

**Annotation:**

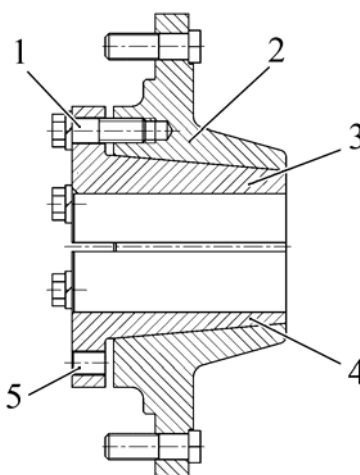
This operation bulletin contains updated information regarding mounting of rear wheel hubs on the rear semi-axle of the tractor.

**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 thus clenching the semi-axle.



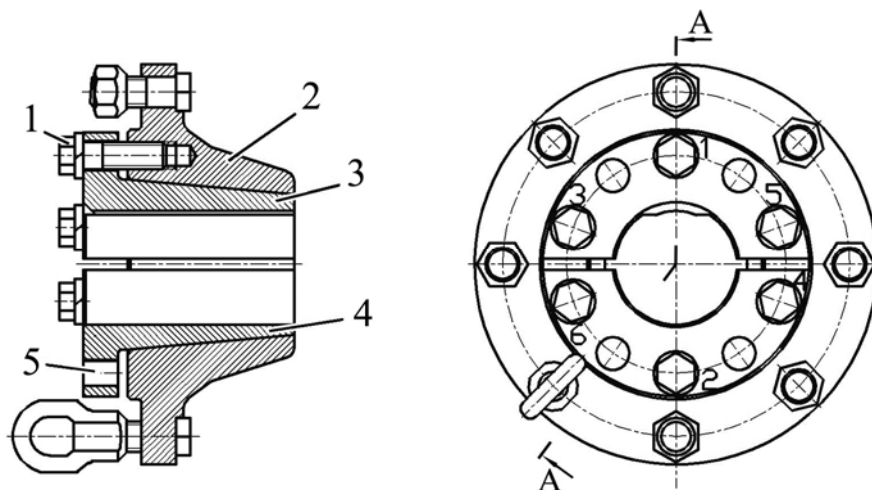
1 – tie bolts; 2 – hub group housing; 3 – upper bushing; 4 – lower bushing; 5 – dismantling holes.

Figure 3.2.3 – 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 3.2.3b). 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!**



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 3.2.3 – Rear wheel hub group

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 3600 to 380 Nm in a sequence of 1, 2, 3, 4, 5, 6 (figure 3.2.3b);
- 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 bolts 1 with a torque of 360 to 400 Nm in the sequence of 1, 2, 3, 4, 5, 6.

3. In manuals 1221.5-0000010 PЭ, 1220.5-0000010PЭ and 1021.5-0000010PЭ clause 5.4.2.2 “Operation 17. Check of threaded joint torquing of wheels mounting” shall be amended as follows:

The information available:

- tightening torque for bolts 4 (Figure 5.4.9) of the rear wheel taper hubs shall be 360 to 450 Nm;

Shall be replaced with:

- tightening torque for bolts 4 (Figure 5.4.9) of the rear wheel taper hubs shall be 360 to 400 Nm;

4. In manual 1221.6-0000010 РЭ clause 5.4.2.2 “Operation 20. Check of threaded joint torqueing of wheels mounting” of subsection 5.4.2 shall be amended as follows:

The information available:

- tightening torque for bolts 4 (Figure 5.4.13) of the rear wheel taper hubs shall be 360 to 450 Nm;

Shall be replaced with:

- tightening torque for bolts 4 (Figure 5.4.13) of the rear wheel taper hubs shall be 360 to 400 Nm.