

TECHNICAL PROCEDURE

AIR DISC BRAKE (ADB) SYSTEMS

SUBJECT: Rotor (U-shape style)
and Caliper Mounting

LIT NO: T71004

DATE: September 2011


This document includes torque values and sequence for mounting Air Disc Brake (ADB) U-shape style rotor and caliper to Hendrickson wheel ends.

THINGS TO CONSIDER:

NOTE: The rotor and hub assembly must be installed before mounting ADB caliper.

IMPORTANT: Hendrickson does not recommend reusing used bolts. Bolt metal and threads are stressed when tightened. Duplicating clamp loads under torque is not assured for used fasteners.

IMPORTANT: Do not apply additional lubricant to fastener threads. Doing so will reduce the friction between fastener components which can lead to overtightening, unpredictable clamp loads and unreliable fastener connections.

 **CAUTION:** Major wheel-end components are heavy and difficult to lift by hand. Use appropriate hoist and support slings to lift into position.

Do not lift caliper assembly by brake pad retainer bracket.

More information can be found on the Hendrickson website:

www.hendrickson-intl.com

- Hendrickson wheel-end literature , e.g.: [L496 Wheel-end Maintenance Procedures](#), [L974 Drum Brake Maintenance Procedures](#).
- Links to [Vendor Components Literature](#).
- [B31 Suspension Torque Specifications](#).

MOUNTING HUB TO ROTOR

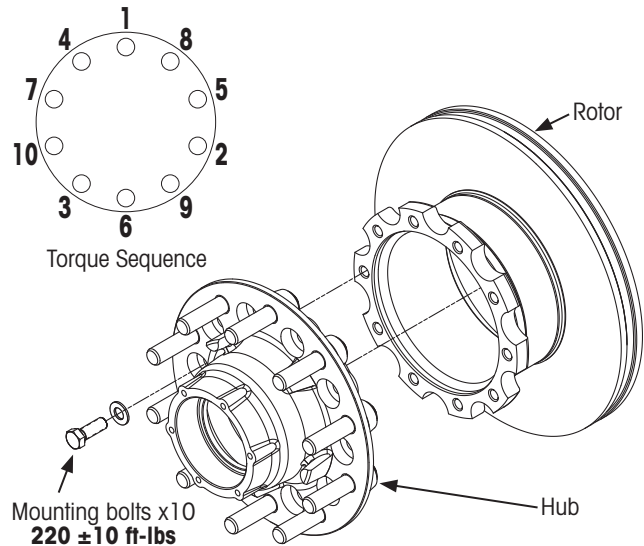


Figure 1: Hub to rotor assembly

1. Ensure both hub and rotor mounting **surfaces are clean** and free of loose dirt, corrosion, grease and debris.
2. **Place rotor onto stable work surface** with the outboard mounting surface facing upward.
3. **Carefully lower hub onto rotor** until hub mounting pilot engages rotor bore.
4. **Align fastener holes** and insert new bolts and washers, hand tighten.
5. Properly constrain assembly and **torque hex cap screws** in the sequence shown in [Figure 1](#).

NOTE: Ensure the head of the new bolts do not extend beyond the height of the wheel mounting flange surface to cause interference.

MOUNTING CALIPER TO TORQUE PLATE

1. Ensure both torque plate and caliper mounting **surfaces are clean** and free of loose dirt, corrosion, grease and debris.
2. **Align and place caliper** over rotor and against torque plate as shown in [Figure 2](#) and [Figure 3](#).

NOTE: If included with pre-assembled pads, pad spacers should pop out as caliper is positioned onto rotor.

3. **Insert and hand tighten** the six new mounting bolts and washers.
4. **Visually inspect** to ensure proper placement.
5. Using 30 mm socket, **torque mounting bolts** in sequence shown in [Figure 2](#).

IMPORTANT: Turning bolts other than the ones **shaded** and numbered sequence in [Figure 2](#) will alter brake performance and must be avoided. Refer to [Vendor Components Literature](#) for ADB service requirements.

6. If not pre-assembled, **install brake pads** and complete installation according to caliper manufacture's procedures.

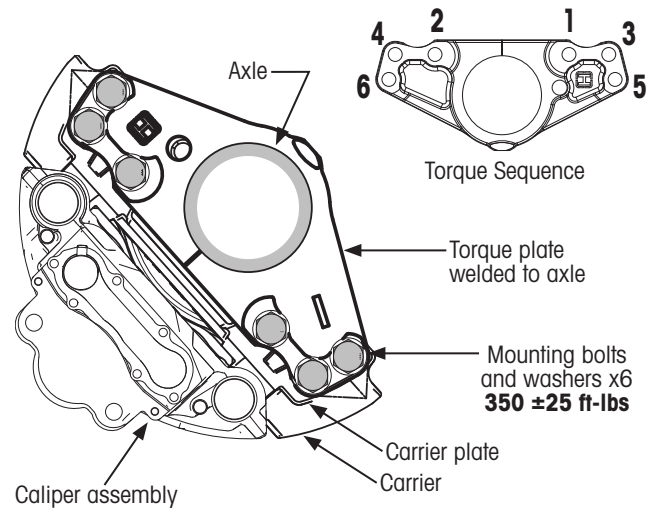


Figure 2: Torque Plate/caliper assembly

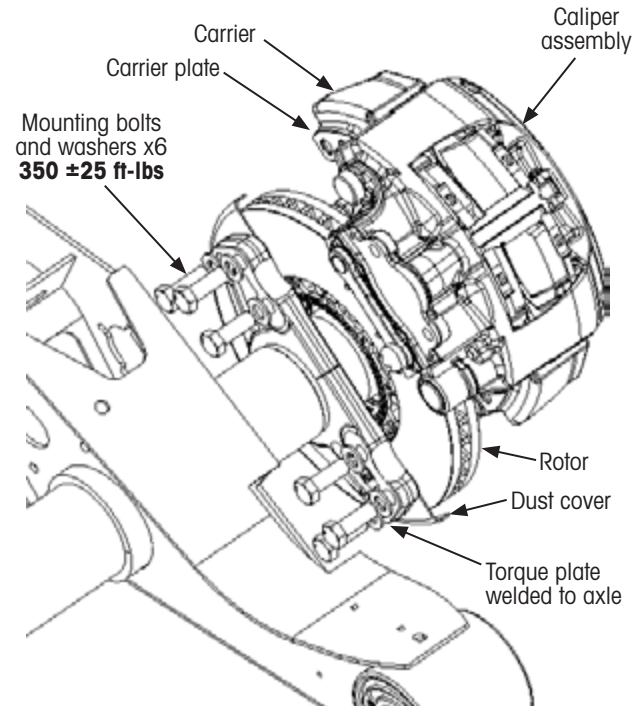


Figure 3: Installing ADB caliper (suspension shown upside down)

www.hendrickson-intl.com

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