

ROCKWHEEL SERVICE DOCUMENT

G40 & G60 Drum Removal

Tools needed

- M16/14mm Allen socket
- M24/19mm Allen socket
- Pry bar
- 2x M16 x 120mm hex pusher bolts

1. Lay the G40 or G60 with the drum you are working on facing upwards to ease the removal of drum from shaft.
2. Remove M24 bolts from cover using a 19MM Allen socket. Also remove the M16 bolts from the cover using a M14 Allen socket.
3. Install pusher bolts in opposite sides and remove the cover. Pusher bolts are M16x120 fully threaded hex bolts.
4. Remove all bolts in drum using an M14 allen socket EXCEPT the two (2) recessed bolts that are in line with the grease port and grease relief. They should be directly under the two grease fittings and will be much further down in the drum than the mounting bolts holding the drum onto the unit. Keep this orientation in mind during reassembly.
5. Now you will remove the drum by finding the blocks most level and lift the drum off the shaft. You may need to use a pry bar to break it free from any dirt or debris if drums are used. Drums should come off smoothly.



ROCKWHEEL SERVICE DOCUMENT

G40 & G60 Drum Installation

Tools needed

- | | |
|--|--------------------------|
| • 14mm Allen socket | 20x M16x90mm socket head |
| • 19mm Allen socket | 8x M24x 80mm socket head |
| • Torque wrench capable of 1000 ft/lbs | 8x M16 x25mm socket head |

1. Lay the G40 or G60 with the side you are working on facing upwards to ease the installation of drum onto the shaft.
2. Carefully lower the drum down onto the shaft making sure to line up the through holes on the drum with the bolt heads protruding from the shrink disc. Figure 1 & figure 2.
3. Once drum is down install your M16 x 90 mm mounting bolts. In the case your drum does not go down over the double wound rings near the housing go to the next step. If the drum does go down over the rings easily skip to step 5
4. Install 4 of the M16 x 90 mounting bolts and tighten them up with a ratchet allowing some tension to be on the drum. While applying this tension you will need to turn the drum clockwise while continuing to apply more tension. Eventually the double wound rings will contract allowing the drum to completely install onto the shaft.

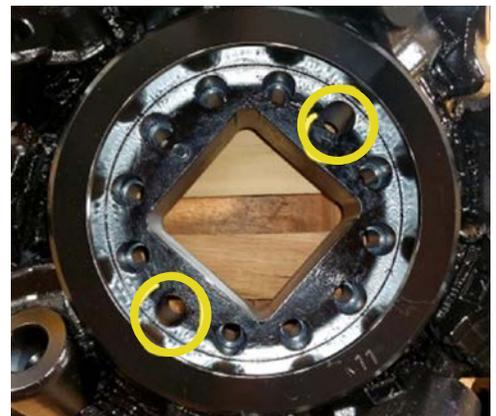


Figure 1. Align drum through holes with shrink disc bolt heads

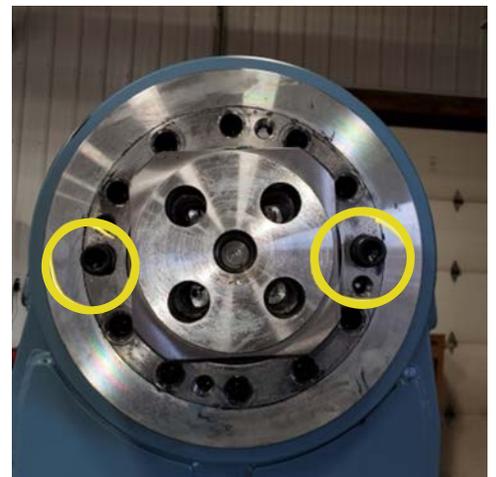


Figure 2. Shrink disc with bolt heads

ROCKWHEEL SERVICE DOCUMENT

G40 & G60 Drum Installation

5. The 10 M16 x 90mm mounting bolts need to be torqued to 269 dry ft/lbs.
6. Install drum cap but ensure the grease fittings line up with the two through holes on the drum. You may need to use an alignment bolt to make it easier to ensure proper drum cap position. Once it is lined up lightly tap on it until you can install the 4 M24 x 90 mm bolts to secure the cover to the end of the shaft. Figure 4. These bolts are torqued to 908 dry ft/lbs.
7. Lastly install the 4 M16 x 25 mm bolts to cover up the pusher holes in the cover and the drum installation is complete. These cover bolts only need to be torqued to 161 dry ft/lbs.

The cover should be flush and the drum should look like this when finished.

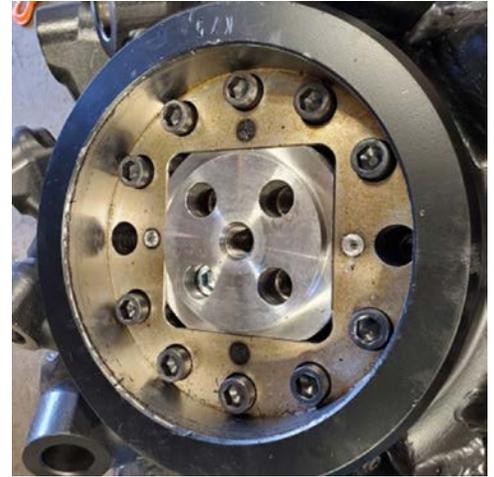


Figure 3. Install drum bolts to 269 ft/lbs.

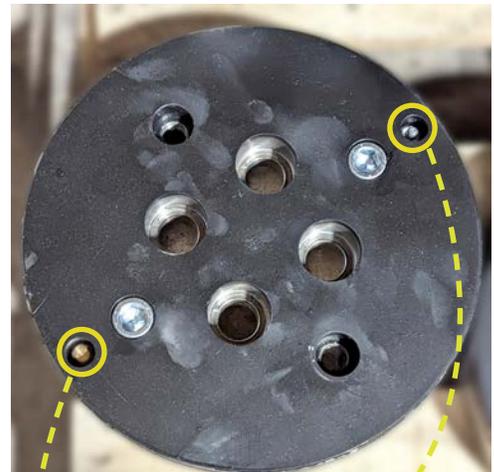


Figure 4. Align grease and breather fittings

