

**AAR Manual of Standards and Recommended Practices**  
**Wheels and Axles**

---

**TABLE OF CONTENTS**

<b>Subject</b>	<b>Standard</b>	<b>Page</b>
1.0 Mandatory Rules Governing Wheel Shop Practices as Required by Interchange Rules	S-659	G-II-1
Rule 1.1 Axles—General Practices	S-659	G-II-1
Rule 1.2 Axles—Roller Bearing Practices	S-659	G-II-5
Rule 1.3 Wheels—Boring Mill Practices	S-659	G-II-9
Rule 1.4 Wheels—Mounting Press Practices	S-659	G-II-10
Rule 1.5 Wheel Lathe Practices	S-659	G-II-14
Rule 1.6 Standard Gauges	S-659	G-II-16
Rule 1.7 General Practices	S-659	G-II-16
Rule 1.8 Roller Bearing Mounting and Removal	S-659	G-II-18
2.0 Recommended Wheel Shop Practices	RP-631	G-II-27
2.1 Axle Lathe Practices	RP-631	G-II-27
2.2 Boring Mill Practices	RP-631	G-II-27
2.3 Wheel Mounting Press Practices	RP-631	G-II-28
2.4 Wheel Lathe Practices	RP-631	G-II-31
2.5 Wheel Shop Inspection	RP-631	G-II-32
2.7 Teardown	RP-631	G-II-34
2.8 MD-11 Reporting	RP-631	G-II-34
2.9 Steel Wheel Defects	RP-631	G-II-51
3.0 General Requirements and Information	RP-632	G-II-61
3.1 Wheel, Axle, and Bearing Failure Reports	RP-632	G-II-61
3.2 Handling, Shipment, and Storage of Wheels and Axles	RP-632	G-II-61
3.3 Wheel and Axle Specifications and Designs	RP-632	G-II-62
4.0 Figures	RP-633	G-II-65
5.0 Gauges—Wheel and Axle Shop	RP-634	G-II-143
6.0 Wheel-Mounting Compound Approval Test Procedure	RP-750	G-II-181
Appendix A. Approved Materials	S-727	G-II-185

IMPLEMENTED 02/04/2019

**AAR Manual of Standards and Recommended Practices  
Wheels and Axles**

---

**TABLE OF CONTENTS—ALPHABETICAL**

Subject	Standard	Page
Approved Materials	S-727	G-II-185
Axle Lathe Practices	RP-631	G-II-27
Axles—General Practices	S-659	G-II-1
Axles—Roller Bearing Practices	S-659	G-II-5
Boring Mill Practices	RP-631	G-II-27
Figures	RP-633	G-II-65
Gauges—Wheel and Axle Shop	RP-634	G-II-143
General Practices	S-659	G-II-16
General Requirements and Information	RP-632	G-II-61
Handling, Shipment, and Storage of Wheels and Axles	RP-632	G-II-61
Mandatory Rules Governing Wheel Shop Practices as Required by Interchange Rules	S-659	G-II-1
MD-11 Reporting	RP-631	G-II-34
Recommended Wheel Shop Practices	RP-631	G-II-27
Roller Bearing Mounting and Removal	S-659	G-II-18
Standard Gauges	S-659	G-II-16
Steel Wheel Defects	RP-631	G-II-51
Teardown	RP-631	G-II-34
Wheel and Axle Specifications and Designs	RP-632	G-II-62
Wheel Lathe Practices	S-659	G-II-14
Wheel Lathe Practices	RP-631	G-II-31
Wheel-Mounting Compound Approval Test Procedure	RP-750	G-II-181
Wheel Mounting Press Practices	RP-631	G-II-28
Wheel Shop Inspection	RP-631	G-II-32
Wheel, Axle, and Bearing Failure Reports	RP-632	G-II-61
Wheels—Boring Mill Practices	S-659	G-II-9
Wheels—Mounting Press Practices	S-659	G-II-10

**IMPLEMENTED 02/04/2019**

**AAR Manual of Standards and Recommended Practices  
Wheels and Axles**

---

**TABLE OF CONTENTS—NUMERICAL**

<b>Standard</b>	<b>Subject</b>	<b>Page</b>
RP-631	Recommended Wheel Shop Practices	G-II-27
RP-632	General Requirements and Information	G-II-61
RP-633	Figures	G-II-65
RP-634	Gauges—Wheel and Axle Shop	G-II-143
RP-750	Wheel-Mounting Compound Approval Test Procedure	G-II-181
S-659	Mandatory Rules Governing Wheel Shop Practices as Required by Interchange Rules	G-II-1
S-727	AAR-Approved Wheel Mounting Lubricants/Compounds	G-II-185

**FORMS**

<b>Subject</b>	<b>Fig. Number</b>	<b>Page</b>
MD-11 Roller Bearing Hot Box and Shop Inspection Report	4.81	G-II-139
MD-11A Recommended Bearing Inspection Report	2.14	G-II-48
MD-12 AAR Failed Axle Report	4.77	G-II-132
MD-115 AAR Failed Wheel Report	4.78	G-II-135
Form 101 Wheel Shop—Periodic Machinery Inspection	4.76	G-II-130

IMPLEMENTED 02/04/2019

**AAR Manual of Standards and Recommended Practices  
Wheels and Axles**

---

THIS PAGE LEFT BLANK INTENTIONALLY

IMPLEMENTED 02/04/2019