



# MGM Brakes

A Division of Indian Head Industries, Inc.

## TECHNICAL BULLETIN

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### SUBJECT: PROCEDURE TO RETIGHTEN SERVICE ACTUATOR CLAMP BAND

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In the event the service clamp band needs to be retightened due to air leakage it is advisable to perform the following procedure:

#### 1.0 Brake Actuator Mounted on Vehicle

- 1.1 Chock wheels with vehicle on level surface to prevent vehicle runaway.
- 1.2 Apply system air pressure to spring port to fully release parking brake.
- 1.3 Cage parking brake by inserting release bolt into piston and rotate clockwise until fully engaged. Place washer and nut on bolt and tighten down nut finger tight. When fully caged, the release bolt will extend approximately 3-1/4 inches above the nut.
- 1.4 Release air pressure.
- 1.5 Tap service clamp band completely around periphery with hammer and tighten nuts clockwise to 30-35 lbs. ft. torque.
- 1.6 Check for air leak by applying air pressure to the service side and then spray a leak detection solution around service clamp. Formation of air bubbles indicates a leak. If a leak is detected, repeat procedures 1.4 thru 1.6.
- 1.7 If no leak is detected, reapply air pressure to spring port and remove release bolt by reversing installation procedure 1.3.

#### 2.0 Brake Actuator Off Vehicle (on Bench)

- 2.1 The parking brake should be caged as received. However, if not caged follow procedure 1.2 thru 1.4.
- 2.2 Tighten clamp per procedure 1.5.
- 2.3 Check for air leak following procedure 1.6.
- 2.4 If no leak is detected, remove release bolt per procedure 1.7.

**WARNING:** When working on the spring brake exercise extreme caution by standing to the side of the unit.