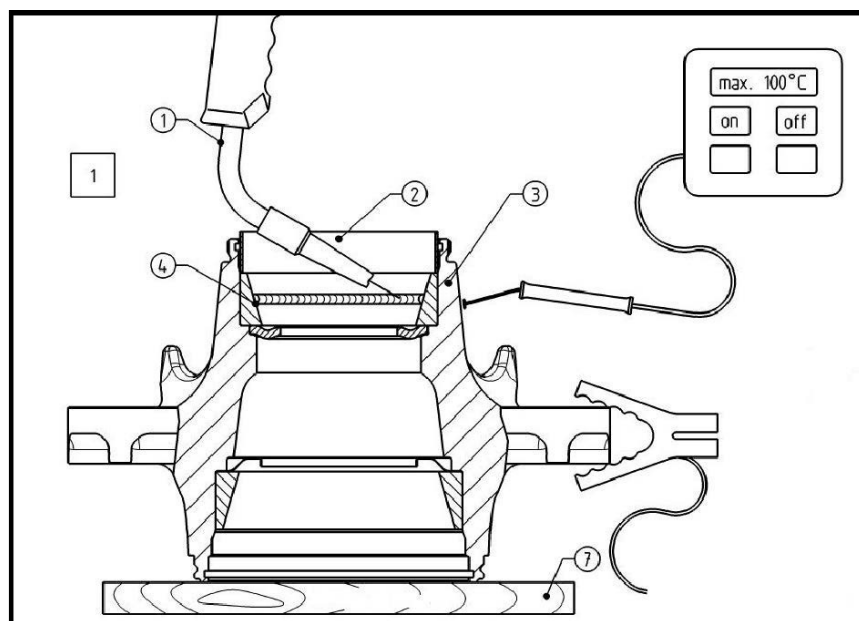


## Service Procedures - Alloy Hubs



1

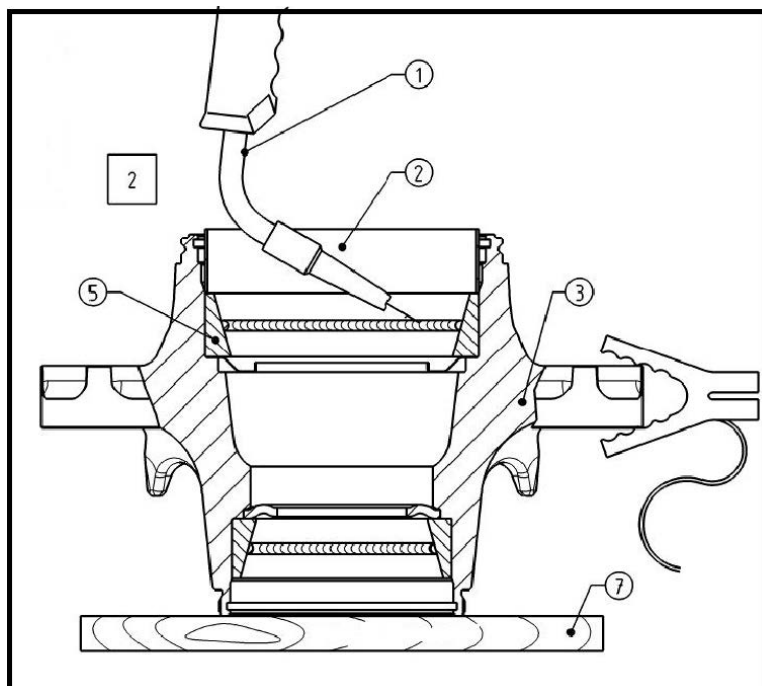
- Attach a thermocouple to the outside of the hub - the hub must never reach a temperature of more than 100° Celsius (3)
- Place the hub on a soft wood base to prevent damage to the hub - (7)
- Make a sheet metal ring (2) and insert into the hub to protect the circlip area from weld splatter.
- Weld a bead completely around the inside of the bearing cup (4) using a shielded arc welding machine.
- As the weld cools it will cause the bearing cup to shrink so that it can be easily removed without damaging the alloy hub.

2

- Repeat the above procedures for the inner bearing cup.
- Once again protect the circlip area from weld splatter with a sheet metal ring (2).
- Allow both bearings to cool to room temperature.

**Recommended welding settings: -**

260A 36V and 1.0mm wire



### Victoria (Head office)

1-11 Cherry Lane,  
Laverton North Vic 3026

Phone (03) 9267 2444

Fax (03) 9369 4826

### New South Wales

10 Squill Place,  
Arndell Park NSW 2148

Phone (02) 8811 7000

Fax (02) 8811 7050

### Queensland

10 Bernoulli Street,  
Darra Qld 4076

Phone (07) 3217 0877

Fax (07) 3217 0230

### Western Australia

1021 Abernethy Road,  
High Wycombe WA 6057

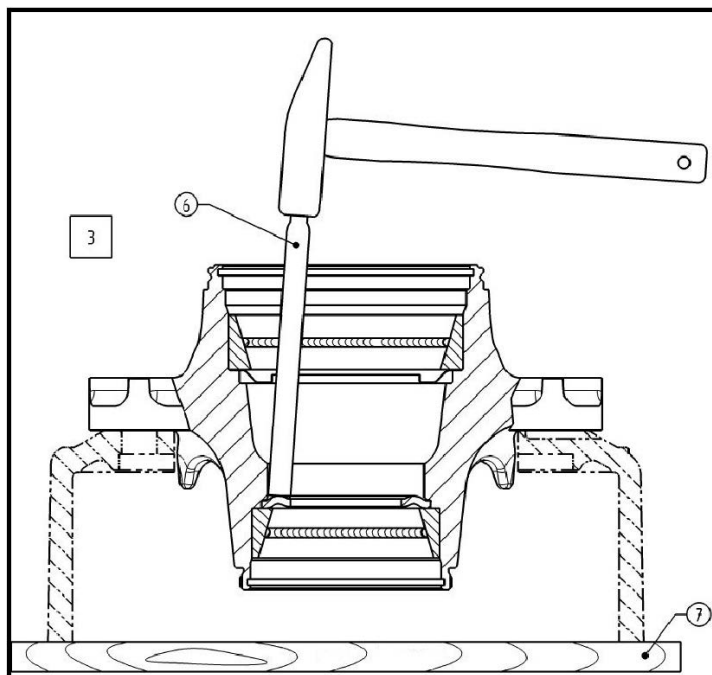
Phone (08) 9454 4000

Fax (08) 9454 4111

1300 651 652

[info@bpwtranspec.com.au](mailto:info@bpwtranspec.com.au)

[bpwtranspec.com.au](http://bpwtranspec.com.au)



## Dismantling the roller bearings.

3

- Place the hub face down in an old brake drum to prevent damage to the hub flange. The brake drum should be placed on top of a soft wood base.
- Once the bearings have cooled use a mandrel (6) to drive the old bearing cup out of the hub.
- Do not damage the bearing seats.

4

- Flip the hub over and repeat the process for the inner bearing cup.
- Clean and inspect both bearing seats.
- Damaged hubs must be replaced.

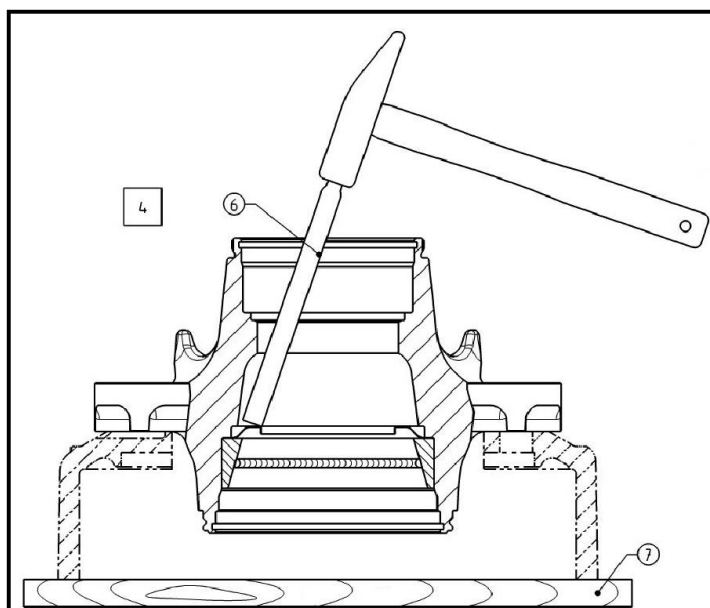
## Assembly of the roller bearings.

- Using an oven heat the hub evenly to 80° Celsius.
- Carefully press in the new bearing cups.
- Inspect the hub for any damage.

## Other alloy hub components.

- The wheel studs, circlips and seals can be dismantled / assembled without having to heat up the hub.
- The bearing setting is done exactly as per the standard hub. Please consult the **Operator's Manual** for bearing setting procedures.

New alloy hubs are also available with the bearing cups already fitted - saving time and effort.



09.801.09.05.0 - Dual Aluminium Wheels - Disc

09.801.09.06.0 - Dual Aluminium Wheels - Drum

For more information contact your local BPW Transpec Representative

### Victoria (Head office)

1-11 Cherry Lane,  
Laverton North Vic 3026

**Phone** (03) 9267 2444

**Fax** (03) 9369 4826

### New South Wales

10 Squill Place,  
Arndell Park NSW 2148

**Phone** (02) 8811 7000

**Fax** (02) 8811 7050

### Queensland

10 Bernoulli Street,  
Darra Qld 4076

**Phone** (07) 3217 0877

**Fax** (07) 3217 0230

### Western Australia

20 Brennan Way,  
Belmont WA 6104

**Phone** (08) 9479 5822

**Fax** (08) 9479 6922

**1300 651 652**

[info@bpwtranspec.com.au](mailto:info@bpwtranspec.com.au)

[bpwtranspec.com.au](http://bpwtranspec.com.au)