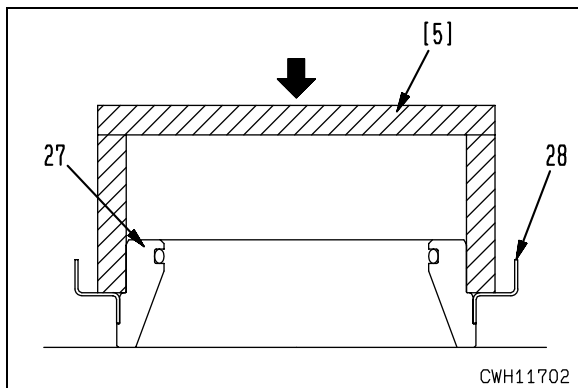


Assembly

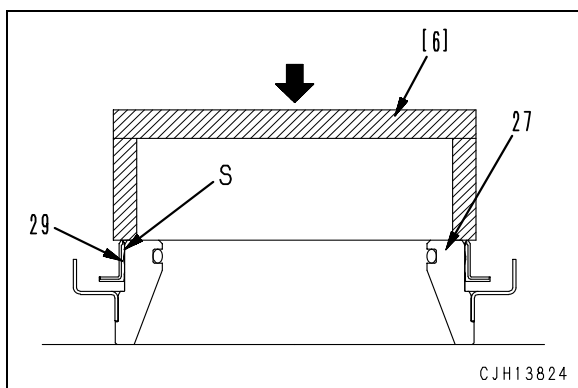
- ★ Before assembling, clean each of the parts thoroughly, then check that it is free of dust and damage and coat the sliding surface with **axle oil (AXO80)**.

1. Retainer assembly

- 1) Install protector (28) to retainer (27), using push tool [5].
 - ★ Keep press-fitting until the protector is flush with the retainer.

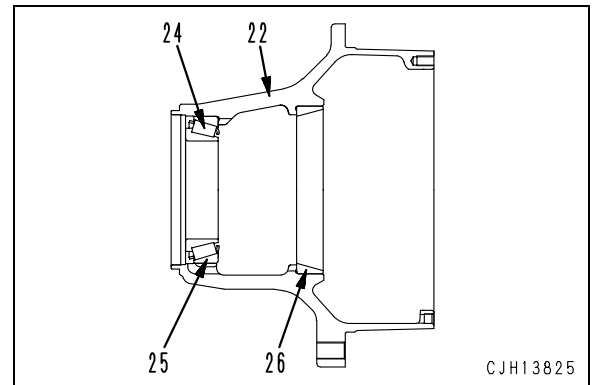


- 2) Press-fit sleeve (29) to retainer (27), using tool [6].
 - ✎ Insertion face (S) of sleeve (29)
: **Axle oil (AXO80) or LM-P**
 - ★ Keep press-fitting until the top end of the sleeve is flush with the retainer.
- 3) Install retainer (27) with an O-ring to the axle housing.

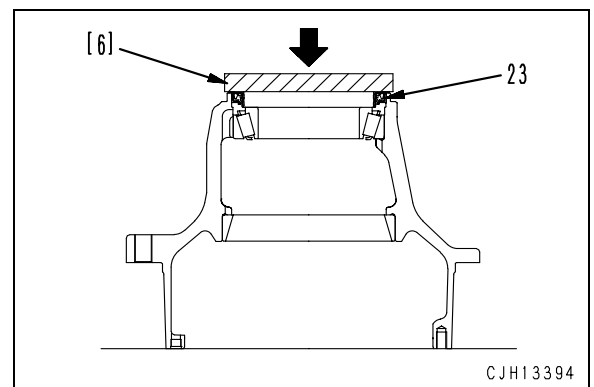


2. Wheel hub assembly

- 1) Install outer races (25) and (26) to wheel hub (22).
- 2) Assemble bearing (24) in.
 - ★ Drip **axle oil (AXO80)** on the bearing.



- 3) Press-fit oil seal (23), using push tool [6].
 - ★ Keep press-fitting until the oil seal comes into close contact with the wheel hub. (Clearance is less than **0.2 mm**)
 - ✎ Oil seal lip face and inside of oil seal (100% full): **Grease (G2-LI)**

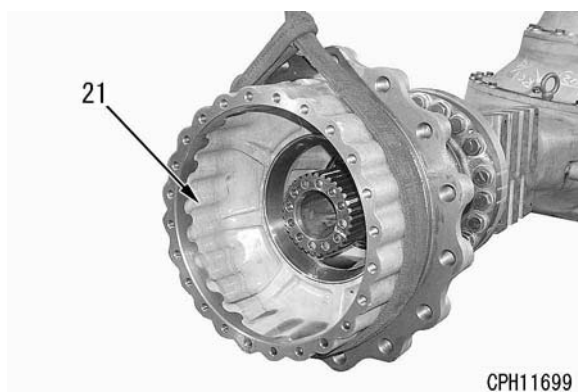
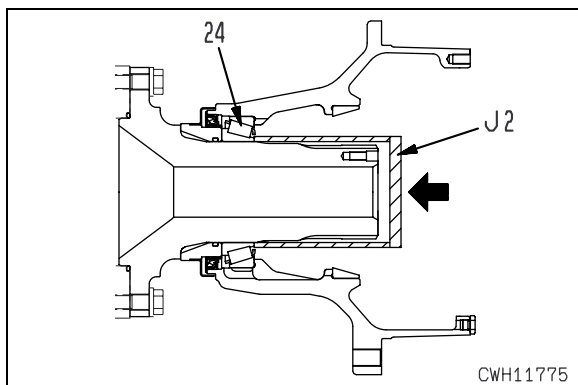


- 4) Sling wheel hub assembly (21) and install it to the axle housing.



Wheel hub assembly: **60 kg**

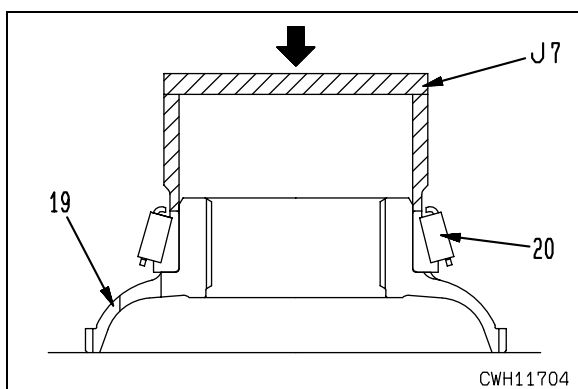
- 5) Press-fit bearing (24), using tool **J2**.



3. Subassembly of ring gear assembly

- 1) Press-fit bearing (20) into inner hub (19), using push tool **J7**.

★ Drip **axle oil (AXO80)** on the bearing after assembly.



- 2) Assemble inner hub (19) in ring gear (18) and install plate (17).



Mounting bolt

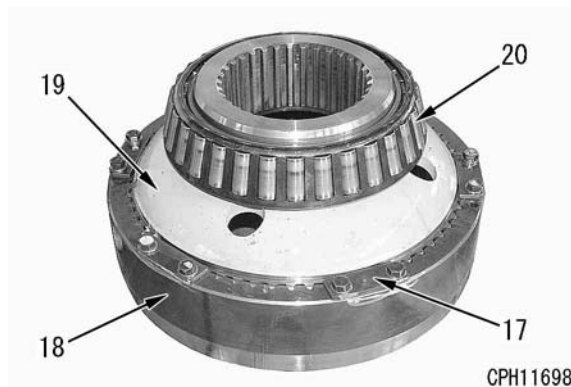
: **Liquid adhesive (LT-2)**



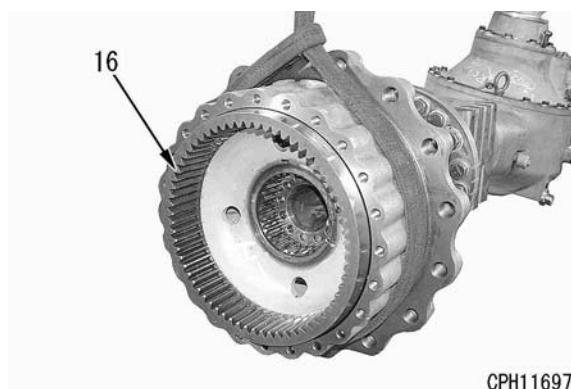
Mounting bolt

: **27.5 – 34.5 Nm {2.8 – 3.5 kgm}**

[Target value: 31 Nm {3.2 kgm}]



- 3) Install ring gear assembly (16).



4. Adjustment of pre-load on bearing

- 1) Install retainer (14) temporarily without shims being assembled in.
- 2) Tighten mounting bolt in every 2 (4 bolts in total) evenly to the specified torque of $49 \pm 4.9 \text{ Nm}$ $\{5 \pm 0.5 \text{ kgm}\}$, while wheel hub assembly (21) by 20 to 30 turns.

★ If the mounting bolts are tightened without rotating the wheel hub assembly (21), the bearing will not sit in well and no right preload is given to the bearing.

