



INSTRUCTION MANUAL



Model 69290

BOLT HOLE CHAMFER WEAR GAUGE

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PURPOSE:

To provide a guide to visually detect excessive wear in .875R spherical chamfers of both holes in disc wheels.

APPLICATION:

The gauge is designed for use with ACCURIDE stud-piloted dual steel wheels which have .875R spherical chamfered bolt holes (3/8 to 1/2 inch disc thickness).

NOTE THIS GAUGE IS NOT DESIGNED TO BE USED WITH ACCURIDE DUPLEX R WHEELS, ACCURIDE ACCU-FORGE® ALUMINIUM WHEELS, OR OTHER ACCURIDE WHEELS WHICH HAVE THICKER DISCS.

INSTRUCTIONS:

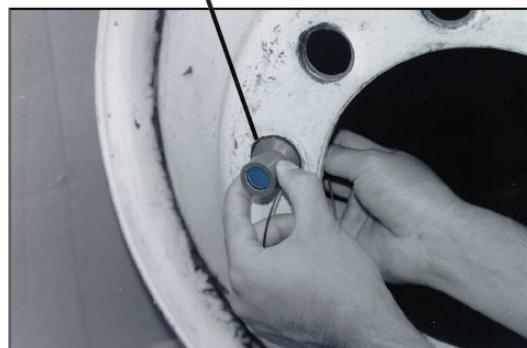
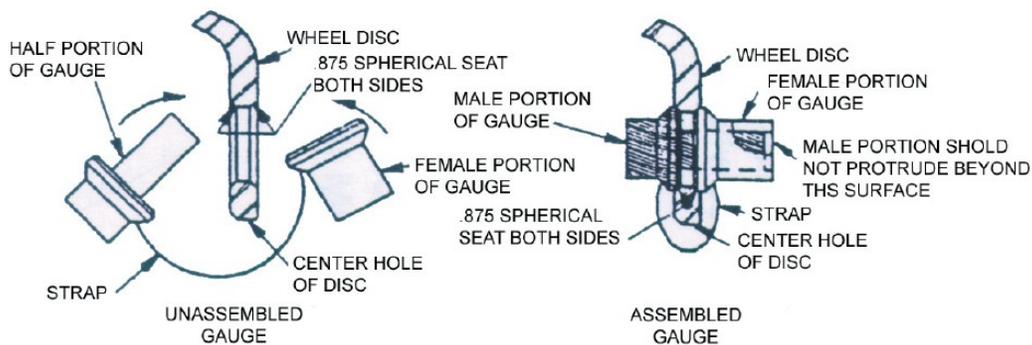
The condition of the bolt hole chamfer must allow the gauge to fit uniformly (no raised material).

From either side of the disc, insert the male (long) portion of the gauge through a bolt hole. It should fit the bolt hole chamfer uniformly and not wobble.

Pull the attached female (short) portion of the gauge through the disc center hole. Slide the female portion of the gauge over the male portion of the gauge (as shown). Seat the gauge snugly in the chamfer on the opposite side of the disc.

Once assembled, the end of the male portion of the gauge **SHOULD NOT PROTRUDE BEYOND THE END OF THE FEMALE PORTION OF THE GAUGE**. This can be determined by feel. If the male portion of the gauge protrudes, this indicates excessive wear in the bolt hole chamfer disc thickness.

Repeat the above procedure for every bolt of the wheel. If the male portion of the gauge protrudes while checking ANY ONE or MORE bolt holes, the wheel should be scrapped. Continued use of an excessively worn wheel can cause disc cracks or premature wheel failure.





INSTRUCTION MANUAL

NUT GAUGE (For .875R Ball Seat Nuts)

PURPOSE:

To provide a guide to determine if inner and outer cap nuts have the proper contour contact with .875R spherical chamfers of bolt holes in disc wheel. This gauge should be used with new nuts and worn nuts to determine their fitness for service.

NOTE: (1) THIS GAUGE IS NOT TO BE USED WITH COLLARED INNER CAP NUTS WITH ALUMINIUM WHEELS. BECAUSE OF VARIATIONS BETWEEN MANUFACTURERS NUTS, THIS GAUGE IS TO BE USED ONLY AS A GUIDE FOR INSPECTING NUTS.

INSTRUCTIONS:

Inner Cap Nut – 3/4" – 16

1. Concentricity is seen at the ball seat contour by rotating the nut on the small spindle. If the clearance between the gauge and nut changes, a worn or off center nut contact surface is indicated.
2. Ball seat contour of the nut should match that of the gauge – a small amount of clearance between gauge and ball seat is accepted if nut surface is parallel to gauge surface (this should not exceed .015").
3. Thread fit – a snug fit to the spindle indicates maximum thread diameter. Excessive wobble on gauge may indicate below minimum thread diameter.
4. The outer diameter of the nut must fit into the gauge. The base of the nut should contact the gauge completely. The ball seat should not show more than .015" clearance in any area.

Outer Cap Nut – 1 1/8" – 16

1. Concentricity is seen at the ball seat contour by rotating the nut on the large spindle. If the nut rides up (as shown), or the radius contacts only one side of the gauge, the nut is worn off center.
2. Ball seat contour of the nut should contact of the gauge contour. The ball seat should not show more than .015" clearance in any area. The tip of the nut hex should be radiuses without sharp edges.
3. Thread Fit – a snug fit to the spindle indicates maximum thread diameter. Excessive wobble on gauge may indicate below minimum thread diameter.

