

## AB38 Gear Box Stud Assembly

### STAGE 1

[1] Place AB38 on hard flat surface.

[2] Loosen all wheel nuts on rear wheels all the way to end of stud.



**Tools:** M22 socket  
Wrench extension bar  
Ratchet wrench

## STAGE 2

[1] Lift rear of vehicle with a minimum of a 2.5 ton Toe Jack so wheels are just clear of ground.

[2] Remove all the wheel nuts by hand or using M22 spanner or socket and ratchet wrench if required.

[3] Lift wheels from gear box hubs and place in a safe area.



**Tools:**

- M22 socket
- Ratchet wrench
- Extension bar
- 2.5 ton jack

### STAGE 3

[1] Place 2 x M14 standard nuts onto first stud screw down nuts, lock both nuts together using 2 x M22 spanners. Loosen stud until completely removed from hub fixing using 1 M22 spanner on bottom nut.

[2] Clean hub wheel stud and stud aperture with LOCTITE CLEANING SOLVENT or white spirit removing any oil and dirt. ALLOW SOLVENT TO DRY.

[3] Open bottle of LOCTITE 648 and cover threads on THE INSIDE OF GEAR BOX HUB WHEEL STUD HOLE [ENSURE THE THREADS ARE WELL COVERED].

[4] Insert wheel stud back into stud aperture in gearbox hub tighten back on using M22 spanner and then tighten using M22 deep socket. **Till 32mm from face of hub to end of stud.**

[5] Leave Loctite to dry in the fixing for 1 hour.

[6] Repeat this process with all studs on both rear wheels.

[7] Remove the two M14 standard nuts from the wheel stud using 2 x M22 spanners. Mark each end of stud to signify end of procedure.



**Tools:**

- 2 XM22 spanners
- M22 deep socket
- Rule/Tape measure

**Parts:**

- Loctite 648
- Loctite cleaning solvent
- Degreasing wipes

## STAGE 4

- [1] After minimum of 1 hour refit wheels to hubs.
- [2] Lift each wheel over gearbox hub and wheel studs to care not to damage stud threads
- [3] Refit wheel nuts to each stud and screw on by hand, tighten using M22 socket with extension bar and ratchet wrench
- [4] Lower jack and remove from machine
- [5] TORQUE WHEEL NUTS USING TORQUE WRENCH SET AT 145 N/M
- [6] MARK NUT HEADS WITH PAINT PEN TO SIGNIFY TORQUE HAS BEEN DONE ON EACH OF THE 10 WHEEL NUTS



**Tools:** M22 socket  
Wrench extension bar  
Torque wrench set 145 N/M  
2.5 Ton Jack

**Parts:** Wheel Nuts M14 057578-000