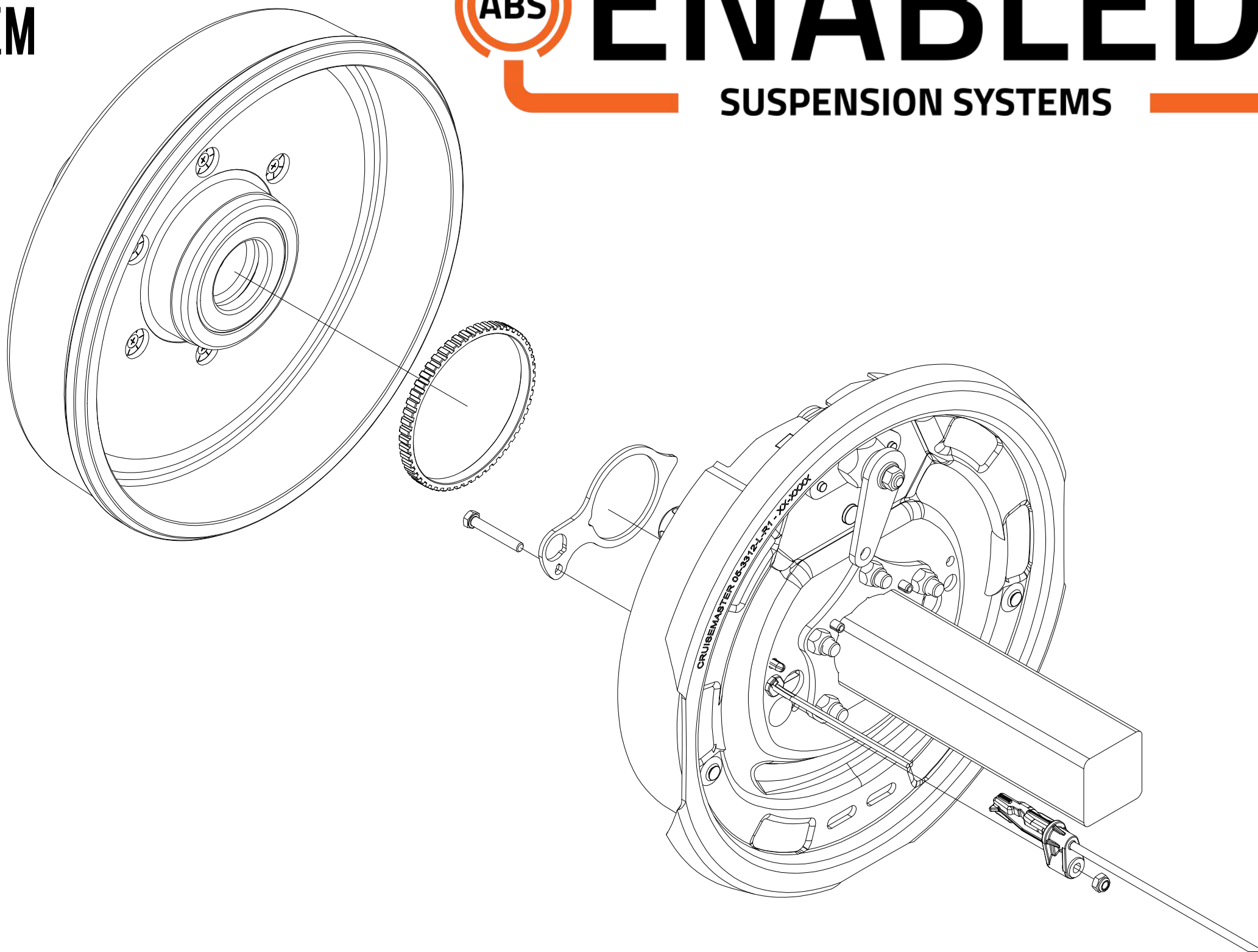




ENABLED BRAKE SYSTEM INSTALLATION GUIDE

- 2. REQUIRED PARTS
- 3. DISASSEMBLY AND INSPECTION
- 4. WELD RING CONVERSION
- 5. DRUM ASSEMBLY
- 6. FINAL ASSEMBLY



ENABLED BRAKE SYSTEM INSTALLATION GUIDE TITLE

85-INSTALLATION-ENABLED-BRAKE PART NUMBER

MATERIAL:

FINISH:

ALL DIMENSIONS IN MILLIMETERS UNLESS OTHERWISE STATED

DO NOT SCALE

MASS: N/A

PAGE: 1 of 6

SUPPLIER CODE:

VOLUME: N/A

SHEET SIZE: A3

UNLESS OTHERWISE STATED	
DIM	TOL
0	± 0.5
0.0	± 0.2
0.00	± 0.05
MACHINED	3.2/

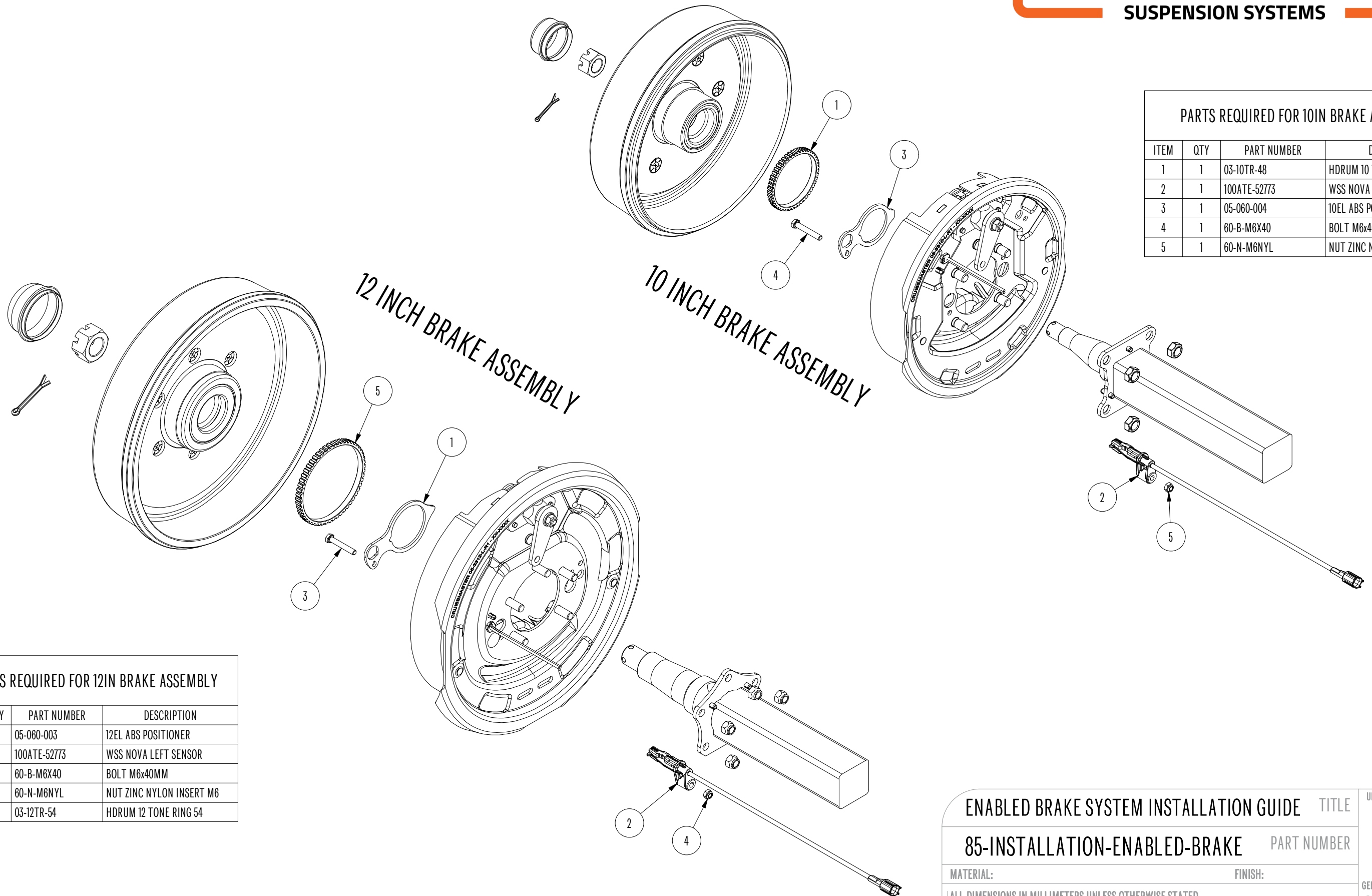
GEN SHORE HARDNESS TOL ± 3
REMOVE SHARP EDGES



REV	DESCRIPTION	ECN	ENGINEER	DATE
1	Initial release	--	SS	22/04/2024



2. REQUIRED PARTS



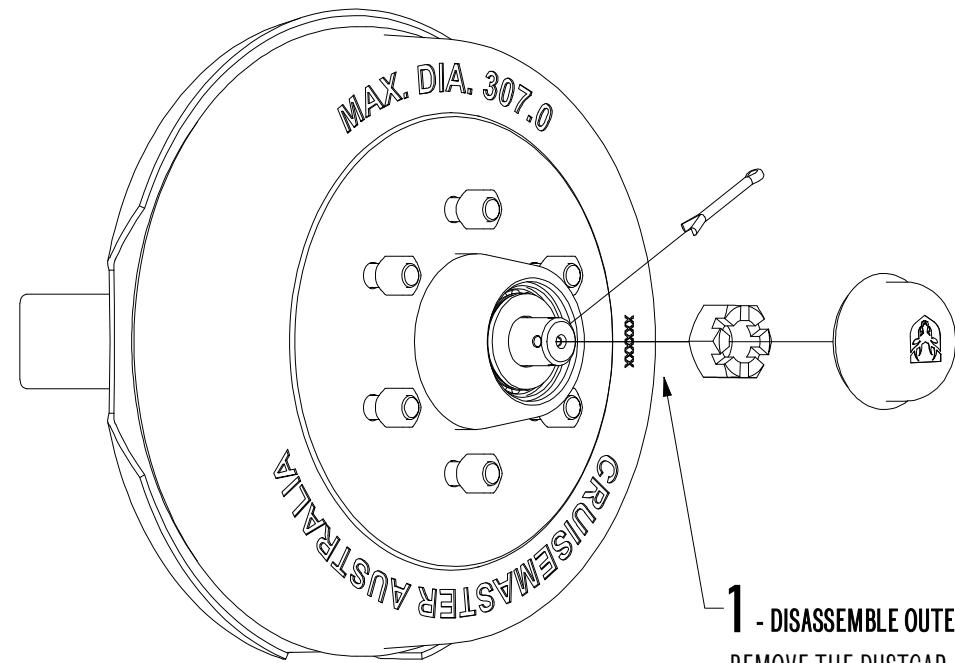
PARTS REQUIRED FOR 10IN BRAKE ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	03-10TR-48	HDRUM 10 TONE RING 48T
2	1	100ATE-52773	WSS NOVA LEFT SENSOR
3	1	05-060-004	10EL ABS POSITIONER
4	1	60-B-M6X40	BOLT M6x40MM
5	1	60-N-M6NYL	NUT ZINC NYLON INSERT M6

PARTS REQUIRED FOR 12IN BRAKE ASSEMBLY			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	05-060-003	12EL ABS POSITIONER
2	1	100ATE-52773	WSS NOVA LEFT SENSOR
3	1	60-B-M6X40	BOLT M6x40MM
4	1	60-N-M6NYL	NUT ZINC NYLON INSERT M6
5	1	03-12TR-54	HDRUM 12 TONE RING 54

ENABLED BRAKE SYSTEM INSTALLATION GUIDE		TITLE
85-INSTALLATION-ENABLED-BRAKE		PART NUMBER
MATERIAL:	FINISH:	
ALL DIMENSIONS IN MILLIMETERS UNLESS OTHERWISE STATED		
DO NOT SCALE	MASS: N/A	PAGE: 2 of 6
SUPPLIER CODE:	VOLUME: N/A	SHEET SIZE: A3
UNLESS OTHERWISE STATED		TOL
DIM		
0 ±		0.5
0.0 ±		0.2
0.00 ±		0.05
MACHINED		3.2/
GEN SHORE HARDNESS TOL ± 3		
REMOVE SHARP EDGES		

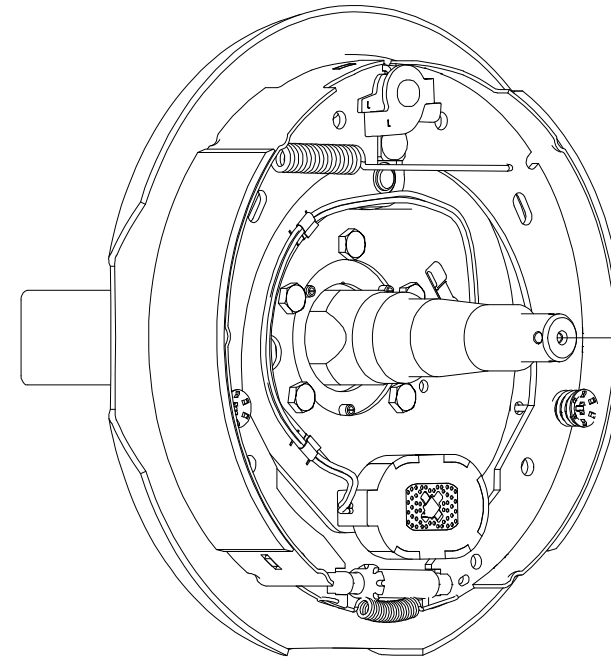


3. DISASSEMBLY AND INSPECTION



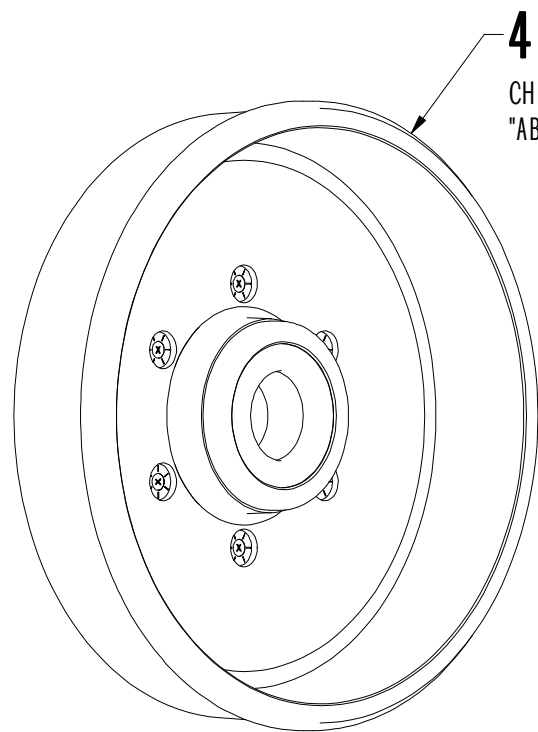
1 - DISASSEMBLE OUTER HUB COMPONENTS

REMOVE THE DUSTCAP, SLOTTED NUT AND SPLIT PIN →

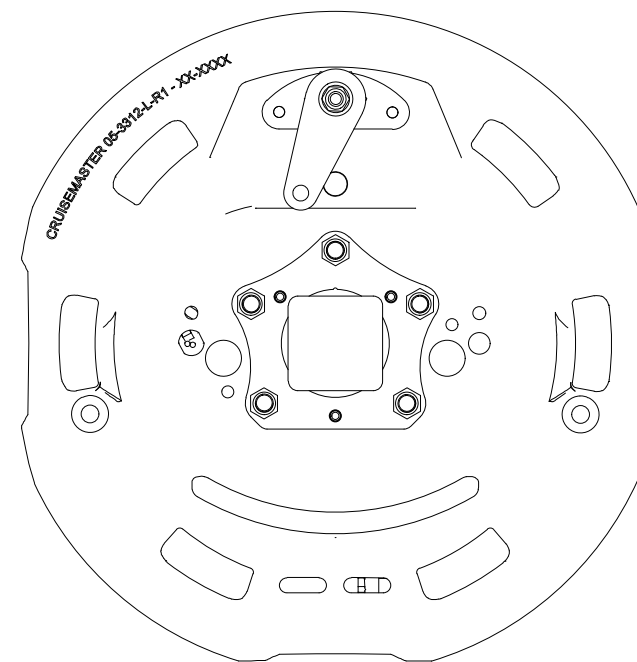


2 - REMOVE DRUM

SLIDE THE DRUM AWAY FROM THE BRAKE AND OFF THE STUB AXLE BEING CAREFUL NOT TO DROP THE OUTER BEARING. REMOVE THE GREASE FROM THE STUB AXLE.



4 - INSPECT DRUM ←
CHECK FOR DRUM COMPATIBILITY. REFER TO THE "ABS SYSTEM COMPATIBILITY GUIDE" FOR DETAILS.



3 - INSPECT BACKING PLATE AND WELD RING

CHECK FOR ABS COMPATIBILITY IN THE BRAKE BACKING PLATE AND WELD RING. REFER TO THE "ABS SYSTEM COMPATIBILITY GUIDE" FOR DETAILS. IF THE BACKING PLATE IS INCOMPATIBLE AND/OR THE WELD RING IS INCOMPATIBLE, REMOVE THE BACKING PLATE AND SEE "4. WELD RING CONVERSION"

NOTES:

- PROCEDURE IS THE SAME FOR BOTH 10 INCH AND 12 INCH BRAKE ASSEMBLIES. THIS SHEET DEPICTS A 12 INCH BRAKE ASSEMBLY.
- CHECK FOR WEAR ON ALL COMPONENTS AND REPLACE IF REQUIRED.

ENABLED BRAKE SYSTEM INSTALLATION GUIDE TITLE

85-INSTALLATION-ENABLED-BRAKE PART NUMBER

MATERIAL:

FINISH:

ALL DIMENSIONS IN MILLIMETERS UNLESS OTHERWISE STATED

DO NOT SCALE

MASS: N/A

PAGE: 3 of 6

SUPPLIER CODE:

VOLUME: N/A

SHEET SIZE: A3

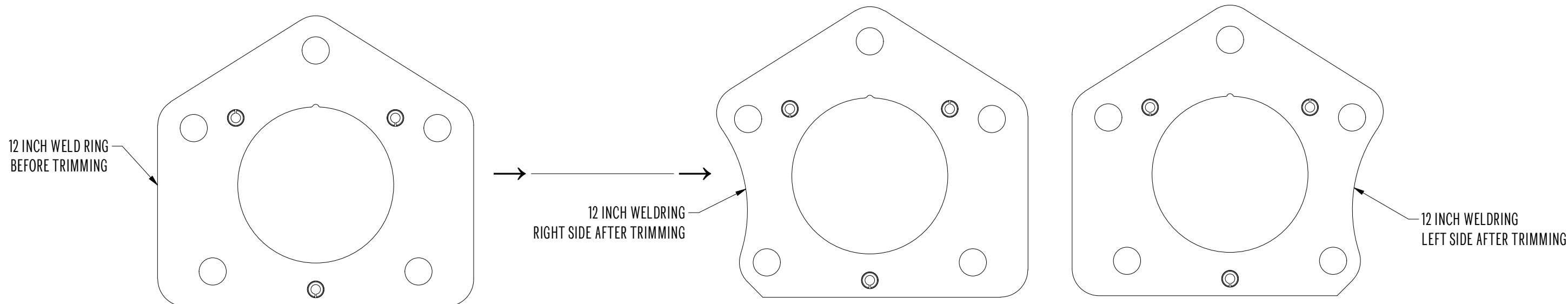
UNLESS OTHERWISE STATED	DIM	TOL
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	0.0 ±	0.2
	0.00 ±	0.05
	MACHINED	3.2

GEN SHORE HARDNESS TOL ± 3
REMOVE SHARP EDGES



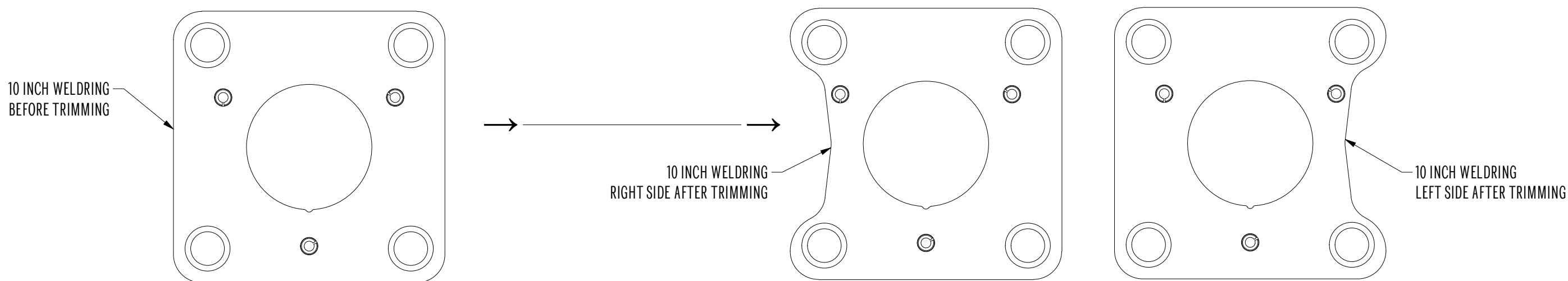


4. WELD RING CONVERSION



WELD RING TRIMMING PROCESS

1. PRINT "BRAKE SYSTEM COMPATIBILITY GUIDE"/PAGE 2 ON A3 PAPER/CARD AND CUT OUT TEMPLATE FOR THE CORRESPONDING WELD RING.
2. MARK LINES TO BE CUT ON THE WELD RING BEING MODIFIED.
3. USING AN ANGLE GRINDER AND/OR DIE GRINDER, REMOVE THE REQUIRED MATERIAL FROM THE WELD RING.
4. ONCE MATERIAL REMOVAL IS COMPLETE, COAT RAW SURFACES WITH TOUCH-UP PAINT. ENSURE SURFACES ARE CLEAN AND EDGES ARE FREE OF BURRS PRIOR TO COATING.



- NOTES:
1. VIEWS IN THIS SHEET ARE NOT TO SCALE AND MUST NOT BE USED AS TEMPLATES. REFER TO "BRAKE SYSTEM COMPATIBILITY GUIDE" FOR SCALE TRIMMING TEMPLATES.
 2. OPTIONAL: BOTH SIDES OF THE WELD RING MAY BE TRIMMED FOR AESTHETIC PURPOSES.
 3. VIEWS ARE FROM AN OUTBOARD PERSPECTIVE LOOKING TOWARDS THE INBOARD OF THE VEHICLE.

ENABLED BRAKE SYSTEM INSTALLATION GUIDE TITLE

85-INSTALLATION-ENABLED-BRAKE PART NUMBER

MATERIAL: FINISH:

ALL DIMENSIONS IN MILLIMETERS UNLESS OTHERWISE STATED

DO NOT SCALE MASS: 0.290 kg PAGE: 4 of 6
 SUPPLIER CODE: VOLUME: 37648.5 mm³ SHEET SIZE: A3

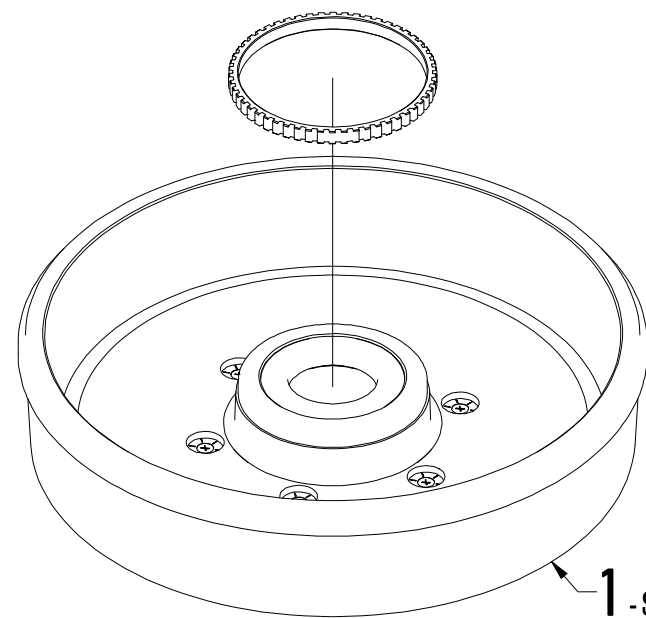
UNLESS OTHERWISE STATED	
DIM	TOL
0	± 0.5
0.0	± 0.2
0.00	± 0.05
MACHINED	3.2/

GEN SHORE HARDNESS TOL ± 3
 REMOVE SHARP EDGES



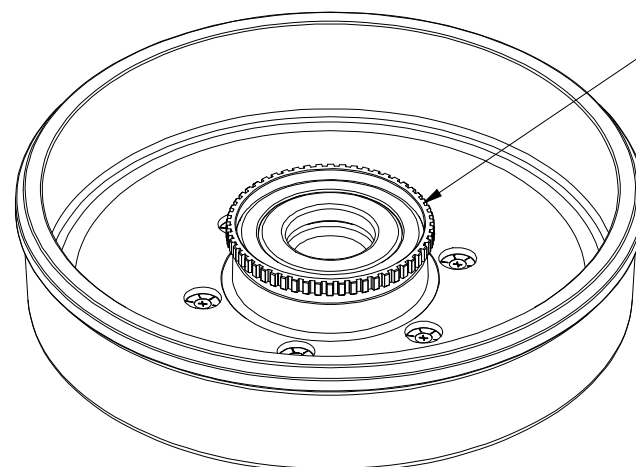


5. DRUM ASSEMBLY



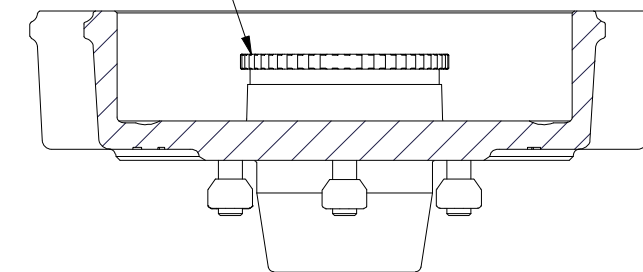
1 - SETUP

PLACE DRUM OUTER HUB FACE ON A FLAT AND STABLE SURFACE. →

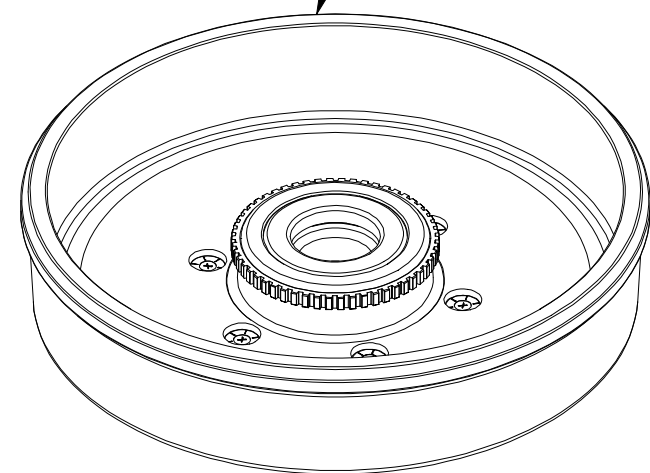


2 - TONE RING POSITIONING

POSITION THE TONE RING ON THE TOP EDGE OF THE INNER HUB. ENSURE THE TOP SURFACE OF THE TONE RING IS PARALLEL TO THE TOP SURFACE OF THE INNER HUB BEFORE PROCEEDING.

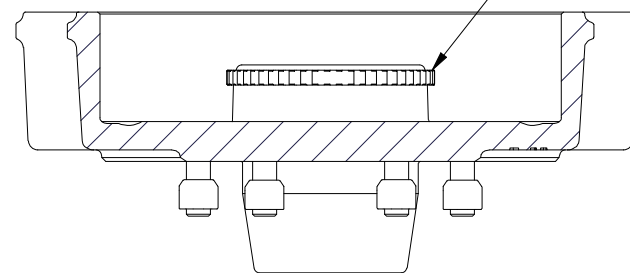


SECTION A



4 - INSPECTION

CHECK THE TONE RING FITMENT IS SEATED AGAINST THE MACHINED STEP IN THE DRUM ALL THE WAY AROUND. IF NOT, REFER TO 3B: PART II.



SECTION B

3A - TONE RING FITMENT (WITH PRESS)

ENSURE DRUM IS ON A FLAT AND STABLE SURFACE IN THE PRESS. USE A PRESS TOOL FIT FOR PURPOSE TO PRESS THE TONE RING DOWN THE HUB FACE UNTIL IT REACHES THE MACHINED STEP IN THE DRUM.

3B - TONE RING FITMENT (WITHOUT PRESS)

- I. USE A SOFT-FACE Mallet TO LIGHTLY TAP AROUND THE TONE RING TO LOWER IT DOWN THE HUB FACE. MOVE THE LOCATION OF EACH TAP TO ENSURE THE TONE RING IS FITTED EVENLY WITHOUT DAMAGE.
- II. ONCE THE TOP FACE OF THE TONE RING IS FLUSH WITH THE TOP HUB FACE, USE A SMALL DRIFT AND HAMMER TO ACHIEVE FINAL FITMENT AGAINST THE MACHINED STEP IN THE DRUM. MOVE THE LOCATION OF EACH TAP TO ENSURE THE TONE RING IS FITTED EVENLY WITHOUT DAMAGE. USE CAUTION TO AVOID DAMAGING THE TEETH OF THE TONE RING.

NOTES:
1. PROCEDURE IS THE SAME FOR BOTH 10 INCH AND 12 INCH DRUM ASSEMBLIES. THIS SHEET DEPICTS A 12 INCH DRUM ASSEMBLY.

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ENABLED BRAKE SYSTEM INSTALLATION GUIDE TITLE

85-INSTALLATION-ENABLED-BRAKE PART NUMBER

MATERIAL:

FINISH:

ALL DIMENSIONS IN MILLIMETERS UNLESS OTHERWISE STATED

DO NOT SCALE

MASS: N/A

PAGE: 5 of 6

SUPPLIER CODE:

VOLUME: N/A

SHEET SIZE: A3

DIM	TOL
0	± 0.5
0.0	± 0.2
0.00	± 0.05
MACHINED	3.2/

GEN SHORE HARDNESS TOL ± 3
REMOVE SHARP EDGES

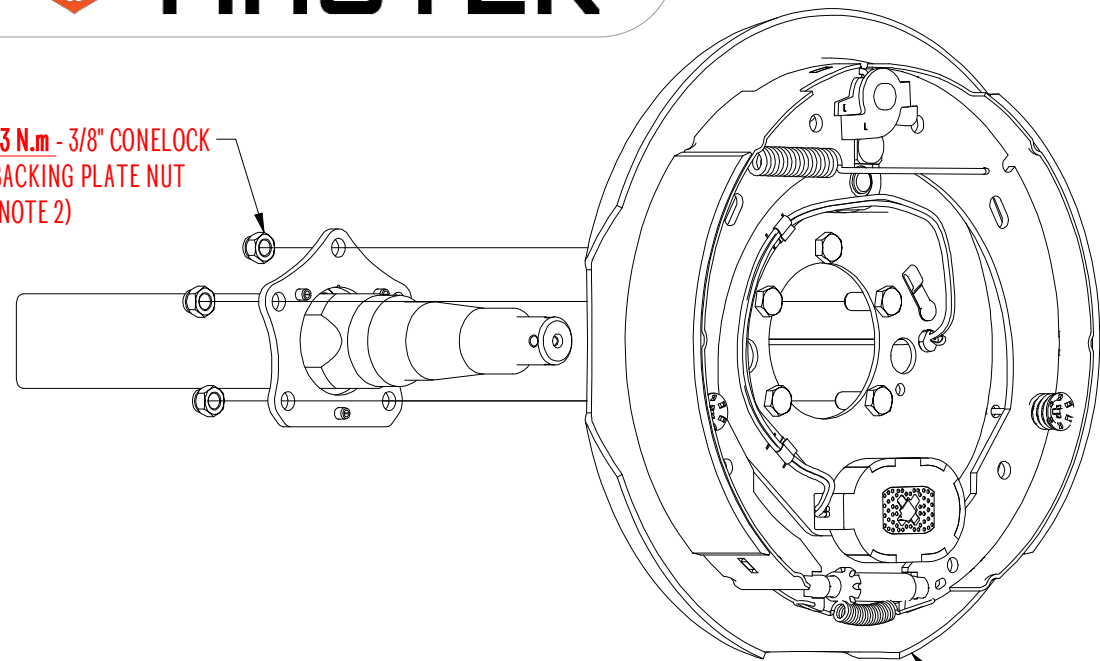




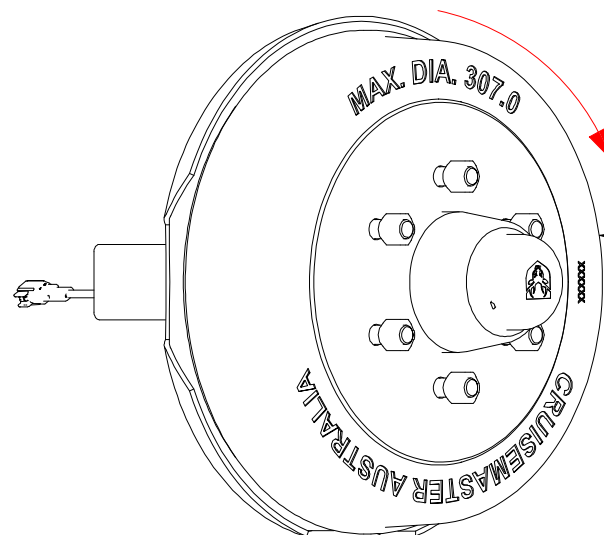
6. FINAL ASSEMBLY



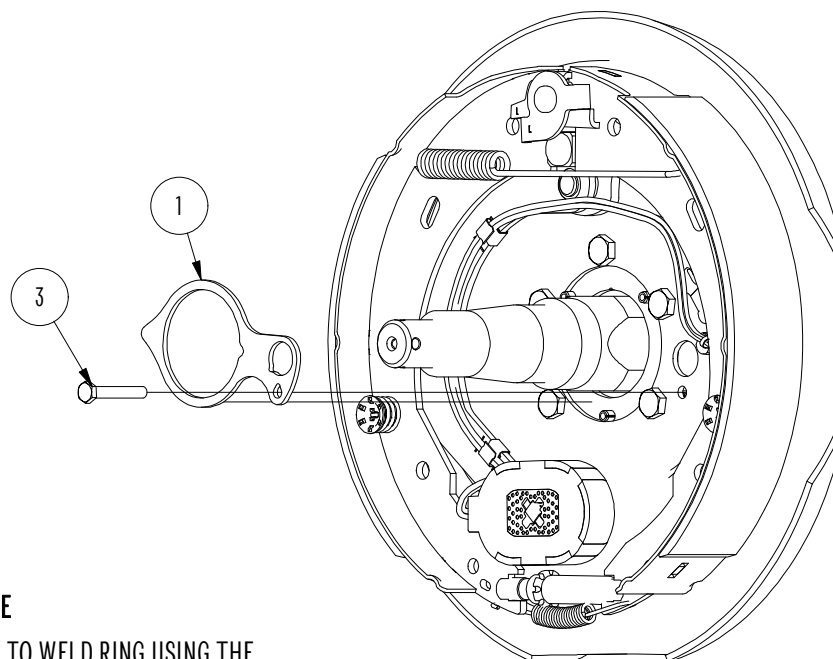
33 N.m - 3/8" CONELOCK BACKING PLATE NUT (NOTE 2)



1 - MOUNT BACKING PLATE
ASSEMBLE BACKING PLATE TO WELD RING USING THE SPECIFIED FASTENERS. →

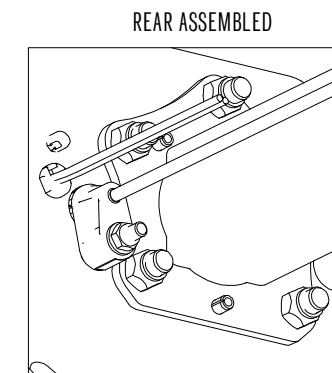
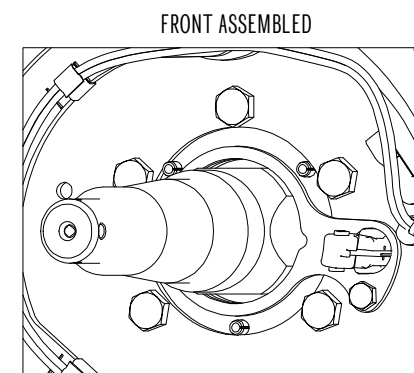


4 - TESTING ←
USING A WHEEL SPEED SENSOR TESTER, ENSURE THE WSS ARE OPERATIONAL.

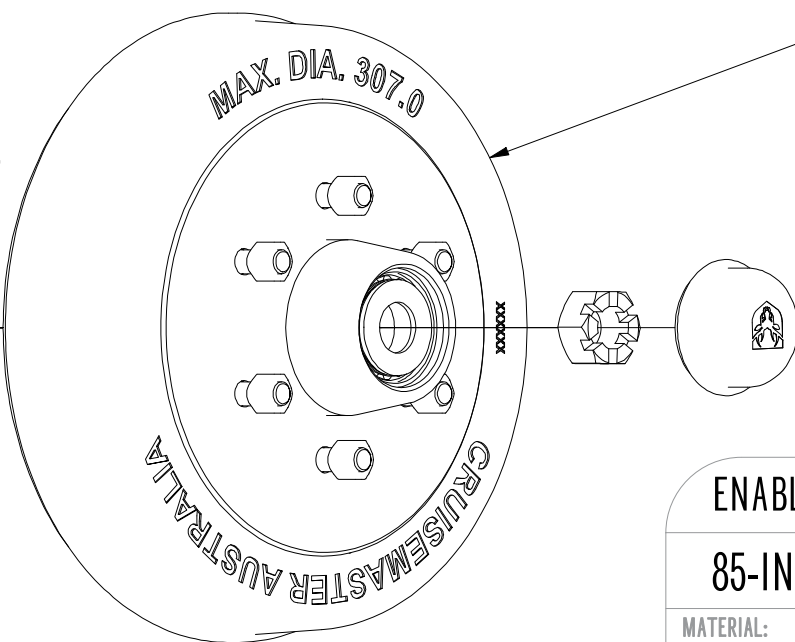


2 - FIT WHEEL SPEED SENSOR
REMOVE PLASTIC PLUG FROM THE PASS-THROUGH HOLE IN THE BACKING PLATE CLOSEST TO BRAKE MAGNET CABLE (OPPOSITE SIDE TO BRAKE MAGNET ARM). SLIDE ABS POSITIONER (1) OVER THE STUB AXLE. PASS THE WHEEL SPEED SENSOR (WSS) (2) THROUGH THE REAR OF THE BACKING PLATE AND PUSH THROUGH THE ABS POSITIONER FIRMLY. PASS THE BOLT (3) THROUGH THE FRONT SIDE OF THE ABS POSITIONER, BACKING PLATE AND WSS. FASTEN WITH NUT (4).

10 N.m - M6 WHEEL SPEED SENSOR NUT



3 - DRUM FITMENT
ENSURE BEARINGS ARE GREASED AND IN GOOD CONDITION PRIOR TO INSTALLATION. SLIDE THE DRUM (FITTED WITH BEARINGS, SEAL AND TONE RING), OVER THE STUB AXLE AND BRAKE SHOES. PRE-LOAD THE BEARINGS WITH THE SLOTTED NUT BY TIGHTENING FIRMLY, THEN BACKING OFF AND TIGHTENING AGAIN TO DESIRED TENSION, ENSURING THE DRUM ROTATES FREELY WITHOUT BEARING PLAY. FIT SPLIT PIN THROUGH THE NUT AND STUB AXLE. FOLD THE LONGER LEG OVER THE END OF THE STUB AXLE AND TRIM THE SHORT LEG. FIT THE DUSTCOVER INTO THE OUTER HUB OF THE DRUM.



- NOTES:
- PROCEDURE IS THE SAME FOR BOTH 10 INCH AND 12 INCH CRUISEMASTER BRAKE ASSEMBLIES. THIS SHEET DEPICTS A 12 INCH ASSEMBLY.
 - FOR 10 INCH CRUISEMASTER BRAKES, 53 N.m - 7/16" CONELOCK

ENABLED BRAKE SYSTEM INSTALLATION GUIDE TITLE

85-INSTALLATION-ENABLED-BRAKE PART NUMBER

MATERIAL:

FINISH:

ALL DIMENSIONS IN MILLIMETERS UNLESS OTHERWISE STATED

DO NOT SCALE

MASS: N/A

PAGE: 6 of 6

SUPPLIER CODE:

VOLUME: N/A

SHEET SIZE: A3

DIM	TOL
0	± 0.5
0.0	± 0.2
0.00	± 0.05
MACHINED	3.2

GEN SHORE HARDNESS TOL ± 3 REMOVE SHARP EDGES

