Бюллетень Bulletin 11-2015 БЭ



Annotation:

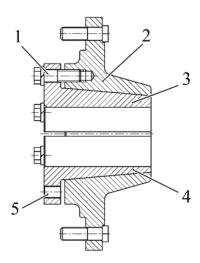
This operation bulletin contains updated information regarding mounting of rear wheel hubs on the rear semi-axle of the tractor.

Content of changes:

1. Subsection 3.2.9 "Rear wheel track formation" shall be amended as follows:

The information available:

The bushings are tightened into the hub group housing with six bolts 1 (M20) with a torque from 360 to 450 Nm, clenching the semi-axle.



1 – tie bolts; 2 – hub group housing; 3 – upper bushing; 4 – lower bushing; 5 – dismounting holes.

Figure 3.2.4 – Rear wheel hub group

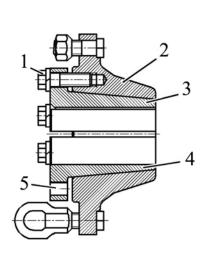
Shall be replaced with:

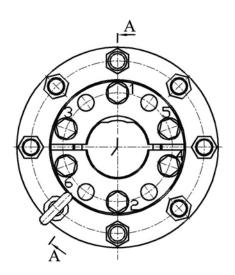
When mounting the wheel hub on the axle shaft bolts 1 shall be tightened with a torque of 360 to 380 Nm in a sequence of 1, 2, 3, 4, 5, 6 (figure 3.2.4b). After you mount the wheel on the hub tighten bolts 1 with a torque of 360 to 400 Nm in the sequence of 1, 2, 3, 4, 5, 6.

ATTENTION: AFTER THE BOLTS ARE TIGHTENED MAKE SURE THE ENDS OF THE TOP AND THE LOWER INSERTS JUT TO A VALUE OF NO MORE THAN 2 MM WITH RESPECT TO EACH OTHER!

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a) wheel hub composition

b) scheme of tightening the bolts that attach wheel hub to axle shaft

1 – tie bolts; 2 – hub group housing; 3 – upper insert; 4 – lower insert; 5 – dismounting holes.

Figure 3.2.4 – Rear wheel hub group

2. Subsection 3.2.9 "Rear wheel track formation" shall be amended as follows:

The information available:

- screw out the tie bolts from the dismounting holes and screw them into the bushings. Screw in the tie bolts with a torque from 360 to 450Nm in stages until all the bolts are screwed in with the required torque;
- mount the wheel onto the hub group, tighten the wheel retaining nuts with a torque from 300 to 350Nm, set the blind plugs to their places;

Shall be replaced with:

screw out the tie bolts from the dismounting holes and screw them into the inserts. Screw in the bolts with a torque of 360 to 380 Nm in a sequence of 1, 2, 3, 4, 5, 6 (figure 3.2.4b);

- mount the wheel onto the hub group, tighten the wheel retaining nuts with a torque from 300 to 350Nm, set the blind plugs to their places;
- after you mount the wheel on the hub group tighten the bolts with a torque of 360 to 400 Nm in the sequence of 1, 2, 3, 4, 5, 6.

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3. Clause 5.4.2.2 "Operation 21. Check of threaded joint tightening of wheel fixing" of subsection 5.4.2 in operation manuals 1523.6-0000010 P9 and 1523.5-0000010-17 P9 shall be amended as follows:

The information available:

- tightening torque for bolts 4 (figure 5.4.14) of rear wheel conic hubs shall be from 360 to 450 Nm;

Shall be replaced with:

- tightening torque for bolts 4 (figure 5.4.14) of rear wheel conic hubs shall be from 360 to 400 Nm;
- 4. Clause 5.4.2.2 "Operation 18. Check of threaded joint tightening of wheel fixing" of subsection 5.4.2 in the operation manual 1523.5-0000010 P9 shall be amended as follows:

The information available:

- tightening torque for bolts 4 (figure 5.4.10) of rear wheel conic hubs shall be from 360 to 450 Nm;

Shall be replaced with:

- tightening torque for bolts 4 (figure 5.4.10) of rear wheel conic hubs shall be from 360 to 400 Nm;