

BRAKE SERVICE NOTES

INSTALLATION INFORMATION:

NOTE: PREASSEMBLY PREP OF MOUNTING STUDS

1. APPLY LOCITE OR DOW CORNING MOLY DRY FILM LUBRICANT TO BODY (NOT THREADS) OF STUD AND ALLOW TO DRY.
2. SPRAY THREADS ONLY WITH LOCITE ACTIVATOR 7471 OR 7649 AND ALLOW TO DRY.

ASSEMBLY INFORMATION:

IMPORTANT:

THERE MAY BE MORE PARTS IN A SERVICE KIT THAN YOUR BRAKE REQUIRES. CHECK THE PARTS LIST CAREFULLY FOR THE EXACT QUANTITY.

BRAKE ASSEMBLY INFORMATION:

NOTE: ALL PARTS MUST BE THOROUGHLY CLEANED PRIOR TO ASSEMBLY.

1. INSERT BUSHINGS.
2. LUBRICATE BUSHINGS WITH A HIGH TEMPERATURE GREASE BEFORE ASSEMBLY. (USE ONLY IF MOLY DRY FILM LUBRICANT IS NOT USED)
3. LUBRICATE THE CYLINDER OF THE HOUSING SQUARE-RING, THE BOOT, AND PISTON BEFORE RE-ASSEMBLY.
4. INSTALL THE SQUARE-RING IN THE GROOVE IN THE CYLINDER BORE FURTHEST FROM THE OPENING.
5. INSTALL A BOOT ONTO THE PISTON. THE SMALL OPENING OF THE BOOT IS TO BE SEATED IN THE GROOVE ON THE FRONT SIDE OF THE PISTON. PULL THE BOOT OVER THE FULL LENGTH OF THE PISTON AND EXTEND THE BOOT BEYOND THE END OF THE PISTON ABOUT 1/4" (INCH). START THE BOOT LIP INTO THE CYLINDER GROOVE. USE A VICE OR SHOP PRESS TO SLOWLY MOVE THE PISTON INTO THE CYLINDER UNTIL THE PISTON BOTTOMS OUT. VERIFY THAT THE BOOT HAS PROPERLY SEATED IN THE CYLINDER BORE GROVE.
6. ASSEMBLE ONTO TORQUE PLATE AS NOTED IN INSTALLATION INFORMATION.

GENERAL SERVICE INFORMATION:

1. REMOVE PIN CLIPS FROM CLEVIS PINS AND SLIDE OUT OF HOUSING.
2. DISCARD WORN STATOR PADS.
3. INSERT CLEVIS PINS INTO BRAKE AND THROUGH EARS OF NEW STATOR PADS. INSTALL PINS CLIP INTO CLEVIS PINS.

BRAKE DISASSEMBLY INFORMATION:

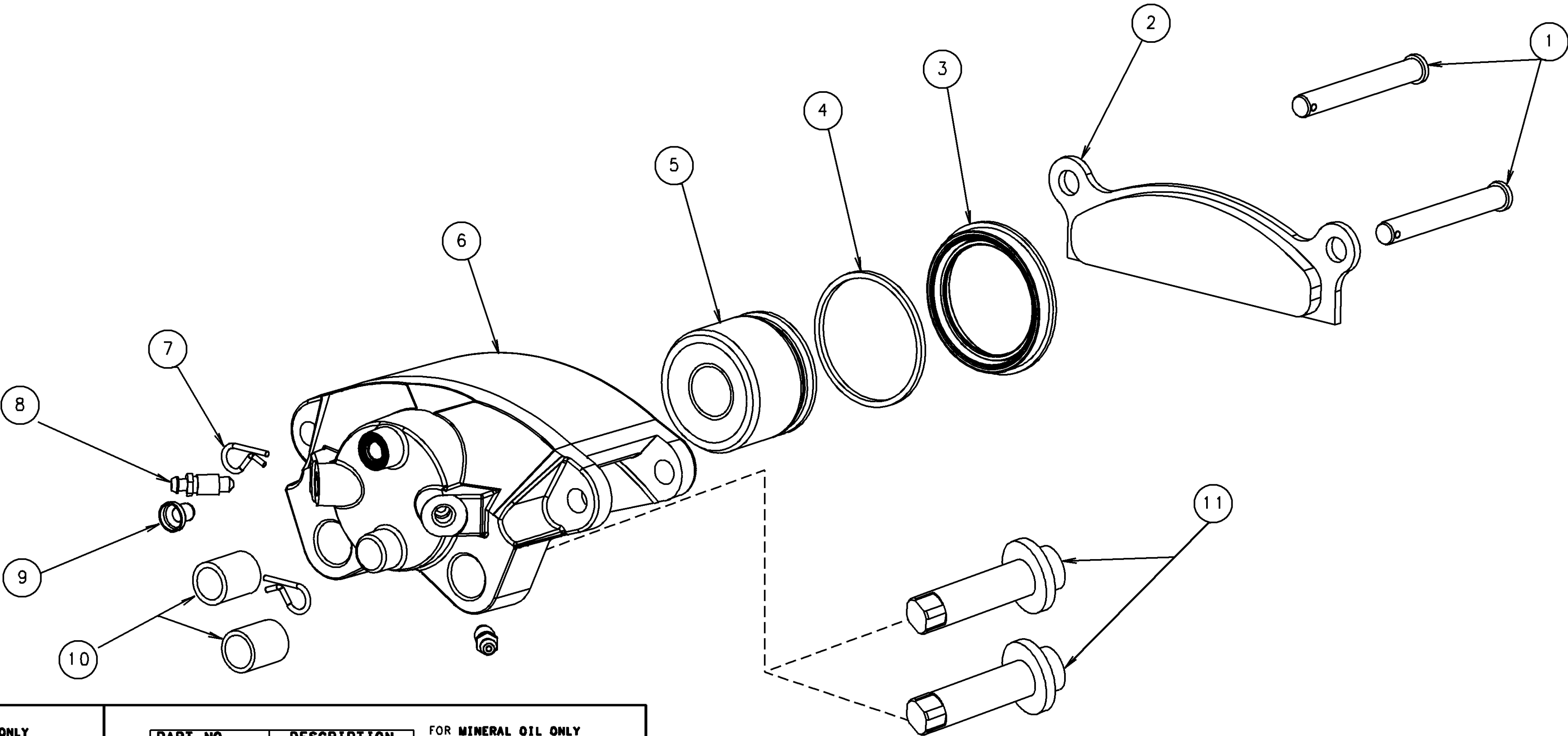
1. REMOVE PIN CLIPS FROM CLEVIS PINS AND SLIDE OUT OF HOUSING.
2. DISCARD WORN STATOR PADS.
3. LOOSEN MOUNTING STUDS FROM TORQUE PLATE.
4. REMOVE CALIPER FROM TORQUE PLATE.
5. REMOVE BOOT AND PISTON FROM THE HOUSING AT THE SAME TIME. DO SO BY HOLDING THE BRAKE AGAINST A TABLE SURFACE WITH THE PISTON FACING DOWN AND SLOWLY APPLYING AIR PRESSURE TO THE INLET PORT. ONCE THE PISTON IS OUT OF THE HOUSING, TILT THE PISTON TO ONE SIDE AND PRY THE BOOT OUT OF THE HOUSING. DISCARD THESE PIECES ONLY IF YOU ARE REBUILDING.
6. REMOVE THE SQUARE-RING FROM THE CYLINDER OF THE HOUSING.
7. INSPECT HOUSING BORE. IT MUST BE CLEAN AND RUST FREE. IF RUST IS PRESENT, USE EMORY OR CROCK CLOTH TO REMOVE. THE SQUARE-RING SEALS AGAINST THE PISTON SURFACE. SO SMALL SCRATCHES AND CAVITIES IN THE BORE WALL WILL NOT AFFECT SEALING PERFORMANCES. HOWEVER, SINCE THE BORE GUIDES THE PISTON MOVEMENT, ANY CYLINDER WALL IMPERFECTION, WHICH CAUSES THE PISTON TO CATCH OR WEDGE IN THE BORE, MUST BE TAKEN CARE OF. IF THE PISTON CANNOT BE PROPERLY GUIDED IN THE BORE, REPLACE THE BRAKE.
8. CLEAN ALL PORTS AND MOUNTING SURFACES. WASH HOUSING IN A SOLVENT TO REMOVE ANY DIRT, LOOSE RUST AND ANY PETROLEUM PRODUCTS.
9. INSPECT BUSHING IN SLIDE MOUNT FOR SIGNS OF WEAR. REPLACE AS NECESSARY.
10. INSPECT ALL OTHER PARTS FOR UNUSUAL WEAR OR RUST. CLEAN OR REPLACE AS NECESSARY.

CAUTION:

1. USE DOT 3 BRAKE FLUID ONLY FOR A3263S1293 CALIPER.
2. USE MINERAL OIL ONLY FOR 757011023A01 CALIPER.

ITEM	DESCRIPTION PARTS LIST	QTY.
1	CLEVIS PIN	2
2	STATOR ASSEMBLY	2
3	PISTON BOOT	1
4	SQUARE RING	1
5	PISTON	1
6	HOUSING	1
7	PIN CLIP	2
8	BLEEDER SCREW	2
9	PROTECTIVE PLUG	1
10	BUSHING (BRONZE)	2
11	MOUNTING STUD	2

LAYOUT NO.		
SIM.PARTS		
INTERPRET DRAWING ENG. STDS. UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS IN INCHES. AXLETECH CASTING TOLERANCES STD 0401 FORGING TOLERANCES +.06-.03 DRAFTS 7*±1* OTHERWISE TOLS.±.015 ON 3-PLACE DECIMALS ±.03 ON 2-PLACE DECIMALS ±1*ON ANGULAR DIMENSIONS ALL MACHINED INSIDE CORNERS .030 RADIUS. BREAK ALL SHARP EDGES. REMOVE ALL BURRS, FINS, FLASH & PROJECTIONS.		FINISH ALLOWANCE F1 = .03 F2 = .06 F3 = .09 F4 = .12 F5 = .16 F6 = .19 F8 = .25 F10 = .31
REVISIONS		
A	RELEASE 940001049P FOR PRODUCTION	101597 TGL 7/6/05 PAE
B	ADDED 940001079A01 AND 940001086A01 SERVICE KITS.	102367 PAE 1/31/06 PAE
C	CHANGED 940001079A01 TO 940001078A01	111438 ADL 12-14-11 GHW



SIX (6) SERVICE KITS AVAILABLE

PART NO.	DESCRIPTION	FOR BRAKE FLUID ONLY REF (A3263S1293 CALIPER)
940001026A01	LINING AND CLIP REPLACEMENT KIT	
940001026A01 CONTAINS THE FOLLOWING PARTS		
ITEM NO.	DESCRIPTION	QTY
1	CLEVIS PIN	2
2	STATOR (LINING) ASSY	2
7	PIN CLIP	2

PART NO.	DESCRIPTION	FOR MINERAL OIL ONLY REF (757011023A01 CALIPER)
940001028A01	PISTON AND SEAL REPLACEMENT KIT	
940001028A01 CONTAINS THE FOLLOWING PARTS		
ITEM NO.	DESCRIPTION	QTY
5	PISTON	1
3	PISTON BOOT	1
4	SQUARE RING	1

PART NO.	DESCRIPTION	FOR BRAKE FLUID ONLY REF (A3263S1293 CALIPER)
940001027A01	BUSHING AND MOUNTING STUD REPLACEMENT KIT	
940001027A01 CONTAINS THE FOLLOWING PARTS		
ITEM NO.	DESCRIPTION	QTY
10	BUSHING (BRONZE)	2
11	MOUNTING STUDS	2

PART NO.	DESCRIPTION	FOR MINERAL OIL ONLY REF (757011023A01 CALIPER)
940001029A01	SEAL REPLACEMENT KIT	
940001029A01 CONTAINS THE FOLLOWING PARTS		
ITEM NO.	DESCRIPTION	QTY
3	PISTON BOOT	1
4	SQUARE RING	1

PART NO.	DESCRIPTION	FOR MINERAL OIL ONLY REF (757011023A01 CALIPER)
940001086A01	PISTON AND SEAL REPLACEMENT KIT	
940001086A01 CONTAINS THE FOLLOWING PARTS		
ITEM NO.	DESCRIPTION	QTY
5	PISTON	1
3	PISTON BOOT	1
4	SQUARE RING	1

PART NO.	DESCRIPTION	FOR MINERAL OIL ONLY REF (757011023A01 CALIPER)
940001078A01	SEAL REPLACEMENT KIT	
940001078A01 CONTAINS THE FOLLOWING PARTS		
ITEM NO.	DESCRIPTION	QTY
3	PISTON BOOT	1
4	SQUARE RING	1

NOTES:
THIS DRAWING PROVIDES GENERAL GUIDELINES AND ASSEMBLY INFORMATION. COMPONENT FEATURES ARE GENERIC AND MAY NOT REFLECT EXACT GEOMETRY.

APPLY SPECIFIED AXLETECH MARKINGS PER ENGINEERING STANDARD 4-66897

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MATERIAL

PROCESS

INQUIRY NO.

APPROVED
PROJ. ENG. MATERIAL SPECIAL

DRAWN BY
PAE 7/6/05

CHECKED BY
TGL 7/6/05

3RD ANGLE PROJECTION

SCALE

101597

RELEASE

DRAWING SIZE
D

DESIGN CONTROL GROUP
OHP-OSH

PART/DWG NO.
940001049P

NAME
CALIPER-SERVICE INFORMATION

PART NO.
940001049P

EDC

ENG. DESC. CODE

AXLETech International

INCH

C.R./T.E. NO.
APP. NO. OHP0127A0

ORIGINAL FOR
TA267HDB

1 2 3 4 5 6 7 8 9 10 100MM

1 2 3 4 5 6 7 8 9 10 IN. 10THS.

WEIGHT
RGH./FIN.

DO NOT CHANGE MANUALLY

2D CAD CENTER