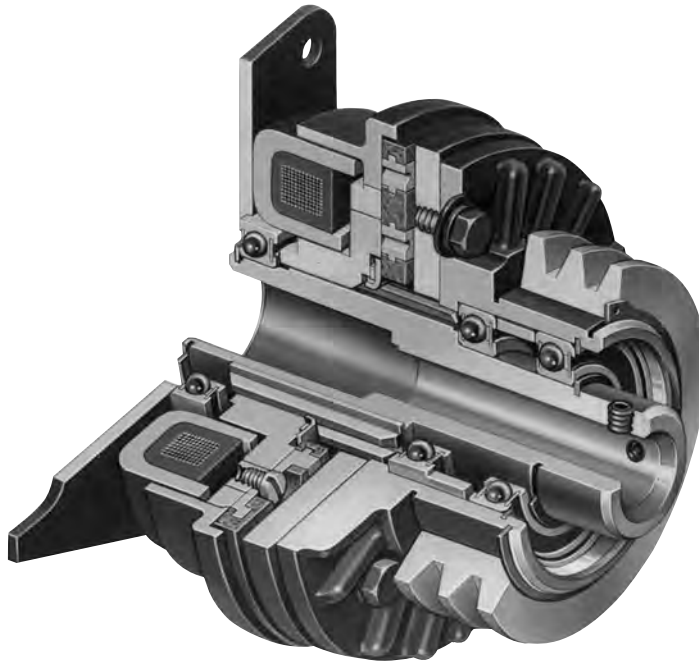


ATT Brakes and Clutches

P-1407
819-0341

Rebuild Instructions



⚠ WARNING Failure to follow these instructions may result in product damage, equipment damage, and serious or fatal injury to personnel.

Brake Repair – On the Shaft Sizes 25, 55, 115

Friction Pads and Armatures

The new ATT design incorporates the latest in advanced technology providing a rugged, durable, patented design for long life, high cycle rates and maximum heat dissipation. Patented, easy-to-replace, friction surfaces extend the design life for continued like-new performance. The ATT offers complete repair on the shaft following ten easy steps. The repair can be completed utilizing the parts in the friction face replacement kit. The unit shown is a brake, but steps apply equally to clutch repair.

1. Move the brake or clutch armature away from the magnet or field for disassembly and reassembly.
 - a. Using a flat blade screwdriver, pry back on armature assembly to increase airgap. (See Figure 1)

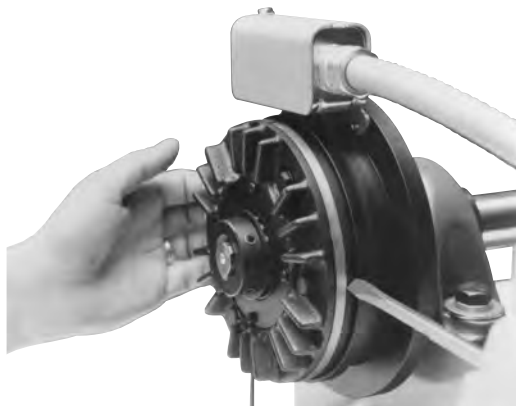


Figure 1

2. Remove hex head capscrews, washers and lockwashers to loosen the armature segments from the cast iron carrier. (See Figure 2)

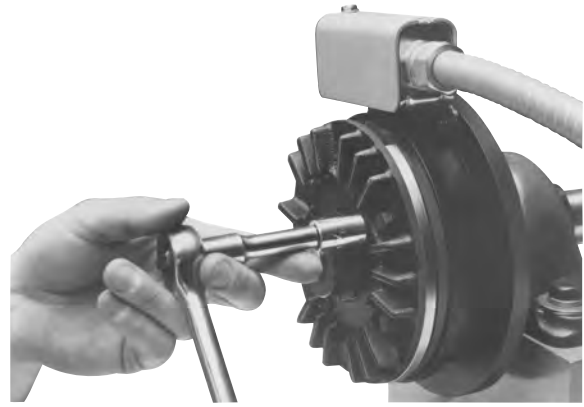


Figure 2

3. Lift out the two worn armature segments. (See Figure 3)

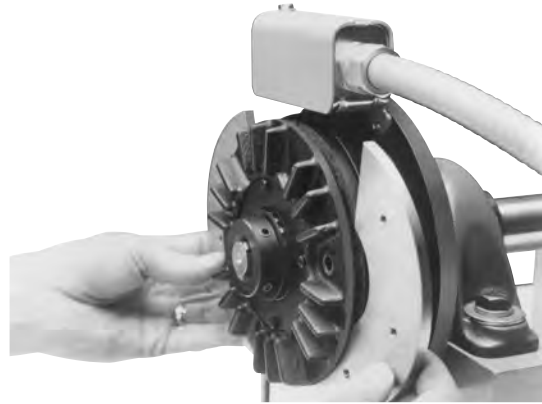


Figure 3

4. Remove the screws, which attach the friction material segments to the brake magnet or clutch rotor through the appropriate access holes in armature face. (See Illustration A and Figure 4)

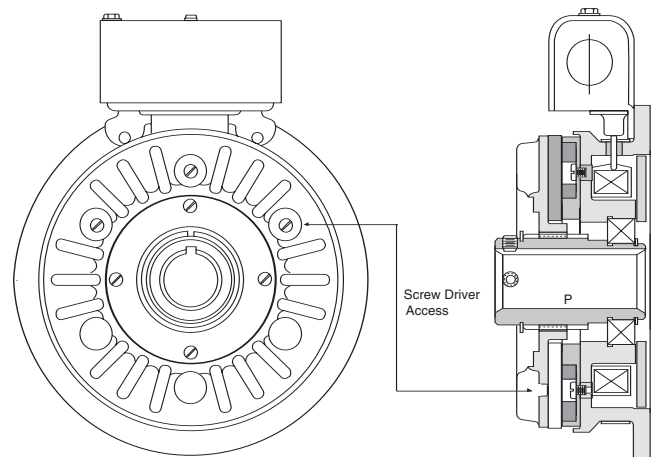


Illustration A

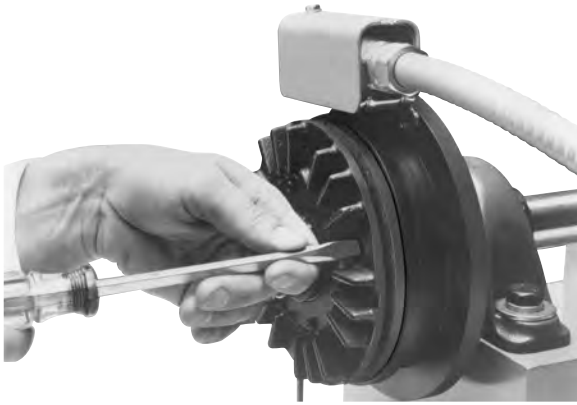


Figure 4

5. Lift out the worn friction material segments. Assure that the autogap plate, detent ring and spring remain in place on the clutch units during this step. (See Figure 5)

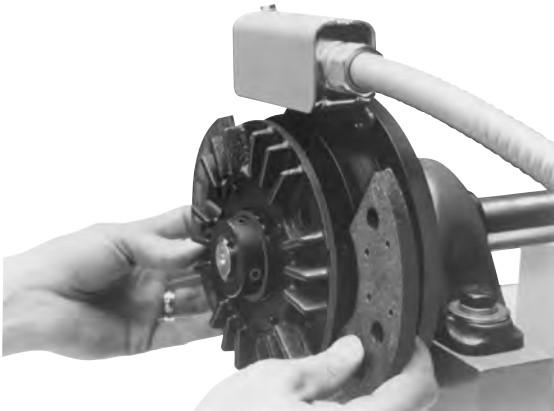


Figure 5

6. Insert two new friction material segments. The recessed holes should be facing away from the magnet body. (See Figure 6)

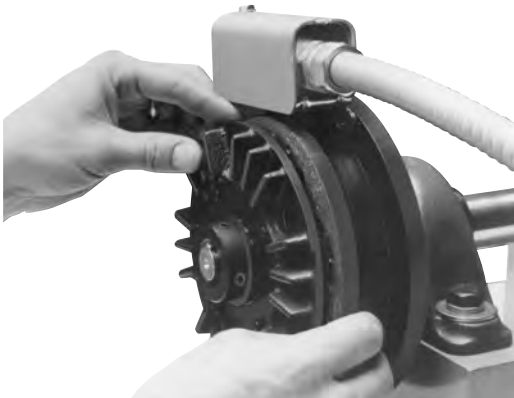


Figure 6

7. Attach the new friction material segments to the brake magnet or clutch rotor with the screws through the appropriate access holes. Apply one drop of Loctite®, (grade AA equivalent) to each screw. (See Figure 7) **Note:** Use only the screws included with the repair kit since any other screws may damage the unit. Tighten screws to 18 to 22 inch pounds torque.



Figure 7

8. Insert the two new armature segments. (See Figure 8)



Figure 8

9. Attach the new armature segments to the cast iron carrier with hex head capscrews, lockwashers and washers. (See Figure 9) Apply one drop of Loctite®, (grade AA or equivalent) to each screw. Clean all hardware to remove old Loctite, and dirt. Tighten to the appropriate torque for your size unit.

Size	Torque
ATT 25	29-35 in.-lbs.
ATT 55	60-84 in.-lbs.
ATT 115	60-84 in.-lbs.

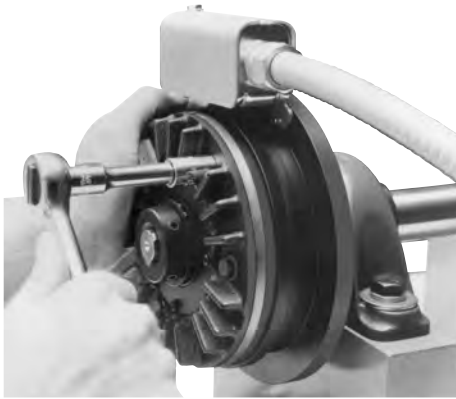


Figure 9

10. Reset the Autogap by pressing the armature toward the magnet or rotor. (See Figure 10)



Figure 10

11. Your ATT brake or clutch is now ready for its static test. Apply DC voltage to the coil through the control. The armature should pull against the friction material face with an audible "click".

12. Run the brake or clutch under its operating load.
13. Your ATT brake or clutch may not achieve its full torque until after a short "break-in" period. To break in, cycle it on and off under full load at operating speed a minimum of ten times in quick succession.

Your ATT brake or clutch is now ready to run.

Note: Your application may require brake to be cycled longer due to load and RPM.

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