



AMC 20 Rear Axle 2-Piece Axle Shaft / Hub Installation Instructions

NOTE: New AMC 20 hubs do not have serrations in their bore. The serrations are created when installing the hub onto the axle shaft.

Installation

- The AMC 20 axle shafts and hubs are a matched pair. When using a replacement axle shaft, a replacement hub must also be used. When using a used hub on a replacement axle shaft, the fit will be loose, resulting in premature failure.
- When using a used axle shaft, a used hub removed from the same axle shaft may be used as long as the serrations on the axle shaft are not worn or damaged. However, a replacement hub is suggested.
- We suggest using a replacement axle shaft nut whenever servicing the axle shaft and hub (Replaces Part #: J3155675).

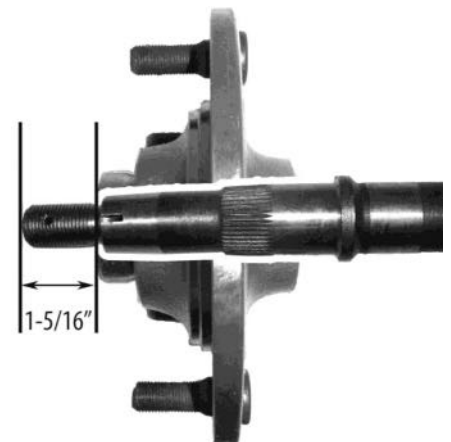
Installing a Used Hub on a Used Axle Shaft

1. Inspect the hub for loose or distorted wheel studs. Replace where necessary.
2. Inspect the keyway and bore of the hub for wear, damaged serrations, or cracks. Replace where necessary.
3. Thoroughly clean the hub, axle shaft, key, washer, and nut.
4. Install the key onto the axle shaft.
5. Install the hub onto the axle shaft, aligning the keyway in the hub with the axle shaft key.
6. Install the washer and nut and tighten until there is no slop between the axle shaft and the hub.
7. Install the drum, drum retaining screws, and wheel.
8. Lower the vehicle enough that the tire and wheel touch the ground and do not spin.
9. Torque the axle shaft nut to 250 ft. lbs. If the cotter pin hole is not aligned continue to tighten the nut to the next castellation and install the cotter pin. **DO NOT LOOSEN THE NUT TO ALIGN THE CASTELLATION.**
10. Install the cotter pin and the dust cap.
11. Fully lower the vehicle to the ground.

Installing a Replacement Hub on a Used or Replacement Axle Shaft with a Hydraulic Press

1. Thoroughly clean the hub, axle shaft, key, washer, and nut.
2. Install the key onto the axle shaft.
3. Install the hub onto the axle shaft, aligning the keyway in the hub with the axle shaft key.
4. Place the axle shaft and hub in the hydraulic press. Press the hub onto the axle shaft until the axle shaft protrudes out of the hub 1-5/16" (see diagram). Remove from the press.

NOTE: This dimension must be achieved in order to form the hub serrations. Failure to achieve the dimension will result in the hub spinning on the axle shaft in high-torque situations.

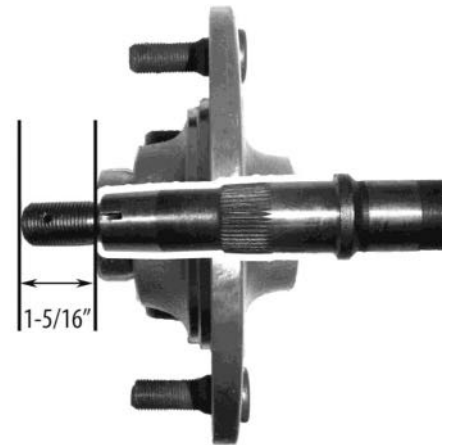


5. Install the washer and nut and tighten until there is no slop between the axle shaft and the hub.

6. Install the drum, drum retaining screws, and wheel.
7. Lower the vehicle enough that the tire and wheel touch the ground and do not spin.
8. Torque the axle shaft nut to 250 ft. lbs. If the cotter pin hole is not aligned continue to tighten the nut to the next castellation and install the cotter pin. DO NOT LOOSEN THE NUT TO ALIGN THE CASTELLATION.
9. Install the cotter pin and the dust cap.
10. Fully lower the vehicle to the ground.

Installing a Replacement Hub on a Used or Replacement Axle Shaft without a Hydraulic Press

1. Thoroughly clean the hub, axle shaft, key, washer, and nut.
2. Install the key onto the axle shaft.
3. Install the hub onto the axle shaft, aligning the keyway in the hub with the axle shaft key.
4. Lubricate 2 washers with a liberal amount of grease. Install the washers onto the axle shaft, followed by the axle shaft nut. Tighten the nut until there is no slop between the axle shaft and the hub.
5. Install the drum, drum retaining screws, and wheel.
6. Lower the vehicle enough that the tire and wheel touch the ground and do not spin.
7. Tighten the axle shaft nut until the axle shaft protrudes out of the hub 1-5/16" (see diagram).



NOTE: This dimension must be achieved in order to form the hub serrations. Failure to achieve the dimension will result in the hub spinning on the axle shaft in high-torque situations.

8. Remove the axle shaft nut and 1 washer.
9. Install the nut and torque to 250 ft. lbs. If the cotter pin hole is not aligned continue to tighten the nut to the next castellation and install the cotter pin. DO NOT LOOSEN THE NUT TO ALIGN THE CASTELLATION.
10. Install the cotter pin and the dust cap.
11. Fully lower the vehicle to the ground.

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