

SERVICE BULLETIN

PLAINTIFF'S EXHIBIT

MAC-65

MAY 27, 1975

No. Q81 under BRAKES

FOR BRANCHES, DISTRIBUTORS AND CUSTOMERS.

CHASSIS AFFECTED ALLENTOWN ☒ HAYWARD ☒ OAKVILLE ☒

BRAKE SHOE SUPPORTS

(SW56, 57, 571, 573, 76, 59, 592 and 68 Series
Bogies with Rockwell-Standard Cam Brakes)

PURPOSE To inform service personnel of an improvement that can be added at time of brake overhaul.

INFORMATION Current brake assemblies incorporate brake shoe supports. These items stabilize the shoes and extend life of shoe and spider anchor pin bores, camshaft splines and bushings and slack adjuster splines. The parts required are contained in kit form and installation is shown in sample instruction sheets.

Parts required:

Bogie	*Brake Shoe Support Kit
SW56C, 57C, 571C, 573C and 76C Series	8235 - MPS2008
SW59C, 592C Series	124QE220
SW68C Series	124QE219

* Each kit services one axle (Two wheels)

Before installing brake shoe supports, check lateral movement of brake shoes at cam head. If it is 3/8 inch or less, add the shoe supports to existing spiders (if not already installed), do not replace spiders.

If shoe movement exceeds 3/8 inch, replace spiders. Replace only spiders that are unusable; it is not necessary to replace in pairs or sets. New service spider assemblies will have provision for shoe supports. Consult with your Mack branch or distributor for part number of latest spiders and related parts.

RECOMMENDATION Install brake shoe supports when rebuilding subject brake assemblies if lateral movement of shoes is within limit specified in bulletin. This is a product improvement to be made at customers option and expense.

CIRCULATION

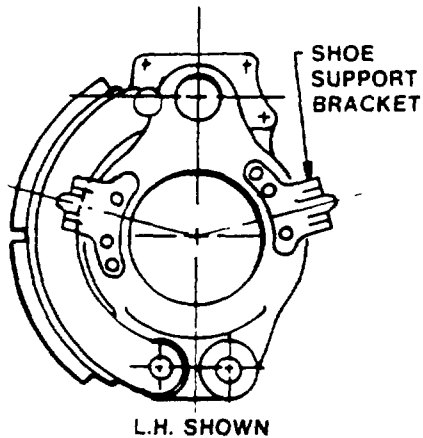
Service Manager	
Shop Foreman	
Night Foreman	
Night Foreman	
Inspector Leadman	
Inspector Leadman	
Inspector Leadman	
Unit Overhaul Room	
Shop Office	

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BRAKE SHOE SUPPORT KIT
(Mack SW-56C, 57C, 76C, 571C & 573C Bogies)

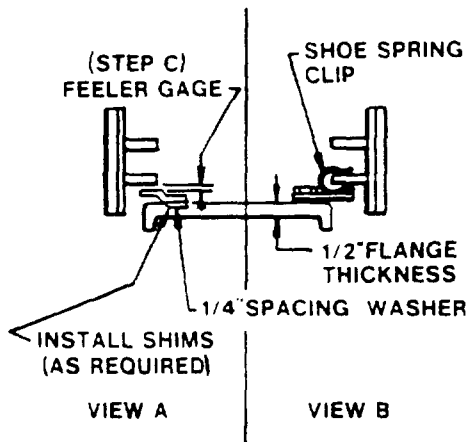
INSTALLATION INSTRUCTIONS:

1. With 1/2 inch thick brake spider flange
 - a. Remove four (4) mounting bolts shown.
 - b. Select and position 1/4 inch spacer washer.



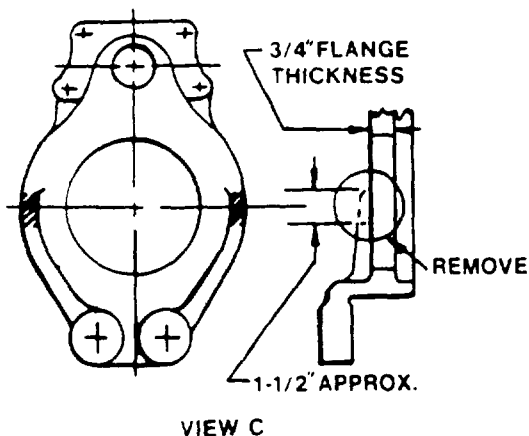
For L.H. Brake
3280-W-6081 Shoe Support Pad

For R.H. Brake
3280-Z-6136 Shoe Support Pad



- c. Use feeler and measure clearance between shoe web and shoe support bracket. (See View A).
- d. Select proper thin shim washers as measured. Install shim washer under support pad at the mounting bolt to nearest .032.
- e. Retorque mounting bolts to 210-270 ft. lb.
- f. Bolt shoe spring clip to brackets with 1/4 inch diameter capscrew, lockwasher and nut provided. (See View B).
- g. Position shoe in proper working position under spring clip. Clip should provide approximately 65 lbs. lateral support force against the shoe support bracket. Check for free return at brake shoe against camhead by normal shoe return spring action. Lubricate if necessary.

2. With 3/4 inch thick brake spider flange
 - a. Remove cast spider material shown in View C flush with mounting face both sides shown shaded.
 - b. Follow steps a through g above but do not use 1/4 spacer washer.



SAMPLE INSTRUCTION

SHEET

BRAKE SHOE SUPPORT KIT
(1-3/4" and 2-1/2" Spider Offset Cast Shoes)
Mack SW59C, 592C and 68C Bogies

INSTALLATION INSTRUCTIONS:

1. With 1/2 inch thick brake spider flange:

a. Remove four (4) mounting bolts shown.

b. Select and position 1/4 inch spacer washer under hole locations marked "X" shown.

For 1.75 Spider Offset
(4) 3280-M-6123 Shoe Support Pads

For 2.50 Spider Offset
(2) 3280-N-6124 Shoe Support Pads
(2) 3280-P-6126 Shoe Support Pads

c. Use feeler and measure clearance between shoe web and shoe support bracket (See View A).

d. Select proper thin shim washer as measured. Install shim washer under support pad at the mounting bolt to nearest .032.

e. Retorque mounting bolts to 210 - 270 ft. lbs. for .625 diameter bolt, 365 - 470 ft. lbs. for .750 diameter bolt.

f. Drill one .312 diameter hole in shoe web located by scribing a radius off of the anchor pin center of 9-3/4 and a radius off of the roller pin center of 5-15/16. (See View B.)

g. Bolt shoe spring clip to underside of shoe for both forward and reverse shoes with 1/4 inch diameter capscrew, lockwasher and nut provided. (See View C.) Torque capscrew to 14 - 18 ft. lbs.

h. Position shoe support between spring clip and shoe in proper working position. Clip should provide approximately 65 lbs. lateral support force against the shoe support bracket.

Check for free return at brake shoe against camhead by normal shoe return spring action. Lubricate if necessary.

2. With 3/4 inch thick brake spider flange:

a. Remove cast spider material shown in View D flush with mounting face both sides shown shaded.

b. Follow steps a through h above, but do not use 1/4 spacer washer.

SAMPLE INSTRUCTION SHEET

