

VOLVO

Volvo Trucks North America, Inc.

June 30, 2003

EXPRESS MAIL

Associate Administrator for Enforcement
National Highway Traffic Safety Administration
400 Seventh Street, S.W.
Washington, DC 20590

RE: NHTSA Recall Campaign Number: **03V-199**

Volvo Trucks North America, Inc., Recall Number: **RVXX0304**

Volvo Trucks North America, Inc. of Greensboro, North Carolina, per the requirements of 49 CFR Part 573.5(c)(9), herewith submits a copy of its recall bulletin and owner notice for the subject recall. Mailing of the bulletin and owner notices was started on June 25, 2003, and completed on June 30, 2003.

Very Truly Yours



Charles D. Powell
Recall Administrator

Enclosures (2)

SAFETY RECALL BULLETIN

VOLVO

**SAFETY RECALL RVXX0304
JUNE 2003**

**ATTENTION: SERVICE MANAGERS
PARTS MANAGERS**

SUBJECT: ArvinMeritor FF98x Series Unitized Steer Axle Bearings

SAFETY RECALL INFORMATION:

Volvo Trucks North America, Inc. has decided that a defect relating to motor vehicle safety exists in certain Volvo VNL and VNM model vehicles assembled with an ArvinMeritor FF98x Series Unitized Front Steer Axle.

The front steer axle wheel bearings may experience premature spalling (wear).

This condition could lead to failure of the bearing and loss of vehicle control.

VEHICLES AFFECTED:

Certain VNL and VNM model vehicles manufactured by Volvo Trucks North America, Inc. between the dates of: August 6, 1998 through December 31, 1998; April 21, 1999 through March 29, 2000; and, February 19, 2001 through March 1, 2002.

VEHICLE IDENTIFICATION NUMBERS (VIN):

There are four hundred and thirty-three (433) vehicles affected by this recall.

NOTE: To verify or determine if a particular vehicle is affected by this recall (or any other recall), you should consult the DCS, Service/Warranty screen. By entering the Vehicle Identification Number into the VEHINQ segment, the screen will display any outstanding recall.

If a "Dealer Listing" is enclosed, it identifies the vehicles that were sold or shipped to your dealership. Be sure to check the VEHINQ screen before performing the recall to verify that the recall is still open.

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SAFETY RECALL RVXX0304
JUNE 2003

INSPECTION INSTRUCTIONS:

There are no vehicle inspections required for this recall.

REPAIR:

The recall repair consists of replacing both steer axle hubs. For repair instructions see the enclosed ArvinMeritor Technical Bulletin TP-0385 Revised 5-20-03.

TIME ALLOWANCE:

Repair: - 2.5 hour per vehicle

RECALL PARTS:

Recall Kit Number:

Vehicles with short studs (steel wheels) - 85105836 one kit per vehicle

Vehicles with long studs (aluminum wheels) - 85105837 one kit per vehicle

Kit consists of two each: hub unit, o-ring, grease, hubcap w/sealant, tabbed washer, inner and outer nut and D- washer.

KIT ORDERING PROCEDURES:

NOTE: Kits for this recall will not be available from ArvinMeritor until September 2003.

Kits for this recall should be ordered after September 15, 2003 through Volvo Trucks North America, Inc. Dealer Communications System on an as required basis only. The following information is required to place an order:

1. Your dealer account number
2. Recall kit number
3. Quantity of kits
4. Order priority: VOR

The cost of the kit plus 30% dealer mark-up will have to be claimed per the guidelines identified under the heading "Claims for Credit".

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DEALER INVENTORY:

No parts in dealer stock should be affected by this recall.

REMOVED PARTS:

Hubs removed per this recall must be tagged with a copy of your claim and shipped freight collect to SKF USA Inc. per the instructions enclosed with the recall kit hubs.

Your claim for performing this recall will ***NOT*** be processed until receipt of the removed hubs and the associated claim attached.

CLAIMS FOR CREDIT:

Expenses associated with the performance of this recall will be reimbursed based on the guidelines identified in this Bulletin, and by submitting a claim following published instructions in the claim preparation section of the "Service Operations Manual".

NOTE: Claims for a recall repair must be submitted within 2 working days from the repair date.

CLAIM CODING INFORMATION:

Type	- P	
Authorization Number	- RVXX0304	
Repair	- 65311-0-02	2.5 hour per vehicle

OWNER RECALL RESPONSE CARD:

The "Owner Recall Response Card" is to provide the vehicle owner with a convenient way to notify Volvo Trucks North America, Inc. of changes affecting the ownership of the subject vehicle. The owner card is not intended for dealer usage other than to assist you in the preparation of the repair orders necessary to perform the applicable recall on the subject vehicle. Please do not use the card as a way to inform Volvo Trucks North America, Inc. that the vehicle has been inspected or modified. Your DCS claim on line is sufficient.

**SAFETY RECALL RVXX0304
JUNE 2003****DEALER RECALL RESPONSIBILITY:**

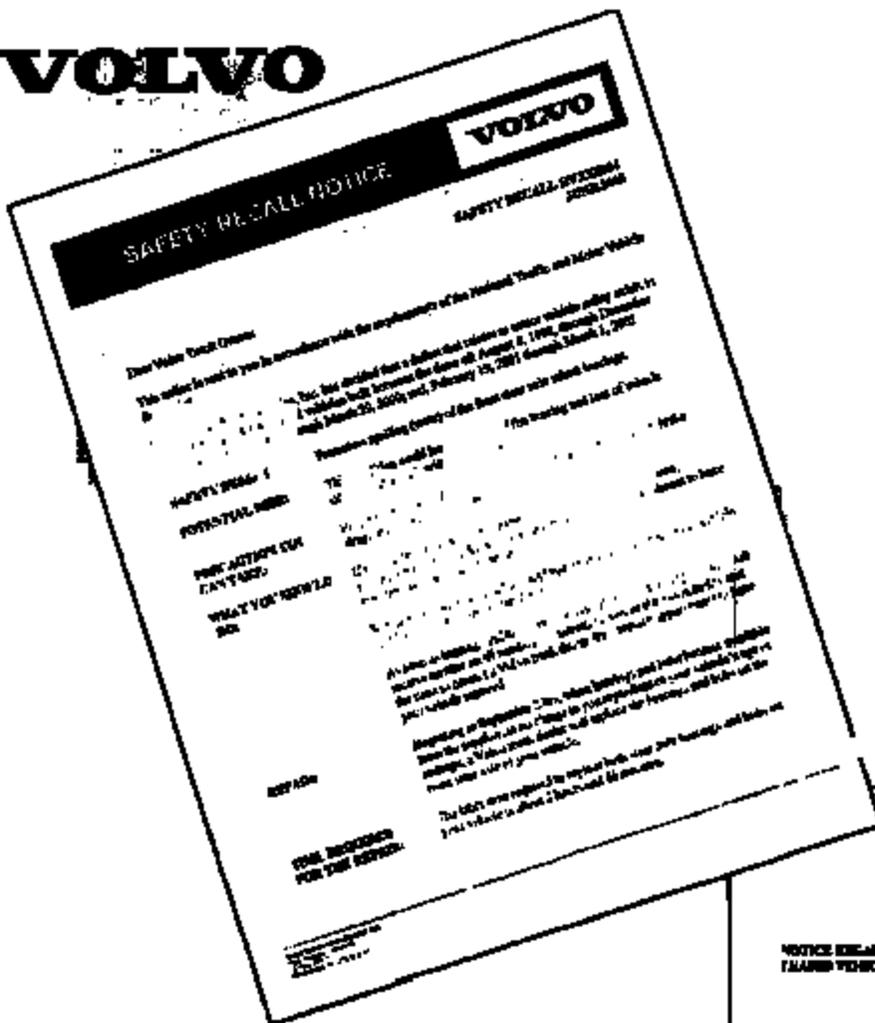
Dealers are to perform the recall on all vehicles subject to the recall at no charge to the owner regardless of mileage, age of vehicle, or ownership from this time forward. Whenever a vehicle subject to this recall is taken into or is in your vehicle inventory or dealership for service, we strongly recommend you make every effort to perform the recall correction before the vehicle is sold or released to the owner.

IMPORTANT NOTICE:

A copy of the Owner Notice has been included for your reference. Please note that the National Traffic and Motor Vehicle Safety Act requires that the owner's vehicle(s) be corrected within a reasonable time after parts are available to you. The law states that failure to repair a vehicle within sixty (60) days after tender for repair shall be a prima facie evidence of unreasonable time. However, circumstances of a particular situation may reduce the sixty (60) day period. If an owner's vehicle is not repaired within a reasonable time, he or she may be entitled, without charge, to a reasonable equivalent vehicle or refund of the purchased price, less reasonable allowance for depreciation.

Volvo Trucks North America, Inc.
P.O. Box 26115
Greensboro, NC 27102-6115

SAFETY RECALL RVXX0304 JUNE 2003



**NOTICE REGARDING
TRAINED TECHNICIANS**

If you are a dealer or retailer subject to this Notice, you have an obligation under Federal Law to provide a copy of this Notice to all Lessees within 10 days of your receipt of this Notice. You must maintain a record of such distribution. If you need a copy of this Notice, the form you need is in the back of this Notice. The Manufacturer's Name(s) of the vehicle(s) that you have listed in this Notice. For purposes of this Notice, the term "owner" means a person or entity that has access, as evidenced on the vehicle's title, to any VIN for that listed vehicle not defined as "VIN" under 49 CFR 570.2, or if the title of address is by the manufacturer of the existence of a substituted dealer, or non-compliance with a Federal Motor Vehicle Safety standard in use or upon or the stated motor vehicle.

**WHY RECALL
REPAIRS ARE NEEDED**

The attached "Owner Recall Request Card" identifies your vehicle. Processing of this card to my dealer and all services Volvo recall dealer will occur in the possession of your vehicle in the shortest time possible. If you do not own, lease, rent or have control the vehicle identified, please to go home by completing, and signing the postage-paid Card and returning it to Volvo Trucks North America, Inc. so we can update our records.

ASSISTANCE

If your vehicle has not been repaired within a reasonable time after delivery, it is the dealer or the agent you've chosen, please contact:
Volvo Trucks North America, Inc.
Recall Department
P.O. Box 20417
Greensboro, NC 27402-0417
or call our toll-free number, 1-800-220-4000. You may also contact a complaint to the Administrator, National Highway Traffic Safety Administration, 400 Seventh Street, S.W., Washington DC 20590 or call the toll-free Auto Safety Hot Line at 1-800-424-3286.

We regret any inconvenience this recall may cause, but hope you will share in our concern for your safety and satisfaction with your Volvo.

Sincerely,
Volvo Trucks North America, Inc.



Technical Bulletin

Unitized Wheel-End Hub Replacement

Meritor Front Non-Drive Steer Axles with Unitized Wheel-End Hubs

How to Obtain Additional Maintenance and Service Information

Refer to Maintenance Manual 2, Front Non-Drive Steer Axles. To obtain this publication, call ArvinMeritor's Customer Service Center at 800-535-5580 or visit the Tech Library on our website at arvinmeritor.com.

Identification

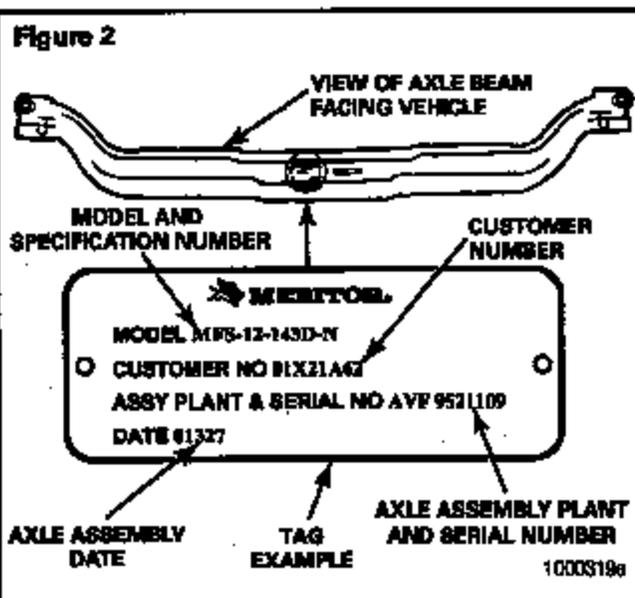
Determine if the Vehicle's Front Non-Drive Steer Axle is Equipped with Unitized Wheel Ends

A unitized wheel end has "half moons" embossed on the center of the hubcap. Figure 1.

Figure 1



If the hubcaps are missing, you can use the axle model number to determine if the axle is equipped with unitized wheel ends. To identify the model number, refer to the axle identification plate on the front of the beam. Figure 2.



Meritor Axle Models Equipped with Unitized Wheel Ends

MFS-10-143D-N	FF-881
MFS-10-144D-N	FF-882
MFS-12-122D-N	FF-883
MFS-12-143D-N	FF-884
MFS-12-144D-N	FF-885
MFS-13-144D-N	FF-887
MFS-13-163D-N	

A unitized wheel end also has been referred to as a truck hub unit, Easy Steer Plus™, and a unitized hub.

Hub Removal

Unitized Wheel Ends

WARNING

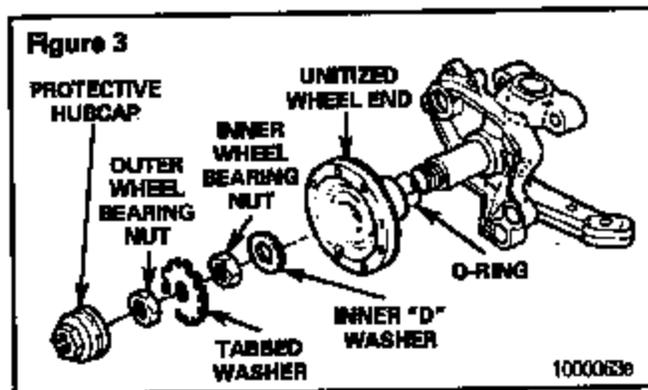
You must follow the uninitialized wheel-end hub removal and installation procedures provided in this bulletin to prevent serious personal injury and damage to components.

- Uninitialized wheel ends are not adjustable.
- Do not attempt to set or adjust end play.

To prevent serious eye injury, always wear safe eye protection when you perform vehicle maintenance or service.

Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Support the vehicle with safety stands. Do not work under a vehicle supported only by jacks. Jacks can slip and fall over. Serious personal injury and damage to components can result.

1. Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Set the parking brake.
2. Use the correct size socket to remove the threaded protective hubcap from the hub by turning the hubcap COUNTERCLOCKWISE. Figure 3.



3. Use a jack to raise the vehicle so that the front tires are off the ground. Support the front axle with safety stands.
4. Remove the tire and wheel assembly.
5. Bend back and flatten the washer tab folded against the flat edge of the outer wheel bearing nut.
6. Remove the outer wheel bearing nut and the tabbed washer from the spindle.
7. Remove the inner wheel bearing nut and the inner washer from the spindle.

CAUTION

Align the uninitialized wheel end STRAIGHT onto the spindle. Do not allow the assembly to misalign and contact the spindle threads. Severe damage can occur that requires replacement of the entire uninitialized wheel end.

Hub bearings are not serviceable. Do not remove bearings from the uninitialized wheel end. Damage to components can result.

8. Remove the uninitialized wheel end STRAIGHT from the spindle. Figure 3.

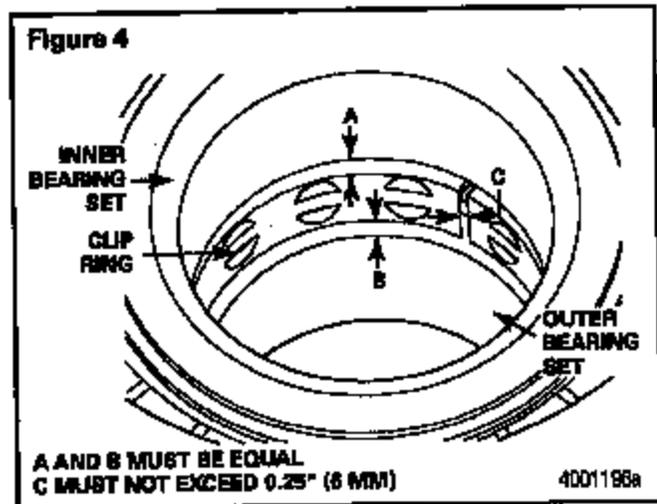
NOTE: The spindle O-ring enables you to remove the uninitialized wheel-end hub from the spindle more easily, because it helps to prevent contaminants from entering the assembly. When you remove the uninitialized wheel-end hub, install a new O-ring.

9. Remove and discard the spindle O-ring. Replace it during assembly.

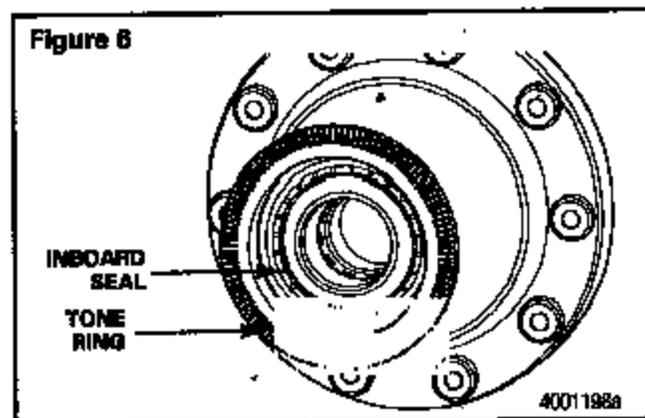
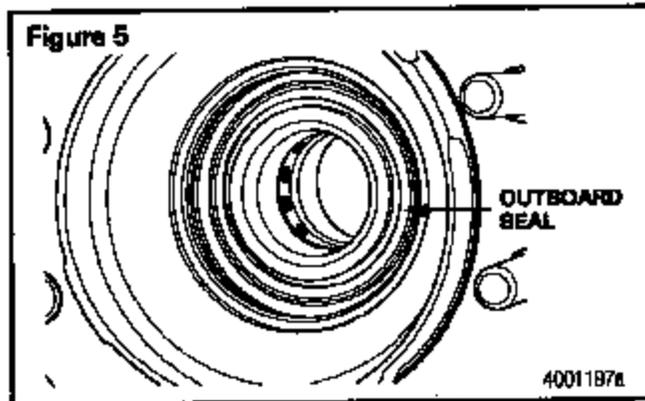
Inspection

Replacement Hub

1. Remove the replacement hub from the box and place it on a clean surface.
2. Examine the interior of the hub to verify the following.
 - A. The inner clip ring has not become dislodged in shipment and is in correct alignment with the inner and outer bearings. The gap between the inner and outer bearing sets and the clip ring must be equal. Figure 4.
 - B. The gap between the ends of the clip ring must be equal and not exceed 0.25-inch (6 mm). If necessary, adjust by hand. Figure 4.
 - C. The bearing face must be clean with no seal coating, dirt or dust.



3. Examine the exterior of the hub to verify the following.
 - A. There is no visible damage to the inboard or outboard seals and the bearings have not become unseated. Figure 5 and Figure 6.
 - B. The tone ring teeth are not damaged and there are no broken or missing teeth on the tone ring. Figure 6.



Installation

Unitized Wheel End

1. Clean the spindle with a clean, dry rag. Do not apply solvent. Check the spindle for any nicks or burrs.

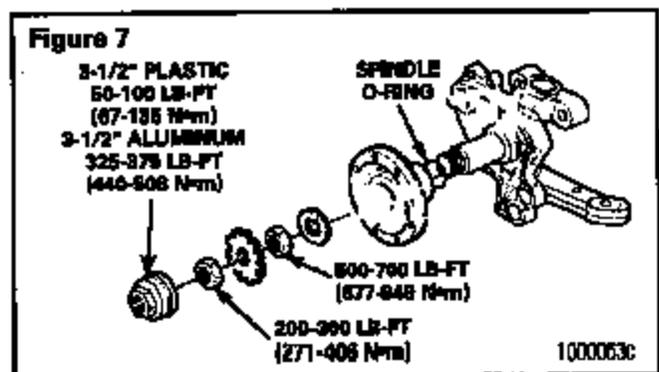
NOTE: The spindle O-ring, Meritor part number 5X-1301 contained in Kit 1433, makes it easier for you to remove the unitized wheel-end hub from the spindle because it helps to prevent contaminants from entering the assembly. When you remove the unitized wheel-end hub, install a new O-ring.

2. Coat the new O-ring with a thin coat of Meritor part number 2297-C-8287 or Dow Corning Molykote D to assist in installing the O-ring.

WARNING

Do not apply anti-seize or anti-fretting compound to spindle threads. These compounds decrease a fastener assembly's capability to maintain clamp load, which can cause wheels to loosen and separate from the vehicle. Serious personal injury and damage to components can result.

3. Coat the inside of the unitized wheel end with anti-seize compound. Make certain to cover the inner and outer bearing races. Do not apply anti-seize or anti-fretting compound onto the spindle or threads. Wipe away any anti-seize or anti-fretting compound that may have dripped onto the spindle threads.
4. Slide a new O-ring, Meritor part number 5X-1301, onto the spindle. The O-ring must be positioned against the knuckle journal. Figure 7.



CAUTION

Align the unitized wheel end **STRAIGHT** onto the spindle. Do not allow the assembly to misalign and contact the spindle threads. Bearing damage can occur that requires replacement of the entire unitized wheel end.

5. Carefully align the unitized wheel-end bore with the spindle and slide the unitized wheel and **STRAIGHT** onto the spindle.
 - If the unitized wheel end does not slide on easily: Do not force it onto the spindle. The unitized wheel end can become jammed on the spindle if it is not aligned correctly with the spindle.
 - If the unitized wheel end becomes jammed on the spindle: Carefully remove the unitized wheel end from the spindle so that the inner bearings do not disassemble or loosen from the unitized wheel end.

6. Install the inner "D" washer and inner wheel bearing nut onto the spindle stud. Tighten the inner wheel bearing nut to 500-700 lb-ft (678-949 N·m) while rotating the unlubed wheel and a minimum of five rotations. **Figure 7.** 
7. Install the tabbed washer and outer wheel bearing nut onto the spindle. Tighten the outer wheel bearing nut to 200-300 lb-ft (271-408 N·m). 

NOTE: The inner wheel bearing nut and the outer wheel bearing nut are identical, but the torque values are different.

8. Bend the parts of the tabbed washer that protrude over the flats of the outer wheel bearing nut and the inner wheel bearing nut. Bend the washer a minimum of one flat edge to each nut.

Metal (Aluminum) Hubcaps

1. Turn the hubcap by hand, until it's seated.
2. Use a torque wrench with the correct size socket to tighten the hubcap to 325-375 lb-ft (440-508 N·m). 

ArvinMeritor™

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Troy, MI 48064 USA
800-535-5580
arvinmeritor.com

Information contained in this publication was in effect at the time the publication was approved for printing and is subject to change without notice or liability. Meritor Heavy Vehicle Systems, LLC, reserves the right to revise the information presented or discontinue the production of parts described at any time.

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DRIVETRAIN PLUS
THE COMPLETE SYSTEM

ArvinMeritor.

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Technical Bulletin

WARNING

YOU MUST FOLLOW THE UNITIZED WHEEL-END MAINTENANCE AND INSPECTION PROCEDURES PROVIDED IN THIS BULLETIN TO PREVENT SERIOUS PERSONAL INJURY AND DAMAGE TO COMPONENTS.

- **UNITIZED WHEEL ENDS ARE NOT ADJUSTABLE.**
- **DO NOT ATTEMPT TO SET OR ADJUST END PLAY.**

To prevent serious eye injury, always wear safe eye protection when you perform vehicle maintenance or service.

Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Support the vehicle with safety stands. Do not work under a vehicle supported only by jacks. Jacks can slip and fall over. Serious personal injury and damage to components can result.

Take care when you use Loctite® adhesive to avoid serious personal injury. Read the manufacturer's instructions before using this product. Follow the instructions carefully to prevent irritation to the eyes and skin.

When you apply some silicone gasket materials, a small amount of odd vapor is present. To prevent serious personal injury, ensure that the work area is well-ventilated. Read the manufacturer's instructions before using a silicone gasket material, then carefully follow the instructions. If a silicone gasket material gets into your eyes, follow the manufacturer's emergency procedures. Have your eyes checked by a physician as soon as possible.

Unitized Wheel-End Assembly Inspection with a Dial Indicator Replacement Hub Inspection Spindle and O-Ring Installation Hubcap Installation All Meritor Front Non-Drive Steer Axles with Unitized Wheel Ends

For Complete Maintenance and Service Information on Meritor Front Non-Drive Steer Axles

Refer to Maintenance Manual 2, Front Non-Drive Steer Axles. To obtain this publication, call ArvinMeritor's Customer Service Center at 800-535-5560, or visit the Tech Library on our website at arvinmeritor.com.

To Order Meritor Parts Specified in This Bulletin

Call ArvinMeritor's Commercial Vehicle Aftermarket at 888-725-9355.

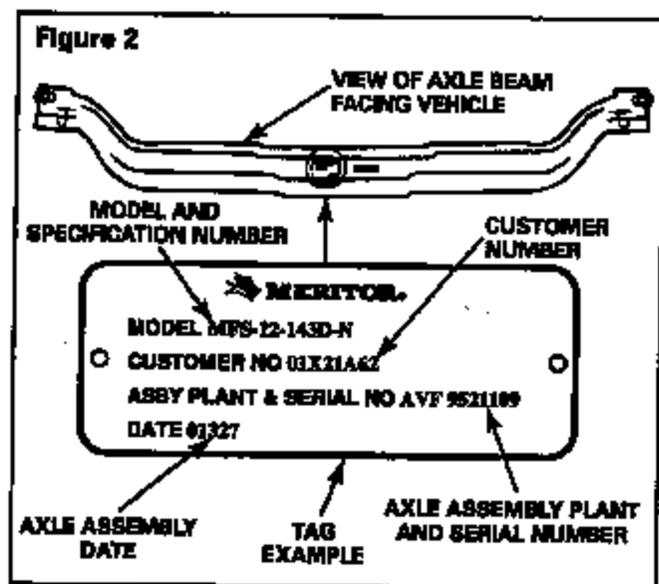
Determine if the Vehicle's Front Non-Drive Steer Axle is Equipped with Unitized Wheel Ends

A unitized wheel end has "half moons" embossed on the center of the hubcap. Figure 1.

Figure 1



If the hubcaps are missing, you can use the axle model number to determine if the axle is equipped with unitized wheel ends. To identify the model number, refer to the axle identification plate on the front of the beam. Figure 2.



Meritor Axle Models Equipped with Unitized Wheel Ends

MFS-10-143D-N	MFS-12-144D-N	FF-983
MFS-10-144D-N	MFS-13-144D-N	FF-984
MFS-12-122D-N	FF-981	FF-988
MFS-12-143D-N	FF-982	FF-987

A unitized wheel end also has been referred to as a truck hub unit, Easy-Steer Plus™, and a unitized hub.

Inspection Intervals

This bulletin provides inspection and maintenance procedures for Meritor axles equipped with unitized wheel ends on front non-drive steer axles. You must perform detailed and basic inspections at the following intervals.

Detailed Inspections

Refer to Detailed Inspection in this bulletin for procedures.

- After the initial 200,000 miles (321 800 km) of operation.
- After every additional 200,000 miles (321 800 km) of operation thereafter.

Basic Inspections

After the initial 200,000-mile (321 800 km) detailed inspection, perform a basic inspection at each scheduled preventive maintenance interval, not to exceed 50,000-mile (80 467 km) intervals. Refer to Basic Inspection in this bulletin for procedures.

If the Vehicle is Equipped with ABS on the Steer Axle

In addition to scheduled preventive maintenance, if driver reports indicate the ABS light has been coming ON, and ABS diagnostics indicate the sensor gap is out-of-adjustment, check for possible wheel-end looseness as the cause.

Tools Required

Basic Inspection

A jack, wheel blocks and safety stands

Detailed Inspection

A dial indicator and a torque wrench with 700 lb-ft (949 N·m) capability

Procedures

The unitized wheel end is sealed and greased for life and does not require lubrication. If you disassemble, or attempt to repair or lubricate a unitized wheel-end assembly, you will void Meritor's warranty. The basic and detailed inspection procedures provided in this bulletin do not instruct you to disassemble the unitized wheel end.

- Unitized wheel ends are not adjustable.
- Do not attempt to set or adjust end play.

Basic Inspection

1. Park the vehicle on a level surface. Block the rear wheels to prevent the vehicle from moving.
2. Raise the vehicle so that the front wheels are off the ground. Support the vehicle with safety stands. Do not use a jack to support the vehicle.

NOTE: If a ticking sound is detected during rotation, this does not indicate a hub problem. It is a normal occurrence.

3. Visually inspect the unitized wheel end as you rotate the tire and unitized wheel-end assembly. Verify that it rotates smoothly and without noise. While rotating the wheel, grasp the brake chamber to feel for unitized wheel-end hub vibration.

- If the tire and unitized wheel-end assembly does not rotate smoothly, or you hear noise (such as wheel bearing grind) or feel wheel-end hub vibration during rotation: Perform a detailed inspection. Refer to Detailed Inspection in this bulletin.

- If the wheel end rotates smoothly: Proceed to Step 4.

4. Grasp the tire and wheel-end assembly at the nine and three o'clock positions. Check for vertical and horizontal movement. With your hands, apply approximately 50 lb (23 kg) of force to the assembly. You should not feel or see any looseness or movement.

- If you feel or see any movement or looseness in the tire and wheel-end assembly: Perform a detailed inspection to determine the cause of the movement, such as worn king pin bushings or pins; wheel-to-hub-mounting end play; unitized wheel-end hub end play; or a combination of them all. To determine unitized wheel-end hub end play, refer to Detailed Inspection which follows.

If other front axle components, such as king pin bushings, require inspection or service, refer to Maintenance Manual 2, Front Non-Drive Steer Axles.

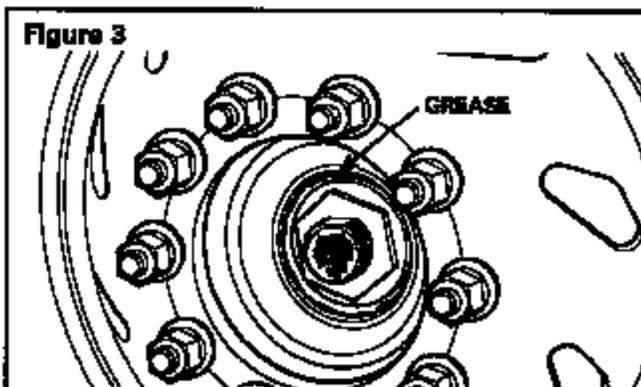
To Help Determine the Cause of Wheel-End Assembly Looseness or Movement

1. Check the wheel-to-hub mounting. Verify that the wheel is mounted correctly and all wheel-end fasteners and hardware are tightened to the correct specification.
2. Apply the service brake to lock the hub and spindle assembly together.
 - If you detect movement or looseness: The king pin or king pin bushings should be inspected. Refer to Maintenance Manual 2, Front Non-Drive Steer Axles.
 - If applying the service brake eliminates movement or looseness: Proceed to Detailed Inspection to determine the unitized wheel-end hub end play.

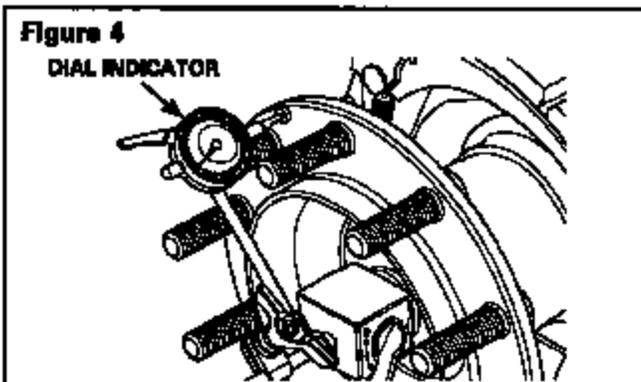
Detailed Inspection

1. Park the vehicle on a level surface. Block the rear wheels to prevent the vehicle from moving.
2. Remove the hubcap.
3. Raise the vehicle so that the front wheels are off the ground. Support the vehicle with safety stands. Do not use a jack to support the vehicle.

NOTE: The outboard and inboard seals may purge small amounts of grease that are visible during inspection. Figure 3. This is a normal occurrence.

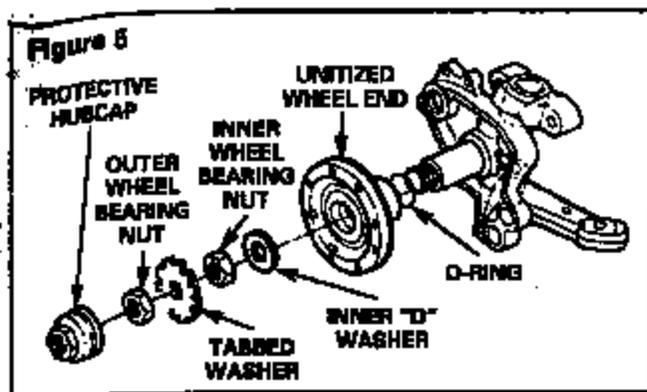


4. Remove the wheel and drum. Attach the magnetic base of a dial indicator to the end of the spindle. Figure 4. Touch the indicator stem perpendicular against the unitized wheel-end's mounting face.



5. Set the dial indicator to ZERO. Do not rotate the wheel end. Place your hands at the nine and three o'clock positions.

6. Push the unitized wheel end straight IN. Note the reading. Pull the unitized wheel end straight OUT. Note the reading.
- If the total movement of the dial indicator is less than 0.003-inch (0.08 mm): Inspection is complete. No adjustment is required.
 - If the total movement of the dial indicator is 0.003-inch (0.08 mm) or greater: Remove the OUTER bearing nut and tabbed washer. Tighten the INNER wheel bearing nut to 500-700 lb-ft (679-949 N·m) while rotating the unitized wheel end a minimum of five rotations. Figure 6. ①



7. Install the tabbed washer and OUTER wheel bearing nut onto the spindle. Tighten the OUTER wheel bearing nut to 200-300 lb-ft (271-476 N·m). ①

NOTE: The inner wheel bearing nut and the outer wheel bearing nut are identical, but the torque values are different.

8. Reattach the dial indicator. Set the dial indicator to ZERO. Do not rotate the wheel end. Place your hands at the nine and three o'clock positions.
9. Push the unitized wheel end straight IN. Note the reading. Pull the unitized wheel end straight OUT. Note the reading.
- If the total movement of the dial indicator is greater than 0.003-inch (0.08 mm) but less than 0.006-inch (0.15 mm): Record the measurement in a maintenance log, and perform a basic inspection at the next regularly-scheduled maintenance interval, or not to exceed 50,000 miles (80 467 km), whichever comes first.
 - If the total movement of the dial indicator is 0.006-inch (0.15 mm) or greater: Replace the unitized wheel-end hub. You must inspect a replacement hub before you install it. Refer to Replacement Hub Inspection in this bulletin.

10. After you've taken the measurement, bend the parts of the tabbed washer that protrude over the flats of the outer wheel bearing nut and the inner wheel bearing nut. Bend the washer a minimum of one flat edge to each nut.

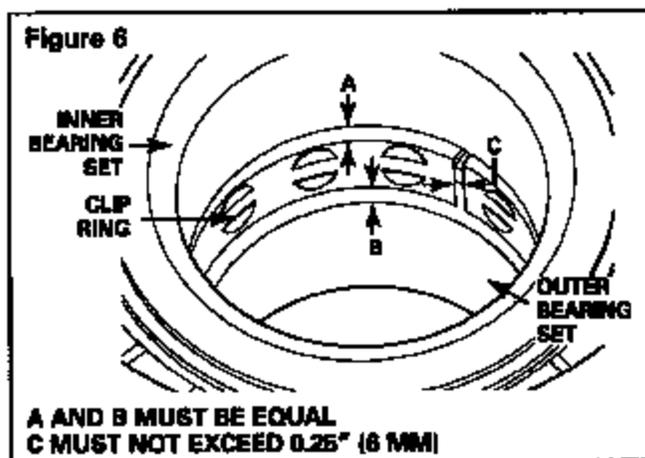
NOTE: If a ticking sound is detected during rotation, this does not indicate a hub problem. It is a normal occurrence.

11. Verify that the unitized wheel end rotates smoothly and without noise. While rotating the wheel, grasp the brake chamber to feel for unitized wheel-end hub vibration.

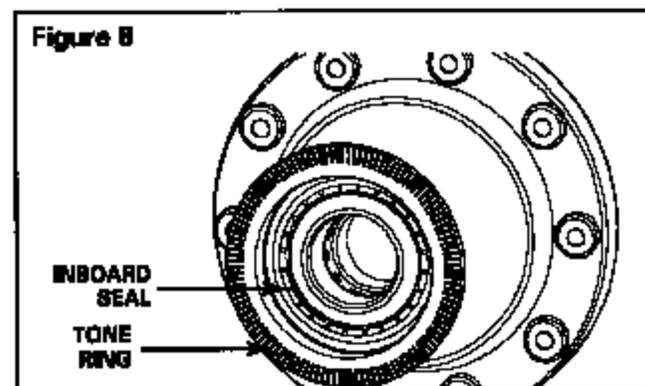
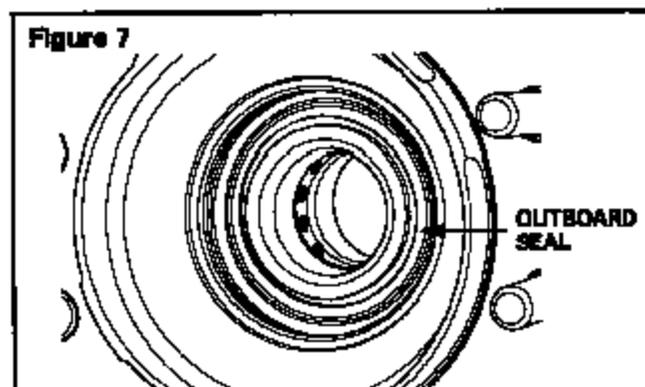
- If the unitized wheel-end assembly does not rotate smoothly, or you hear noise (such as wheel bearing grind) or feel wheel-end hub vibration during rotation: Replace the unitized wheel-end hub. You must inspect a replacement hub before you install it. Refer to Replacement Hub Inspection in this bulletin.
- If the wheel end rotates smoothly: Inspection is complete. Reinstall wheel-end equipment. Return the vehicle to service.

Replacement Hub Inspection

1. Remove the replacement hub from the box and place it on a clean surface.
2. Examine the interior of the hub to verify the following.
 - A. The inner clip ring has not become dislodged in shipment and is in correct alignment with the inner and outer bearings. The gap between the inner and outer bearing sets and the clip ring must be equal. Figure 8.
 - B. The gap between the ends of the clip ring must be equal and not exceed 0.26-inch (6 mm). If necessary, adjust by hand. Figure 8.
 - C. The bearing face must be clean with no seal coating, dirt or dust.



3. Examine the exterior of the hub to verify the following.
 - A. There is no visible damage to the inboard or outboard seals and the bearings have not become unseated. **Figures 7 and 8.**
 - B. The tone ring teeth are not damaged and there are no broken or missing teeth on the tone ring. **Figure 8.**



Install the Spindle O-Ring

The spindle O-ring, Meritor part number 5X-1301 contained in Kit 1433, enables you to remove the unitized wheel-end hub from the spindle more easily, because it helps to prevent contaminants from entering the assembly.

When you remove the unitized wheel-end hub, install a new O-ring.

1. Clean the unitized wheel-end inner bore and spindle with a clean dry rag. **DO NOT** apply any solvent.
2. Check the bore of the unitized wheel end for any obstructions and check the spindle for any nicks or burrs.
3. Coat the new O-ring with a thin coat of Meritor part number 2297-C-8297 or Dow Corning Molykote D to assist in installing the O-ring.

WARNING

Do not apply anti-seize or anti-fretting compound to spindle threads. These compounds decrease a fastener assembly's capability to maintain clamp load, which can cause wheels to loosen and separate from the vehicle. Serious personal injury and damage to components can result.

4. Coat the inside of the unitized wheel end with anti-seize compound. Make certain to cover inner and outer bearing races. Do not apply anti-seize or anti-fretting compound to spindle or threads. Remove any anti-seize or anti-fretting compound that may have dripped onto the spindle threads.
5. Slide a new O-ring, Meritor part number 5X-1301, onto the spindle. The O-ring must be positioned against the knuckle journal.

CAUTION

Align the unitized wheel end **STRAIGHT** onto the spindle. Do not allow the assembly to misalign and contact the spindle threads. Bearing damage can occur that requires replacement of the entire unitized wheel end.

- Carefully align the unitized wheel-end bore with the spindle and slide the unitized wheel end **STRAIGHT** onto the spindle.
 - If the unitized wheel end does not slide on easily: Do not force it onto the spindle. The unitized wheel end can become jammed on the spindle if it is not aligned correctly with the spindle.
 - If the unitized wheel end becomes jammed on the spindle: Carefully remove the unitized wheel end from the spindle so that the inner bearings do not disassemble or loosen from the unitized wheel end.
- Install the **INNER "D" washer** and the **INNER wheel bearing nut**. Tighten the **INNER wheel bearing nut** to 500-700 lb-ft (679-949 N•m) while rotating the unitized wheel end a minimum of five rotations. 
- Install the **tabbed washer** and **OUTER wheel bearing nut** onto the spindle. Tighten the **OUTER wheel bearing nut** to 200-300 lb-ft (271-478 N•m). 

NOTE: The inner wheel bearing nut and the outer wheel bearing nut are identical, but the torque values are different.

- Bend the parts of the tabbed washer that protrude over the flats of the outer wheel bearing nut and the inner wheel bearing nut. Bend the washer a minimum of one flat edge to each nut.

Install the Hubcaps

Threaded Plastic Hubcaps

NOTE: It is not necessary to remove residual Loctite® sealant from the original hubcap installation.

- Wipe the inner truck hub unit threads with a clean shop cloth. Do not use compressed air, solvents or power washers to clean the hub unit threads.
 - To remove grease or mud from the exposed inner threads: Use a wire brush to remove grease or mud from the inner hub unit threads. Wipe the inner threads with a clean shop cloth.

WARNING

Only use RTV sealant (Meritor part number 2297-Z-7098, Loctite® Adhesive Sealant number 5699) when you service a unitized wheel-end assembly. Do not use any other brand of RTV sealant, which can cause corrosion, damage and incompatibility between unitized wheel-end components. Serious personal injury and damage to components can result.

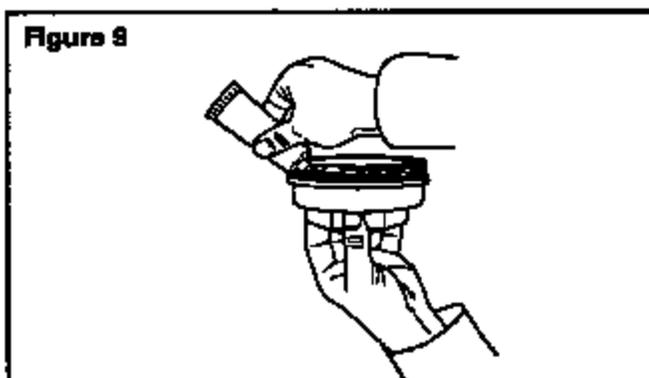
- Apply a continuous 1/8-3/16-inch (3-5 mm) bead of RTV sealant to the outside first thread around the entire circumference of the hubcap. You must use Meritor part number 2297-Z-7098 RTV sealant, Loctite® Adhesive Sealant number 5699. 

Figure 9

- Install the plastic hubcap into the unitized wheel end by hand.
- Use a torque wrench with the correct size socket to tighten plastic hubcaps to 50-100 lb-ft (67-135 N•m). Disregard the torque value embossed on the hubcap. 

Metal (Aluminum) Hubcaps

- Clean the **INNER unitized wheel-end threads** and **threaded hubcap external threads** with a wire brush. Apply Meritor part number 2297-Z-7098 RTV sealant, Loctite® Adhesive Sealant number 5699, to the hubcap threads.
- Turn the hubcap by hand, until it's seated.
- Use a torque wrench with the correct size socket to tighten the hubcap to 325-375 lb-ft (440-508 N•m). 

Threaded plastic hubcap	RTV sealant (Meritor part number 2297-Z-7098 RTV sealant, Loctite® Adhesive Sealant number 5699)	50-100 lb-ft (67-135 N•m)
Metal (aluminum) hubcap		325-375 lb-ft (440-508 N•m)

NOTE: Threaded plastic and metal hubcaps are interchangeable. For non-threaded hubcaps, refer to TP-0254, Removing and Installing Hubcaps with Snap Rings.

Reusing Hubcaps

If you observe any of the following conditions while tightening a used hubcap, replace the hubcap with a new one. Refer to Install the Hubcaps in this bulletin.

- The hubcap "jumps" threads and makes a popping sound while you're tightening it.
- The hubcap begins to yield because threads are stripped.
- You cannot achieve the correct torque specification of 50-100 lb-ft (67-135 N-m) for plastic hubcaps or 325-375 lb-ft (440-508 N-m) for metal hubcaps.