

MERITOR®
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Service Parts Instructions

Installing Bridge Bolts on Meritor Four-Piston Quadraulic™ Disc Brake Calipers Using Kit 6172

Hazard Alert Messages

Read and observe all Warning and Caution hazard alert messages in this publication. They provide information that can help prevent serious personal injury, damage to components, or both.

WARNING

To prevent serious eye injury, always wear safe eye protection when you perform vehicle maintenance or service.

Park the vehicle on a level surface. Block the wheels to prevent the vehicle from moving. Support the vehicle with safety stands. Do not work under a vehicle supported only by jacks. Jacks can slip and fall over. Serious personal injury and damage to components can result.

Do not remove the bridge bolts to perform normal service procedures. If the bridge bolts are removed, they must all be replaced and installed correctly or serious personal injury, brake loss or damage to components can result.

ASBESTOS AND NON-ASBESTOS FIBERS WARNING

Some brake linings contain asbestos fibers, a cancer and lung disease hazard. Some brake linings contain non-asbestos fibers, whose long-term effects to health are unknown. You must use caution when you handle both asbestos and non-asbestos materials.

How to Obtain Additional Maintenance and Service Information

Refer to Maintenance Manual MM-2075, Four-Piston Quadraulic™ Disc Brake Caliper. To obtain this publication, visit Literature on Demand at arvinmeritor.com.

How to Obtain Kits

Kit 6172 contains four bridge bolts and washers for installation on Quadraulic™ disc brake calipers.

To obtain Kit 6172, call Meritor Aftermarket at 888-725-9355.

How to Obtain Tools

Order Owatonna tools from OTC Tool and Equipment Division, 655 Eisenhower Drive, Owatonna, MN 55060.

Inspection Guidelines to Determine If You Should Replace Just the Bridge Bolts or Replace the Caliper

Use the following inspection guidelines to determine if you should replace just the bridge bolts, or if you should replace the caliper.

Replace All of the Bridge Bolts:

- If one bolt is missing on either side of the caliper.
- If one bolt is missing on each side of the caliper.


Replace the Caliper:

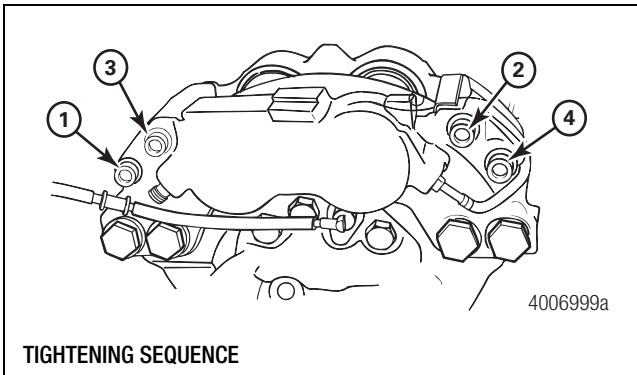
- If two bolts are missing on the same side of the caliper.

Procedure

If a bridge bolt was removed or broken, replace the bridge bolts and washers on the caliper with four new bridge bolts and washers. Install and tighten the bridge bolts in the correct sequence according to the following procedure. Do not rebuild the calipers with used caliper parts.

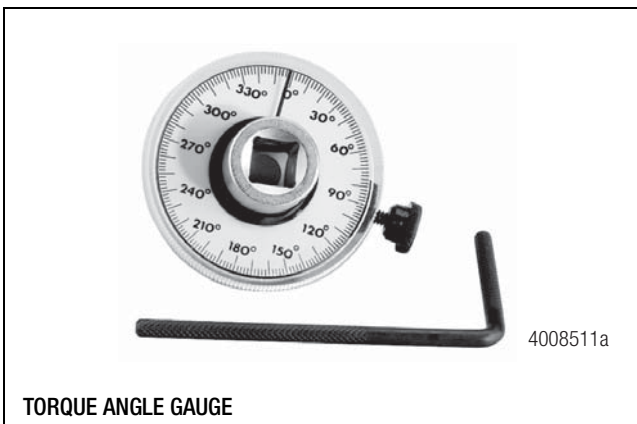
1. Wear safe eye protection.
2. Remove the caliper from the vehicle to perform service.
3. Verify the two caliper halves are seated. If necessary, lightly press the halves together until correctly seated.
4. Loosely assemble all bridge bolts and washers.

5. Perform the following two step bolt tightening procedure.
 - A. Tighten all four bolts to an initial torque of 50 lb-ft (68 N•m) in the sequence 1, 2, 3, 4. Figure 1. 
 - B. Use torque angle equipment, OTC torque angle gauge (OTC part number 4554) or equivalent, to turn the bolts 70 +3/-2 degrees in the sequence 1, 2, 3, 4. Figure 1 and Figure 2.



TIGHTENING SEQUENCE

Figure 1



TORQUE ANGLE GAUGE

Figure 2

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