

The purpose of this bulletin is to assist users in converting from hubs with “pre-adjusted” bearings to hubs with “conventional” bearings. Customers can easily convert to a conventional style hub by simply installing a Webb conventional hub and manually adjusting the bearings per TMC RP 618 “Wheel Bearing Adjustment Procedures.” It is critical to follow the procedures outlined below to ensure optimal wheel-end performance. If additional information is required, please refer to TMC Recommended Practice 618 or contact Webb Wheel Products.

Webb Hubs

- Converting a pre-adjusted hub to a conventional hub is easy. Simply install a Webb conventional hub and follow the procedures outlined below to manually adjust the bearings.
- Do **NOT** install bearing spacers in Webb conventional hubs.

Bearing Adjustment for Conventional Hubs – TMC RP 618

Step 1 Lubricate the bearings with clean axle lubricant of the same type used in the bearing assembly

Step 2 After the wheel hub and bearings are assembled on the axle, torque the inner nut to 200 ft-lbs while rotating the wheel assembly.

Step 3 Back off the inner nut one full turn, and then rotate the wheel.

Step 4 Re-torque the inner nut to 50 ft-lbs while rotating the wheel hub assembly.

Step 5 Back off inner nut. See Table 1 for proper back-off amount.

Step 6 Install locking washer.

Step 7 Install and torque the outer jam nut. See Table 1 for proper torque specifications.

Step 8 Attach a dial indicator to the hub and verify end play. End play should read between .001”-.005.” End play is the free movement of the tire and wheel assembly along the spindle axis. NOTE: If end play is not within specification, readjustment is required.

Table 1

The chart below details proper service procedures for D-type, bendable-type, and dowel-type spindle nut washers.

Final Back Off Amount			Jam Nut Torque	
Axle	Threads Per Inch	Final Back Off	Nut Size	Torque Specifications
STEER (Single Nut)	12	1/6 Turn*	Install Cotter Pin to Lock Axle Nut in Position	
	18	1/4 Turn*		
STEER (Double Nut)	12	1/3 Turn	Less Than 2-5/8"	200-300 ft-lb
	14	1/2 Turn		
	18			
DRIVE	12	1/4 Turn	Dowel Type Washer	300-400 ft-lb
	16		Tang Type Washer**	200-275 ft-lb
TRAILER	12	1/4 Turn	2-5/8" and over	200-300 ft-lb
	16			

Important Note:

Not all single nut self-locking systems can be used with manually adjusted bearings. Webb recommends you consult the spindle nut manufacturer’s instructions before installation.

If you have any questions about this bulletin, please contact Webb Engineering: engineering@webbwheel.com.

*If dowel pin and washer (or tang and nut flat) are not aligned, remove the washer, turn it over, and reinstall. If required, loosen the inner adjusting nut just enough for alignment

**Bendable 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.



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