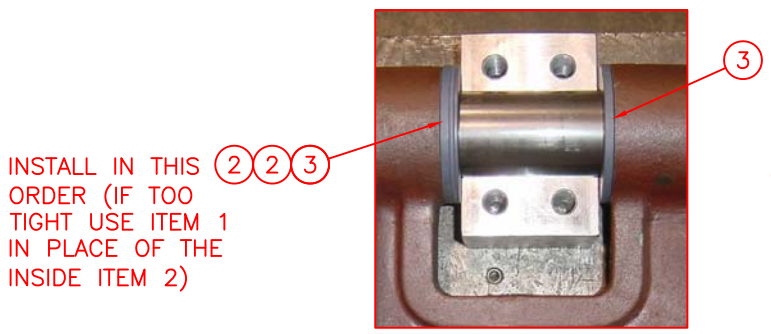
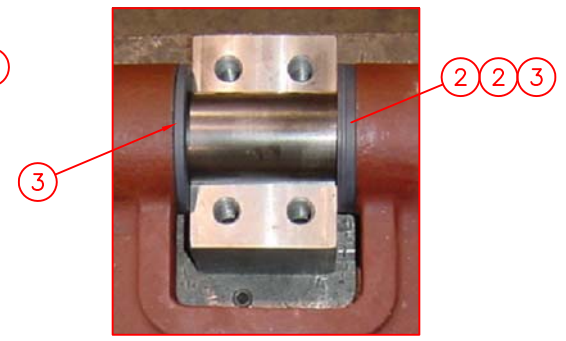
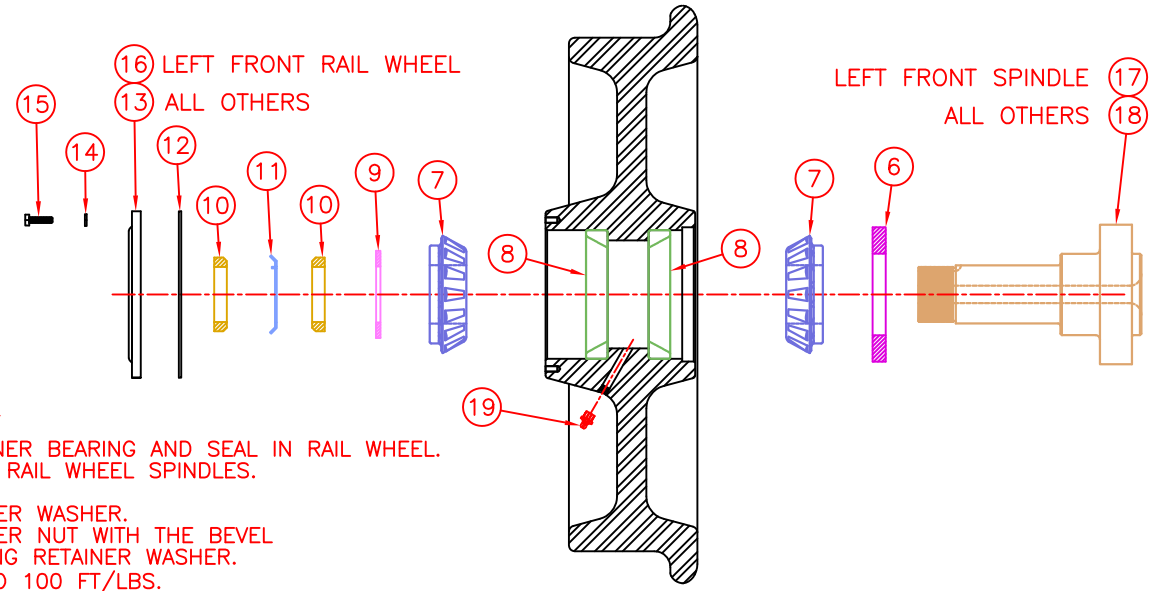
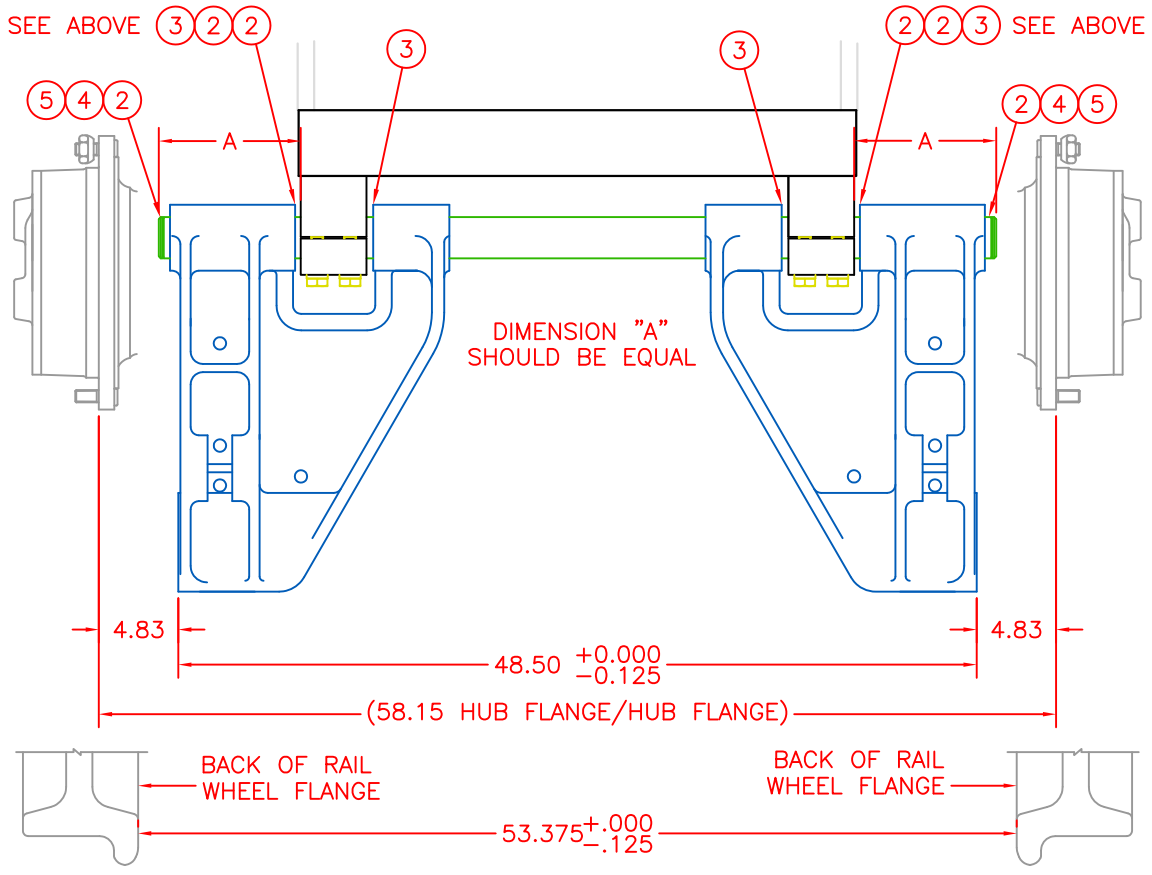
REV	E.C.O.	DESCRIPTION	BY	DATE
A	–	RELEASED TO PRODUCTION	SH	3/1/2010





INSTALL IN THIS ORDER (IF TOO TIGHT USE ITEM 1 IN PLACE OF THE INSIDE ITEM 2)



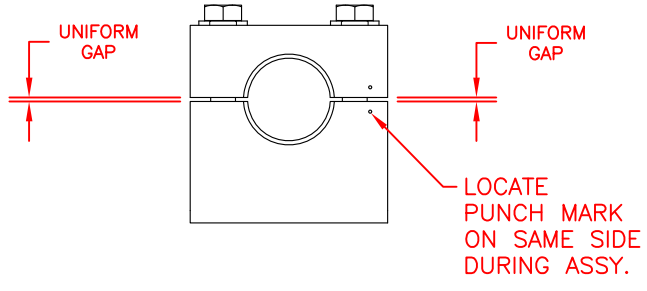


INSTALLATION INSTRUCTIONS:

1. GREASE AND INSTALL INNER BEARING AND SEAL IN RAIL WHEEL.
2. INSTALL RAIL WHEEL ON RAIL WHEEL SPINDLES.
3. INSTALL OUTER BEARING.
4. INSTALL BEARING RETAINER WASHER.
5. INSTALL BEARING RETAINER NUT WITH THE BEVEL AWAY FROM THE BEARING RETAINER WASHER.
6. TORQUE BEARING NUT TO 100 FT/LBS.
7. SPIN RAIL WHEEL IN BOTH DIRECTIONS. LOOSEN BEARING RETAINER NUT AND RE–TORQUE TO 50 FT/LBS.
8. SPIN RAIL WHEEL A FEW MORE TIMES AND CHECK BEARING RETAINER NUT TO SEE IF IT IS STILL AT 50 FT/LBS
9. INSTALL BEARING RETAINER LOCK WASHER WITH THE TANGS FACING AWAY FROM THE INNER BEARING RETAINER NUT.
10. INSTALL THE SECOND BEARING RETAINER NUT WITH BEVEL TOWARD THE BEARING RETAINER LOCKWASHER.
11. TIGHTEN NUT TO HOLD RETAINER LOCK WASHER AGAINST INNER NUT.
12. BEND LOCK WASHER TANG INTO INNER BEARING NUT SLOT.
13. TORQUE OUTSIDE BEARING RETAINER NUT TO 35 FT/LBS.
15. CONTINUE TO TIGHTEN OUTSIDE BEARING NUT UNTIL BEARING RETAINER LOCKWASHER TANG ALIGNS WITH SLOT ON OUTSIDE BEARING NUT. (DO NOT EXCEED 50 FT/LBS)
16. GREASE RAIL WHEEL CONES THROUGH GREASE ZERK ON RAIL WHEEL UNTIL GREASE PROJECTS THROUGH OUTER BEARING CONE.
17 INSTALL HUB CAP GASKET AND HUB CAP.

SHOP INSTALLATION:
EACH CLAMP WILL TAKE (4) 3/4–10UNC X 3 1/2" LONG GRADE 9 BOLTS AND (4) 3/4 GRADE 9 FLAT WASHERS. OIL LUBRICATE BOLTS. EVENLY TIGHTEN EACH BOLT TO SURFACE OF CLAMP BLOCK. MAKE SURE CLAMP BLOCK RESTS EVENLY ON PIVOT SHAFT. HOLD A UNIFORM GAP AROUND THE PERIMETER OF THE BLOCK AS SHOWN. TORQUE TO 60 FT/LBS. MARK BOLT POSITION. CONTINUE TO TIGHTEN AN ADDITIONAL 1/4 TURN PAST MARKED POSITION.

FIELD INSTALLATION:
EACH CLAMP WILL TAKE (4) 3/4–10UNC X 3 1/2" LONG GRADE 9 BOLTS AND (4) 3/4 GRADE 9 FLAT WASHERS. OIL LUBRICATE BOLTS. HAND TIGHTEN EACH BOLT TO SURFACE OF CLAMP BLOCK. MAKE SURE CLAMP BLOCK RESTS EVENLY ON PIVOT SHAFT. HOLD A UNIFORM GAP AROUND THE PERIMETER OF THE BLOCK AS SHOWN. MARK BOLT POSITION. CONTINUE TO TIGHTEN AND ADDITIONAL 1/2 TURN PAST MARKED POSITON.



(QUANTITIES IN THIS B.O.M ARE FOR THE ENTIRE TRUCK)

ITEM	QTY.	PART NO.	DWG. SIZE	AMOUNT	UNITS	DESCRIPTION
19	4	300–032250	SP	–	EA	FITTING – GREASE SPECIAL
18	3	717–049524	B	–	EA	SPINDLE – RAIL WHEEL W/O ENCODER
17	1	717–082481	B	–	EA	SPINDLE – RAIL WHEEL W/ ENCODER
16	A	402–046583	B	–	EA	CAP – HUB (ENCODER)
15	12	105–100380	SP	–	EA	BOLT – HHCS 1/4–20UNC X 3/4
14	12	861–100634	SP	–	EA	WASHER – FLAT 1/4"
13	3	160–032303	B	–	EA	CAP – HUB
12	3	324–032803	SP	–	EA	GASKET – HUB CAP
11	4	867–032246	SP	–	EA	LOCKWASHER – BEARING RETAINER
10	8	522–032245	SP	–	EA	NUT – BEARING RETAINER
9	4	861–032244	SP	–	EA	WASHER – BEARING RETAINER
8	8	608–032243	SP	–	EA	BEARING – CUP
7	8	072–032242	SP	–	EA	BEARING – CONE
6	4	659–032247	SP	–	EA	SEAL – INNER BEARING
5	4	635–032302	SP	–	EA	RING – RETAINING
4	4	861–032817	SP	–	EA	WASHER – SPACER 2.50 ID X 3.87 OD
3	8	861–048063	A	–	EA	WASHER – NYLON SHIM (1/4")
2	12	861–032304	A	–	EA	WASHER – NYLON SHIM (1/8")
1	4	861–037660	A	–	EA	WASHER – NYLON SHIM (1/16")

PAINT: NA

TOLERANCES UNLESS OTHERWISE SPECIFIED:

1 PLACE DECIMAL	±0.1
2 PLACE DECIMAL	±0.06
3 PLACE DECIMAL	±0.030
4 PLACE DECIMAL	±0.0050
METRIC (mm)	±1
FRACTIONAL	±1/32
ANGULAR	±1°

NOTE: ALL CHANGES MUST BE MADE ON CAD. ALL UNITS ARE INCHES UNLESS OTHERWISE SPECIFIED.

NOTICE: All Information is confidential and proprietary to Central Manufacturing. Any person accepting is required to accept this information in confidence and agrees to make no disclosures or use thereof except as authorized by Central Manufacturing.

WEIGHT: NA

CATEGORY: SW

SHUTTLEWAGON
4116 Dr. Greaves Road, P.O. Box 777
Grandview, MO 64030
PH: 816-767-0300 FAX: 816-763-0705

TITLE: SERVICE – RAIL ARMS & WHEELS (315/420)

DWG. SIZE:	DRAWN BY:	APPROVED BY:	DWG. NO.	REV. NO.
B	SH	SH	662 – 083258	A
	SCALE: NONE	DATE: 03/01/2010	SHT. 1 OF 1	