



Installing Meritor's SteelLite X30™ Brake Drums

WARNING

To prevent serious eye injury, always wear safe eye protection when you perform vehicle maintenance or service.

Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Support the vehicle with safety stands. Do not work under a vehicle supported only by jacks. Jacks can slip and fall over. Serious personal injury can result.

Always replace both brake drums on an axle to ensure even braking power and load on the wheels and axle. Do not replace only one drum on an axle, which can cause uneven braking load and affect vehicle performance. Serious personal injury and damage to components can result.

Ensure that you do not damage stud threads when you install the drum. Damaged threads will not allow studs to provide the required clamp load to support the wheel retention system. The wheels can loosen and separate from the vehicle. Serious personal injury and damage to components can result.

Always thoroughly clean the hub mounting surfaces before you mount a new brake drum. Dirt and contaminants can cause parts to seat incorrectly, which can loosen the drum and cause the wheel to separate from the vehicle. Serious personal injury and damage to components can result.

CAUTION

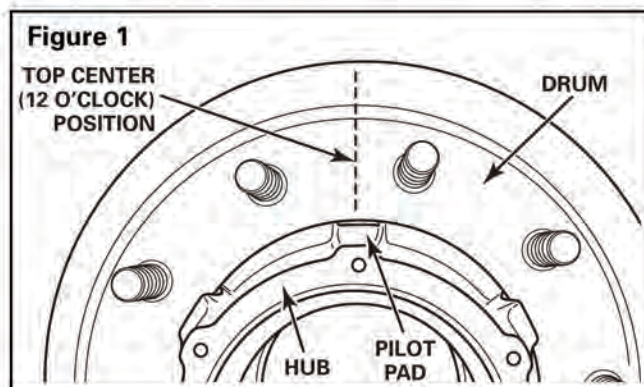
Verify that the drum is installed correctly and does not rest on the wheel pilot, which will damage the drum pilot surface when you tighten the wheel nuts to the specified torque. Also the drum will not seat correctly, causing the brakes to drag. Damage to components can result.

For Complete Maintenance and Service Instructions for Meritor's SteelLite X30™ Brake Drums

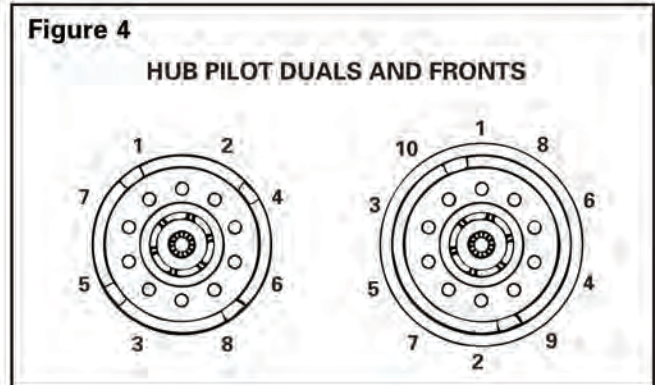
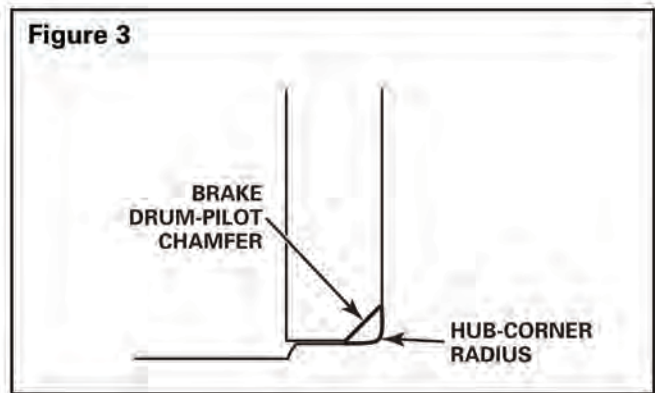
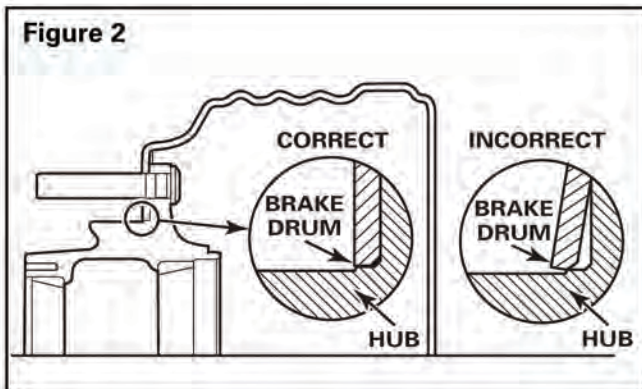
Refer to Maintenance Manual MM-99100, Wheel Equipment Disc Wheel Hubs Brake Drum Failure Analysis. Call Meritor's Customer Service Center at 800-535-5560 to order this publication or visit the Tech Library on our web site at the following address:

www.meritor.com/lod

1. Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Raise the vehicle so that the area you will service is off the ground. Support the vehicle with safety stands.
2. Use a scraper and wire brush to thoroughly clean the hub mounting surface of paint, dirt and any other contaminants before you mount a new brake drum.
3. Rotate the hub so that one pilot pad is at the TOP CENTER (12 o'clock) position. **Figure 1.**




4. Install the drum over the hub and brake shoes. Take care that you don't damage the stud threads. Verify that the drum seats flat against the hub flange and mates correctly with the hub brake drum pilot. **Figure 2.**
5. Verify that there's no interference between the brake drum pilot chamfer and the hub's corner radius. Interference will not allow the brake drum to function properly. **Figure 3.**
 - **If there's interference between the brake drum pilot chamfer and the hub's corner radius:** The drum is not meant to mate with that hub.



WARNING

Tighten fasteners to the correct torque specification. Do not over-tighten or under-tighten fasteners, which can cause the wheels to separate from the vehicle. Serious personal injury and damage to components can result.

6. Tighten flange nuts 50 lb-ft (68 N•m) using the torque sequence shown in **Figure 4**. Then tighten the flange nuts 450-500 lb-ft (610-678 N•m). 
7. Check flange nut torque after the first 50-100 miles of service. Perform regularly scheduled checks to maintain the correct torque specification.



Meritor Heavy Vehicle Systems, LLC
 2135 West Maple Road
 Troy, MI 48084 USA
 800-535-5560
 meritor.com

Information contained in this publication was in effect at the time the publication was approved for printing and is subject to change without notice or liability. Meritor Commercial Vehicle Systems reserves the right to revise the information presented or discontinue the production of parts described at any time.

Copyright 2002
 Meritor, Inc.
 All Rights Reserved

Printed in the USA

TP-0118
 Issued 01-02
 16579/Meritor