

## TAPERED ROLLER BEARING ADJUSTMENT PROCEDURE RP-618

**Step 1:** Lubricate the tapered roller bearing with clean axle lubricant of the same type used in the axle sump or hub assembly.

NOTE: Never use an impact wrench when tightening or loosening lug nuts or bolts during the procedure.

INITIAL ADJUSTING NUT TORQUE	INITIAL BACK OFF	FINAL ADJUSTING NUT TORQUE	BACK OFF		FINAL BACK OFF	JAM NUT TORQUE		ACCEPTABLE END PLAY
			AXLE TYPE	THREADS PER INCH		NUT SIZE	TORQUE SPECIFICATIONS	
STEP 2	STEP 3	STEP 4	STEP 5		STEP 6	STEP 7		STEP 8
200 lbf•ft (271N•m) While Rotating Wheel	One Full Turn	50 lbf•ft (68 N•m) While Rotating Wheels	Steer (Front) Non-Drive	12	1/6 Turn *	Install Cotter Pin to Lock Axle Nut in Position		0.001" - 0.005" (.025 - .127 mm)  As Measured Per Procedure With Dial Indicator
				18	1/4 Turn *			
				14	1/2 Turn *	Less Than 2 5/8" (66.7 mm)	200-300 lbf•ft (271-407N•m)	
				18				
			Drive	12	1/4 Turn *	Dowel Type Washer	300-400 lbf•ft (407-542 N•m)	
				16		Tang Type Washer **	200-275 lbf•ft (271-373 N•m)	
			Trailer	12	1/4 Turn *	Less Than 2 5/8" (66.7mm)	300-400 lbf•ft (407-542 N•m)	
				16				

\* If dowel pin and washer (or washer tang and nut flat) are not aligned, remove the washer, turn it over and reinstall. If required, loosen the inner (adjusting) nut just enough for alignment.

\*\* Bendable type washer lock only: Secure nuts by bending one wheel nut washer tang over the inner and outer nut. Bend the tangs over the closest flat perpendicular to the tang.