



Misc/TP-1008A

46110

INSTRUCTIONS FOR REMOVAL AND REPLACEMENT OF BRAKE DRUM ON B. F. GOODRICH WHEEL MODEL D3-13A-1

1. Remove the brake drum from the wheel by drilling out the six (6) rivets from around the inside of the brake drum. Take precaution against enlarging the hole in the wheel casting.
2. Press fit the replacement drum into the wheel by the use of an arbor press, until the small rim face (backleg) is flat against the wheel base.
3. Turn the wheel base over and use the rivet holes in the wheel assembly as a fixture to drill 0.203 (0.199 - 0.207) dia. holes through the drum leg. Rivet the drum to the wheel assembly with six AN441-6-6P rivets.

NOTE

This brake drum is not in a finished condition ready for use. The drum must be finish machined after installation in the wheel so that the inside diameter of the drum will be concentric with the bore of the wheel.

4. Chuck the wheel in any suitable lathe and indexing either the tube well outside diameter or the bearing bore inside diameter, machine the drum inside diameter to 4.995 - 5.015 inches.