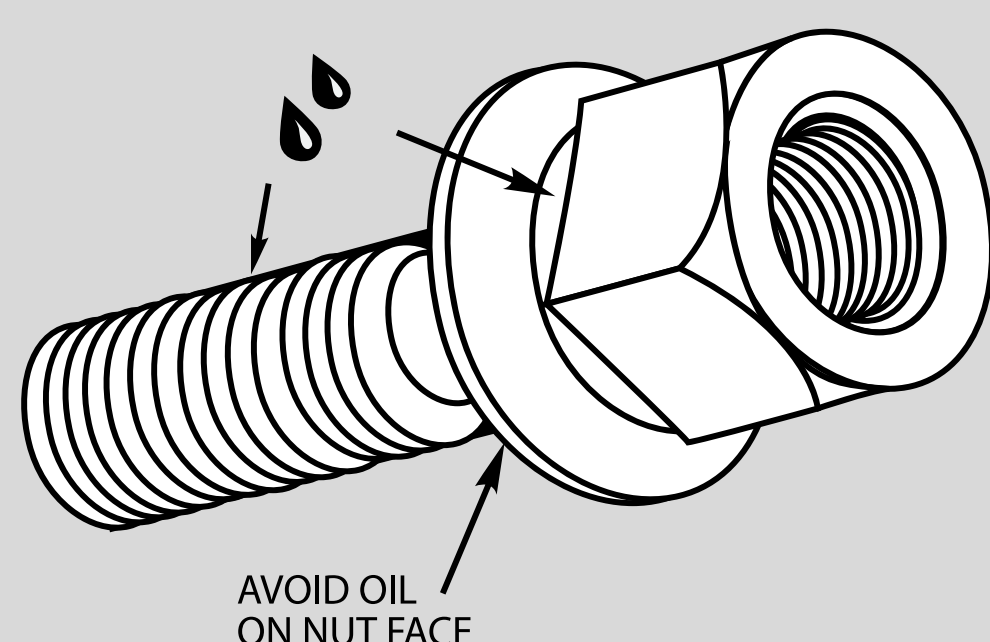
**3** With wheels square to hub, mount inner and outer wheels as far back on the pilot pad as possible. Be sure both tire valve stems are accessible.



**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.

**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.

**6** Complete procedure by tightening all the nuts in 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 50 - 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 dates.