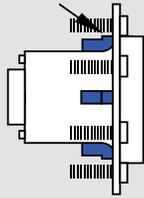




## BRAKE DRUM INSTALLATION PROCEDURES

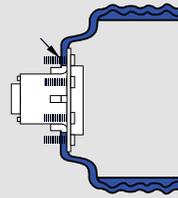
Locate one hub pilot pad at twelve o'clock position.

1



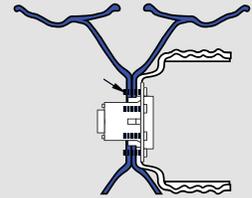
Before mounting wheels, be sure the drum is properly positioned on raised step of the pilot pad.

2



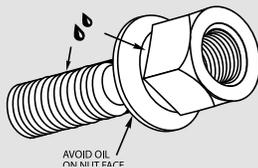
With wheels square to the hub, mount inner and outer wheels as far back on the pilot pad as possible. Be sure both tire valve stems are accessible.

3



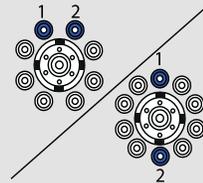
Apply two drops of oil on leading threads of studs and between the nut body and flange. Avoid getting oil on face of the nut, wheels, or the brake drum.

4



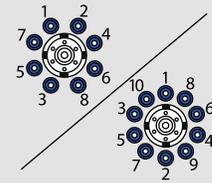
Finger tighten nuts on top two positions on an 8-hole wheel; top and bottom positions on a 10 hole wheel. Apply remaining nuts finger-tight. Then snug all nuts to 50 ft.-lbs. following the sequence shown in step 6.

5



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.

6



### IMPORTANT

Axle end parts "seat in" during normal vehicle operation. Therefore, it is recommended to repeat the torquing procedure after 50 - 100 miles of operation, after each tire change or whenever nuts are removed. Torque to 450-500 ft.-lbs. Check the torque output of impact wrenches frequently. Torque wrenches should be calibrated periodically. Record calibration dates.