DISC BRAKES

PREMIUM PERFORMANCE BRAKES

INSTALLATION INSTRUCTIONS

Brake Caliper Kit for 6,000 lbs. to 8,000 lbs. Hydraulic Disc Brakes

K71-636-00 Caliper Replacement Kit for 6,000 lbs. Disc Brakes
K71-693-00 Caliper Replacement Kit for 7,000 lbs. Disc Brakes
K71-630-00 Caliper Replacement Kit for 8,000 lbs. Disc Brakes

Notice to Buyer: It is recommended that all brakes be replaced at the same time to insure balanced braking performance.

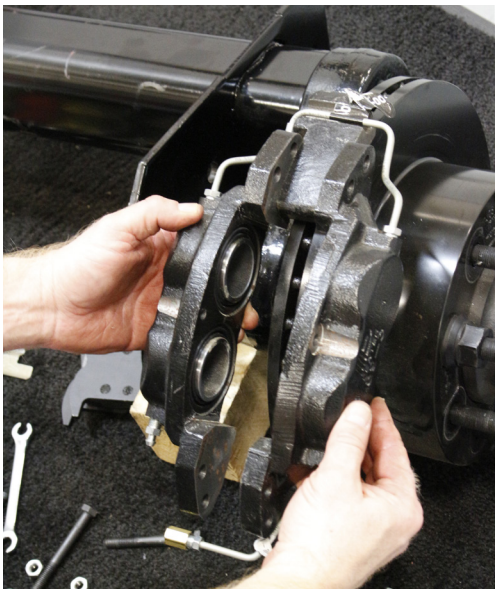
Remove the old brake calipers

1. Jack up trailer and secure on adequate capacity jack stands. Follow the trailer manufacturers recommendations for lifting and supporting the unit.

⚠ CAUTION

Do not lift or support the trailer on any part of the axle or suspension system. Never go under any trailer unless it is properly supported on jack stands which have been rated for the load. Improperly supported vehicles can fall unexpectedly and cause serious injury or death.

2. Remove the wheel from the hub, leaving the brake exposed.
3. Disable the brake actuation system. Check that the hydraulic system has zero pressure and that the hub and rotor rotate freely.
4. For brakes produced after April 2008, locate the crossover brake line threaded into the bottom side of both calipers. The crossover brake line is attached to the inboard side of the anchor yoke using a metal tube clamp. Remove the 1/4-20 bolt that connects the tube clamp to the yoke.
5. Remove the hose from the caliper, then remove the four caliper mounting bolts. Do not allow the caliper assembly to hang from the hose.



Installing the new brake caliper

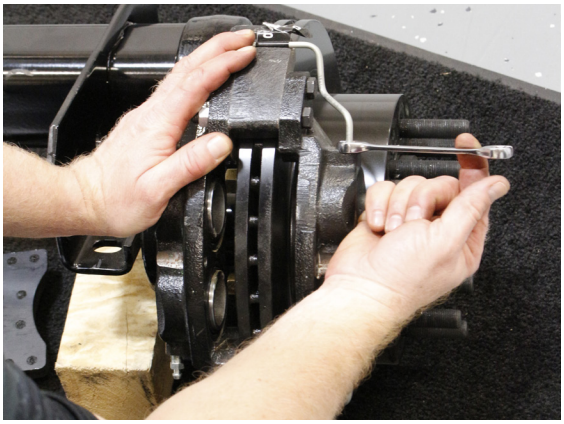
1. First inspect the brake assembly for grooves, flaking, cracks, heat checking, thickness variation, insufficient rotor thickness, and look to see that the mounting hardware is straight. Replace any component as needed (or desired) per manufacturer recommendations.
2. Assemble the new caliper assembly.

   Note for 6K and 8K only: Use two lug nuts to secure the rotor against the hub face when assembling the calipers. After the brake is assembled, remove the lug nuts.

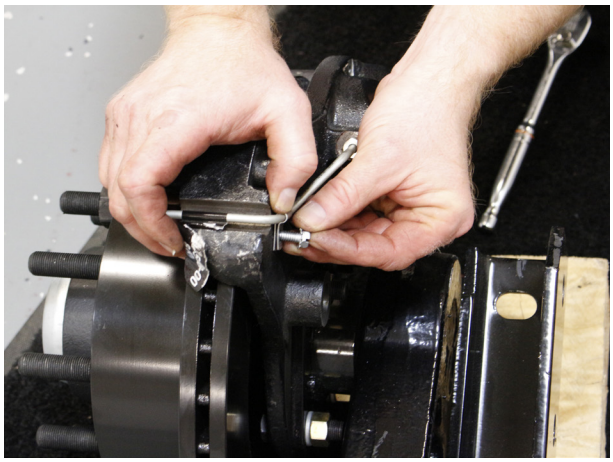
3. One caliper will be used on the inboard side, with the hydraulic line fitting adapter installed on the top side of the piston boss. The other caliper will be used on the outboard side, with the bleed screw installed at the top of the piston boss. Install both of these calipers onto the attaching bracket. Make sure that the bleed screw points up and is located on the outboard caliper. Torque bolts to **25-35 Ft. Lbs.**
4. Connect the new crossover brake line on the bottom sides of the piston boss on both calipers.

   Note: Make sure the crossover line fits snug around the calipers and rotor without touching the rotor.

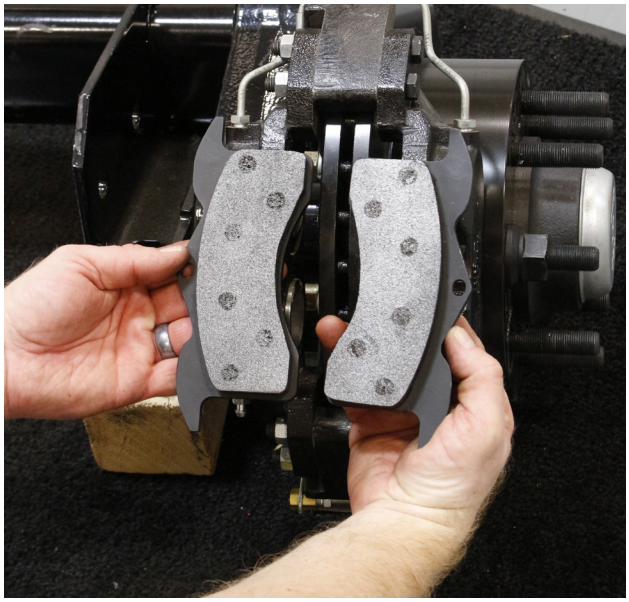
5. Torque the crossover line to **12-15 Ft. Lbs**. Torque the bleed screw and the hydraulic line fitting adapter to **60-75 Inch Lbs.**

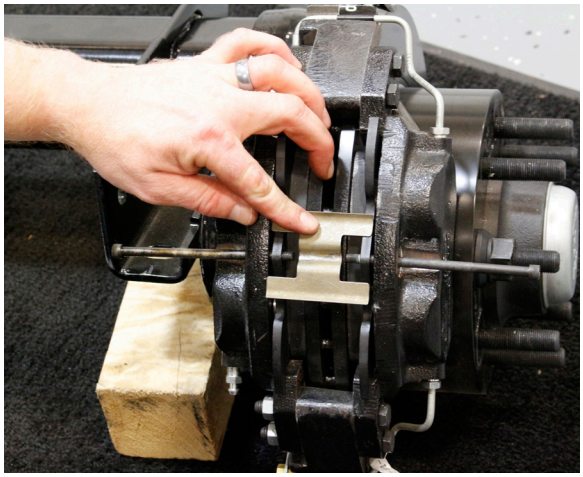


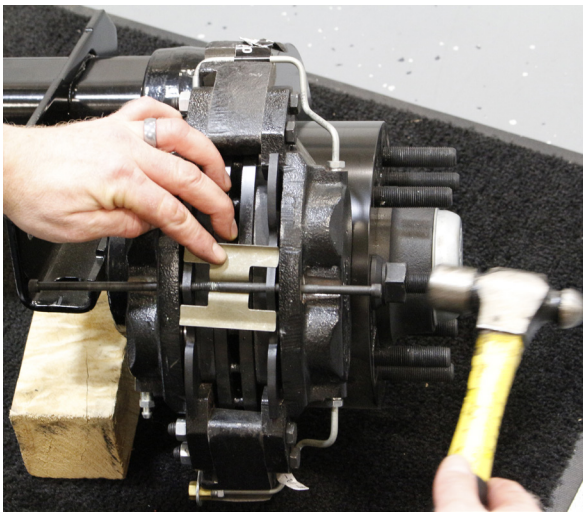
6. For brakes produced after April 2008, the crossover brake line also attaches to the inboard side of the caliper mounting bracket using the metal tube clamp. Slide the clamp over the crossover brake line and bend it to the closed position. Apply anti-seize or similar thread lubricant to the 1/4-20, 1/2" length bolt. Attach the tube clamp to the threaded hole in the caliper mounting bracket using the 1/4-20, 1/2" length bolt. Torque to **85-100 Inch Lbs.**



7. Reassemble the brake pads into the disc brake. Make sure to locate the brake lining side of the pads toward the rotor surface, and the steel side of the pads toward the calipers. Align the holes in the brake pads with the ones in the calipers. Insert two brake pad retaining pins into each caliper half. Place the anti-rattle spring against the brake pads and press the center toward the rotor while you slide the outboard pad retaining pin toward the inner lining. Continue sliding the pad retainer pin until it engages both pads and pushes the second pin out of the inboard caliper half. Install the cotter ring in the hole of retaining pin.







8. Reconnect the brake actuation system. Refer to your Operation Maintenance Service Manual for proper operation.
9. Bleed and flush brake system per your actuation systems Operation Maintenance Service Manual.
10. Remount the wheel. Refer to your Operation Maintenance Service Manual for proper wheel nut torque procedures.
11. Spin wheel to ensure proper clearance between the wheel, brake lines, rotor, and the calipers.

    Note: The Dexter Operation Maintenance Service Manual is available for downloading at www.dexteraxle.com.