



## TECHNICAL BULLETIN

February 22, 2007

### SUBJECT: F22 Spindle Modification to accept Conmet Preset Hubs

**Product Affected:** F22 Spindles manufactured between May 15<sup>th</sup> and Oct. 1<sup>st</sup>, 2006 that are to be used with a ConMet Preset Hub.

**! WARNING !**

*Under NO circumstances should material be removed from the bearing spacer. The integrity of the spacer is critical for acquiring and maintaining proper bearing preload and endplay.*

Before proceeding, refer to the date code stamped on the end of the spindle and verify that the year is '6' and the Julien date is between 135 and 274.

EXAMPLE OF STAMP CODE :

**H 6 T 0 0 0 D**

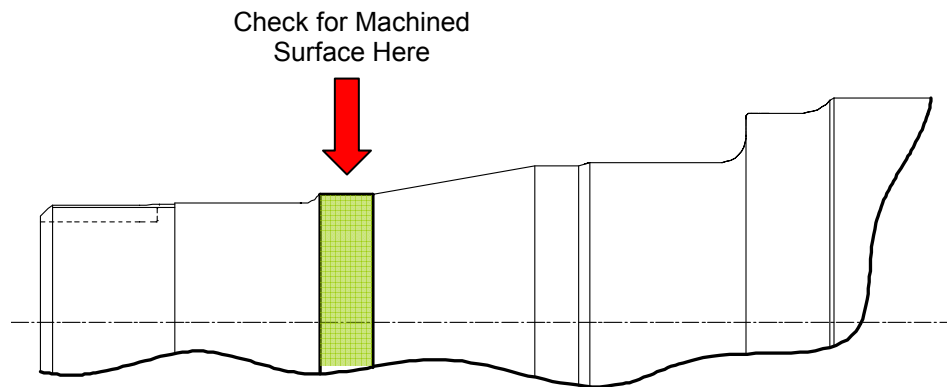
OPERATOR I.D.  
JULIEN CALENDER DATE  
T FOR I.M.T.  
YEAR IE 6 = 2006  
S OR H FOR SPINDLE TYPE

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**Check Spindle for Machined Surface**

- Remove hub.
- Look for a machined surface where indicated in the illustration.



- If the surface is machined, no further action is necessary. Install hub according to step 10.  
If the surface is un-machined (forging), material removal is required. Continue with step 1.

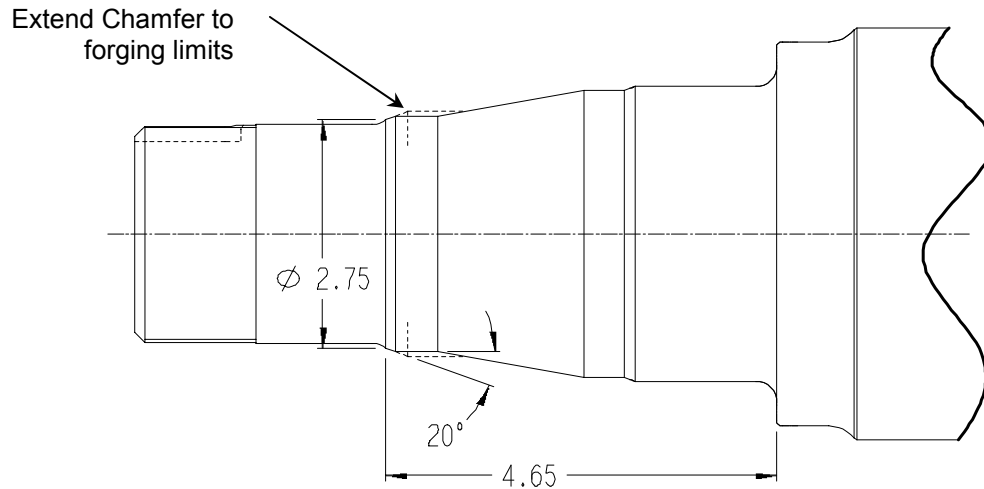
**Remove Material Causing Interference**

1. Remove Conmet Hub.
2. Remove any remaining seals and bearings from the spindle.
3. Clean and degrease the spindle to completely remove the lubricating compound.

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4. Chamfer to the edge leading into the transition taper.

**\*\* NOTE \*\***

Take precautions to ensure the bearing journal surfaces are not marked or damaged.

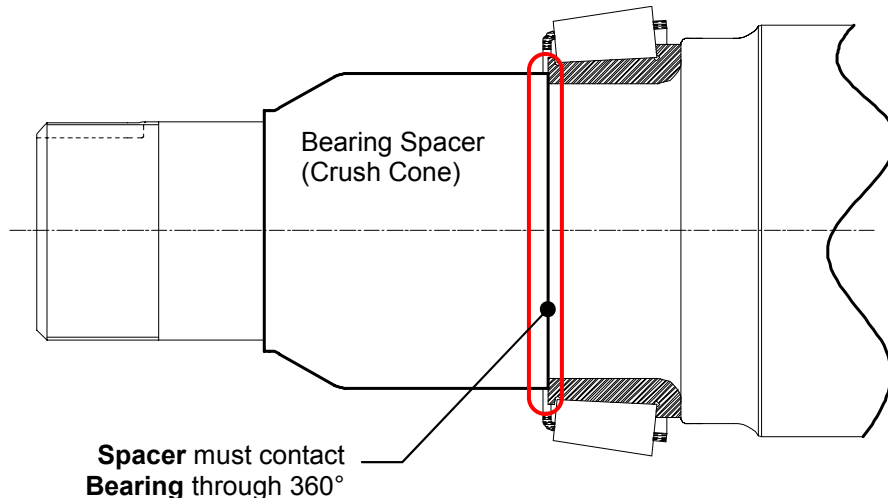
**Verify Bearing Spacer Fit**

5. Thoroughly wipe the large bearing journal to remove any debris deposited during material removal.
6. Install the large bearing cone.
7. Place the bearing spacer (crush cone) on the spindle and gently push it towards the large bearing as far as it will travel.

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8. When adequate material has been removed the spacer will butt up against the bearing cone. Verify 360° contact by holding the spacer in place and checking for gaps using thin stock (paper strip, feeler gauge, etc).



9. Repeat step 4 if correct positioning has not been achieved.

**Replace Hub and Drum Assembly**

10. Re-assemble the hub. Replace seal and install hub according to IMT Procedure IN033<sup>❶</sup>. If bearings contain signs of excessive wear or other damage, replace them as well.

Please address all technical inquiries to IMT Engineering at:  
1-800-663-2953 or 1-519-485-2210.

- ❶ IN033 is included in the IMT Installation and Maintenance manual supplied with each axle. It can also be downloaded from [our website](#) or requested by contacting our customer service department.
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