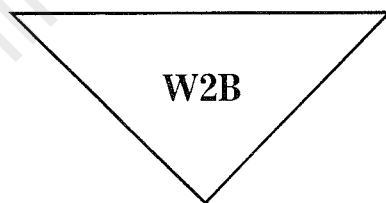


TORQUE-HUB[®]

Final Drives

ASSEMBLY-DISASSEMBLY MANUAL

FOR THE



UNIT

Fairfield Manufacturing Company Inc.

INTRODUCTION

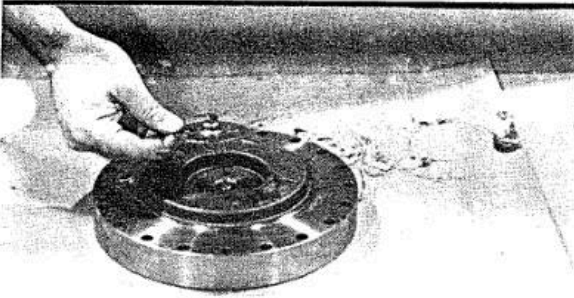
This manual is a step-by-step guide to assembly and disassembly of torque-hub units. It is designed for the customer or shop mechanic who is repairing a particular model of torque-hub final drive. Users of this manual should note that each part mentioned is followed by an identification number enclosed in parentheses. These part numbers may be referred to in the Parts List section of this manual and on the cross-sectional view of this unit. A print of each tool discussed in this manual is shown in the Tooling section. Users should familiarize themselves with the procedures for roll and leak testing and bolt tightening and torquing found on the following two pages before getting started.

This manual includes the following sections.

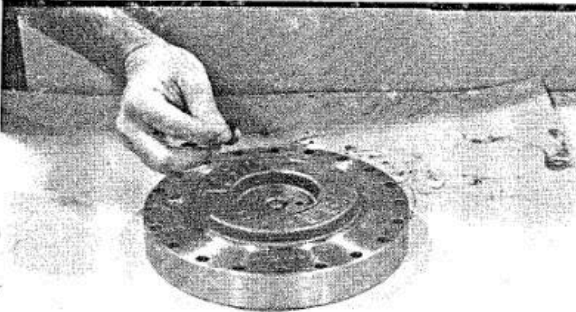
1. Roll and Leak Testing Procedures
2. Bolt Tightening and Torquing Procedures
3. Disassembly Procedures
4. Sub-Assembly Procedures
5. Main Assembly Procedure
6. Drawings of all Essential Tools
7. Parts List
8. Cross-Sectional View of the Unit

SAFETY

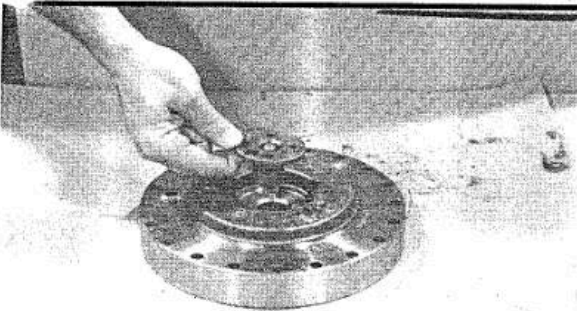
Standard safety practices should be followed during the disassembly and assembly procedures described. Safety glasses and safety shoes should be worn. Heavy, heat resistant gloves should be used when heated components are handled. Be especially alert when you see the word CAUTION. This indicates that a particular operation could cause personal injury if not performed properly or if certain safety procedures are not followed.



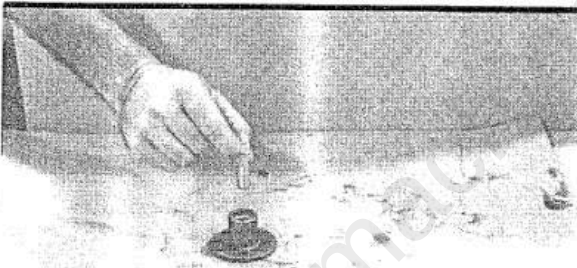
5. Remove disconnect cap(6D) from cover(6A).



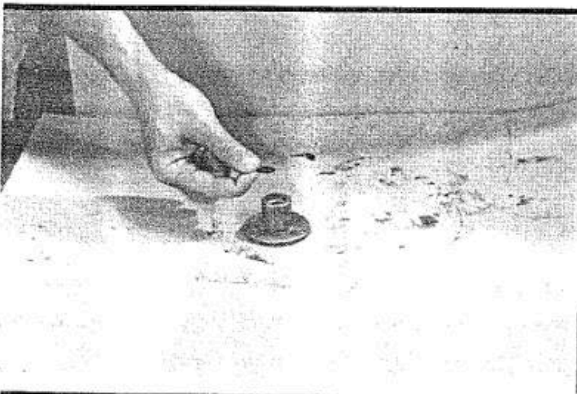
6. Remove the two remaining bolts(6C) that hold cover cap(6B) in place.



7. Remove cover cap(6B) from cover(6A).

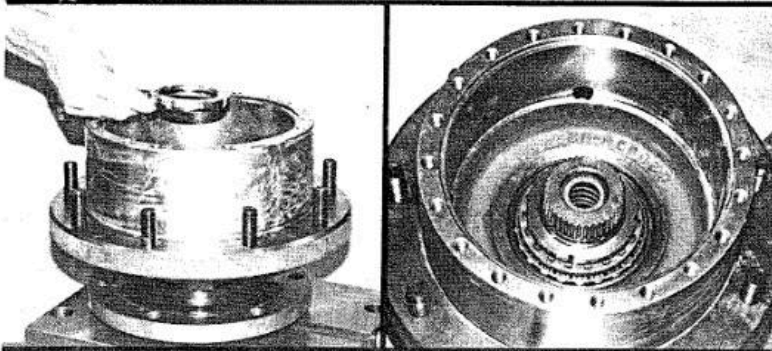


8. Remove disconnect rod(6E) from cover cap(6B).

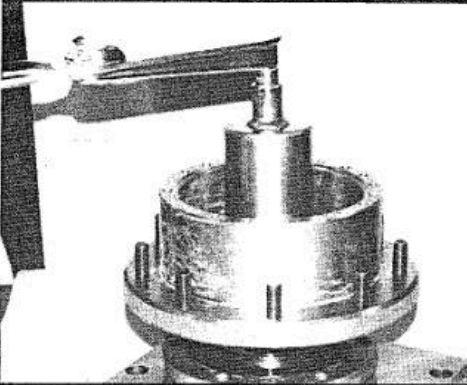


9. Remove "O" ring(6F) from the groove around the inside of cover cap(6B).

NOTE: Loctite 277 is an anaerobic adhesive. Once it has been removed from contact with the air, it sets. Therefore, once the locknut has been placed on the spindle it must be tightened and torqued immediately or the adhesive will make it difficult to turn.

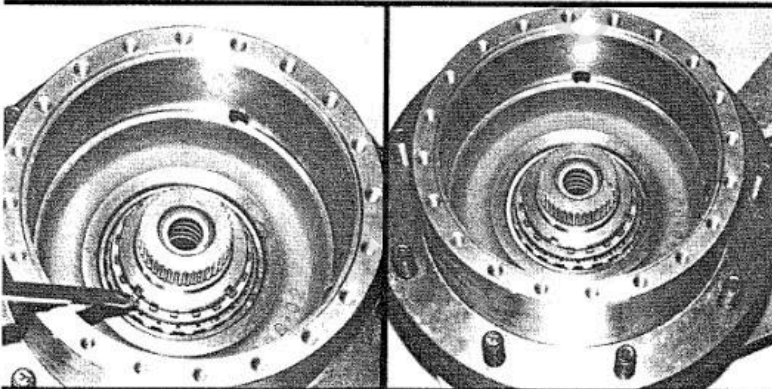


20. Place **locknut(1J)** onto **spindle(1A)**. Use an N-12 locknut wrench (tool no. T-136699) to tighten the locknut.

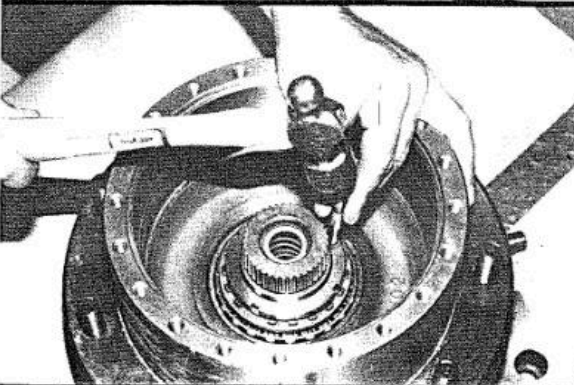


21. Using a torque wrench, apply 50 ft.-lbs. of torque to **locknut(1J)** then rotate the hub in both clockwise and counterclockwise directions. Repeat the procedure in this step two more times.

NOTE: One tang on **lockwasher(1J)** must line up with one notch on **locknut(1J)**. If this is not the case, apply sufficient increased torque until one tang and notch are aligned. Never loosen the locknut.



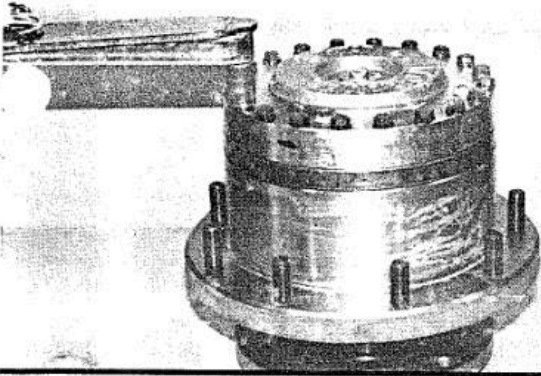
22. Bend the aligned tang on **lockwasher(1J)** up into the notch on **locknut(1J)**.



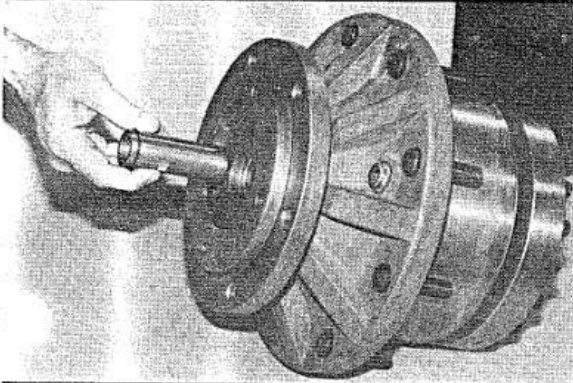
23. Using a center punch and hammer, stake **locknut(1J)** at four equally spaced points at a distance of 1/8 in. from the inside edge of the locknut.

24. At this point the hub-spindle sub-assembly is complete.

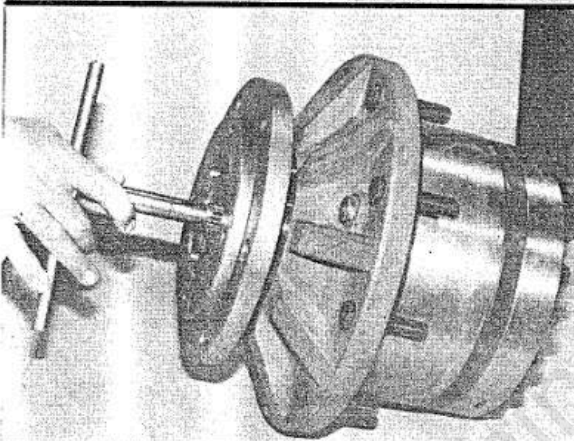
20. Apply 34-45 ft.-lbs. of torque to each bolt(12).



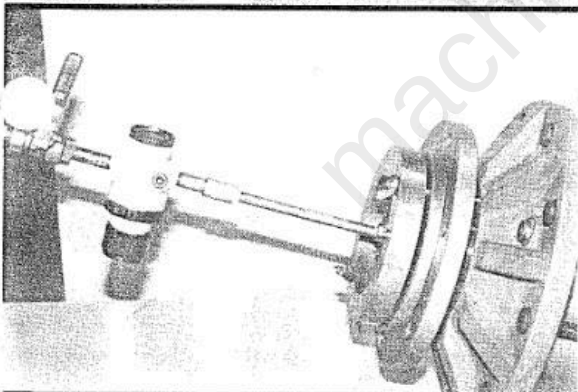
21. Set the unit on its side and insert coupling sub-assembly(19) into the counterbore of spindle(1A).



22. Roll test the unit in both clockwise and counterclockwise directions. Perform the same number of turns in each direction as the ratio of the unit. The ratio number is the same as the last two digits in the model number found on the ID tag of the unit.



23. Leak test the unit at a pressure of 5 psi for 2-3 minutes.



24. At this point the main assembly is complete.

Full Version Available

Fairfield W2B Axle Service Manual

Fairfield W2B axle service manual with disassembly, assembly, torquing and leak testing procedures for Torque-Hub final drives. Instant PDF download.

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