WHEEL BEARING ADJUSTMENT PROCEDURE

Double Nut System

For Manually Adjusted Hubs (with No Spacer or Crush Sleeve)

STEP 1	STEP 2	STEP 3	STEP 4			STEP 5		STEP 6
Initial Torque	Initial Back Off	Final Adjusting Torque	Final Back Off			Torque Outer Jam Nut		Check End-Play with Dial Indicator
			Axle Type	Threads Per Inch	Back Off	Nut	Torque	
200 ft. lbs. while rotating the wheel	One Full Turn	50 ft. lbs. while rotating the wheel	Steer	12	1/6 with cotter pin	Install Cotter Pin to Lock Nut Into Position		0.001”-0.005”
				18	1/4 with cotter pin			
				12	1/3	Less Than 2-5/8	250 ft. lbs.	
				14	1/2			
				18	1/2			
			Drive	12	1/4	Dowel Type Washer	350 ft. lbs.	
				16	1/4	Tang Type Washer	250 ft. lbs.	
			Trailer	12	1/4	2-5/8 and over	300 ft. lbs.	
				16	1/4			

- If dowel pin and washer are not aligned, remove the washer, turn it over, and reinstall. If required, loosen the inner adjusting nut just enough for alignment.
- Bendable Tang 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.

Single Nut System

For Manually Adjusted Hubs (with No Spacer or Crush Sleeve)

STEP 1	STEP 2	STEP 3	STEP 4			STEP 5	STEP 6
Initial Torque	Initial Back Off	Final Adjusting Torque	Final Back Off			Check End-Play with Dial Indicator	If the single locking nut has a clip, insert it at this time. Make sure that the tab on the clip goes into the keyway of the spindle as well as underneath the lip of the nut. Then use a flathead screwdriver to insert each leg into place.
			Axle Type	Threads Per Inch	Back Off		
200 ft. lbs. while rotating the wheel	One Full Turn	100 ft. lbs. while rotating the wheel	Steer	12	1/4	0.001”-0.005”	
				18	1/3		
			Drive	12	1/8		
				16	N/A		
			Trailer	12 TP Straight Spindle	1/8		
				16 TN Tapered Spindle	1/4		

Hubs Containing a Spacer or Crush Sleeve

With hubs containing a spacer or crush sleeve, there is generally one single torque with no back-off. However, the amount of this torque can vary depending on the manufacturer or the type of spacer or crush sleeve. For this reason, RevHD strongly recommends you check with the manufacturer of the spacer or crush sleeve for the specific torque requirements of each system.