PINION NUT REPLACEMENT PROCEDURE
STAKING & DE-STAKING PINION NUTS

DATE: 4/5/2010

TO: All Service Departments

All D170 / R170 & D190 / R190 Drive Axles Input & Rear Pinion Locations only

Dana have noticed an increase in Pinion / Input shaft thread damage claims. The explanation to why this kind of damage is being experienced in the field is that the nut is not being De-Staked prior to removal. Claims for damaged threads that are found to be as a result of the nut not being de-staked will not be accepted.

Shown below are detailed instructions on how to properly stake and de-stake the input and / or Rear pinion nuts for Dana’s 170 & 190 drive axles. It is important to follow the procedure carefully. Failure to de-stake the nut may cause damage to the input shaft or pinion threads. Failure to stake the nut properly may result in the nut coming loose during service.

The nut should never be reused, always replace with new.

De-staking Instructions:
1. Disconnect the driveline from the yoke.
2. Before removing the nut it must be De-staked. Use a chisel or drift with a round trip. The flange of the nut must be pushed far enough outward so that the staked area will not interfere with the shafts threads when the nut is removed. The nut should not be reused for any reason. See diagram below.

Caution: Failure to de-stake the nut will result in damage to the shafts threads when removed.
Staking Instructions:
1. Install driveline yoke.
2. Apply Loctite 270 to the threaded area of the Input shaft and / or the rear pinion.
3. Install flanged nut; run down with an impact wrench.
4. Torque the Input or rear pinion nut to 800 – 1000 ft. lbs. (1084 – 1355 N.m).
5. Use a punch with a round tip to stake the nuts flange into the machined slot of the shaft. The stake must be deep enough to enter the machined slot. Failure to stake the nut properly may result in the nut coming loose during service.

The nut should never be reused, always replace with new.

See diagram below.

Warning: Failure to stake the nut properly may result in the nut coming loose during service. The nut should never be reused, always replace with new.

Current literature can be downloaded from www.spicerparts.com. Click on the Literature button or The EXPERT® icon, and navigate to the literature needed.

Should you have any queries on the above or require further information, please contact Dana Australia on 1300 00 DANA

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