Component Procedures: Brake Drum

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Parts and Labor (itype_189)

Parts

Qualifier	Part #	Name	Price	Note
Rear Brakes > Drum > 9 Inch ?	52005350AC	Drum	0.00	

Labor

Operation	Qualifier Path	Skill	Std Hrs	Wty Hrs
Replace	Rear Brakes > One Side	B	0.5	0.3
Resurface/Grind	Rear Brakes > One Side	B	0.3	0.0

Brake Drum Removal and Installation (Article 2039306)

BRAKE DRUM
MACHINING
The brake drums can be machined on a drum lathe when necessary. Initial machining cuts should be limited to 0.12-0.20 mm (0.005-0.008 inch)
at a time as heavier feed rates can produce taper and surface variation. Final finish cuts of 0.025 to 0.038 mm (0.001 to 0.0015 inch)
are recommended and will generally provide the best surface finish.
Be sure the drum is securely mounted in the lathe before machining operations. A damper strap should always be used around the drum to reduce vibration and avoid chatter marks.
The maximum allowable diameter of the drum braking surface is stamped or cast into the drum outer edge.
CAUTION:
Replace the drum if machining will cause the drum to exceed the maximum allowable diameter.

Mechanical (including Torque) (itype_28)

BRAKE DRUM SIZE 228.6 x 63.5 mm (9 x 2.5 in.)
DRUM DIAMETER (Maximum) This marking includes 0.76 mm (0.030 inch) for allowable drum wear beyond the recommended 1.52 mm (0.060 inch) of drum refacing. Cast/stamped into outside surface of drum
DRUM DIAMETER VARIATION (Maximum) 0.076 mm (0.003 in.)
DRUM RUNOUT (on lathe) 0.20 mm (0.008 in.)
INITIAL DRUM MACHINING CUTS Initial machining cuts should be limited to 0.12 - 0.20 mm (0.005 - 0.008 in.) at a time as heavier feed rates can produce taper and surface variation. 0.12 - 0.20 mm (0.005 - 0.008 in.)
FINISH DRUM MACHINING CUTS 0.025 - 0.038 mm (0.001 - 0.0015 in.)

Brake Drum Runout (Article 2039308)

The maximum allowable diameter of the drum braking surface is indicated on the drum outer edge. Generally, a drum can be machined to a maximum of
1.52 mm (0.060 inch)
oversize. Always replace the drum if machining would cause drum diameter to exceed the size limit indicated on the drum.
BRAKE DRUM
RUNOUT
Measure drum diameter and runout with an accurate gauge. The most accurate method of measurement involves mounting the drum in a brake lathe and checking variation and runout with a dial indicator.
Variations in drum diameter should not exceed
0.076 mm (0.003 inch).
Drum runout should not exceed
0.20 mm (0.008 inch)
out of round. Machine the drum if runout or variation exceed these values. Replace the drum if machining causes the drum to exceed the maximum allowable diameter.