



SECTION A-A
SCALE 1:2

AXLE SPECIFICATION

1. RATED AXLE LOAD - 10,000 kgs
2. WEIGHT OF AXLE WITH BRAKES - 320 kgs (TO BE CONFORMED)
3. BRAKE SIZE - ϕ 408.0 X 180 WIDE

NOTE:

WEIGHT OF GREASE IN EACH HUB ASSY :- 650 grms
REAR HUB WHEEL BEARING GREASE CONSISTENSY -3 SS : 6808

HUB BEARING ASSY ADJUSTMENT

MEASURE THE GAP BETWEEN THE INNER RACES OF HUB INNER & OUTER BEARINGS. ASSY 'X' (THIS CAN BE DONE EITHER WITH THE FIXTURE PRIOR TO ASSY OR BY TRIAL & ERROR INSERTION OF THE SPACER & SHIM PACKAGES BETWEEN THE BEARING IN THE AXLE ASSY).
 TAKE THE HUB LUG SPACER (D668 3560 86 02) & INSERT SHIMS (D668 3560 04 01) SUCH THAT THE TOTAL THICKNESS OF THE PACKAGE IS MORE THAN "X" BY ANY VALUE BETWEEN 0.02 & 0.12. PRESS THE INNER RACE OF THE OUTER BEARING WITHOUT DAMAGING THE THREADS & TAKE THE HUB LUG SPACER (D668 3560 86 02) & THE HUB LUG WASHER (D668 3560 86 04) TO BUTT AGAINST THE BEARING FACE & SCREW THE HUB LOCKNUT ON THE BEAM & TIGHTEN IT APPLYING OF 30-40 MFT. HAMMER THE HUB FRONT FACE GENTLY SO THAT WHEEL BEARINGS SET & RUN FREELY.
 ASSY THE TOUNGE WASHER (D668 3560 86 04) BY ALIGNING THE TOUNGE INTO BEAM SLOT, AND CHECK FOR THE ALIGNMENT WITH THE TOUNGE HOLE OF TOUNGE WASHER TO TAPPED HOLES ON NUT.
 IF THERE IS A MISMATCH, THEN TIGHTEN THE NUT FURTHER SO AS TO ALIGN THE IMMEDIATE NEXT HOLES THE NUT AND LOCK IN POSITION
 ENSURE THE AXLE PLAY TO BE WITHIN 0.02 TO 0.12.

NOTE:
THIS AXLE DRAWING IS REPLACEMENT FOR
EXISTING AXLE DRAWING NO. 2736 3900 01 30

FOR FORGE AND FOUNDRY DIVISIONS ONLY											Unless otherwise stated, general tolerance on machining as per: ISO 2768-1S (medium class) / TS 16949											
Customer	Die-wear (Surface)	Mis-match	Thickness	Flash thickness	Clip	Pierce	Restrictor	Draft	Contraction	Minimum radius	SURFACE TOLERANCE / VALUES in µm Ra											
											General tolerance on machining as per: ISO 2768-1S (medium class) / TS 16949											
											Dimension	Up to & incl.	Over	6	30	120	400	1000	2000	2500		
											Value	30	25	20	16	12.5	10	8	6.3	5	4	
											Tolerance	±0.1	±0.2	±0.3	±0.4	±0.5	±0.8	±1.2	±1.6	±2	±2.5	
For other roughness Ranges & VALUES, see: TS 10779																						

[illegible]