



## **WHEEL BOLT REMOVAL AND INSTALLATION PROCEDURES** **(Round Head Serrated Shank)**

### **REMOVAL:**

**Note: Use of hammers to remove/install wheel bolts is not recommended.**

When replacing wheel bolts in outboard mount hubs remove the hub from the axle to prevent damage to wheel end assembly components. Once the hub is removed from the axle, use a press to remove/replace wheel bolt. Be sure to support the hub flange evenly around and adjacent to the wheel bolt being serviced in order to avoid bending in the flange area. Care must be taken so as to avoid damaging the ABS ring, seal bore diameter, and hub flange while replacing wheel bolts.

Specialty tools are available commercially that are designed for servicing wheel bolts and may also allow wheel bolts to be serviced while hub is on the axle. When using these specialty tools be sure to use caution so that damage does not occur on either side of the hub flange.

### **INSTALLATION:**

Thoroughly inspect hub flange for any damage, clean wheel bolt hole on hub to remove any debris or foreign material. Inspect the bolt hole for damage that may affect the press-fit between the hole and new wheel bolt. Install wheel bolts using a press while supporting the hub flange evenly around. After installing new wheel bolts use a feeler gage under the head of the bolt to ensure bolt is fully seated. Stud is not seated if gap under head is greater than .002".

### **CAUTION:**

- 1. Do not install wheel bolts using hammers. This can cause bending of the head of the bolt in which the bolt will not seat properly, eventually leading to a failure. Wheel bolts must be installed using a press.**
- 2. Do not attempt to pull the wheel bolt into place during assembly using the impact wrench. This can damage the hub, cause elongation of the wheel bolt or damage to the threaded surface of the wheel bolt.**
- 3. If a damaged wheel bolt is found, it must be replaced immediately along with the wheel bolt on either side of the damaged wheel bolt. If more than one damaged wheel bolt is found, replace ALL of the wheel bolts immediately.**