

**LIST OF FIELD MODIFICATIONS
SINGLE & DUAL DISC BRAKES ASSEMBLY
9540, 238-243-245-281-321-366-418-485-505-572-
606-612-661-662-726-729-776-792-9560156-164, 175
GOODYEAR**

(This EO replaces EO 15-45BB-6A dated 17 Sep 56)

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| 23 Mar 60 | 15-45BB-6A/1 | (Rescinded) |
| * 23 Mar 60 | /2 | Modification of Brake Assemblies Parts 9540418 and 9540281 to Brake Assembly Part 9540726 |

*Asterisks appearing opposite entries denote changes since last issue

ISSUED ON AUTHORITY OF THE CHIEF OF THE AIR STAFF

MODIFICATION
MODIFICATION OF BRAKE ASSEMBLIES
PARTS 9540418 AND 9540281
TO BRAKE ASSY PART 9540726

(This EO replaces EO 15-45BB-6A/2 dated 12 Jan 60)

| | |
|----------------------------------|--|
| EQUIPMENT AFFECTED: | Brake Assemblies T33 Mk. 3 Aircraft |
| BY WHOM WORK WILL BE PERFORMED: | Operating Units |
| WHEN WORK WILL BE PERFORMED: | At next Lining Change after receipt of parts |
| RCAF FORM ENTRIES: | L14-1B, L14-6 |
| MODIFICATION OF SPARES IN STOCK: | To be modified prior to installation on the aircraft |

PURPOSE

1 To prevent the brake lining from being dislodged and causing aircraft accidents, brake assemblies will be modified to incorporate a positive lining retention device, thereby converting the brake into an improved unit.

MODIFICATION DATA

2 This modification will be accomplished as follows:-

- (a) Disassemble the brake in accordance with existing instructions.
- (b) The piston subassembly will be assembled as follows:-
 - (1) Assemble the piston subassembly using adjusting pin Part 9510573, brake release spring, Part 9510808, and spring guide Part 9510807 into piston Part 9520646.
 - (2) Apply pressure to the spring guide until it bottoms, and hold.
 - (3) Screw the threaded retaining ring Part 9510832 into the piston until it bottoms on the spring guide.
 - (4) Back off one full turn and then to the first locking position. This will give a built-in clearance of .062" + .005", - .000"
- (5) Lock with 9510831 retaining ring.

MODIFICATION DATA (Cont'd)

NOTE

If oversize piston is required in lieu of the standard size piston furnished in kits the brake assembly is to be returned for overhaul in accordance with EO 15-45BB-3 brake assembly Part 9540726.

(c) The centre carrier will be modified as follows:-

(1) Place a fastener button Part 9521519, on both sides of the centre carrier lining recess and rivet using a rivet Part AN427-5C6.

NOTE

Ends of rivets must not extend above the surface of the fastener button.

(2) * On centre carrier assembly Part 9530562, install carrier guide lining, Part 9511139, with rivet Part AN450C12B9, with the oval head on the lining side.

(3) Remove the last three digits of the carrier assembly Part and substitute 964F to denote re-work.

(d) The housing back plate will be modified as follows:-

(1) Place rivet Part AN426AD5-8, through the back plate with the shank extending into the lining recess.

(2) Place fastener button Part 9521519, on the rivet and set rivet.

NOTE

End of rivet must not extend above the surface of the fastener button

(3) Re-identify the housing back plate by removing the last five digits and substituting 21542F to denote re-work.

(e) Using brake lining Part 9521539, 9521541, all new "O" rings and gaskets assemble the brake (reference EO 15-45BB-3 brake assembly Part 9540726). Fill the lining buttons with grease Spec. 2-GP-690/Sec. /Reference 34A/122 and snap lining into place. Remove the last three digits from the brake assembly Part number and substitute 726. Area where paint has been removed is to be finished in accordance with EO 15-45-2.

* Applicable to brake assembly Part 9540281 only.

PARTS REQUIRED

3 The following parts are required per aircraft and will be demanded from AMCHQ as modification Kit 57/1545BB6A2:-

| RCAF REF. | PART | DESCRIPTION | QUANTITY |
|--------------|------|---|------------|
| 57/1545BB6A2 | | Kit Modification brake assembly Part 9540418, 9540281 * | ea. 2 kits |

| RCAF REF. | PART | DESCRIPTION | QTY PER KIT |
|-----------|------|-------------|-------------|
|-----------|------|-------------|-------------|

Each kit consists of the following parts:-

| | | | |
|----------------------|-----------------------|---------------------------------|-------|
| 27A/1630-00-031-4384 | 9520646 or 9522166 | Piston | ea. 3 |
| 27A/1630-00-218-8835 | 9521519 | Button, snap fastener | ea. 9 |
| 27A/1630-00-031-4390 | 9521541 | Lining centre carrier and anvil | ea. 9 |
| 27A/1630-00-031-4389 | 9521539 | Lining brake (piston) | ea. 3 |
| 28/ | AN426AD5-8 | Rivets | ea. 3 |
| 28/ | AN427-5C6 | Rivets | ea. 3 |
| 28/ | AN6227B-32 | Packing "O" ring | ea. 3 |
| 28/ | AN6227B-5 | Packing "O" ring | ea. 3 |
| 28/ | AN6290-8 | Gasket | ea. 2 |

* To modify brake Part 9540281 the following additional parts are required per brake assembly and are to be demanded from stock as individual items under section, reference numbers and quantities as noted.

| | | | |
|----------|------------|-------------------------|-------|
| 27A/3111 | 9511139 | Lining carrier guide | ea. 2 |
| 27A/2480 | 9530597 | Disc rotating brake | ea. 2 |
| 28/ | AN450C12B9 | Rivet - brass oval head | ea. 2 |

PARTS RENDERED SURPLUS OR OBSOLETE

4 Parts removed as a result of this modification are to be disposed of in accordance with CAP 16, Vol. 1, Chap. 13. 1:-

| RCAF REF. | PART | DESCRIPTION | QTY PER ASSY |
|-----------|-----------|--------------------------------|--------------|
| 27A/3124 | 9520774 | Piston | ea. 3 |
| 27A/2220 | 9521136 | Lining, carrier and back plate | ea. 9 |
| 27A/2477 | 9521137 | Lining brake piston | ea. 3 |
| * 27A/ | 9511108 | Lining carrier guide | ea. 2 |
| * 27A/ | 9530323 | Disc rotating brake | ea. 2 |
| 28/ | AN6227-32 | Packing "O" ring | ea. 3 |
| 28/ | AN6227-5 | Packing "O" ring | ea. 3 |
| 28/ | AN6290-8 | Gasket | ea. 2 |

* Parts of brake assembly Part 9540281 only.

WEIGHT, LOADING AND BALANCE DATA

5 Negligible.

ADDITIONAL DATA

6 Torquing procedure:-

(a) Bleeder adaptor Part 9511157 - place rubber gasket at the relief neck of the adaptor making sure that it is not twisted and that it lies flat against the adaptor flange. Wet external threads of the adaptor with brake fluid (same type used in brake). Screw in adaptor by hand and tighten to torque reading of 30 to 40 in. -lbs.

(b) Inlet bushing Part 512054 - install as in (a) torque 17 to 23 in. -lb.

(c) Valve, bleeder AN6204-1 - lubricate with brake fluid, torque 50 to 65 in.-lb.



Bleeder adaptor to be held by wrench while torquing bleeder valve, to prevent overtightening of adaptor.

(d) Man-hours required - approximately one man-hour per assembly.

(e) Part 9540419 is brake assembly 9540418 less discs, Part 9540727 is brake assembly 9540726 less discs. Both assemblies less discs are referenced under 27A/10026. Refer to EO 15-45BB-5A/2.

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