

# Webb Torque Specification Guidelines

The following publication is a guide to help you understand and maintain proper torque specifications for the maintenance of your wheel and hub assembly. If additional information is needed, please refer to the TMC Recommended Practices: 217D, 222C, 237A, 656, and 662.

## Hub Piloted with Flange Nut (8 & 10 Stud Hubs)

Applied M22 1.5 and 1.75 - Torque Specifications - Recommended Torque: 450 - 500 ft-lb

**Step 1.** Place a drum on the 12:00 o'clock position. A 1/2" of 30 degree oil be seen between the drum and the hub flange, and do not use more than 2-3 heads of the heel rod. For the 10 stud hubs, a 1/2" of oil be seen between the drum and the hub flange. **Note:** A ridge on the hub can be the main cause of the hub flange, drum flange, disc heel mounting flange area.

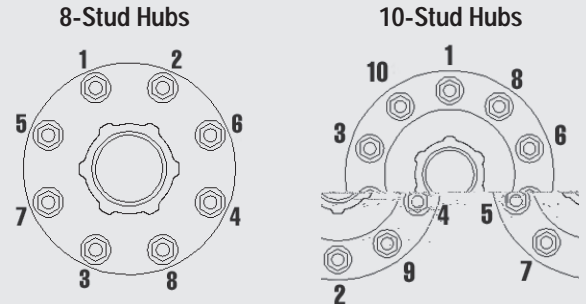
**Step 2.** Sighting in the drum, tighten all flange nuts to 50 ft-lb of torque to ensure proper alignment.

**Step 3.** Tighten all flange nuts to the recommended torque of 450-500 ft-lb of torque to ensure proper alignment.

**Step 4.** Check all disc heel for proper seating in the hub and reseat if necessary.

Recheck torque at 50, 100 mile intervals. Refer to TMC RP 237A, Tire Checking Guidelines For Disc Wheel, for individual tire maintenance details.

### Tightening Sequence



## Stud Piloted with Double Cap Nuts (6 & 10 Stud Hubs)

Applied 3/4-16 and 1 1/8-16 fasteners - Recommended Torque: 450 - 500 ft-lb

### Inner Cap Nuts

**Step 1.** Place a drum on the 12:00 o'clock position. For the 10 stud hubs, a 1/2" of oil be seen between the drum and the hub flange. **Note:** A ridge on the hub can be the main cause of the hub flange, drum flange, disc heel mounting flange area. Sighting in the drum, tighten all inner cap nuts to 50 ft-lb of torque to ensure proper alignment.

**Step 2.** Tighten all inner cap nuts to the recommended torque of 450 - 500 ft-lb, and sight in the drum to ensure proper alignment.

### Outer Cap Nuts

**Step 1.** Place a drum on the 12:00 o'clock position. Then, sighting in the drum, tighten all outer cap nuts to 50 ft-lb of torque to ensure proper alignment.

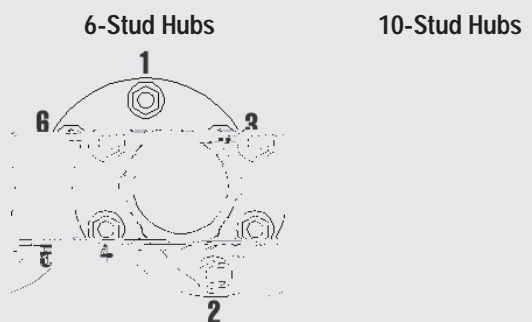
**Step 2.** Tighten all outer cap nuts to the recommended torque of 450 - 500 ft-lb of torque to ensure proper alignment.

**Step 3.** Check disc heel for proper seating in the hub and reseat if necessary.

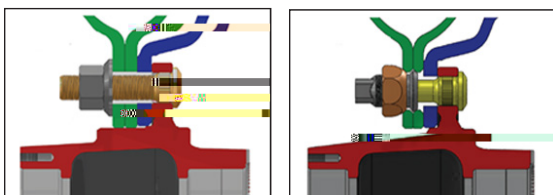
Recheck torque at 50, 100 mile intervals. Refer to TMC RP 237A, Tire Checking Guidelines For Disc Wheel, for individual tire maintenance details.

NOTE: In all applications, the minimum disc heel bearing allowance shall be maintained.

### Tightening Sequence



## Mount Identification



FN Mount (Flange Nut)

BSN Mount (Ball Seat Nut)

[www.webbwheel.com](http://www.webbwheel.com)

Contact your local Webb Wheel Products supplier for training that can cut your operating costs!

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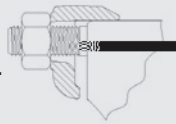
The effective publication is available in all applicable and maintenance facilities while maintaining inventory of maintenance facilities. If additional maintenance facilities are needed, please refer to TMC Recommended Practices: 217D, 222C, 237A, 656, and 662.

## 3, 5 and 6 Spoke Wheels

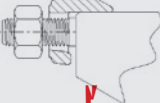
Recommended Speed: 200 - 260 ft-lb (Apply 10% faster if needed)

Tighten clamps evenly in the sequence shown at right.

**Heel-Less Clamps:** Do not exceed the amount of the clamp force the center edge of the heel. Heel clamp does not touch heel.



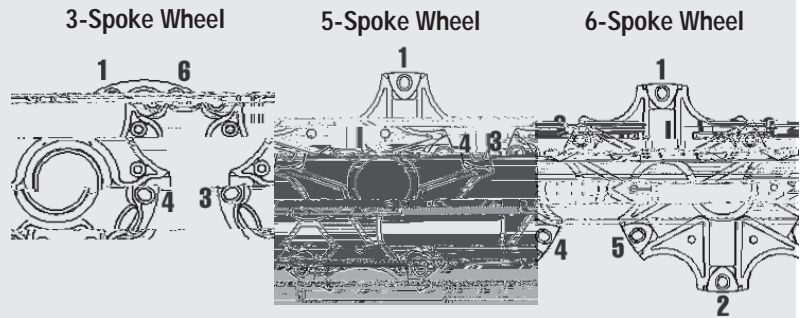
**Heel-Type Clamps:** Gauge is available but is required. If gauge reads 1/4", if clamp bottom is before eaching 80% of recommended value, check if the heel of the clamp and force are being applied.



Recheck wheel after 50 - 100 miles of service if necessary. Refer to TMC RP 237A, Tire Checking Guidelines For Disc Wheel, for individual fleet maintenance schedule.

**IMPORTANT:** Do not over-tighten! Rim clamp does not have heel. Over-tightening can deform rim and damage back fange.

### Tightening Sequence



## Drive Studs and Hub Cap Bolt Torque

### Recommended Dry Torque Values

Description	Thread Size	Torque Requirements ft-lbs Min/Max
Drive Stud / Washer Washer	1/2 - 20	80/90
	5/8 - 18	175/185
	3/4 - 16	250/275

## Bolt-On ABS Ring

### Recommended Dry Torque Values

Description	Thread Size	Torque Requirements ft-lbs Min/Max
Steel Bolt-On ABS Ring	# 8 - 32	15/20

## Brake Drum or Rotor Assembly Torque Requirements

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