

Service Letter

Service Letter No. 450 March, 1996

SUBJECT: Brake Housing Installation Procedure

MODELS AFFECTED: 310, 310A, 317B, 317C, 317D and 317E

The brake housing installation procedure for the above referenced brake models has been revised. The new procedure calls for the cylinder head bolt spacers to be torqued in place of being installed hand tight. This revision is intended to provide consistency between the procedures detailed in service literature published by Caterpillar for the 3176 engine family and service literature published by Jacobs for the brake models used on those engines.

There is no difference in brake performance or system durability between the old and the new installation procedures. Brakes installed according to the original procedure DO NOT need to be reworked according to the new procedure. The revision to the housing installation procedure is presented below. The slave piston lash must be reset if the cylinder head bolt spacer is set up according to this procedure on housings originally installed following the old procedure.

1. Refer to Fig. 1. Torque the cylinder-head bolt (1) to 203 lb.-ft. (275 N•m). Install the cylinder-head bolt spacer (2) on cylinder head bolt (1).

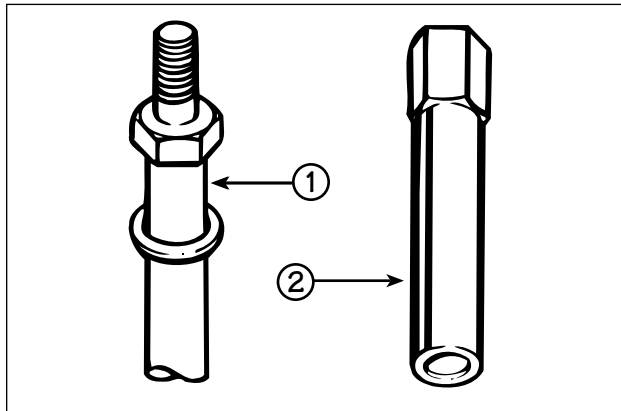


FIG. 1

2. Refer to Fig. 2. Torque the cylinder-head bolt spacer (2) to 70 lb.-ft. (95 N•m). Torque the brake mounting studs (3) to 70 lb.-ft. (95 N•m).
3. Refer to Fig. 3. Position the engine brake housings on the mounting stud nuts and install the Jacobs hold-down nuts (4) on the brake mounting studs. Torque to 59 lb.-ft. (80 N•m).

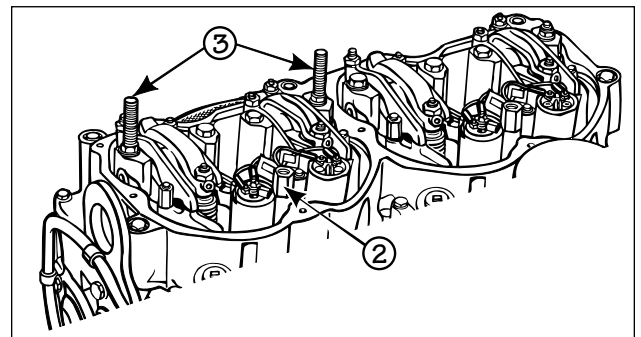


FIG. 2

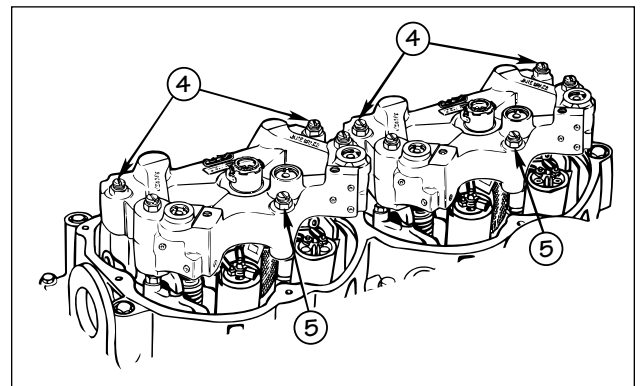


FIG. 3

4. Refer to Fig. 3. Install the 70 mm bolts (5) through the housing into the spacer (one per housing) and torque to 41 lb.-ft. (55 N•m).
5. Set the slave piston lash.