

Marmon-Herrington



## Technical Bulletin

# TB0018 - Checking the Flange Yoke Bolt Torque on Marmon-Herrington Drive-Steer and Rear Drive Axles

MT14, MT17, MT22, R17 and R22  
Models Produced from 7/31/14  
through 7/15/15

### Important Information

To prevent serious injury always wear appropriate personal protective equipment. This includes but is not limited to safety glasses, gloves and steel toe boots.

**WARNING!** Before performing maintenance on the vehicle, park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving and perform necessary lockout/tagout procedures. Do not work under a vehicle supported only by jacks.

### Flange Yoke Torque Check

This technical bulletin provides instructions to check torque and, if required, tighten the flange yoke bolts on MT14, MT17, MT22, R17 and R22 axles.

### How to Obtain Additional Maintenance, Service and Product Information

Contact Marmon-Herrington by calling (800) 227-0727 or visiting [www.Marmon-Herrington.com](http://www.Marmon-Herrington.com)

### How to Obtain Parts

The flange yoke bolts may be tightened to the proper torque without replacement. If replacement bolts, washers or nuts are needed, contact Marmon-Herrington at (800) 227-0727.

### Parts Required for Torque Check

- None

### Tools Required

- Torque Wrench, click or sweep face
- 9/16 crow's foot
- 9/16 combination wrench

### Standard Repair Time (SRT)

The standard repair time is 0.25 hours for checking torque and tightening bolts.

### Checking the Flange Yoke Bolt Torque

1. Wear safety glasses. Park the vehicle on a level surface
2. Block the wheels and perform necessary lockout/tagout procedures.
3. Locate the eight (8) 3/8" bolts at the flange yoke joint (Figure 2).

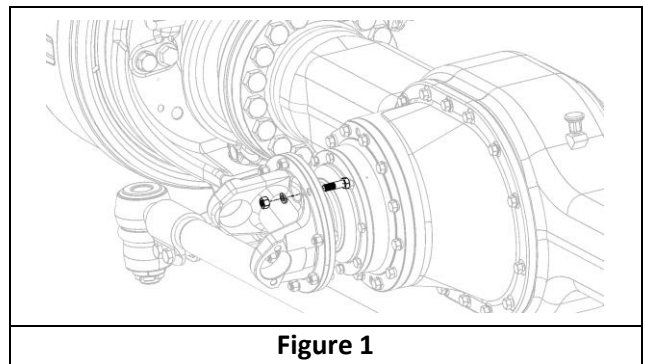
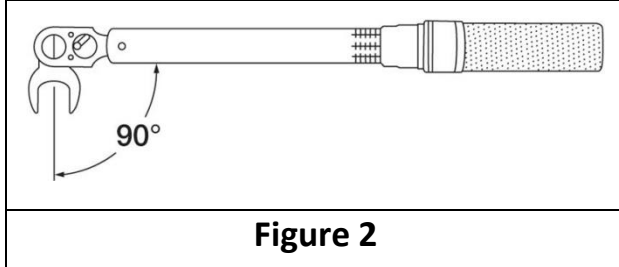


Figure 1

- Use a calibrated torque wrench. A crow's foot or a box end wrench socket must be used to access the nuts behind the ears of the yoke. Make sure the crow's foot is at 90° (Figure 2). If the crow's foot is not at 90°, use the appropriate correction factor for your torque wrench.



- Holding the bolt head with a 9/16" combination wrench, torque the nut to 45-50 ft lbs (60-68 Nm). Repeat for each of the eight (8) bolts.

## Appendix

### Parts used in replacement, if required

Part	Part Number
Flange Yoke Bolt	M8042521
Flange Yoke Washer	103321
Flange Yoke Nut	103026

If replacement bolts, washers or nuts are needed, contact Marmon-Herrington at (800) 227-0727.