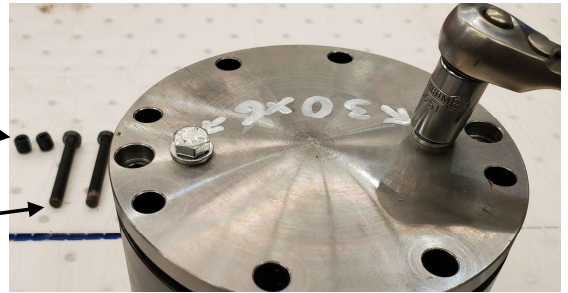


Task

Install a new BUT45 TURNING DEVICE BRAKE

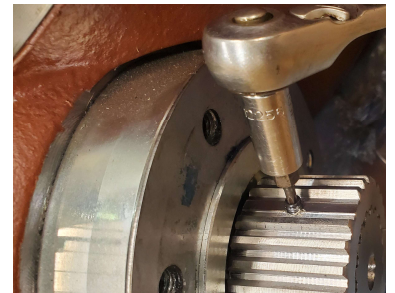
Fig 1

- 1) Remove the 2 grub screws from the brake cover
- 2) Install 2 x 6mm x 20mm bolts, screw these in alternately until the bolts are bottomed out to compress the piston and springs.
- 3) Remove the brake assembly cap screws and separate the piston / cover from the brake disc unit.



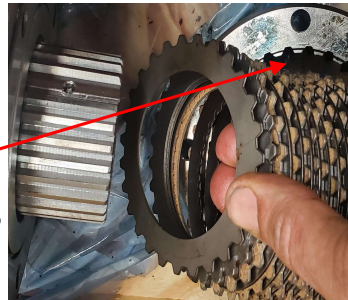
- 4) Remove the old brake unit.
- 5) Install the drive gear and lock into place with the grub screw, ensure the grub screw locates into the slot in the drive spline. FIG 2.

Fig 2



- 6) Assemble the steels and fibres onto the spline as delivered, spacers first, followed by alternate fibre/steel, FIG 3
- 7) Slide the outer gear over the discs, FIG 4.

Fig 3



Ensure the step faces the turning device and the outer spacer is fitted

Fig 4



Fig 5

- 8) Fit the brake piston/cover, first align and install the 2 smaller assembly Cap screws.
- 9) Install and tension the 8 main cap screws.
- 10) **Remove the M6 piston jacking bolts**, replace with the supplied Grub screws.
The M6 bolts should become loose after only 2 or 3 turns indicating the brake is sufficiently preloaded and correctly assembled.

