

# INSTALLATION - SERVICE INSTRUCTIONS

765 South Pierce Avenue Louisville, Colorado 80127

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Bulletin #32 page 1 of 3 **40 Spline Floater Assembly**

March 2017

## 55XXX FLOATER ASSEMBLY PART LIST PRE (2009 SERIES II DESIGN) 95XXX FLOATER ASSEMBLY SERIES II DESIGN (2010 AND LATER), PAGE 3

### PART NUMBERS:

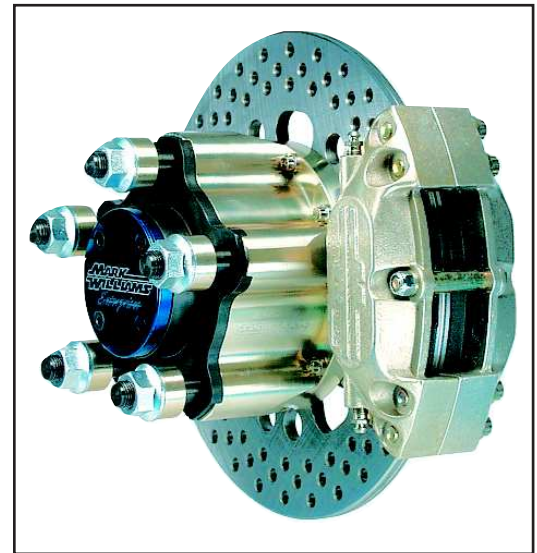
### DESCRIPTION

|            |   |
|------------|---|
| 55700..... | Complete full floater assembly, 5" B.C..            |
| 55750..... | Full floater assembly, 5" B.C. (less spindles).     |
| 55800..... | Complete full floater assembly, 5 1/2" B.C.         |
| 55750..... | Full floater assembly, 5 1/2" B.C. (less spindles). |

55800 Assembly

### PARTS INCLUDED:

|                                     |  |
|-------------------------------------|--|
| 2 - 55001..(55700, 55750 kits)..... | 5" BC Aluminum floater hub.                    |
| 2 - 55030..(55800, 55850 kits)..... | 5 1/2" BC Aluminum floater hub.                |
| 4 - 55010.....                      | Sealed hub bearing.                            |
| 2 - 55020.....                      | Drilled steel brake rotor .                    |
| 20 - 215.05.16NF.....               | Brake rotor mounting bolt.                     |
| 2 - 55005..(55700, 55750 kits)..... | 5" BC drive plate.                             |
| 2 - 55031..(55800, 55850 kits)..... | 5 1/2" BC drive plate.                         |
| 2 - 55004.....                      | Floater spindle w/seat ring.                   |
| 2 - 55021.....                      | Caliper mounting bracket.                      |
| 8 - 03224334.....                   | Caliper bracket bolt.                          |
| 8 - AN960-616, 21FC-624.....        | Caliper bracket washer and nut.                |
| 2 - 81100.....                      | MW 4 piston brake caliper.                     |
| 4 - 81130.....                      | MW brake linings.                              |
| 4 - AN6-10A, AN122584.....          | Caliper bolt and hardened washer.              |
| 2 - 55028.....                      | Spacer, between bearings                       |
| 2 - 55018.....                      | Drive plate cover.                             |
| 8 - 03213824.....                   | Drive plate cover bolt.                        |
| 2 - -034.....                       | Drive plate cover "O" ring.                    |
| 2 - RSN168.....                     | Axle retaining spiral lock ring.               |
| 2 - 3100-255.....                   | Hub retaining snap ring.                       |
| 2 - 76X6261.....                    | Spindle seal.                                  |
| 10 - 55030.....                     | Steel flanged Snap-Lock lug nut.               |
| 10 - 515X1.....                     | Wheel stud (see variables below).              |
| 10 - 5501X.....                     | Aluminum lug nut washer (see variables below). |



### VARIABLE PARTS:

|            |                                       |
|------------|---------------------------------------|
| 51561..... | Wheel stud, 2" long shoulder.         |
| 55019..... | Wheel stud, 2.812" long shoulder.     |
| 55013..... | Aluminum lug nut washer, 3/8" thick.  |
| 55014..... | Aluminum lug nut washer, 9/16" thick. |
| 55015..... | Aluminum lug nut washer, 3/4" thick.  |

### PRIMARY APPLICATIONS:

Drag racing. Any class requiring floating rear axle, advanced ET to Top Fuel.

### INSTALLATION OVERVIEW:

- 1) After the floater spindles have been welded on the housing tubes and all bracing is completed install spindle seals.
- 2) Slide the caliper bracket onto the spindle (make sure the threaded inserts in the bracket are facing out). Brackets center on the ring against the flange of the spindle. Align holes in the bracket with holes in the flange to position the brake caliper to the rear and install the 3/8" flat head allen bolts with self locking nuts and washers.
- 3) Slide assembled floater hubs (brake rotor and studs installed) onto the spindle. Inner bearing must seat against ring on the spindle then install the large snap ring retainer.
- 4) Install spiral lock on the end of the floater axles and slide them thru the drive plates until the spiral lock seats against the face of the drive plate then install the blue anodized covers with the "O" rings in place using the 1/4" flat head allen bolts. (Note: If using one piece axle spiral locks are not used)
- 5) Install brake calipers and brake linings. Check that the caliper is centered on the brake disc. If required, install shims to make final alignment. Shims can be placed between the bracket and spindle (p/n 55030) to move caliper towards wheel. Shim (p/n 71018) can be placed between caliper and bracket to move caliper towards center of rear.
- 6) Slide assembled axles and drive plates into the spindle and seat the drive plate against the face of the hub.

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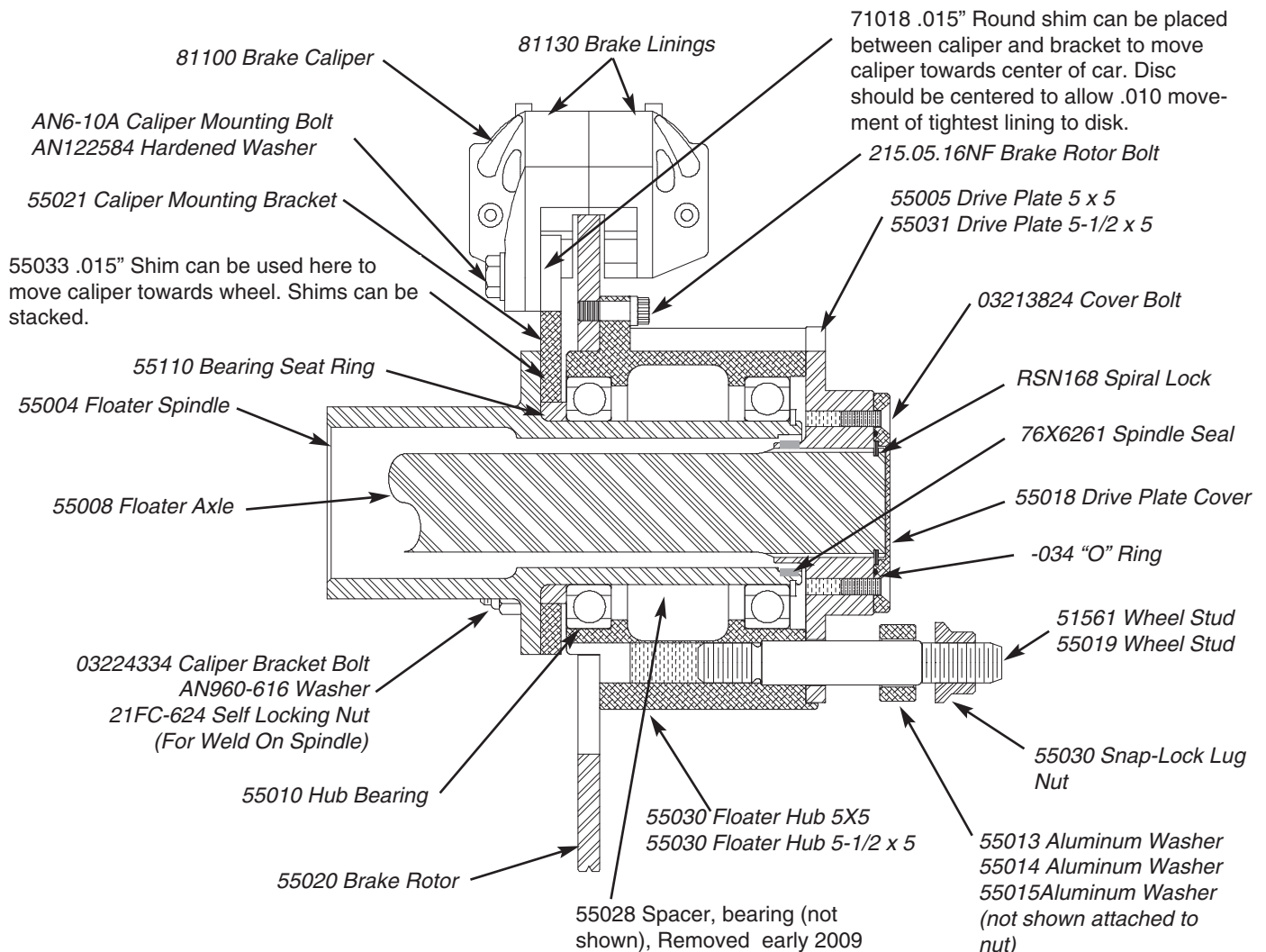
## TORQUE SPECS:

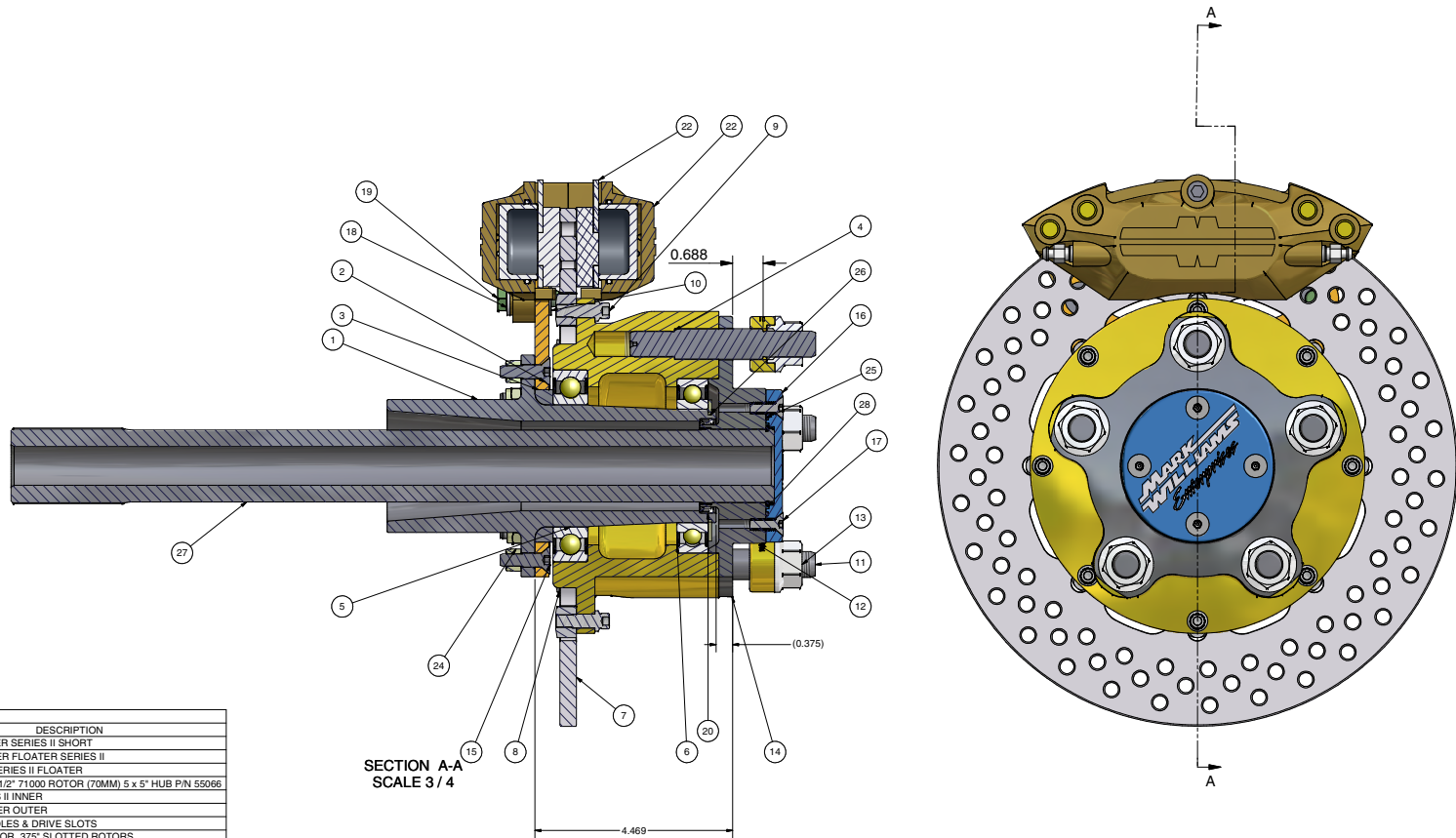
Drive plate cover bolts (1/4-20) 15-20 ft/lbs.  
 Caliper bracket bolts, caliper mounting bolts (3/8-24) 30-35 ft/lbs.  
 Lug nuts (5/8-18) 95-100 ft/lbs.

## MAINTENANCE REQUIREMENTS:

Periodic visual inspection of entire assembly is required. Check torque on all fasteners. Inspect brake rotors for excessive heat and run-out. Inspect for flatness and minimum thickness (.320"). Disc cannot be resurfaced. Replace Disc when worn or warped. Rotate hub assembly with axle and drive plate removed to check hub bearings for smoothness.

## 55XXX FLOATER ASSEMBLY PART LIST PRE (2009 SERIES II DESIGN)






| Parts List |     |                    |   |
|------------|-----|--------------------|---|
| ITEM       | QTY | PART NUMBER        | DESCRIPTION   |
| 1          | 1   | 90304              | SPINDLE, FLOATER SERIES II SHORT                            |
| 2          | 1   | 90301              | BRACKET, CALIPER FLOATER SERIES II                          |
| 3          | 1   | 90310              | RING, SPINDLE SERIES II FLOATER                             |
| 4          | 1   | 55068              | HUB, FLOATER 5-1/2" 71000 ROTOR (70MM) 5 x 5" HUB P/N 55068 |
| 5          | 1   | 6014-2RS1          | BEARING, SERIES II INNER                                    |
| 6          | 1   | 6013-2RS1          | BEARING, FLOATER OUTER                                      |
| 7          | 1   | 71010              | DISC, STEEL L HOLES & DRIVE SLOTS                           |
| 8          | 8   | 71032              | BUTTON, DRIVE FOR .375" SLOTTED ROTORS                      |
| 9          | 8   | 71033              | BOLT, 12 POINT BRAKE ADAPTOR                                |
| 10         | 2   | 71017              | INSERT, CALIPER   |
| 11         | 5   | 93061              | DRIVE STUD, SERIES II FLOATER C=2"                          |
| 12         | 5   | 550XX              | WASHER, DRIVE STUD  |
| 13         | 5   | 51530              | LUG NUT, CARBON STEEL, SNAP WASHER (MW)                     |
| 14         | 1   | 55031              | DRIVE PLATE, 40 SPLINE W/ 5-1/2" B.C.                       |
| 15         | 7   | 90340              | BOLT, CALIPER BRACKET 5/16-18 X 1                           |
| 16         | 1   | 55018              | COVER, DRIVE PLATE 40 SPLINE                                |
| 17         | 4   | 03213824           | 1/4-20 X 3/4 FLAT HEAD SCOKET DRIVE                         |
| 18         | 2   | AN122584           | WASHER, HARD 3/8 .078 THICK                                 |
| 19         | 2   | AN6-10A            | BOLT, AIRFRAME 3/8 X 1.078                                  |
| 20         | 1   | 76X6261            | SEAL, FLOATER SPINDLE, TO DRIVE PLATE                       |
| 22         | 3   | 81100              | BRAKE CALIPER ASSEMBLY                                      |
| 23         | 1   | 002912N            | BOLT, FLOATER SPINDLE (WELD ON)                             |
| 24         | 8   | 5/16-24 NYLOCK NUT | 5/16-24 NYLOCK NUT (WELD ON FLOATER)                        |
| 25         | 1   | -Q34 INSTALLED     | O-RING BUNA -N 2-1/4 OD X 1/16                              |
| 26         | 1   | 3100-255           | RING, RETAINING FLOATER SPINDLE                             |
| 27         | 1   | 55008-10-XX        | AXS 40 SPLINE GUN DRILL (SPECIFY LENGHT)                    |
| 28         | 1   | RSN168             | RETAINING RING, SPIRAL-LOCK                                 |

SECTION A-A  
SCALE 3/4

**ASSEMBLY PARTS LIST 5 HOLE X 5-1/2" BOLT CIRCLE**  
95800 FLOATER ASSEMBLY WITH SPINDLE  
95850 FLOATER ASSEMBLY FOR MODULAR HOUSING

**ASSEMBLY PARTS LIST 5 HOLE X 5" BOLT CIRCLE**  
95700 FLOATER ASSEMBLY WITH SPINDLE  
95750 FLOATER ASSEMBLY FOR MODULAR HOUSING

| MATERIAL                                   | HEAT TREAT           | <br><b>765 SOUTH PIERCE AVE, LOUISVILLE, CO 80027</b>  |  |
|--|----------------------|---|--|
|  |                      | <small>THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION. IT MAY NOT BE REPRODUCED, TRANSMITTED TO OTHER DOCUMENTS, DISCLOSED TO OTHERS, USED FOR MANUFACTURING OR ANY OTHER PURPOSE WITHOUT PRIOR WRITTEN PERMISSION.</small> |  |
| Z:\InventorFiles\Assembly_Files\AS0098.iam |                      | CAD NO.<br>AS0098.idw   | DRAWN BY<br>mwilliams<br>DATE<br>12/1/2009 |
| STOCK INFORMATION                          | MACHINING TOLERANCES | TITLE<br>FLOATER ASSEMBLY SERIES II   |  |
| BAR LENGTH: 0                              | WEIGHT: 0            | .XX   | .XXX                                       |
| WELDS PER BAR: 0                           |                      | .015  | .005                                       |
| PROCESS WEIGHT (PART): 0                   |                      | .0005   | 1/2  |
|  |                      | PLOT DATE<br>3/7/2017   | PART NUMBER<br>95800/95850                 |
|  |                      | CHANGE<br>NA  |  |
| SURFACE FINISH UNLESS NOTED                |                      |   |  |