

Work Instructions

Woodruff Key Addition

1. Remove the hub from the wheel with a hydraulic press.
2. Send the wheel and hub to the machine shop currently approved by WTI's Quality department to perform the modifications with a purchase order and a current drawing.
3. Upon receipt of the parts give them to the Quality department for receiving inspection.
4. Install a woodruff key(41) by tapping it in place with a hammer angle the key about 30 degrees.
5. If this modification is to a 14" or 17" wheel, place 4 retaining clips(12) in the interior groove in the bore of the wheel. Leave a space for the woodruff key. Spread the clips with the clip spreader tool part # TF-252.
6. Position the hub over the wheel so the short side of the key engages first.
7. Align the key with the slot in the wheel.
8. Use a hydraulic press to force the hub into the wheel till it is centered.
9. If this modification is to a 26" wheel install the retaining rings(12) on each side of the hub with a pair of snap ring pliers. Make sure the ring is fully in the groove all the way around.

Note: The numbers referred to in parenthesis correspond to the item numbers in the assembly drawings.