SERVICE BULLETIN

JUNE 8, 1973 **No.** Q72 **under** BRAKES

PLAINTIFF'S EXHIBIT

MAC-57

FOR BRANCHES, DISTRIBUTORS AND CUSTOMERS.

BRAKE LINING FASTENERS
(All Models with Rockwell "P" Series Brakes)

PURPOSE To inform field of a brake lining rivet change and the availability of brake lining bolts.

INFORMATION Effective March 1, 1973 all brake lining will be secured with 1/4 inch rivets in place of 3/16 inch rivets used previously. When replacing brake lining, drill the brake shoes to accept the new 1/4 inch rivets.

Where service facilities are not equipped with a rivet machine, a brake shoe lining bolt is available for securing the lining to the brake shoe.

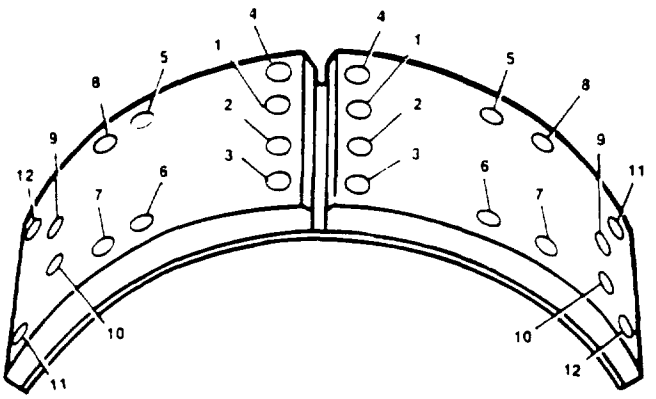
Parts required:

Part No.	Description	Replaces
8235-15X882	Brake Shoe Lining Bolt	- - -
20AX1	Nut, 1/4-28	- - -
36AX1	Lockwasher, 1/4 inch	- - -
	Rivet	341SZ110-P2 or 341SZ113

Installation Instructions

1. Position the lining on the brake shoe so the holes in the lining and shoe are in perfect alignment.
2. Clamp the lining to the shoe with "C" clamps. Locate the clamps as close to the holes as possible.
3. Line drill the lining and brake shoe holes 0.261 inch diameter using a "G" drill or 0.257 inch with an "F" drill.
4. Secure the lining to the brake shoes with the bolts, nuts and lockwashers in the sequence shown in the illustration. Torque the nuts to 84 lb. in. and remove the "C" clamps.

RECOMMENDATION When replacing brake lining, secure the lining to the brake shoes as instructed herein. Parts are available now.



BRAKE LINING BOLT INSTALLATION SEQUENCE

CIRCULATION

Service Manager
Shop Foreman
Night Foreman
Night Foreman
Inspector Leadman
Inspector Leadman
Inspector Leadman
Unit Overhaul Room
Shop Office

PRINTED IN U.S.A.