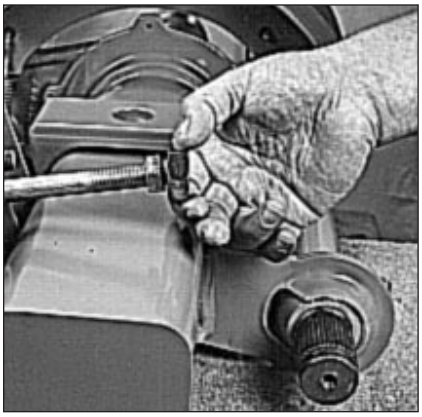
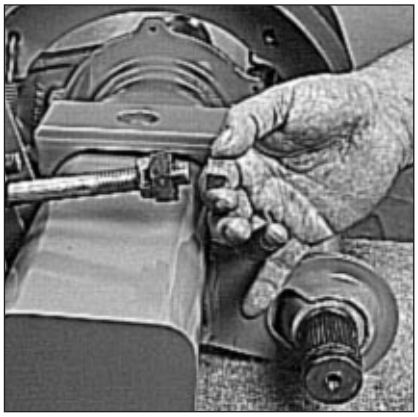
GUNITE Service Bulletin

Gunite Automatic Slack Adjuster Collar Lock Clevis Installation Procedure

The following procedure is a guideline for OEM installation of the Gunite automatic slack adjuster with the collar lock clevis. This procedure may need to be modified to meet specific assembly line requirements.

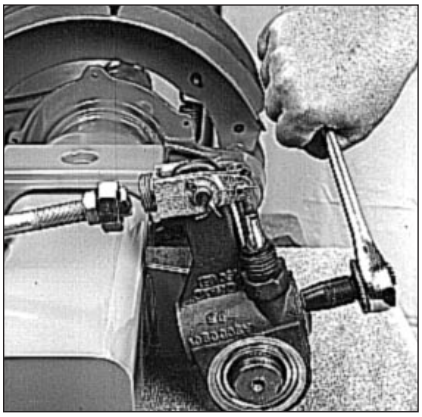


Step 1: Mount the service chamber and/or spring brake chamber in the appropriate mounting holes as determined by the arm length of the automatic slack adjuster. The spring brake should be fully caged either manually or using air pressure. Shipping T-clips DO NOT fully retract spring brake chambers. The push rod MUST be in the released position. Place the 1-1/4" nut on the push rod against the 15/16" jam nut.



Step 2: Coat the end of the push rod with an anti-seize product. Thread the 3/4" collar nut onto the push rod. The 3/4" collar nut is available in two thread sizes: 5/8"–18 UNF and 1/2"–20 UNF.

Step 3: Coat the S-cam spline with an anti-seize product. Mount the automatic slack adjuster onto the S-cam. Attach the S-cam mounting hardware making sure to properly shim the automatic slack adjuster. A properly shimmed automatic slack adjuster has at least one washer on each side of the automatic slack adjuster, and no more than 1/16" end play.



Step 4: Rotate the 7/16" automatic slack adjuster hex extension clockwise until the collar nut is positioned inside the clevis housing.

Step 5: If you do not know if you have the correct push rod length use the OEM installation gauge - (part #AS4008).

The installation gauge is designed to accommodate either end of the pins. When properly installed, the push rod, large clevis pin, and S-cam will have an inclusive angle of 103° ± 2°.

(Continued from Step 5)

Place the pins into the clevis. Set the pointer of the OEM installation gauge for the appropriate automatic slack adjuster arm length. Place the pointer into the end of the S-cam shaft. Align the large sleeve of the gauge to fit over the large pin. Rotate the 3/4" collar nut until the small sleeve fits over the small pin. The angle is now set.

The push rod must have full thread engagement of the 3/4" collar nut. The push rod may extend up to 1/8" past the inside of the clevis. If the push rod threads protrude more than 1/8" past the clevis mark the push rod, remove the clevis, and cut the push rod to length.

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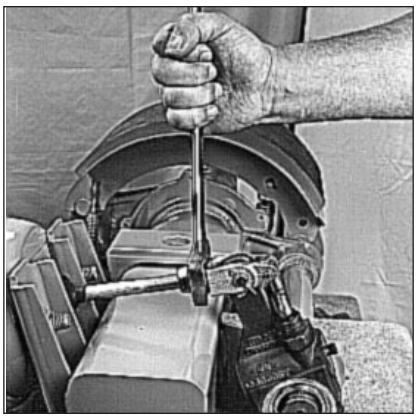
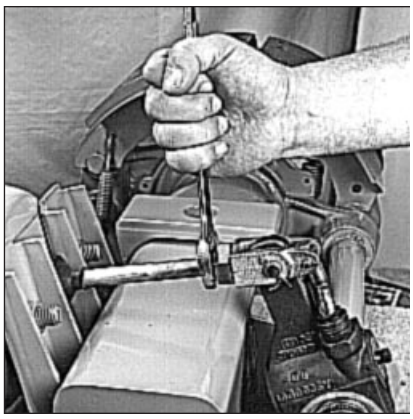
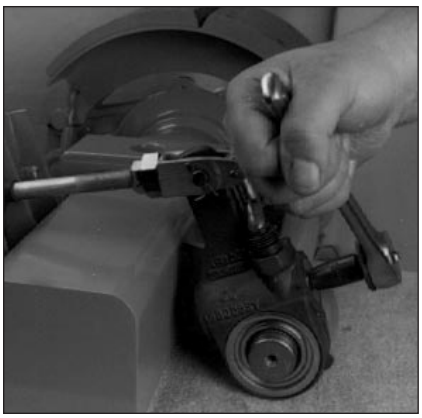
Step 6: Thread the 1-1/4" nut onto the clevis.



Step 7: Tighten the 1-1/4" nut to 40–50 ft•lbs of torque.



Step 8: Tighten the 15/16" jam nu against the 1-1/4" nut. Tighten t 40–50 ft•lbs of torque.



Step 9: Adjust the automatic slack adjuster by rotating the 7/16" hex extension CLOCKWISE until the lining comes in contact with the drum surface. Now back the automatic slack adjuster off 1/2 a turn in the COUNTER CLOCKWISE direction. Backing off the automatic slack adjuster will require approximately 40 ft•lbs of force. A ratcheting sound will be heard when the automatic slack adjuster is backed off.

The Gunite automatic slack adjuster is now properly installed and adjusted on this assembly. Measure the distance from the face of the air chamber to the back of the clevis. This measurement can be used to install the clevises on other brake assemblies of the same configuration with fully caged spring brake chambers. Automatic slack adjusters on remaining assemblies can now be quickly installed and adjusted.

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If additional assistance is required, con tact a Gunite Field Service Representative at (800) 677-3786.

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