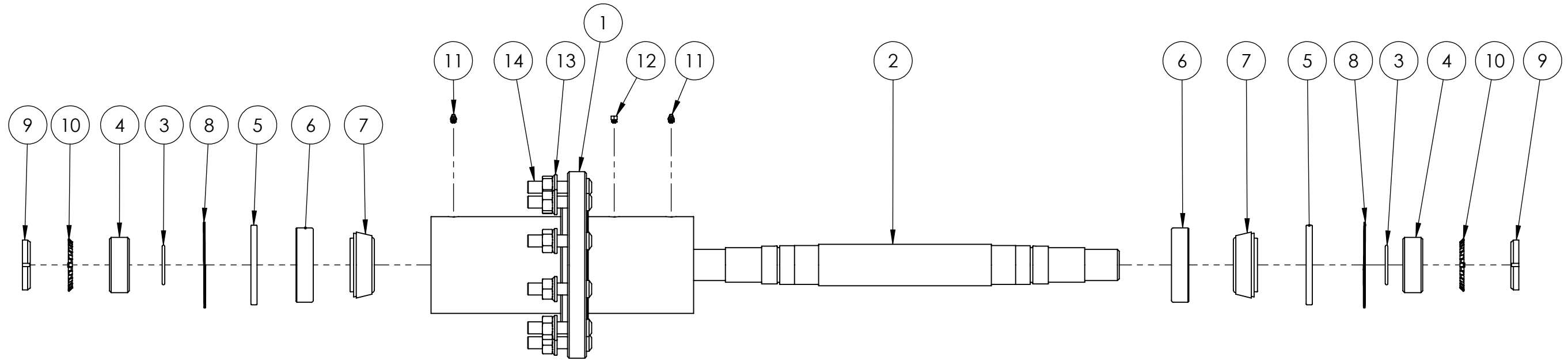


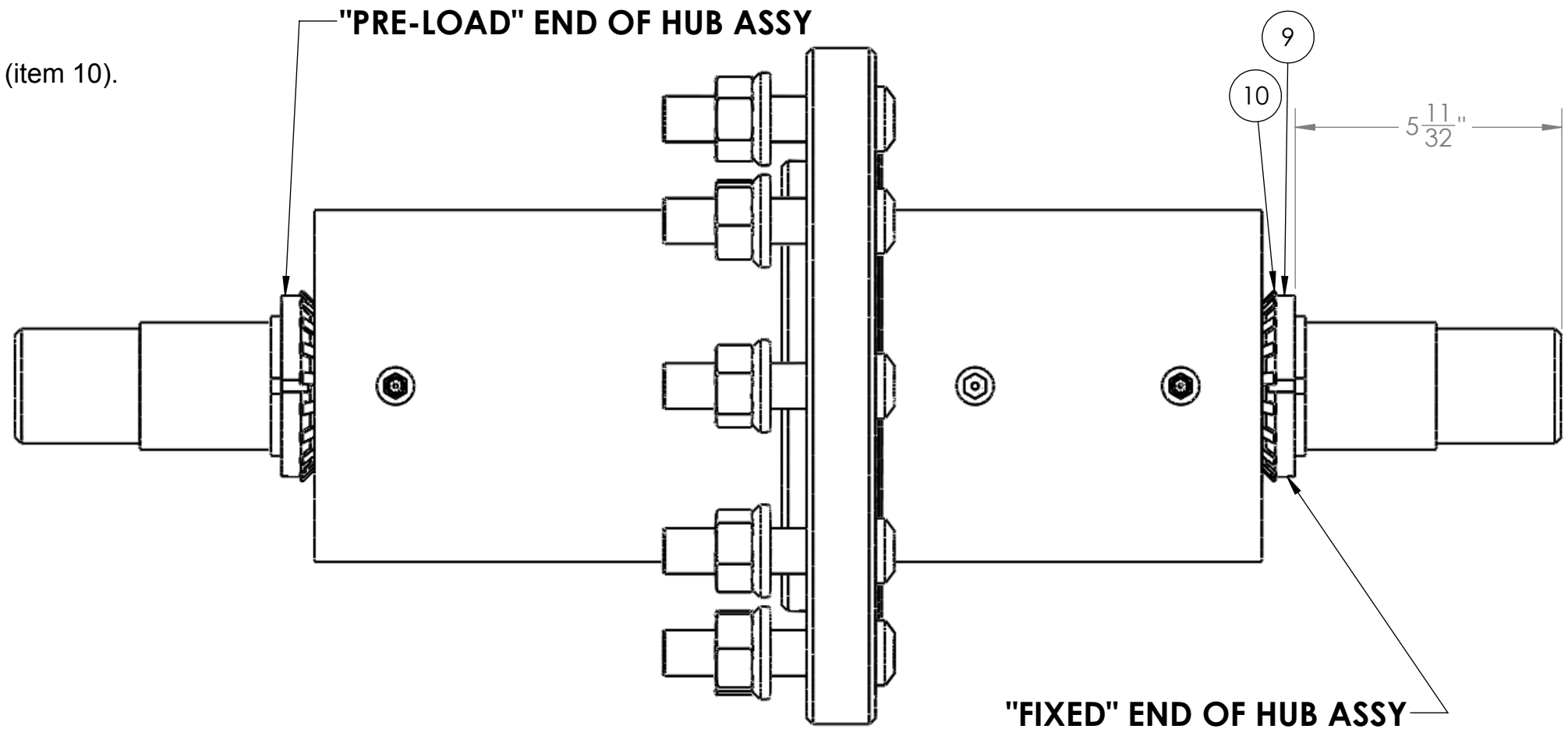
| ITEM NO. | PART NUMBER | Default/ QTY. |
|----------|-------------|---------------|
| 1 | 500278 | 1 |
| 2 | 500138 | 1 |
| 3 | A130H13 | 2 |
| 4 | 500140 | 2 |
| 5 | A125214 | 2 |
| 6 | A14014 | 2 |
| 7 | A14015 | 2 |
| 8 | A125204 | 2 |
| 9 | A125202 | 2 |
| 10 | A125203 | 2 |
| 11 | 14505 | 2 |
| 12 | A125466 | 1 |
| 13 | A125156 | 10 |
| 14 | A125236 | 10 |



| | | | | | |
|--|---|-------------------------------------|------|--|----------|
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| DIMENSIONS ARE IN INCHES | | DRAWN | | TITLE: CS18 HUB ASSY | |
| TOLERANCES: | | CHECKED | | | |
| FRACTIONAL $\pm 1/64$ | | | | SIZE | DWG. NO. |
| ANGULAR: MACH $\pm 1^\circ$ | | | | B | 600024 |
| BEND $\pm 3^\circ$ | | | | REV | B |
| TWO PLACE DECIMAL $\pm .010$ | | | | SCALE: 1:8 WEIGHT: 215.08 SHEET 3 OF 3 | |
| THREE PLACE DECIMAL $\pm .005$ | | | | | |
| NOTE: BREAK ALL SHARP EDGES & CORNERS | | PROPRIETARY AND CONFIDENTIAL | | | |
| MATERIAL | THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF ASHLAND INDUSTRIES, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF ASHLAND INDUSTRIES, INC. IS PROHIBITED. | | | | |
| FINISH | | | | | |
| DO NOT SCALE DRAWING | | | | | |

Hub/Axle Disassembly:

- 1.) **Disengage** lock tab on "pre-load" side of axle lockwasher (item 10).
- 2.) **Remove** axle locknut (item 9) & lockwasher (item 10).
- 3.) **Remove** seal retaining rings (item 8, x2).
- 4.) **Remove** hub seals (item 5, x2).
- 5.) **Remove** axle (item 2) out "fixed" end of hub.
- 6.) **Remove** bearing spacers (item 4, x2).
- 7.) **Remove** bearing cones (item 7, x2).
- 8.) **Remove** o-rings from axle (item 3, x2).



Hub/Axle Preparation:

- 1.) **Remove** old lubricant and thoroughly clean axle.
- 2.) **Inspect** machined axle seal surface for nicks, scratches, burrs or marks. If needed, use crocus cloth or emery cloth to repair any damaged areas.
- 3.) **Clean** axle threads and keyways thoroughly with a wire brush to avoid false bearing adjustments and to avoid introduction of contaminants into the lubricant cavity.
- 4.) **Thoroughly clean** axle machined surfaces of rust, dirt, grease or any contaminants that could damage the hub seal and cause it to leak.
- 5.) **Thoroughly clean** the hub bore of any dirt, grease, rust or any other substance that may be present.
- 6.) **Remove** all sharp edges, nicks and burrs from seal bore, hubcap bore and hubcap mounting surface of the hub.
- 7.) **Inspect** hub seal bore for roughness. If needed, use emery cloth to remove any burrs or old bore sealant, and wipe hub clean.
- 8.) **Inspect** bearing cups (item 6, x2) for damage/wear. **Replace** if necessary.

Axle/Hub Assembly:

- 1.) **Lubricate** bearing cones (item 7, x2).
- 2.) **Install** (1) bearing cone onto axle.
- 3.) **Install** new o-rings (item 3, x2) onto axle.
- 4.) **Install** bearing spacer against lubricated bearing.
- 5.) **Install** (1) lock washer against bearing spacer with internal tab positioned in keyway of axle.
- 6.) **Install** (1) locknut. Torque to **50 ft-lb**. Bend Appropriate lockwasher tab into locknut slot.
- 7.) **Install** axle assembly into hub from "Fixed" end.
- 8.) **Repeat** steps 2-5 for parts on "Pre-Load" end of hub.
- 9.) **Install** locknut and torque as follows:
 - **Initial Torque** Locknut to **200 ft-lb**.
 - **Back off** locknut one full turn.
 - **Rotate** axle at least 5 revolutions.
 - **Torque** locknut to **50 ft-lb** while rotating axle.
 - **Back off** locknut 1/4-1/2 turn.
 - **Final Torque** locknut to **55-65 in-lb**.
- 10.) **Bend** appropriate lockwasher tab into locknut slot.
- 11.) **Lubricate** seals and install into hub.
- 12.) **Install** Retaining rings (item 8, x2).

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|--|--|--|------|--|--------------------|
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| DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ±1/64 ANGULAR: MACH ±1° BEND ±3° TWO PLACE DECIMAL ±.010 THREE PLACE DECIMAL ±.005 | | DRAWN | | TITLE: CS18 HUB ASSY | |
| NOTE: BREAK ALL SHARP EDGES & CORNERS | | CHECKED | | SIZE B | DWG. NO. 600024 |
| MATERIAL | | PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF ASHLAND INDUSTRIES, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF ASHLAND INDUSTRIES, INC. IS PROHIBITED. | | REV B | |
| FINISH | | DO NOT SCALE DRAWING | | SCALE: 3:9 | WEIGHT: 215.08 |
| | | | | SHEET 4 OF 4 | |