IMPORTANT
Inspect spindle to ensure threads are clean and free of damage and distortion. Ensure bearings are lubricated prior to installation.

SPINDLE NUT SOCKET CAP SCREW HEX
PRECISION240™ 3 11/16" 5/32"
PRECISION320™ 4 7/8" 3/16"

Wheel bearings should be set within 0.001" to 0.005" end play. Following this procedure will consistently produce a bearing setting of 0.001" to 0.003" end play.

**WARNING**
FAILURE TO FOLLOW THESE INSTRUCTIONS COULD CAUSE WHEEL TO COME OFF AND CAUSE BODILY INJURY. OVER-TIGHTENING NUT COULD CAUSE BEARINGS TO RUN HOT AND BE DAMAGED.

**STEP 1**
*IMPORTANT*
Inspect spindle to ensure threads are clean and free of damage and distortion. Ensure bearings are lubricated prior to installation.

**STEP 2**
Torque to 200 ft. lbs. (271 Nm) while rotating hub 3 full turns.

**STEP 3**
Inspect

**STEP 4**
4A: Back-off nut 1 full turn
4B: Rotate hub 1 full turn

**STEP 5**
Torque to 50 ft. lbs. (68 Nm), then rotate hub 3 full turns. Repeat torque and rotations three more times. See note 1.

**STEP 6**
Back-off nut 1/6 turn (60°)

**STEP 7**
Do not rotate nut if washer and nut teeth do not align, flip interlock washer over, then install.

**STEP 8**
SPINDLE NUT SCREW TORQUE
ft. lbs. Nm
PRECISION240™ 10±2 13.5±2
PRECISION320™ 15±2 20±2

Rotate hub at least five revolutions. Use a dial indicator to verify end play is within 0.001" to 0.005". Adjust nut as necessary to achieve acceptable end play. If required, refer to applicable wheel-end maintenance procedures.

**STEP 9**
Inspect

**STEP 10**
End Play

NOTES:
1. These steps must be performed four times to ensure bearings are fully seated.
2. If reusing existing screws, apply a small amount of Loctite® Threadlocker Blue to screw threads.

Questions?
Call Hendrickson Trailer Technical Services Department
In United States and Canada at 866-RIDEAIR (743-3247) or e-mail HTTS@Hendrickson-intl.com

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