



SECTION G-C  
SCALE 2:5

## AXLE SPECIFICATION

1. RATED AXLE LOAD = 10,000 kgs  
2. WEIGHT OF AXLE WITH BRAKES = 320 kgs (TO BE CONFORMED)  
3. BRAKE SIZE =  $\varnothing 408.0 \times 180$  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, SAY '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 TUBULAR SPACER (2668 3560 86 03) & INSERT SHIMS (2651 3560 83 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 BEARING ASSEMBLY THE TOUNGE SPACER (2668 3560 86 04) TO BUTT AGAINST THE BEARING FACE  
SCREW THE HUB LOCKNUT ON THE BEAM & TIGHTEN IT APPLYING OF 30-40 Nm/kg  
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.

FOR FORGE AND FOUNDRY DIVISIONS ONLY											SURFACE FINISH, RUGGNESS SYMBOLS & VALUES IN $\mu\text{m Ra}$																																																																																																																																																																																																																																																																																																	
Customer	Die-wear (surface)	Mis-match	Thickness	Flash Thickness	Clip	Pierce	Restrike	Draft	Contraction	Minimum Radius	General tolerance on machining as per ISO 17026-International class 1/1016																																																																																																																																																																																																																																																																																																	
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300.0$	$\pm 500.0$	$\pm 800.0$	$\pm 1200.0$	$\pm 2000.0$	$\pm 3000.0$	$\pm 5000.0$	$\pm 8000.0$	$\pm 12000.0$	$\pm 200.0$	$\pm 300.0$	$\pm 50000000000000000000$

 <b>TML</b> <b>Drivelines</b> TML DRIVELINES LIMITED	Orig/Part Description INFO DRAWING REAR AXLE ASSEMBLY (SEC-135X150X14 : TRACK-1814)	Supplier Name and Orig/Part No. 7700 3900 01 16 Sheet No. 1 of 1 Sheets
	Orig/Part No.	Date