



MISC/TP-1000

PROCEDURE FOR REPLACING BRAKE DRUM FLANGE ON PA-22 (3040) WHEEL ASSEMBLY

1. Place inner wheel assembly into boiling water for five (5) minutes and remove old drum flange from wheel casting.
2. Dry and paint inside of inner wheel half, where brake drum flange seats, with a heavy coat of zinc chromate.
3. Place the wheel half into boiling water again for a few minutes, remove and drop new replacement drum flange into place. Ascertain that the three (3) holes in the brake drum flange are aligned with the three (3) holes in the wheel half before the wheel half cools.

PROCEDURE FOR REPLACING BRAKE DISC ON PA-23 (3060 AND 3080) AND PA-24 AND PA-25 (3070) WHEEL ASSEMBLIES

1. Remove eight (8) rivets attaching brake discs to inner wheel half by chiseling off heads inside drum and punching out. (See Figure 1.)
2. Place wheel half assembly into boiling water for five (5) minutes and remove disc from wheel casting by the use of pry bars. (See Figure 2.)
3. Clean casting thoroughly and apply heavy coat of zinc chromate paint in brake disc recess.
4. Place wheel casting into boiling water for a few minutes, remove and insert new replacement brake disc into the expanded wheel. Ascertain that brake disc is properly seated in recess in wheel half.
5. Clamp wheel half and brake disc assembly in vise, as shown in Figure 3, and locate eight (8) 3/16" holes with a 3/16" drill. Drill through disc with an 11/64" drill and then re-drill with a 3/16" drill.
6. Rivet wheel half to brake disc with eight (8) AN425 AD6-7 rivets. Set from both ends of rivet to be certain rivet has properly filled the hole.
7. File rivet heads flush with tire seat and paint.

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FIGURE 1

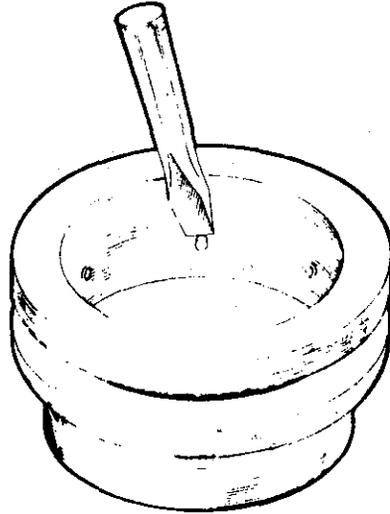


FIGURE 2

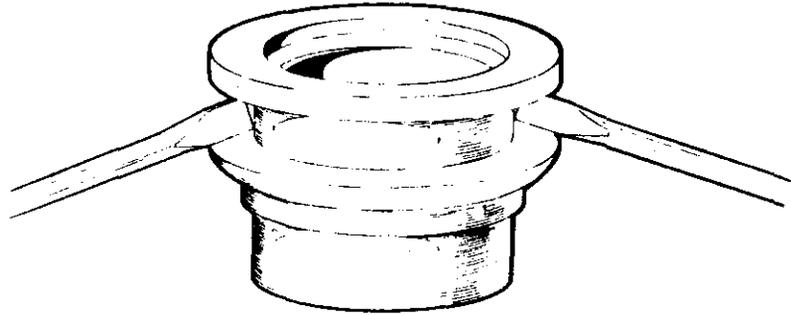


FIGURE 3

