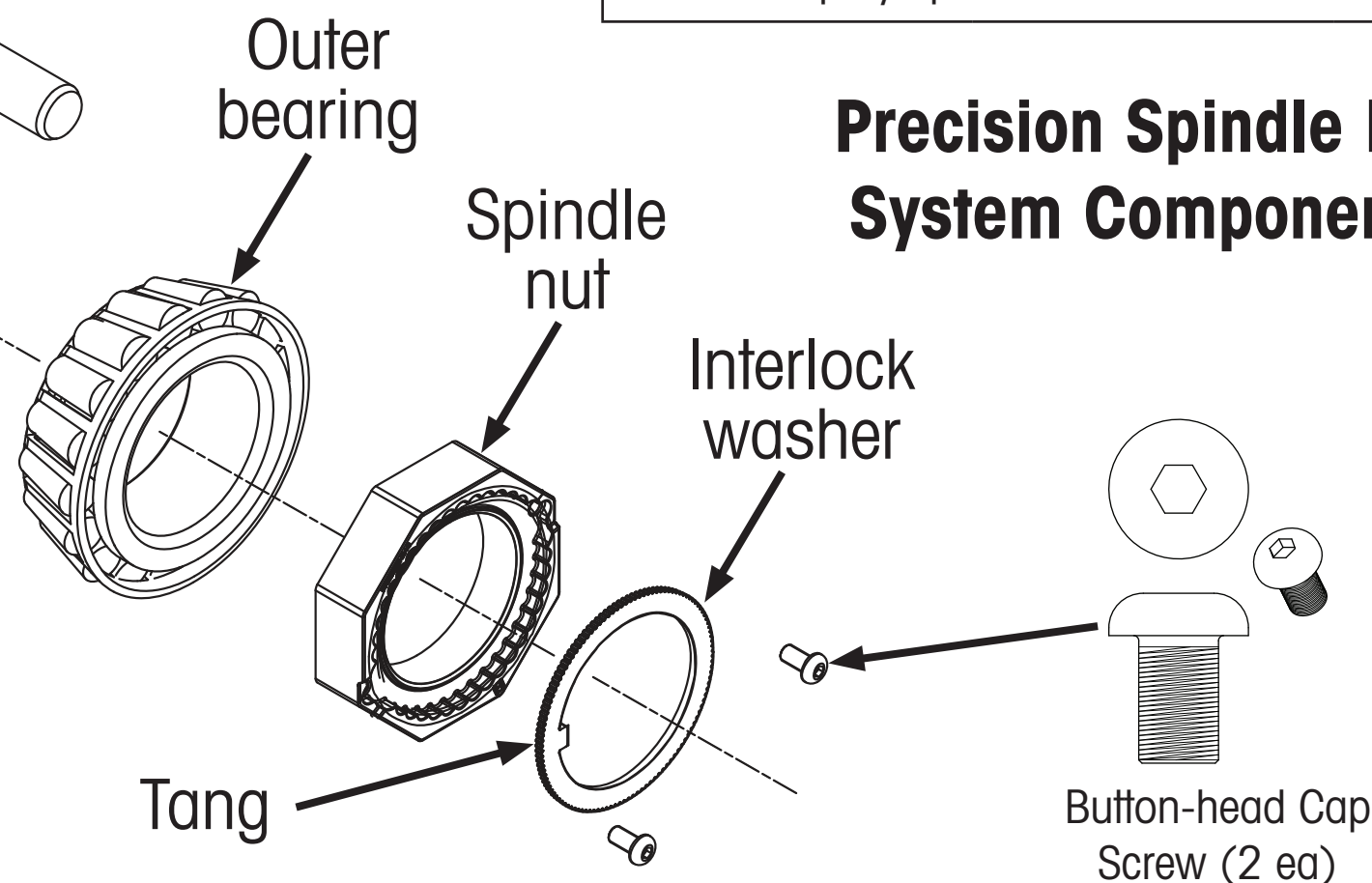
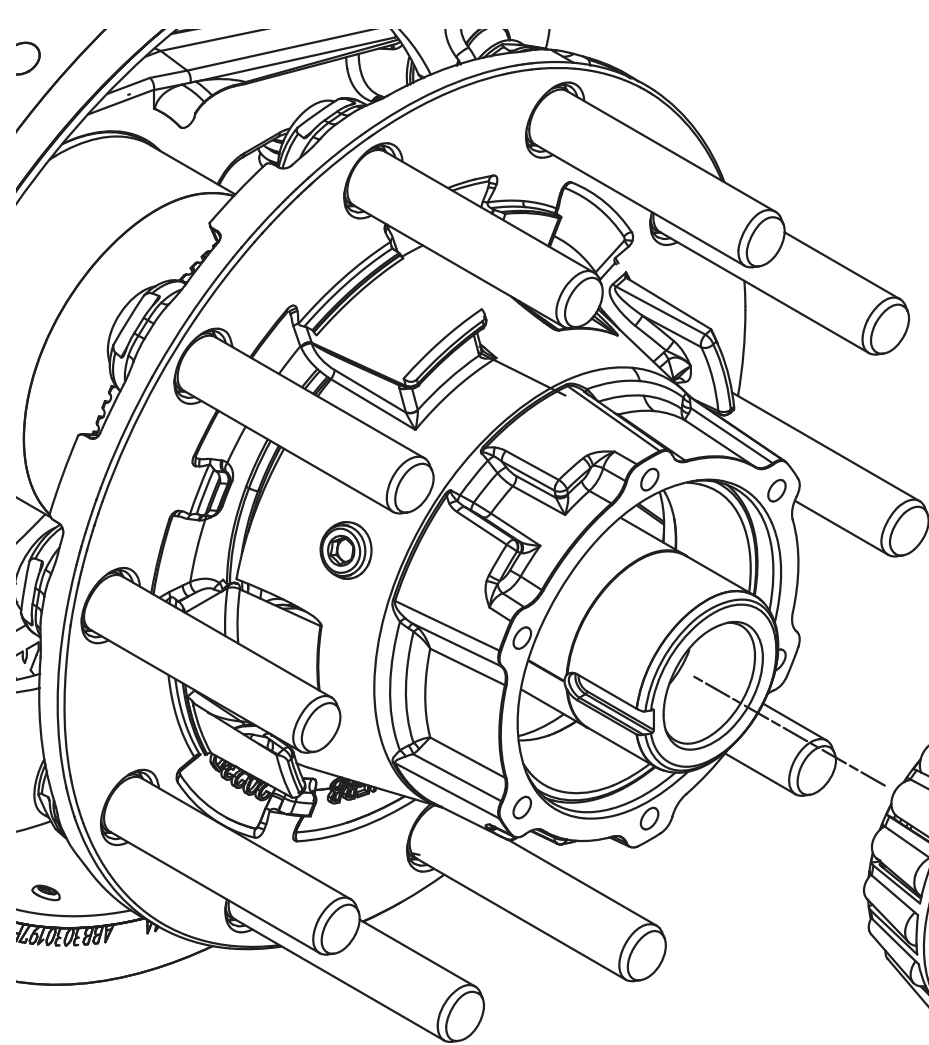


PRECISION240™, PRECISION320™ NUT SYSTEM Installation Procedures

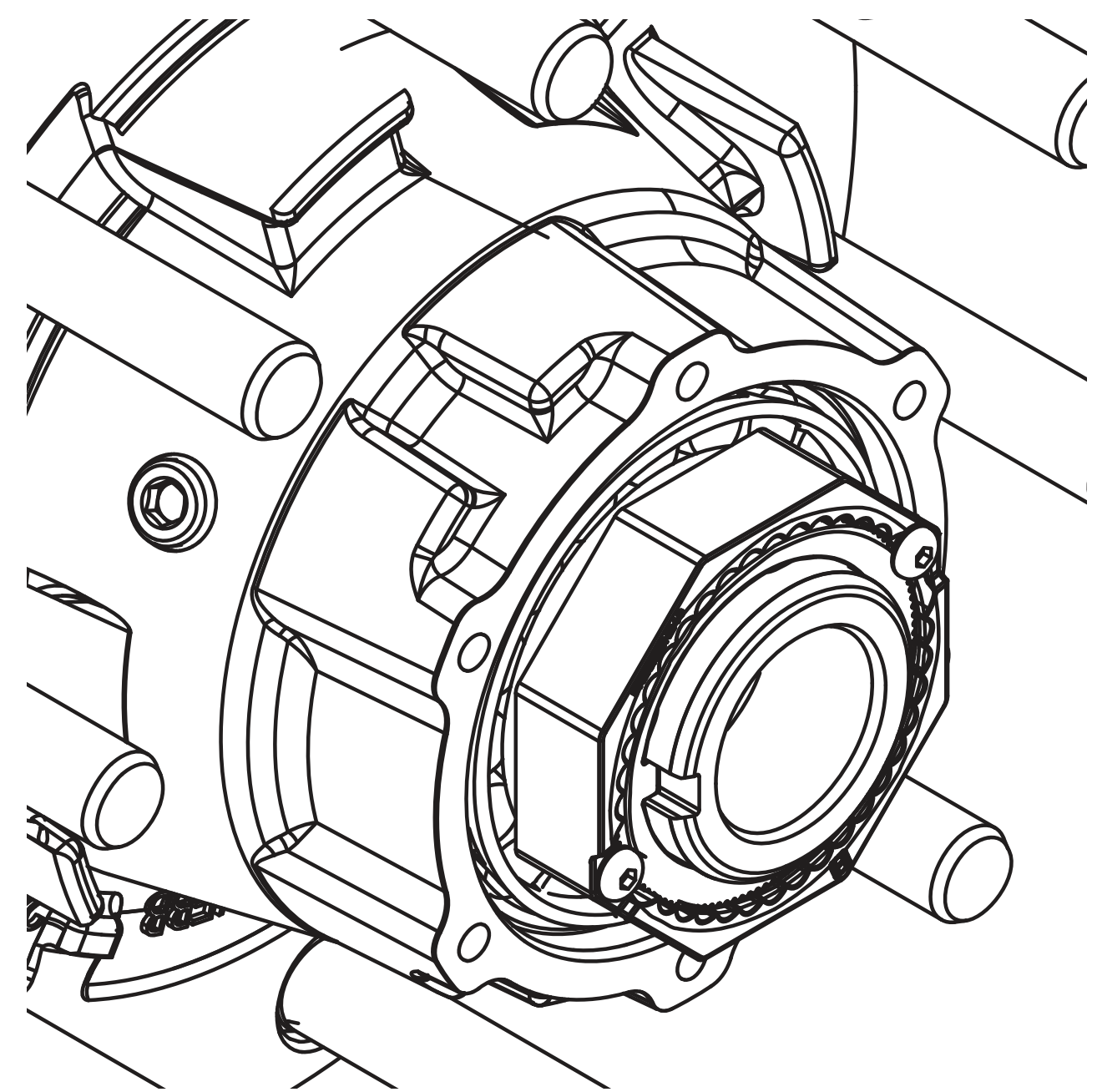
T71005

October 2012



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

Wheel end play specification: 0.001" to 0.003"



NOTICE

Failure to exactly follow the steps of this procedure could cause improper bearing setting, resulting in reduced bearing life.

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.

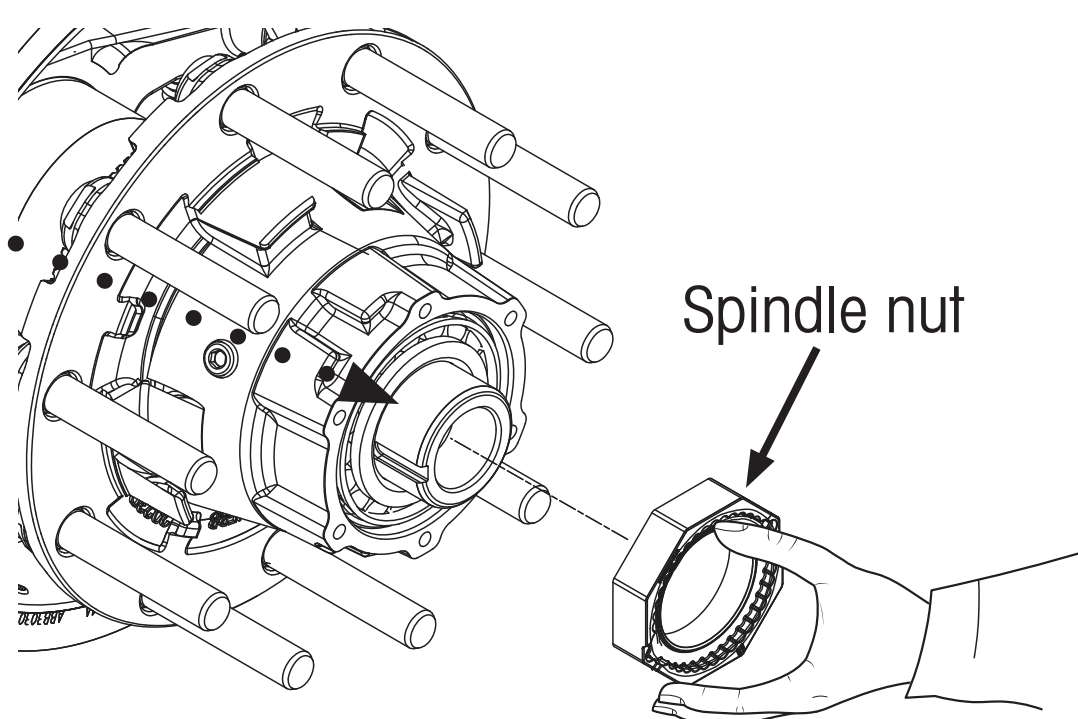
STEP 1



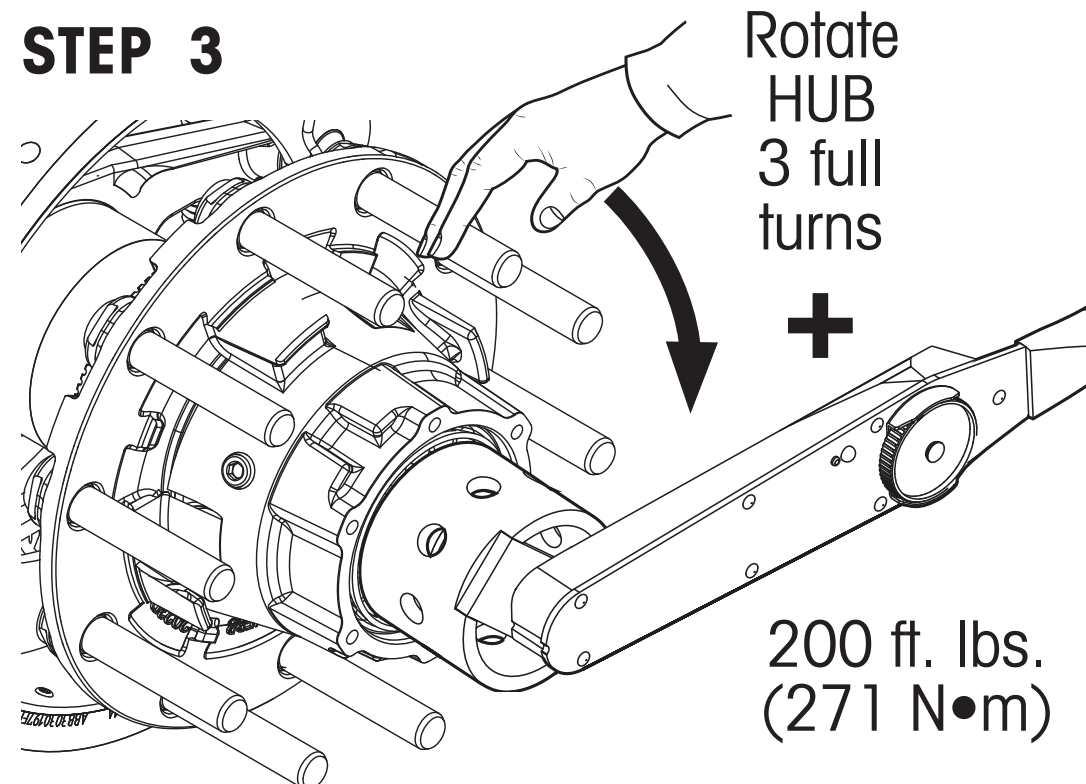
IMPORTANT

Inspect spindle to ensure threads are clean and free of damage and distortion.

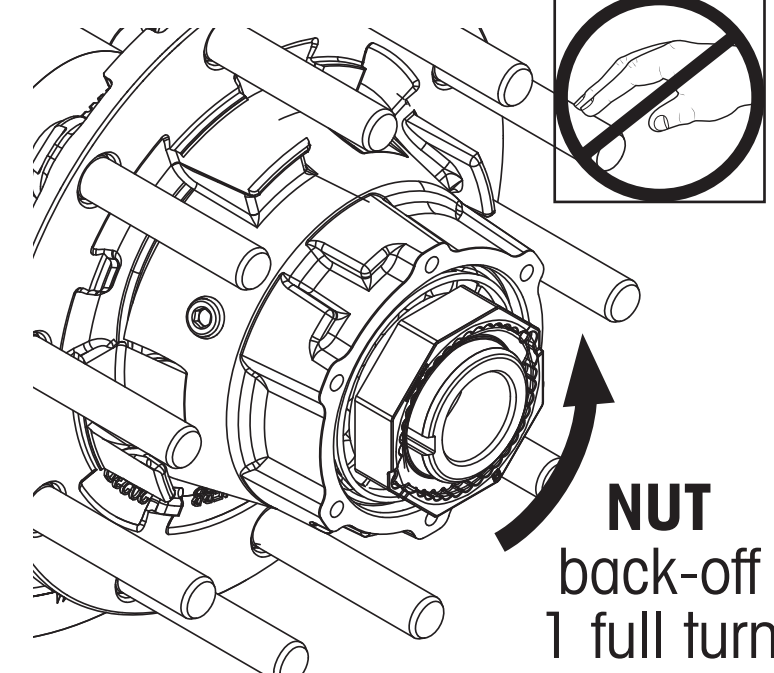
STEP 2



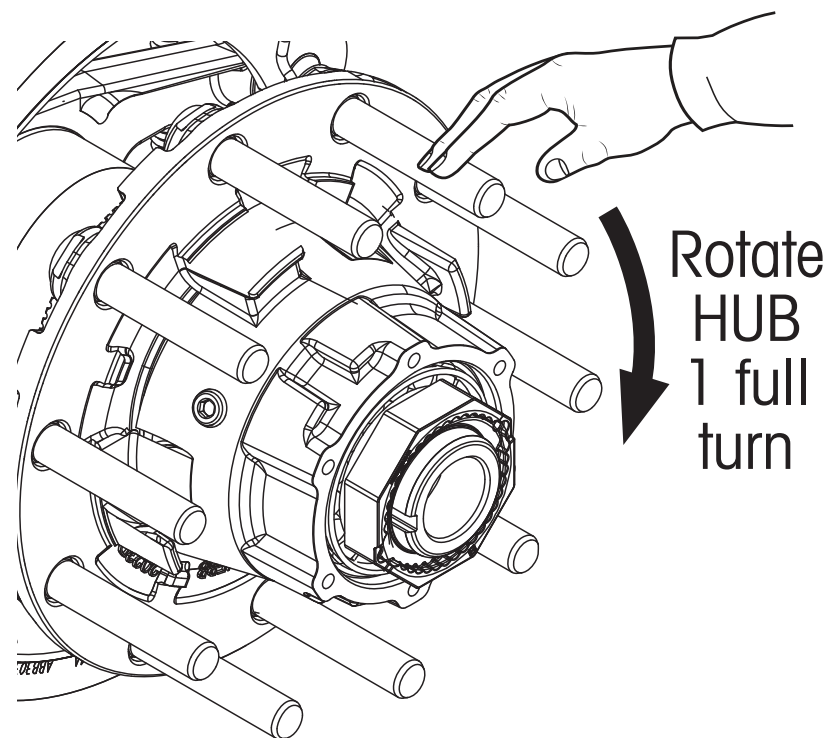
STEP 3



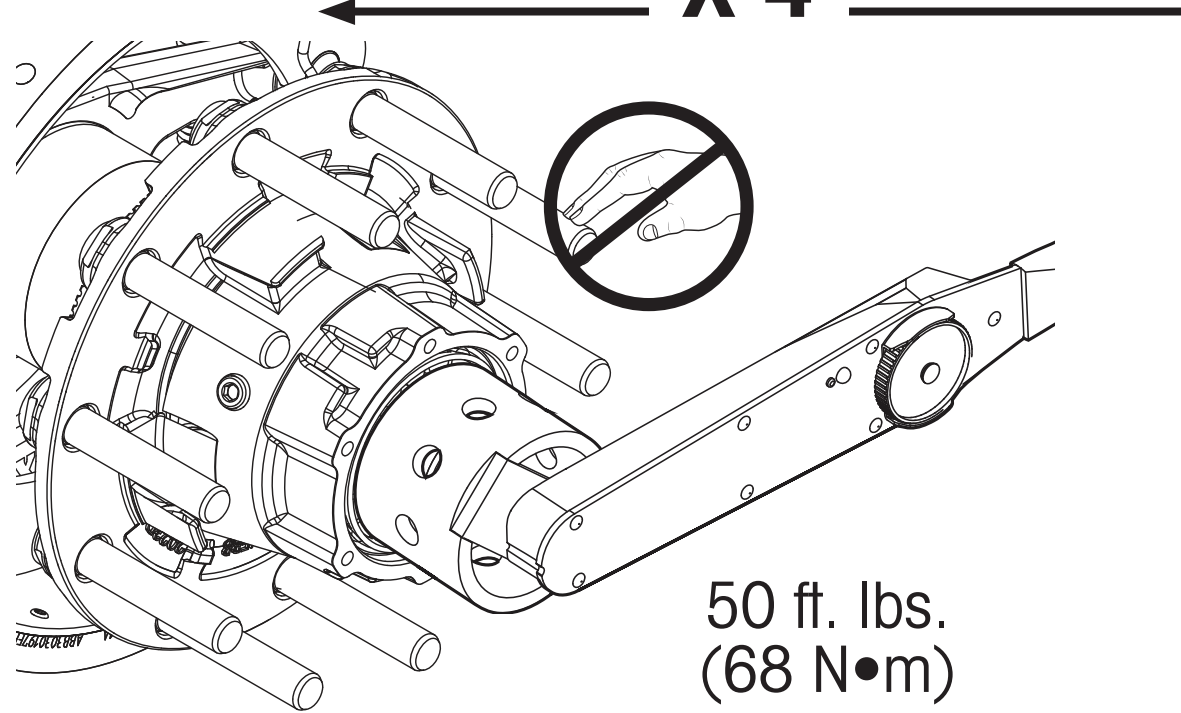
STEP 4



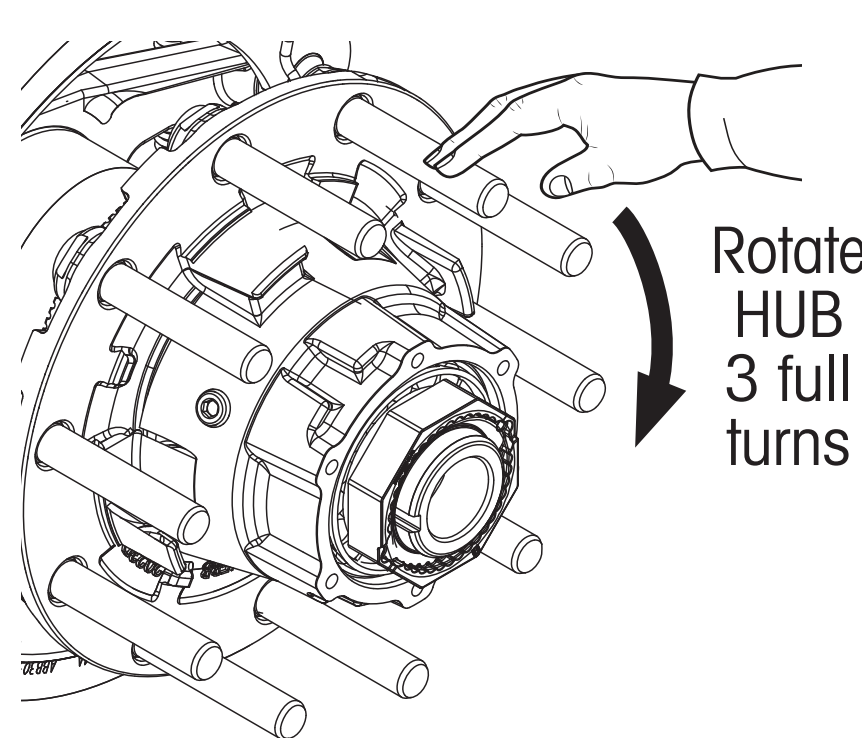
STEP 5



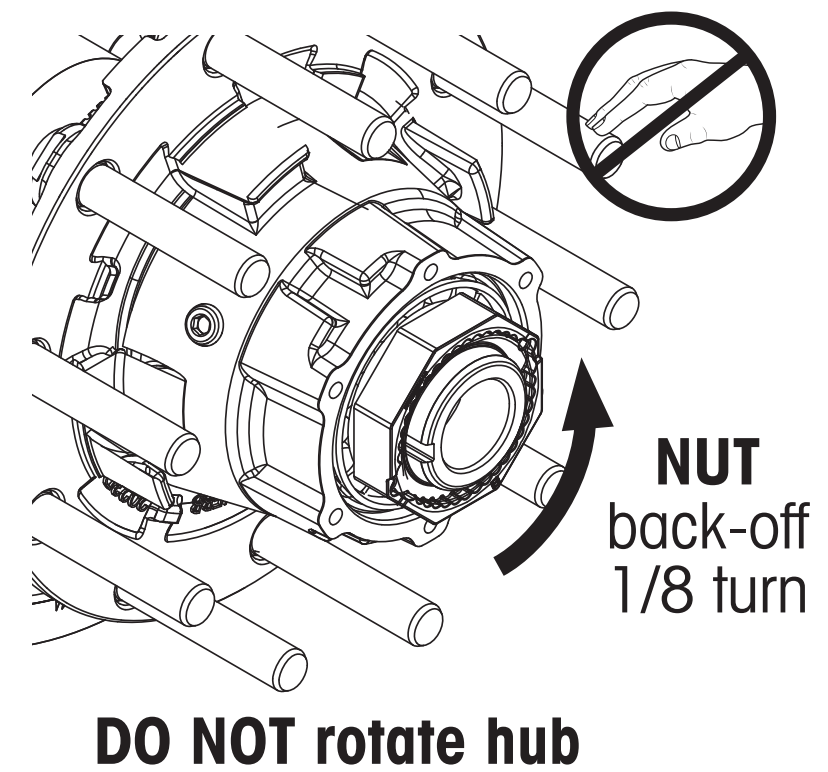
STEP 6



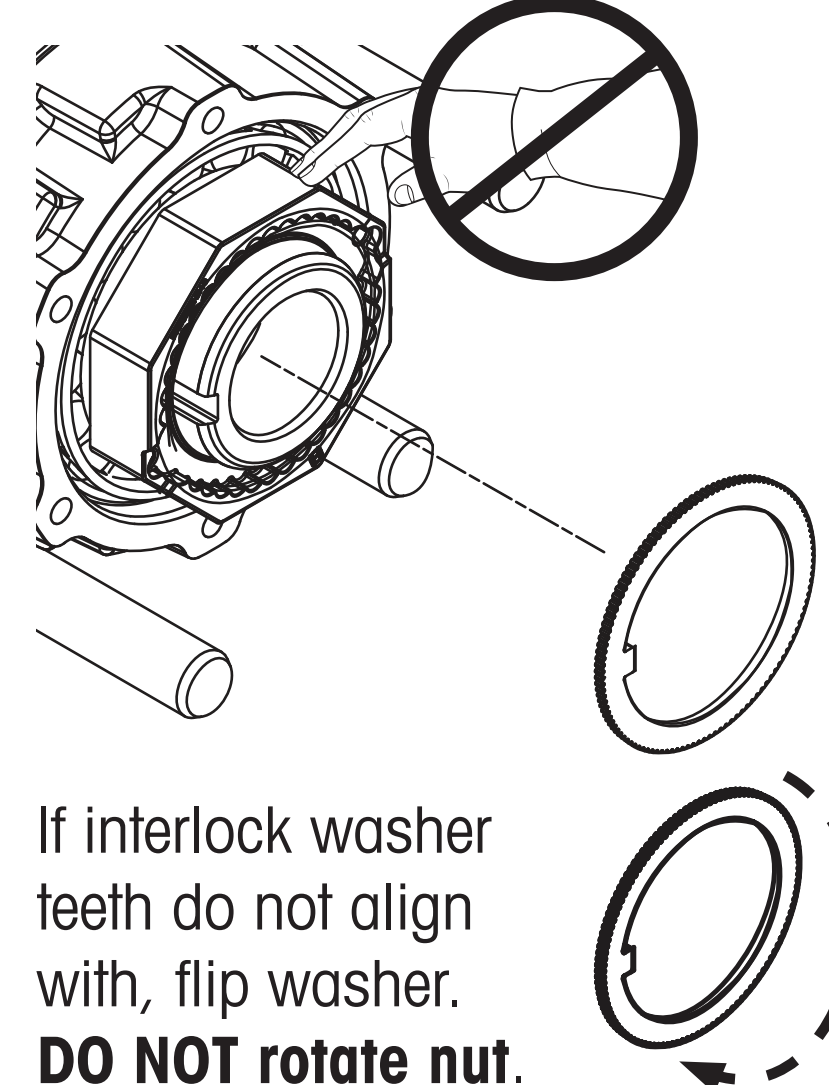
STEP 7



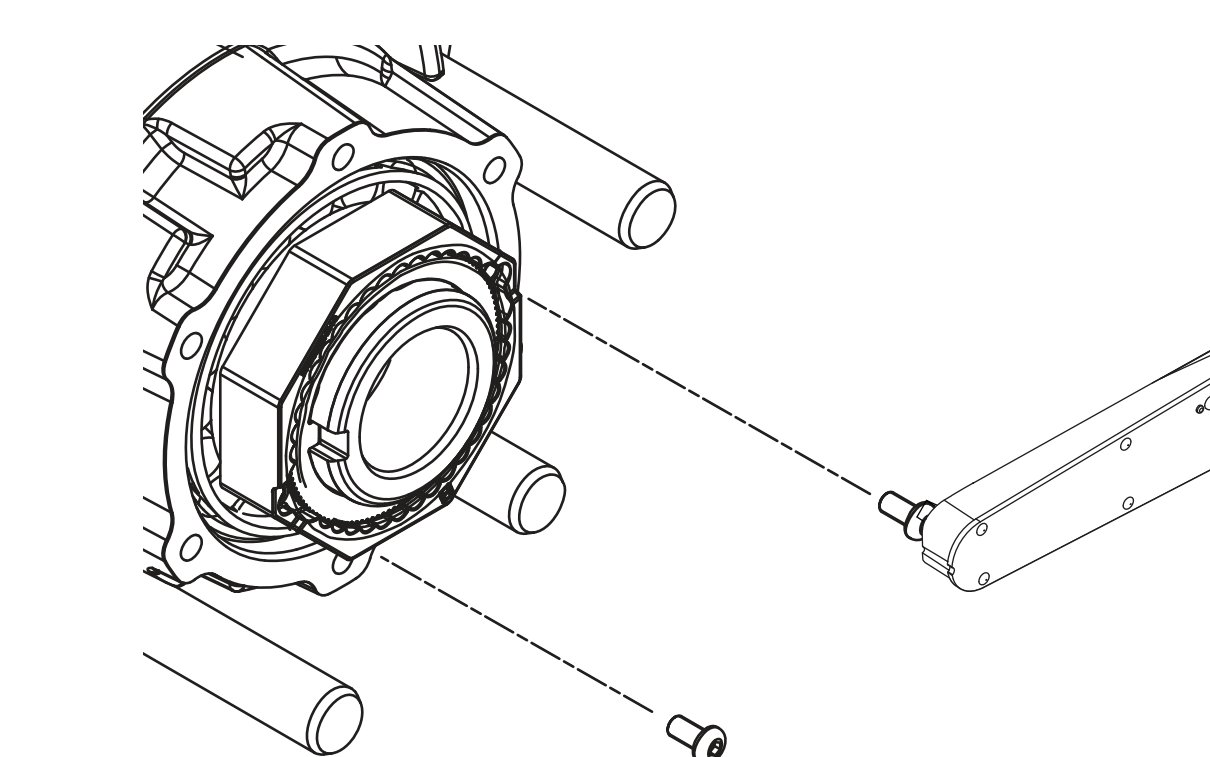
STEP 8



STEP 9 *



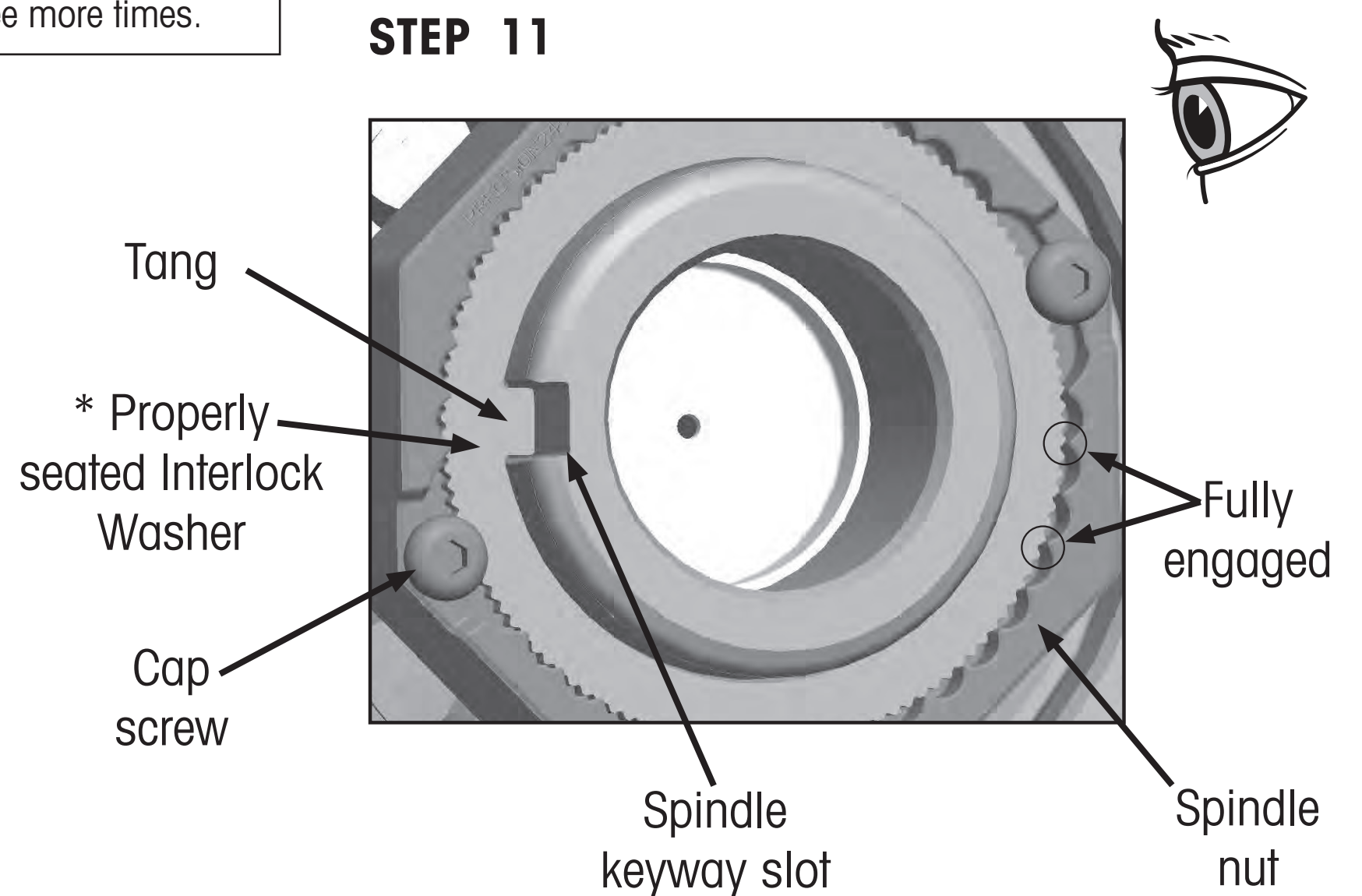
STEP 10



Steps 5 through 7:

1. Rotate hub clockwise at least one full turn.
2. Tighten spindle nut to 50 ft. lbs. of torque.
3. Rotate hub clockwise three full turns.
4. Repeat step 6 and step 7 three more times.

STEP 11



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