

FITTING INSTRUCTIONS FOR 3/8 UNC TRAILING ARM / HUB STUDS



Setting Drill Depth

**Drill jig, Taping Jig, 8.0 drill, first and third taps
4 off 5/16" plain nuts, drill depth tube not shown**

- The fitting of these studs is really very simple; but it does rely on the initial drilling operation to be done accurately. The drill must be exactly perpendicular to the hub surface in the X and Y axis.
- It is strongly advised that the drilling and tapping jigs are used, a little misalignment has consequences !
- Keep 2 opposing studs in place. Remove the other 4.
- Set the drill depth, 18 mm of full drill dia from the jig face, using the tube.
- Clean the hub face. Place the drill jig (marked D) onto the 2 studs, flat against the face and secure.
- Drill the 4 tapping holes to the full 18 mm depth, withdrawing the drill often to remove swarf. Use a vacuum cleaner with tube to finish.
- Swap jigs.
- With tape / felt tip mark the drill depth on the (First) Taper tap so it only goes in 18 mm.
- Use oil or thread cutting lubricant on the taps, replenish / recoat frequently. Start to cut the thread, half turn in followed by half turn out. When you have done 2 turns in remove tap and clear out any swarf. (thin screw driver to loosen it and a vacuum cleaner with nozzle.) Take your time and be methodical.
- When you have got to the drilled depth with the taper tap you will feel the tap positively lock up as it bottoms out; be gentle do not try to turn any more as you can strip threads. Repeat for all 4 holes.
- Do the same procedure with the (Third) Full tap, take your time. Do not allow swarf to build up and if while turning the taps you feel a change, stop and investigate. Remove Jig.
- Screw in the 4 studs all the way, use the plain nuts locked together, so that only the 5/16 dia is above the surface and 1" protrudes. Thread Lock should be used. Tighten to 18 lbs ft torque.
- Remove the remaining 2 old studs.
- Repeat the drilling and tapping procedure for these 2 holes. The drilling jig may be a little 'tight' this time over the studs, tap GENTLY with a soft mallet to make sure it is against the hub face, secure with plain nuts.
- When securing the hub assembly tighten the 5/16 unf nuts to 12 to 15 lbs ft torque

If in doubt, ask !

Drills & Taps + Drilling & Tapping jigs are available
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