

## **AXLE SPECIFICATION** 1. RATED AXLE LOAD = 10,000 kgs2. WEIGHT OF AXLE WITH BRAKES = 320 kgs (TO BE CONFORMED) 3. BRAKE SIZE = $\emptyset$ 408.0 X180 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. SAY 'X' (THIS CAN BE DONE EITHER WITH THE FIXTURE PRIOR TO ASSY OR BY TRIAL & ERROR INSERSTION OF THE SPACER & SHIM PACKAGES BETWEEN THE BEARING IN THE AXLE ASSY TAKE THE TUBULAR SPACER (2668 3560 86 02) & INSERT SHIMS (2668 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 ON THE AXLE BEAM. THEN ASSEMBLE THE TOUNGE SPACER (2668 3560 86 04) TO BUTT AGAINST THE BEARING FACE SCREW THE HUB LOCKNUT ON THE BEAM & TIGHTEN IT APLLYING OF 30-40 MKg. HAMMER THE HUB FRONT FACE GENTLY SO THAT WHEEL BEARINGS SET & RUN FREELY. ASSY THE TOUNGE WASHER (2668 3560 86 04) BY ALIGNING THE TOUNGE INTO BEAM SLOT. AND CHECK FOR THE ALIGNMENT WITH CLEARANCE 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

Unless otherwise stated.general tolerance on geometrical characteristics as per ISO 2768-2-K (medium class)/TS12114 Unless otherwise stated.general tolerance on angular dimensions.radii and chamfers as per ISO 2768-1-m (medium class)/TS1211 Unless otherwise stated.general tolerance on machining as per ISO 2768-1-m (medium class)/TS12115

of TML Drivelines Limited.

For all Vehicle Components & Assemblies.

Material description.size.spec.std No.

Classification of characteristics:

Applies to upper limit

Tata Group Mark & Part No. to be marked as per TS 11

For M1 & N1 class of vehicles, applicable standards are: TS11414.TS11418.TS11419 & TS11420

This drawing is the sole property of TML Drivelines Limited.

It should not be copied or communicated to any person without the written approval of TML Drivelines Limited.

Appl AKS 22/1 Product/Group Mo

Modification

Envelope Dimensions in kg.

Final mass Surface protection as per s in kg.

- 2220.35 x 466.00 x 541.65 24.791 Tolerance as per standard Applies to lower limit Final mass Surface protection as per standard 2736 3900 01 23 Reference Drg No. RA-909 RR Opposite Hand Drg/Part No. Drg/Part Designation

14
For explanation of drawing format contents, refer to TS11103
8845 4130 70 66 PCF- 071(R4) 6/2011

Do not scale the drawing.

If in doubt, ask.

Unless otherwise stated. 1) All dimensions in mm. 2) Drawing drawn to first angle projection

INFO DRAWING REAR AXLE ASSEMBLY (SEC- 135X150X14; TRACK- 1950)

General tolerance on machining as per ISO 2768-1m(medium class)/TS12115 SURFACE ROUGHNESS SYMBOLS / VALUES IN Jum Ra FOR FORGE AND FOUNDRY DIVISIONS ONLY Customer Die-wear Mis-match Thickness Flash Clip Pierce Restrike Draft Contraction Minimum - (surface)

7700 3900 01 85

MSS AKS

Chkd Appd

SPACER REMOVED. 273639600116 WAS 770039600103

PART 280842307501 W AS 770039106301 SPRING W ASHER REMOVED 263242303734 W AS 263242303708 &

NEW RELEASE