

Date: 30.08.2019

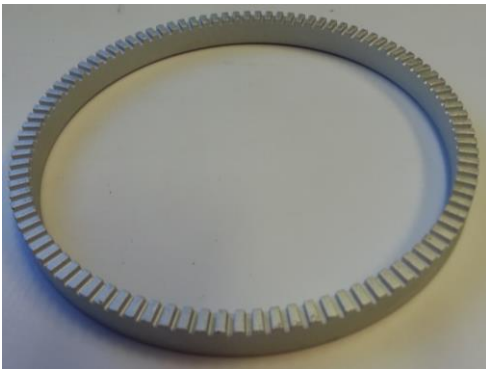
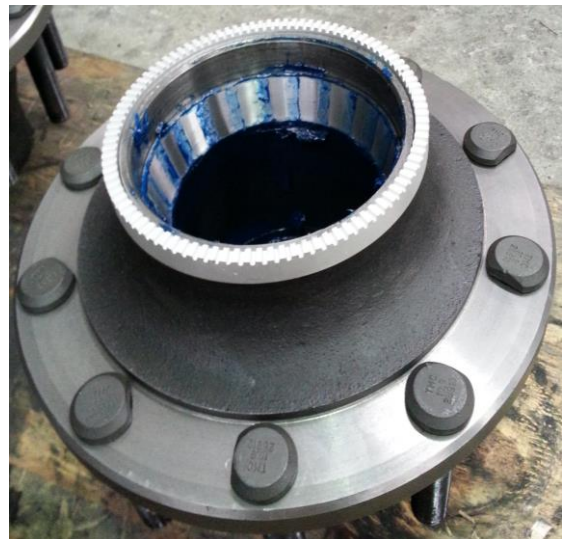
Subject: ABS pole ring and sensor block fitment on Drum brake axles.

This Bulletin specifies how to assemble a pole ring onto a hub and welding of the sensor block onto an axle. This applies to drum brake axles configuration only.

Contact TMC Australia for part numbers and quantity needed. Type of hubs (alloy or steel) and brake configuration are required as the part numbers may vary.

Assembly of pole ring (Machined pole ring and Stamped pole ring)

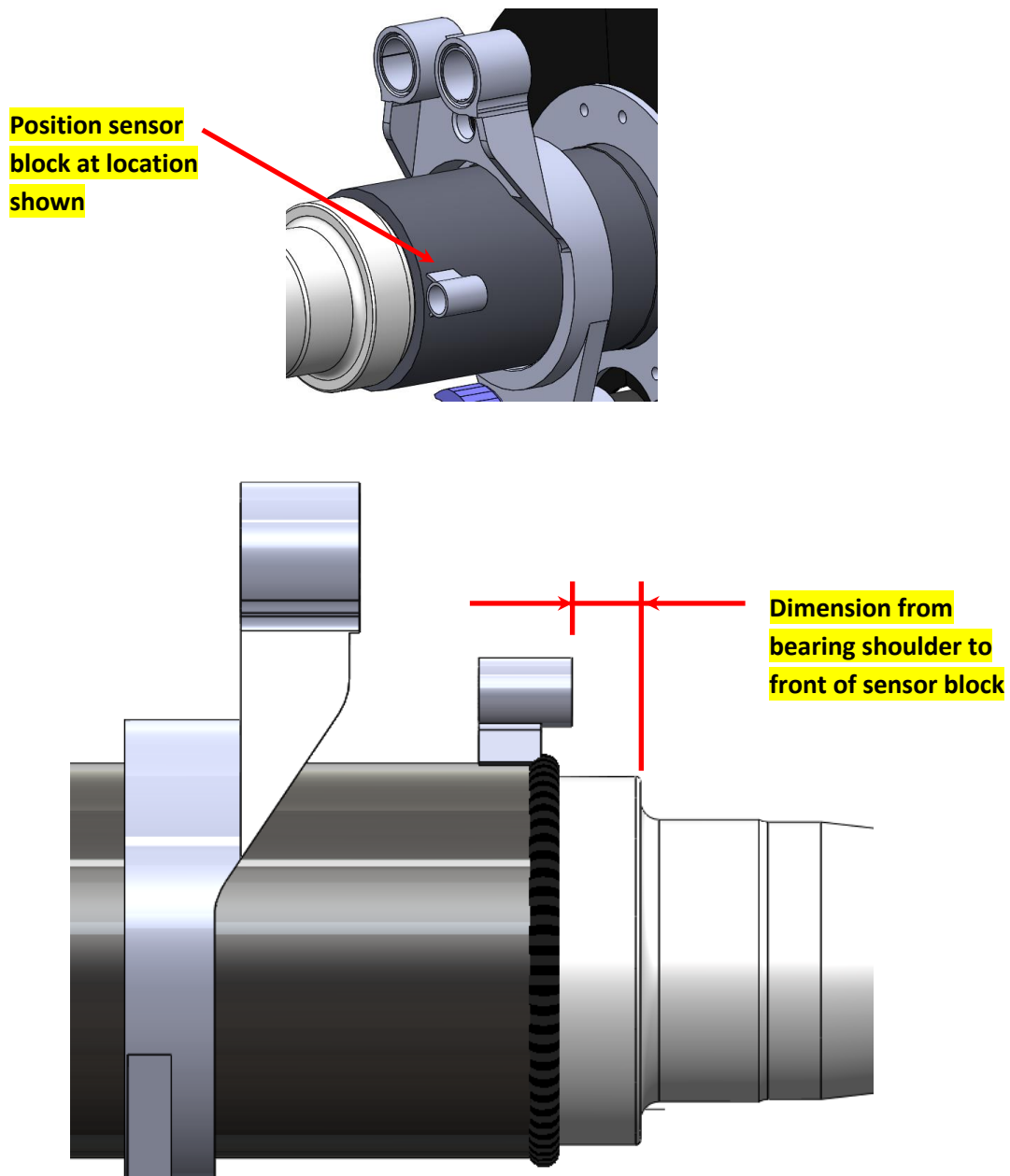
- Remove hub and drum from axle.
- Clean all corrosion and contamination from hub surface (where pole ring sits).
- Machined pole ring - Heat up pole ring **evenly** using oxy acetylene torch for about 1 minute (DO NOT TOUCH POLE RING (HOT!) & DO NOT CUT/DAMAGE RING) and fit onto the back of the hub. Ensure pole ring sits flat on hub.
- Stamped pole ring - Place ring onto back of the hub and gently tap ring into position. Visually inspect the ring to ensure that it is completely seated onto the hub.
No heating is required.

**Machined Pole Ring****Stamped Pole Ring****Heating up pole ring using Oxy-Acetylene****Steel Hub Drum Brake with pole ring fitted**

Date: 30.08.2019

Assembly of sensor block

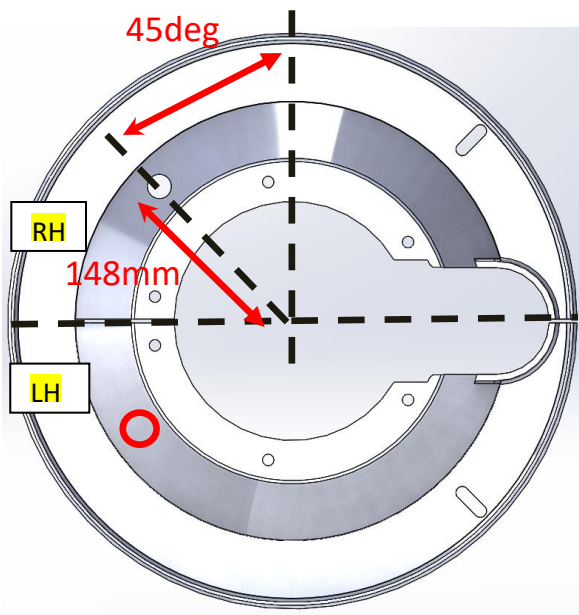
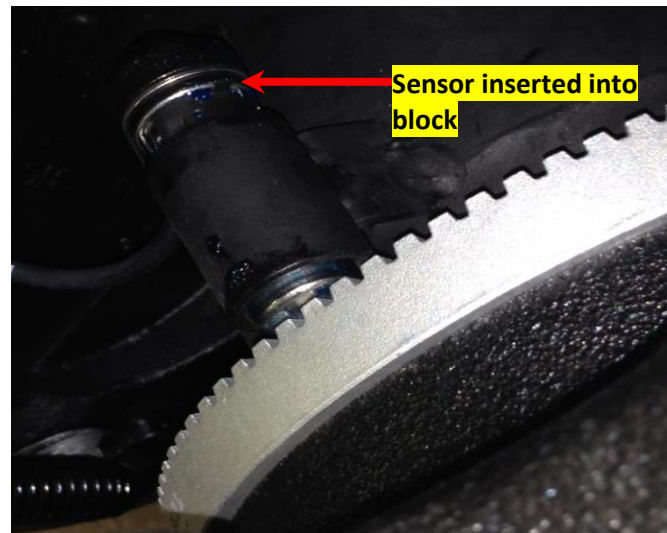
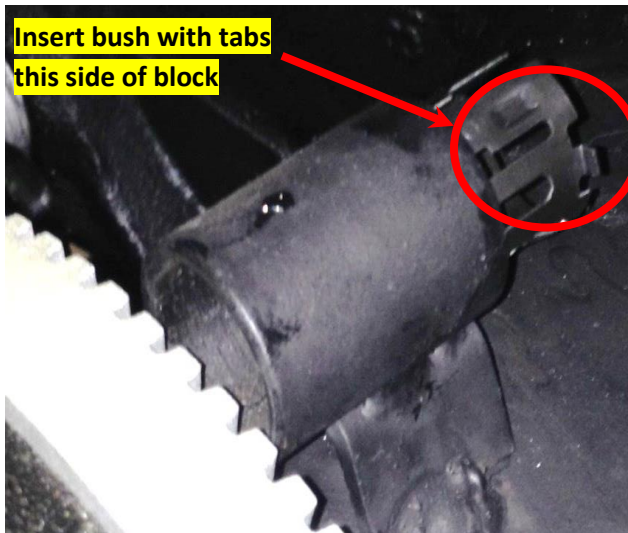
- With hub and drum removed, clean all contaminants from axle beam and bearing edge shoulder.
- Position sensor block at location shown. Dimension required from edge of bearing shoulder to front of sensor block are as follows:
 - **TN & TP = 22 +/- 1mm**
 - **UB90 = 59 +/-1mm**
 - **UB82 = 37 +/-1mm**
- Spot weld both sides of sensor block (at least 4mm continuous fillet weld) to axle beam. **AVOID WELD SPATTER ON OIL SEAL AND BEARING JOURNAL. CLEAN UP IF REQUIRED.**



Date: 30.08.2019

Assembly of sensor bush and leads

- Assemble hub with pole ring onto axle and adjust bearings as required.
- Insert sensor bush into sensor block/brackets as shown. Ensure correct orientation of bush.
- Lightly grease sensor and insert into bracket. Push sensor leads until it contacts the pole ring.

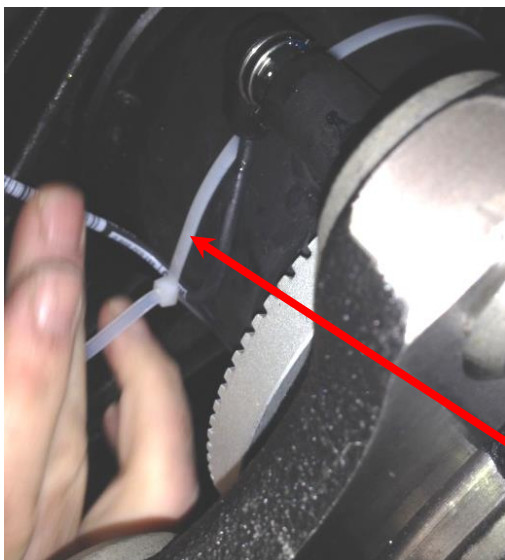


Dust cover with hole drilled to suit sensor lead

- (22.5" axle only) Drill a 19mm diameter hole on the right dust cover (see picture below). Drill a 19mm diameter hole on the opposite side for the left hand dust cover.
- Insert rubber grommet into drilled hole (*grommet size - 7/16" ID, 3/4" OD, 1/16" thick*)

Date: 30.08.2019

- Fit dust covers back onto axle and route lead thru the grommets. Cable tie lead at block and another one behind dust cover. **DO NOT KINK** sensor leads.



Cable tie lead at
two positions

