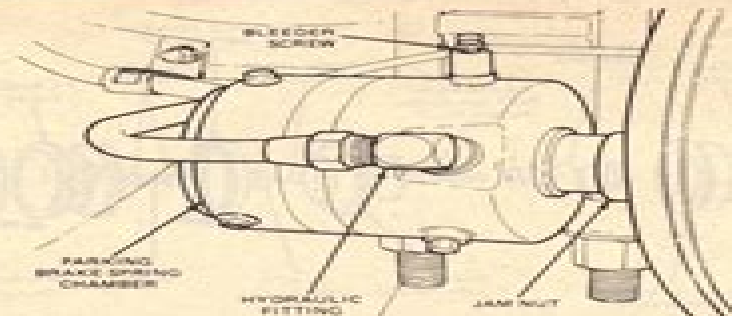
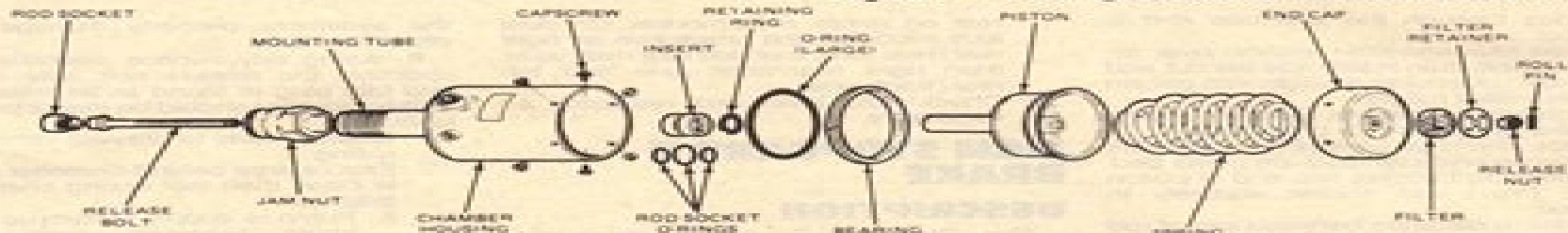


**Fig. 38 Caging spring brake unit**



**Fig. 39 Parking brake chamber installation**



**Fig. 40 Exploded view of parking brake chambers. Ford**

cylinder/parking brake expander. Rotate chamber clockwise until it stops. Then rotate chamber in opposite direction until the bleeder screw is facing straight up and fluid inlet port is facing away from the axle (less than one complete turn).

5. Torque locknut to 150 ft. lbs. While tightening locknut, ensure brake chamber does not rotate.
6. Install bleeder screw and adapter, fitting, plug and fluid inlet line.
7. Check and replenish brake pump reservoir as necessary. Use Ford Automatic Transmission Fluid, XT-2-QDX, Dexron II or equivalent.
8. Bleed brakes as outlined elsewhere in this section.
9. Apply brakes, then check for signs of leakage. Repair as necessary.
10. De-cage springs. Refer to Caging Brake Chambers for procedure.

## BRAKE CHAMBER OVERHAUL Disassembly

1. Remove brake chambers. Refer to Brake Chamber, Replace for procedure.
2. De-cage brake spring, then drive roll pin from release bolt and nut. Unscrew nut and remove the filter retainer and filter, Fig. 40.
3. Insert suitable screwdriver in release bolt slot and rotate bolt until it is completely below end cap and all threads are disengaged.

4. Position brake chamber assembly in suitable press. Support mounting tube with tube-type press stock and have the end cap assembly facing the press ram. Bring the press ram down firmly on the end cap, ensuring the ram is centered on the end cap. Press must have a minimum press capacity of 2500 lbs. and a minimum ram travel of 6 inches.
5. Remove end cap-to-chamber attaching screws. Do not relax ram pressure at this time.
6. Slowly relax ram pressure and allow parking brake spring to expand until it raises the end cap 6 inches above the chamber housing. Remove spring and end cap from chamber.
7. Using hammer and suitable drift, drive piston assembly out of chamber housing.
8. Support piston assembly, then drive out release bolt and socket with suitable hammer. Discard release bolt.
9. Remove chamber housing retaining ring, then using a suitable drift, drive out chamber insert.
10. Remove and discard O-rings.
11. Inspect all parts for signs of wear or damage and replace as necessary. If parking brake spring shows signs of rust or corrosion, clean with wire brush and paint with suitable rust inhibitor.

## Assembly

Prior to assembly, clean all parts thoroughly. Remove all foreign particles, other-

wise early O-ring failure may occur. Coat all parts with Ford Automatic Transmission Fluid XT-2-QDX, Dexron II or equivalent.

1. Install insert O-rings, then coat chamber interior surfaces with transmission fluid.
2. Place insert in position in mounting tube, then install retaining ring.
3. Install large O-ring and bearing on piston, then place piston assembly in chamber housing. Compress O-ring and bearing into piston groove with suitable tool and install piston assembly into chamber housing.
4. Position chamber housing assembly in suitable press. Support mounting tube with tube-type press stock and the end cap portion of the chamber facing upward.
5. Insert brake spring into chamber and place the end cap on top of spring. Ensure end cap bolt holes are aligned with chamber housing bolt holes. Slowly bring press ram down to compress end cap and spring. Ensure press ram is centered on end cap and the end cap is aligned with the housing. Compress end cap and spring until end cap and housing are aligned. Press must have a minimum press capacity of 2500 lbs. and a minimum ram travel of 6 inches.
6. Install end cap-to-chamber attaching screws. Torque to 40-60 inch lbs.
7. Install release bolt through mounting tube and piston. Insert a  $\frac{3}{16}$  inch hex driver and rotate the bolt through the end cap. Tighten the bolt until it pro-

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**Geoffrey Freeman Allen**



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