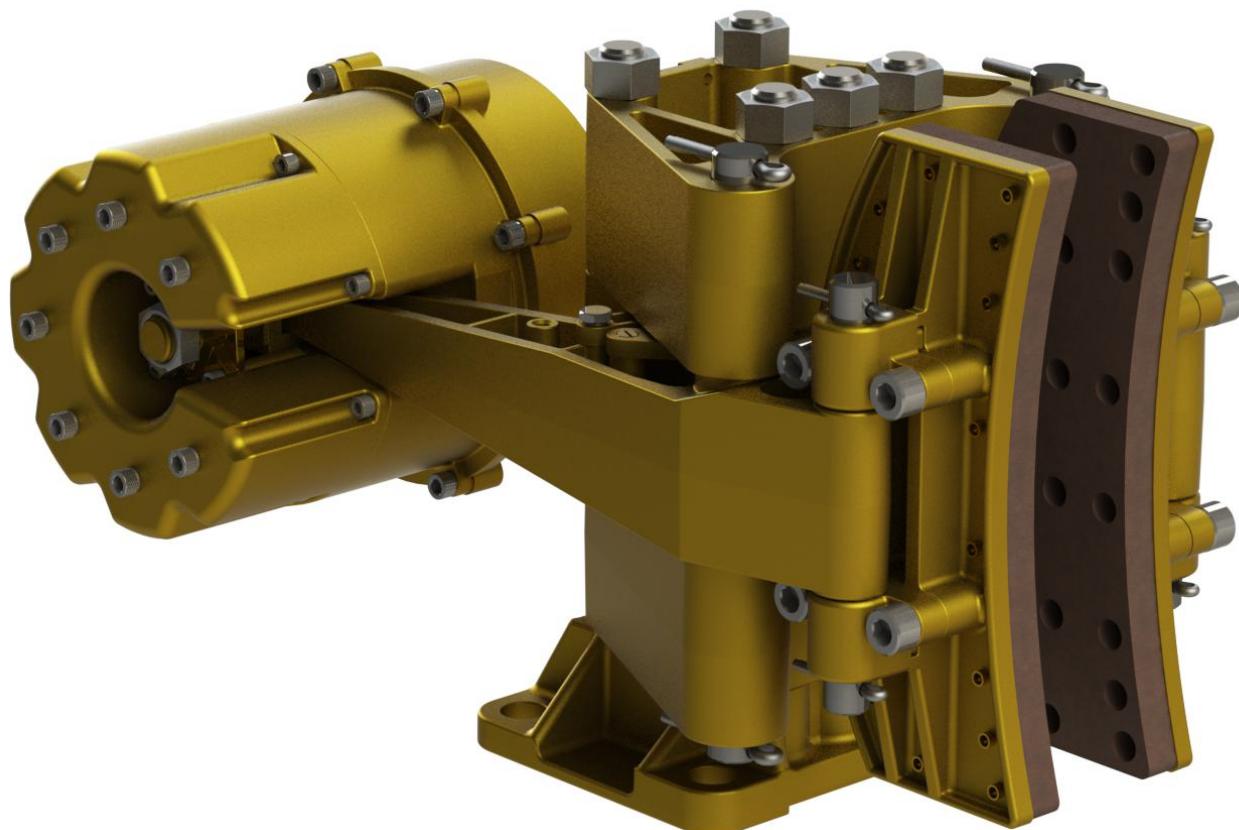




## 5024-SA DISK BRAKE SPRING / AIR VERSION

*Owner's Operation, Installation &  
Maintenance Manual*



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# 1 INTRODUCTION

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## 1.1 CONTACT INFORMATION

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Website: [www.kobelt.com](http://www.kobelt.com)

For further instructions, please contact our distributors or visit our website.

## 1.2 SAFETY INFORMATION

### 1.2.1 Safety Alerts

Throughout this manual, the following symbols, and their accompanying explanation, are used to alert the user to special instructions concerning a service or operation that may be hazardous if performed incorrectly or carelessly. The associated risk levels are stated below.

 <b>DANGER</b>	This symbol indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.
 <b>WARNING</b>	This symbol indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.
 <b>CAUTION</b>	This symbol indicates a hazardous situation, which if not avoided, could result in minor or moderate injury.
<b>NOTICE</b>	This symbol informs the reader of events not related to personal injury but which there is a risk of damage to property or equipment.
<b>SAFETY INSTRUCTIONS</b>	This symbol informs the reader of safety-related instructions or procedures.

### 1.2.2 Safety Instructions

**Notice to Installer:**

Disregarding the following safety measures can result in an accident, causing severe injury to personnel and damage to material assets:

- Only use the product as directed in this manual.
- Never put the product into service if there is evidence of visible damage.
- Never put the product into service before fully completing installation and commissioning.
- Do not carry out any modifications to the product.
- Only use authentic Kobelt spare parts.

- Observe all local regulations, directives and laws during the installation of this product.
- All installation, commissioning and maintenance work must only be conducted by qualified personnel. (For the purpose of this manual, qualified personnel are persons who are familiar with the assembly, installation, commissioning, and operation of the product and who have the qualifications necessary for their occupation.)
- Observe all specifications in this manual. If these guidelines are not followed and damage occurs, the warranty will be voided.

### 1.2.3 Hazards

 <b>DANGER</b>	<p><b>Equipment Starts Automatically:</b> Brake systems frequently are controlled remotely and may activate suddenly causing bodily harm. Ensure all power sources are locked out prior to performing work.</p>
 <b>DANGER</b>	<p><b>Brake Actuators Contain Compressed Springs:</b> The brake actuators contain springs that are under compression even when the brakes are not pressurized. The springs will release suddenly if disassembled incorrectly posing a risk of serious injury or death. Do not attempt to disassemble the actuators without clear work instructions and training.</p>
 <b>WARNING</b>	<p><b>Pinch Points:</b> Brakes contain numerous pinch points which can cause serious injury. Ensure all power sources are locked out prior to performing work.</p>
 <b>WARNING</b>	<p><b>High Pressure Fluids:</b> Kobelt lever brakes use high pressure fluids. Ensure all pressure is exhausted and the pressure source locked out prior to performing work.</p>
 <b>WARNING</b>	<p><b>Hot Surfaces:</b> Disc brakes are capable of making the surfaces of the brake disc dangerously hot when burnishing or during braking events. Ensure the disc is adequately guarded to prevent inadvertent contact with the disc.</p>
<b>SAFETY INSTRUCTIONS</b>	<p><b>Airborne Dust:</b> Brake linings contain fibers that may become airborne during cutting or sanding operations. Over exposure to these dusts should be considered hazardous. Use NIOSH approved respirators when working with brake linings. Request a MSDS for further information.</p>

## 1.3 PRODUCT DESCRIPTION

### 1.3.1 Overview

The diagram below shows a typical Kobelt caliper brake with all the major components identified. All of the Kobelt caliper brakes can be fitted with either air applied, hydraulic applied, spring applied with air released or spring applied with hydraulic released actuators depending on the required service.

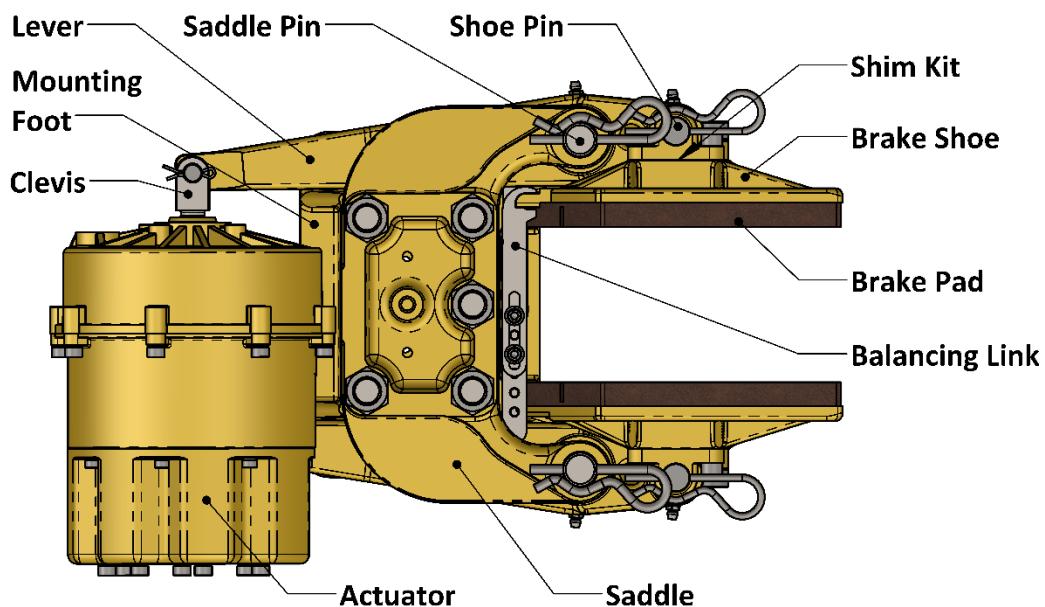


Figure 1: Caliper Brake Nomenclature

## 1.4 TECHNICAL DATA

Table 1: 5024-SA Technical Data

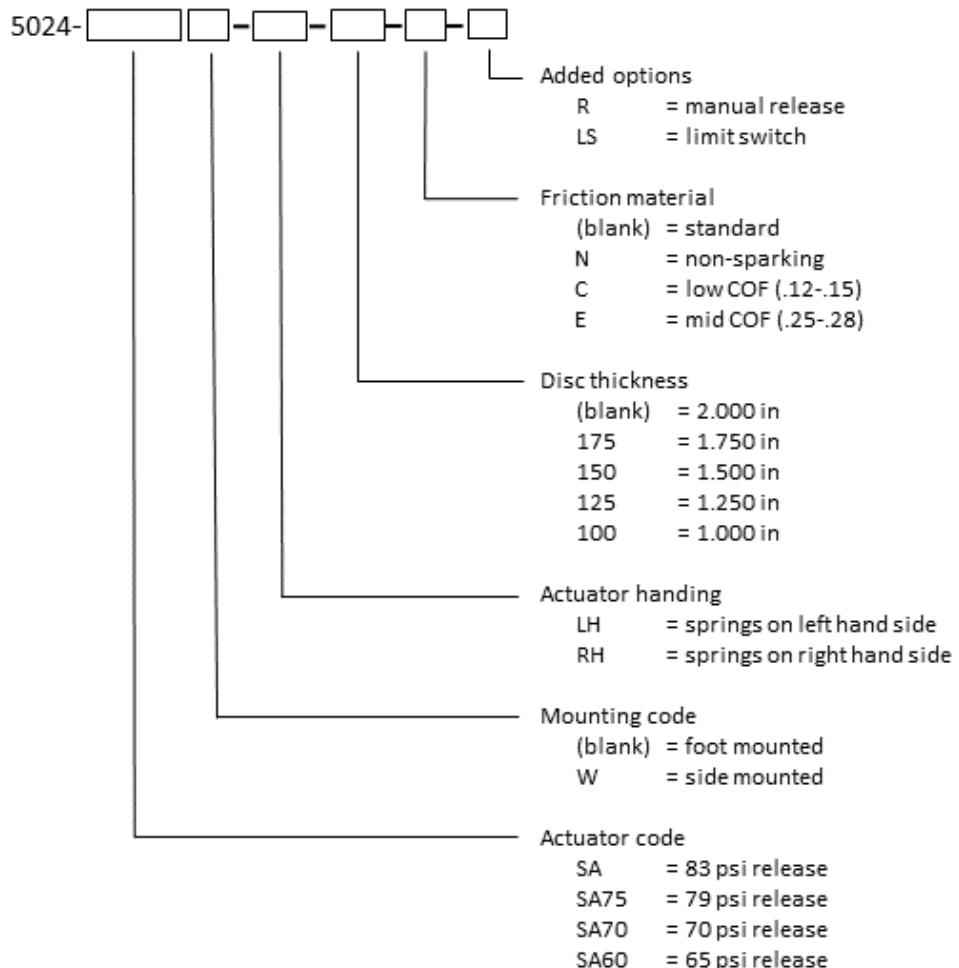
MODEL	NORMAL FORCE	PRESSURES	
		RELEASE	HOLD-OFF
5024-SA	10,470 lbs [46.6 KN]	83 psi [5.7 bar]	70 psi [4.9 bar]
5024-SA75	10,190 lbs [45.3 KN]	79 psi [5.4 bar]	68 psi [4.7 bar]
5024-SA70	9350 lbs [41.6 KN]	70 psi [4.8 bar]	62 psi [4.3 bar]
5024-SA60	8610 lbs [38.3 KN]	65 psi [4.5 bar]	56 psi [3.9 bar]

Maximum Pressure:	150 psi [10.3 bar]	
Port Size:	3/8 NPT	
Actuator Volume:	60.1 in <sup>3</sup> [985 cc]	
Temperature Range:	-40°F ...+131°F -40°C ...+55°C	
Disc Thickness:	2 in	[51 mm]
Max Running Clearance:	.06 in	[1.5 mm]
Minimum Disc Diameter:	20 in	[508 mm]
Maximum Disc Diameter:	unlimited <sup>1</sup>	
Total Pad Area:	69 in <sup>2</sup>	[448 cm <sup>2</sup> ]
Pad Life:	4775 hp-hr	[3540 kw-hr]
Weight:	142 lbs	[64 kg]

1) Requires a minimum 4.72 in [120 mm] wide face

Technical data and specifications are also available from our datasheet posted on [www.kobelt.com](http://www.kobelt.com) or the technical drawings in Appendix A.

## 1.5 MODEL CODE KEY



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## 2 INSTALLATION

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### 2.1 PREPARATION

The foundation plate to support the brake caliper must be designed to withstand the maximum braking forces generated by the brake caliper. The foundation must also be flat to ISO tolerance grade IT8 and square to the brake disc. See Appendix A for key installation dimensions. The brake pedestal must be designed to allow the mounting bolts to be inserted from underneath.

The rotating element should have bearings sufficient to carry the weight of the disc and also resist the additional stress when the disc brake is applied.

The spigot that centers the brake disc must not be designed in such a way that it impedes the thermal expansion of the disc.

Actuator ports are plugged to prevent contamination of the seals. Remove the plugs prior to connection to the piping.

Brake discs are shipped with a light rust inhibitor applied to the surfaces. Remove the rust inhibitor using solvent and a cloth prior to installation.

Any guarding around the brakes must provide enough room to allow full extension of the brake actuators plus full pad wear adjustment.

#### 2.1.1 Rigging – 5024-SA

The 5024-SA model brake has a lifting provision at the top of brake as shown in Figure 1. Customers may attach a lifting device such as an eye bolt(not included) into the 3/8 UNC hole and use it as a lifting point to lift and position the brake during installation. Ensure lifting devices are rated for the weight of the 5024-SA assembly.

 <b>WARNING</b>	<p><b>Only use the lifting provision for lifting the weight of the 5024 brake.</b></p> <p><i>Additional hardware such as a brake mounting pedestal should be lifted separately, and should not be lifted through the brake lifting provision.</i></p>
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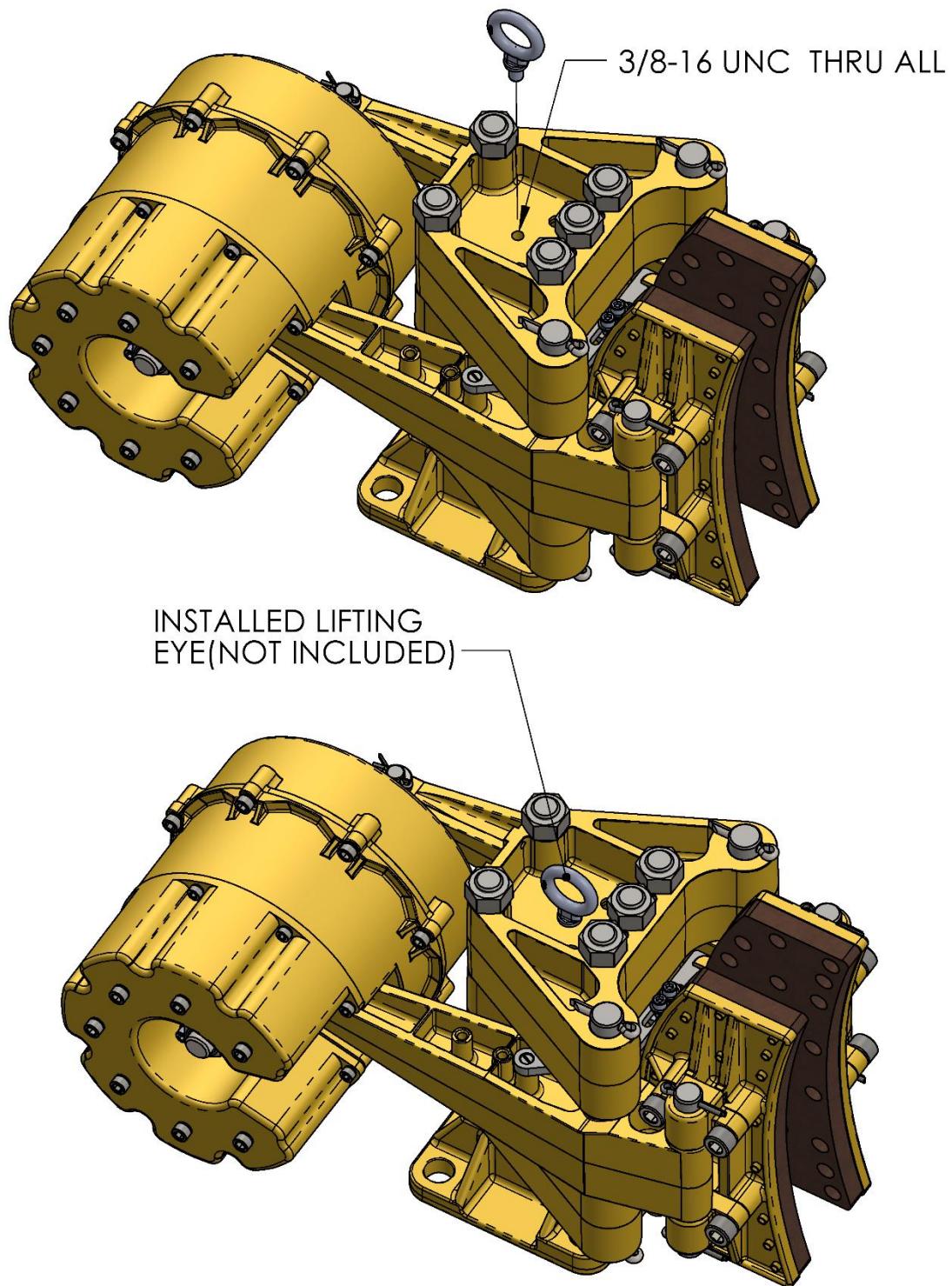


Figure 1: 5024-SA Rigging

## 2.2 BRAKE DISCS

The brake disc must be installed onto the rotating element before installing the caliper. Brake discs must meet the following requirements:

*Table 2: Brake Disc Requirements*

MODEL	5000-SERIES
AXIAL RUN OUT	IT9 (TIR) <sup>1</sup>
RADIAL RUN OUT	IT11 (TIR) <sup>1</sup>
FLATNESS	.004 in [.10 mm]
PILOT FIT	H9/f8
SURFACE FINISH	63 micro inches [1.6 micrometers] RMS
SURFACE HARDNESS	Light Duty <sup>2</sup> HB135 minimum
	Heavy Duty <sup>3</sup> HB235 minimum

To achieve the runout tolerance the mounting face on the rotating element must be machined flat. Excessive run-out of the disc could cause premature wear of the linings, caliper pins, lever journals as well as the actuators.

The disc mounting bolts used must be of a suitable size and grade to safely resist the brake torque plus the stresses induced from thermal expansion of the disc. For high temperature disc applications, the holes for the mounting bolts must be machined oversized to allow the disc to expand during operation. Ensure that adequate washers are used to bridge the gap between the bolt and bolt hole.

*Table 3: Mounting Bolt Radial Clearance*

MOUNTING BOLT RADIAL CLEARANCE					
Disc Bolt Circle In [mm]	Maximum Disc Temperature, °F [°C]				
	400 [204]	500 [260]	600 [316]	700 [371]	
10 [254]	0.011 [0.3]	0.014 [0.4]	0.017 [0.4]	0.021	
15 [381]	0.016 [0.4]	0.021 [0.5]	0.026 [0.7]	0.031	
20 [508]	0.022 [0.6]	0.028 [0.7]	0.035 [0.9]	0.041	
25 [635]	0.027 [0.7]	0.035 [0.9]	0.043 [1.1]	0.051	
30 [762]	0.032 [0.8]	0.042 [1.1]	0.052 [1.3]	0.062	
35 [889]	0.038 [1.0]	0.049 [1.2]	0.061 [1.5]	0.072	
40 [1016]	0.043 [1.1]	0.056 [1.4]	0.069 [1.8]	0.082	

To reduce the size of the mounting bolt clearance hole it is recommended to offset the bolt

<sup>1</sup> International tolerance class. Allowable run out is proportional disc O.D.

<sup>2</sup> Parking brakes and emergency brakes with stopping times of 10 seconds or less are considered light duty.

<sup>3</sup> Ventilated discs are exempted from this requirement

circle on the brake disc inwards the required amount for radial clearance. The end result is the brake disc will have a slightly smaller bolt circle than the hub and the required radial clearance will be on the side where it is needed.

<b>⚠ WARNING</b>	Do not use fitted bolts for installing brake discs. The bolt holes must be over sized to permit uninhibited expansion.
<b>⚠ WARNING</b>	Do not secure a brake disc to a rotating element by welding.
<b>⚠ WARNING</b>	Do not paint the cooling fins of a ventilated disc. The cooling efficiency will be compromised, and overheating may result.
<b>⚠ WARNING</b>	<b>Keep Discs free from contaminants:</b> Failure to keep the brake discs free from some contaminants such as dirt and oil can result in the brake not generating the rated brake force. Discs and brake pads that have been contaminated must be cleaned thoroughly. A burnishing procedure should follow cleaning before returning the brake to service.

If the disc was damaged during installation with nicks or welding marks, remove the defects before putting into service.

For cases where a disc guard or some protective cover is required for a ventilated disc ensure that the guard does not compromise the performance. An improperly designed cover or shield may cause air recirculation through the disc or radiant heat reflection, which could result in the disc overheating. The cooling air pumped through the disc must be exhausted away from the outer diameter of the disc to allow fresh, cool air to enter the inner vent opening of the disc.

## 2.3 CALIPER BRAKES

### 2.3.1 Mechanical

Perform the following steps to properly install a caliper brake:

1. Ensure that the brake has been manually opened (see section 3.1).
2. Lower the brake onto the brake pedestal and center over the mounting holes.
3. Using feeler gauges to ensure that the brake air gap is equal on both sides of the disc.

#### NOTICE

Ensure the caliper is centered. The balancing link will be subjected to excessive stresses that will damage it.

4. Position the brake so that the outer radius of the brake shoe is in full contact with the Disc. Do not move the brake too close as enough radial distance must be provided to allow for disc expansion without causing interference between the outer circumference of the disc and the inner caliper frame.

5. Manually apply the brake onto the disc. The brake shoes will naturally align with the disc.
6. Probe under the brake base with feeler gauges to determine the shimming requirement.
7. Manually release the brake again and lift the brake up approximately two inches.
8. Insert the shims determined from step 6. Use ANSI shims that straddle the mounting bolts.
9. Insert the mounting bolts from underneath the pedestal using appropriate flat washers. The nut must be on top of the brake foot. The mounting bolts must be of SAE grade 5 or better. It is recommended to use a thread locking product such as Loctite® to ensure a vibration resistant and secure joint.
10. Lower the brake down and tighten the mounting bolts to the recommended preload.

### 2.3.2 Piping

The piping to the brakes must be adequately sized to ensure rapid response times in all weather conditions. The piping must be selected to safely withstand the pressures required to operate the brakes. Secure the piping against vibration with pipe clamps per the schedule in the table below.

*Table 4: Pipe Clamp Table*

PIPE CLAMP TABLE				
PIPE SCHEDULE	3/8"-1/2" tube [DN6]	1/4" – 1/2" pipe 1/2"-3/4" tube [DN8-DN15]	3/4" pipe 1"-1.25" tube [DN20]	1" pipe 1.50" tube [DN25]
CLAMP SPACING	3 ft [914 mm]	4 ft [1219 mm]	5 ft [1524 mm]	6.5 ft [1981 mm]

All piping must be cleaned prior to connection to the actuators. Welded carbon steel piping must be pickled to remove the scale produced by welding.

The connections to the brake actuators must be made by hoses of suitable rating to accommodate the movement of the brake levers.

The brake actuators are equipped with different sizes of pressure ports. Consult the technical drawing of the relevant model code for the specific port data. Install the port fitting using thread sealant and tighten to 2 - 3 turns from finger tight. Use brass pipe fittings for making the connection as steel fittings are too heavy and may split the port.

#### NOTICE

Do not over tighten the fitting in the actuator port as damage to the actuator may occur.

For spring applied / air released caliper brakes it is recommended to install a quick exhaust valve at each actuator.

For operation in sub-zero temperatures down to a minimum of 0°F [-20°C] the air must be dried to a dew point of -50°F [-44°F]

**WARNING**

Failure to adequately dry the compressed air supply may result in the brake valve freezing and rendering the brakes inoperable in sub-zero weather conditions.

### 2.3.3 Instrumentation

Kobelt caliper disc brakes may be equipped with sensors and switches, such as the **6233-MSKIT**. The connection to the instruments must be made by cable or flexible conduit.

The **6233-MSKIT** is a release indicating microswitch. Ensure that the **NORMALLY OPEN** contacts are used to indicate the brakes are released when the switch is closed.

Follow the governing electrical code for wiring practices. Use only hardware approved for the zone that the brake is installed in.

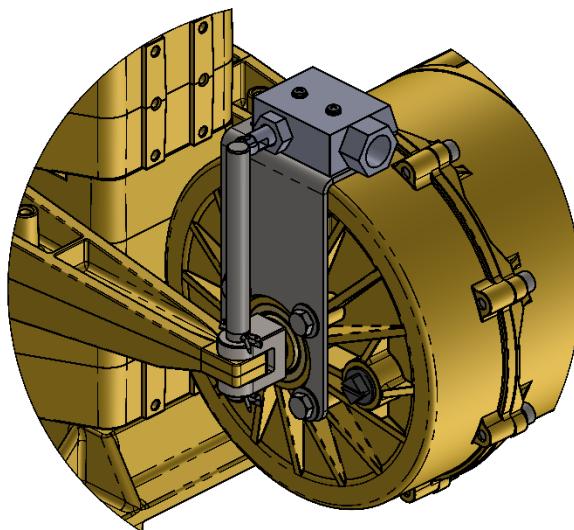


Figure 2: 6233-MSKIT

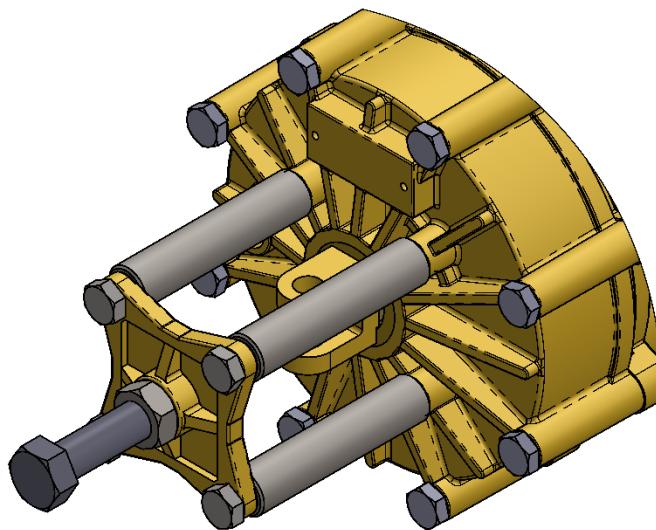
## 3 COMMISSIONING

### 3.1 CAGING



The Kobelt 5024-SA spring applied / air released caliper brake can be equipped with a manual release kit, part number **6233-RLKIT**. The release kit permits manual release of the brake in the event that fluid pressure is lost or not available. To manually release the brakes;

1. Ensure that the fluid supply line is open to tank or atmosphere to permit the piston to displace the fluid from the actuator.
2. Screw in the manual release bolt clockwise to open the brake shoes. If the brake is equipped with two actuators the release screws must be advanced in equal increments of one turn at a time.



The manual release screw must be fully retracted prior to putting the brakes into service. Failure to do so may result in a complete loss of brake torque

Brakes without the manual release screw option will have to be opened using an external pressure source.

### 3.2 FLUSHING

Kobelt spring applied, air released disc brakes may be used in low pressure hydraulic applications. Before subjecting the brake system to full hydraulic pressure, the brake lines must be flushed to an ISO 4406 cleanliness rating of 19/17/14.

### 3.3 AIR GAP

Prior to putting the brakes into service ensure that the airgap between the brake pads and disc when the brakes are released is set to .01" [.25 mm] per shoe. Adjust if necessary, per [section 5.3.2](#).

### 3.4 FUNCTION TEST

Before burnishing the brakes perform a quick inspection and function test of the brakes:

---

- (1) Ensure that all mounting bolts are properly installed.
- (2) Ensure proper running clearance (air gap) with the disc.
- (3) Ensure unobstructed movement of the brake levers for full actuator extension.
- (4) Ensure the brake disc surface is clean. Remove all contamination from the disc with cleaning solvent.
- (5) Check the source of fluid supplied that it complies with the specified pressure range and that it is properly interlocked with other machinery such as clutches, electric motors, etc.
- (6) Check that all bolts are tight and cotter pins are in place.
- (7) Cycle the brakes and ensure that the brakes are operational

### 3.5 BURNISHING

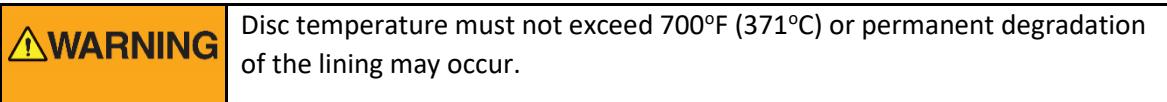
Burnishing is required in order to achieve rated brake torque. The process of burnishing removes minor contaminants from the rubbing surfaces and improves the degree of contact between the brake pad and disc.

Before burnishing, the brake disc must be checked to ensure it is free from contamination and oil. Use a solvent and cloth to remove any oil residue. Slight surface rust will be removed during the burnishing process, but heavy rust should be removed prior to burnishing.

If present, safety interlocks of the drive mechanism should be temporarily defeated to allow the disc to be driven with the brake partially applied.

The temperature of the disc surface must be monitored during the burnishing process and kept between 250°F (120°C) and 500°F (260°C). If the upper temperature is reached, pause the burnishing process until the disc is cooled to the lower limit.

Extreme care must be taken not to overheat the disc during the process. On water cooled discs it may be necessary to limit the flow of cooling water in order to achieve the necessary disc temperature for effective burnishing.



Burnishing is best achieved by applying the maximum torque and minimum speed that the drive can tolerate. Depending on the configuration of the brake system it may be necessary to reduce the burnishing torque by;

- a) Partially releasing the brake with fluid pressure to a level that the drive can tolerate, or
- b) In systems with more than one brake, isolate all but one brake and burnish one brake at a time.

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Three important points to consider when burnishing are;

- i. The temperature of the disc must be closely monitored. Excessive heat will damage the friction linings.
- ii. The duration of burnishing varies with each application.
- iii. Burnishing is not complete until the brake is producing rated torque. This will be indicated by the motor current while burnishing.



Failure to properly burnish will not allow the brake to produce adequate torque for the intended duty.

### 3.6 TORQUE TEST

Before putting equipment into service, confirm that full rated braking torque has been achieved through load testing or a torque test against the drive motors. If full brake torque has not been achieved, continue burnishing.

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## 4 OPERATION

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### 4.1 FUNCTIONAL REQUIREMENTS

#### 4.1.1 Pressure Supply

The release pressure for spring applied air release actuators are a maximum of 125 psi. Ensure that the system pressure is adequate to fully release the brakes.

It is necessary to size air compressors and storage tanks to provide sufficient air for the intended duty of the brakes. Actuators and control valves equipped with "U" cups and "O" rings require lubrication in order to provide long service life. Unlubricated seals will have excessive friction and wear. The oil that is required for the lubricator should be a hydraulic type with a viscosity grade of 10 to 32 centistokes. Heavy oils do not work well for lubricators.

The main supply line to the control and brake system should be equipped with a filter, regulator and lubricator. The filter's function is to remove moisture and dirt in the system and the regulator will provide a constant air pressure to the control system. If the brake system is operating in sub-zero temperatures, it is recommended to have an air dryer in the system to remove all moisture. Alternatively, a lubricator can be filled with methyl hydrate (wood alcohol) to prevent freezing of the air system.

For hydraulic applications the pressure supply system must supply a hydraulic oil appropriate for the service conditions. Consult the table below for approved oils.

*Table 5: Approved Hydraulic Oil*

Ambient Temperature Range	Approved Oil	Approved Brands
0...+40 °C [+32...+104 °F]	ISO VG 32, VI 60	Rando HD32, Mobil DTE, Tellus S2 V 32
-20....+20 °C [-4...+68 °F]	ISO VG 22, VI 150	Rando HDZ22, Mobil DTE10
+40....+80 °C [+104...+176 °F]	ISO VG 68, VI 60	Rando HD68, Mobil DTE, Tellus S2 V 68
-40 ...-20 °C [-40...-4 °F]	ISO VG 26, VI 300	Univis HVI 26, Tellus S4 VX, Hydrex MV Arctic

In all cases hydraulic circuits must have a relief valve that is set to limit the system pressure to the rated maximum pressure of the actuator. In applications where the brakes cycle infrequently with significant changes in ambient temperature it may be necessary to provide a thermal relief to protect the actuators from over pressurization due to thermal expansion.

#### 4.1.2 Control

Emergency brakes must be controlled by a system adhering to a “fail safe” methodology. Relays, contacts and valves must be “normally open”. The use of detented, manual or spool valves is strongly discouraged as these devices can either be inadvertently closed or fail closed.

### 4.2 SERVICE LIMITS

#### 4.2.1 Disc Temperature

The Kobelt brake lining achieves maximum friction at 300°F. Over 300°F the brake begins to fade or experience diminishing friction. The maximum operating temperature of the brake linings is 700 °F [371° C]. Temperatures in excess of this limit will permanently damage the linings and require replacement.

#### 4.2.2 Ambient Temperature

In sub-zero temperatures, ventilated discs must be warmed up gently to avoid causing excessive thermal stresses in the disc. Failure to do so could cause the disc to crack. Once the temperature of the disc is out of freezing condition it can be used as normally intended.

Operating temperature of standard brake actuators is -40°C [-40°F] to 120°C [248°F]

#### 4.2.3 Pressure

Do not allow the supply pressure to exceed the values given in the [Technical Data](#) section. If the available supply pressure exceeds the maximum allowable working pressure, then some form of a pressure regulator is required. Also, the pressure supply system must be equipped with a safety relief valve to ensure the given maximum allowable working pressure.

#### 4.2.4 Disc speed

The potential imbalance in the ventilated disc could be detrimental to rotating equipment at high speeds. For running speeds greater than the values listed in the table below the discs must be balanced. Under no circumstances must the running speed exceed the value given in the right-hand column.

*Table 6: Maximum Disc Speeds*

Part Number	Nominal OD		Max. Speed	
	inch	mm	rpm	
2" x 4" Series				
2-4-18	18	457	1450	3070
2-4-20	20	508	1260	2750
2-4-25	25	635	960	2200
2-4-30	30	762	770	1800
2-4-35	35	889	650	1550
2-4-40	40	1016	560	1350
2-4-45	45	1143	490	1200
2-4-50	50	1270	440	1070

## 5 MAINTENANCE

### 5.1 PREVENTATIVE MAINTENANCE

#### Maintenance Schedule

Maintenance Item	Daily	Monthly	Annually	5 years
Torque Test	✓			
Inspect for leaks	✓			
Measure air gap		✓		
Determine pad life		✓		
Lubricate pivot pins			✓	
Inspect brake disc			✓	
Inspect Brake pins				✓
Service Actuators				✓

### 5.2 INSPECTION

#### 5.2.1 Pad Wear

The running clearance (air gap) between lining and disc must be maintained within the specified limits. Failure to do so will result in the brake not capable of producing rated torque. When the running clearance has reached .04" [1 mm] the brake must be adjusted back to .01" [.25 mm] per shoe. Refer to [section 5.3.2](#).

The maximum allowable pad life has been reached when the brake pad has worn down to 3/16" [4.8 mm] thick. The lining must be replaced before the shoe lining bolts or rivets start making contact with the brake disc.

#### 5.2.2 Seals

The actuator seals should be inspected on a periodic basis. Soapy water applied to the actuator rod would indicate any seal leakage.

#### 5.2.3 Actuator Test

Occasionally it may be necessary to test the actuator springs as a means of trouble shooting. The easiest method is to measure the hold-off and release pressure of the actuator. The release pressure is defined as the minimum pressure required to fully retract the actuator whereas

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hold-off pressure is defined as the pressure at which the actuator begins to extend. Both of these pressures give an indication of the condition of the actuator.

To conduct this test a dial indicator or depth micrometer is required as well as a pressure source with a calibrated gauge. The pressure source must have a means of accurately controlling the pressure. Follow these steps to perform the test:

1. Connect the pressure source to the actuator and fully retract the actuator. Be careful not to exceed the MAWP of the actuator.
2. Install the dial indicator to sense the rod stroke and set the dial to zero.
3. Begin reducing the pressure in small increments (5% of rated system pressure) and observe the displacement on the dial indicator.
4. When the dial indicator has moved at least .01" [.25 mm] note the pressure. This is the hold-off pressure. The measured value must be within +/- 5% of the specified value.
5. Continue dropping the pressure to allow the actuator to extend 0.1" [2.5 mm].
6. Begin increasing the pressure in small increments and observe the displacement on the dial indicator.
7. The minimum pressure required to return the actuator rod back to within .01" [.25 mm] is the release pressure. Note this pressure. The measured release pressure must be within +/- 5% of the specified value.

#### 5.2.4 Pin Wear

The pivot pins must be removed for inspection once every five years. If there is any evidence of heavy scoring more than .01" [.25 mm] deep or if any area of the pin has been worn down by more than .01" [.25 mm] then replace the pins.

#### 5.2.5 Brake Disc

The brake disc must be inspected periodically to monitor the condition of the braking surface. When the condition of the braking surface has deteriorated to the point that the quality requirements in section 2.2 are no longer met the disc must be removed and resurfaced or replaced. Follow the minimum thickness allowances in the table below as a guideline for when a disc must be replaced.

*Table 7: Brake Disc Minimum Thickness Allowances*

Brake Disc Minimum Thickness		
Disc Series	Original Thickness in [mm]	Minimum Thickness in [mm]
2-4-XX	2.00 [50.8]	1.90 [48.5]

**NOTICE**

When re-machining the disc surface, equal amounts must be taken off of each face.

## 5.3 SERVICE

### 5.3.1 Lubrication

Disc brake calipers equipped with spring applied, air released actuators must have a lubricator in the control air system using light hydraulic oil as a lubricant. This is to prevent premature seal wear and reduce seal friction.

All Kobelt calipers, during assembly, are pre-greased on the shoe pin and saddle pin with a Lithium based NLGI 2 grease. These pins must be re-greased no less than once annually.

### 5.3.2 Stroke Adjustment

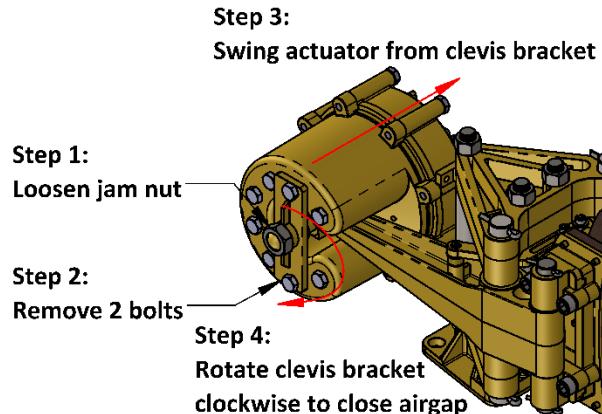
On spring applied calipers, the running clearance between the shoe and disc must be maintained within specifications.

#### DANGER

Failure to maintain the running clearance within the specified limits will not allow the brake to produce adequate torque for the intended duty.

#### Air Gap Adjustment Procedure:

1. Apply 120 psi of pressure to open the brake & Loosen the clevis jam nut
2. Remove the 2 screws on the clevis bracket
3. Push the actuator away to separate the actuator assembly from the clevis bracket
4. Rotate the clevis bracket to desired position (1 full turn = 0.025in [0.7mm] of shoe movement)
5. Reinstall clevis brackets into position, tighten screws



#### WARNING

Ensure that the valve isolating the brakes is locked out and the pressure securely retained in the brake actuator prior to performing work.

#### Note:

1. When the spring side clevis has been adjusted to its maximum position, further adjustments may be made to the rod side clevis.
2. When the brake linings are replaced it will be necessary to reset the clevises by turning inward to allow for the extra thickness of a new lining.

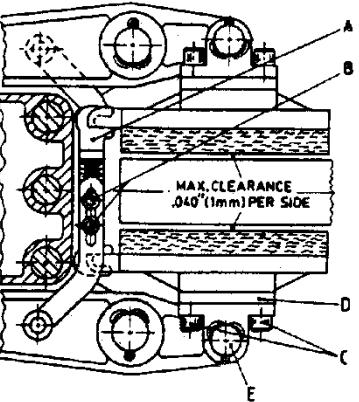
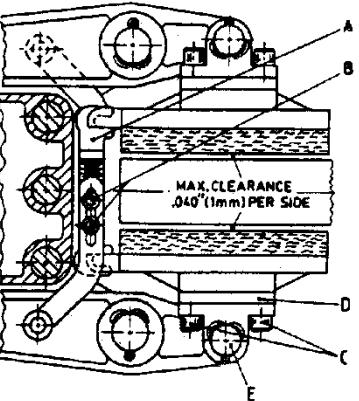
### 5.3.3 Spring Actuators

If maintenance is required on the spring applied actuator, it must first be removed from the brake assembly. In order to remove the actuator, pressure must be applied to the actuator to release the brake. After removal, the actuator must be retained in a press strong enough to retain the spring tension. The bolts holding both housings can now be removed, and the pressure of the press can be slowly released thus allowing the housings to separate. Clean actuator, replace seals, inspect springs and change parts if necessary. Lubricate all moving parts, re-assemble and re-install actuator in reverse order.

<b>BRAKE ACTUATORS CONTAIN COMPRESSED SPRINGS</b>	
<b>WARNING</b>	The brake actuators contain springs that are under compression even when the brakes are not pressurized. The springs will release suddenly if disassembled incorrectly posing a risk of serious injury or death. Do not attempt to disassemble the actuators without clear work instructions and training.

### 5.3.4 Brake Linings

The linings must be replaced before the rivets make contact with the disc. Remove worn linings from the shoe by drilling out the rivets with a  $\frac{1}{4}$ " drill. Install new linings with the proper rivets.

<b>LINING REPLACEMENT</b>	
	<ol style="list-style-type: none"><li>1. Remove bottom cotter pins from pins 'E'.</li><li>2. Remove pins 'E' by pulling upwards.</li><li>3. Remove shoes by sliding radially forward to clear the ends of the levers.</li></ol> <p>When re-installing the shoes into the caliper assembly, be sure to re-engage the balancing links "A".</p> <p>If there is insufficient room radially to remove the shoe, then screws 'C' must be removed.</p>
<b>BALANCING LINK ADJUSTMENT</b>	
	<p>To adjust;</p> <ol style="list-style-type: none"><li>1. Loosen screws 'B',</li><li>2. Apply brakes onto the disc,</li><li>3. Ensure link 'A' has no tension on it. Adjust if necessary.</li><li>4. Tighten screws 'B'</li></ol>

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When reinstalling the shoes and pivot blocks reinstall the shoe pin first to align the pivot blocks before tightening screws 'C'. Apply a thread locker such as Loctite 243 to the threads of screws 'C'. Tighten screws 'C' to **37 ft-lbs [50.1 Nm]**.

## 5.4 RECOMMENDED SPARES

The spare parts kept on hand will depend on the severity of the service. As a minimum Kobelt recommends keeping the following parts for each brake in service:

1. One Lined set of brake shoes
2. One set of brake pads with rivets
3. One actuator
4. Two seal kits

Refer to the parts list drawings in [Appendix B](#) for a complete list of parts.

The table below itemizes which kit/spare part numbers change with the various brake configuration options. Please reference this table to ensure you receive the correct parts.

*Table 8: Configuration Kit Numbers*

Configuration Kit Numbers		
Actuator Code	Actuator No.	Description
-SA	6233	83 psi release
-SA75	6233-75	79 psi release
-SA70	6233-70	70 psi release
-SA60	6233-60	65 psi release
Disc Code	Shim Kit	Disc Thickness
-175	5024-1750	1.750 in
-150	5024-1500	1.500 in
-125	5024-1250	1.250 in
-100	5024-1000	1.000 in
Friction Code	Lined Shoe	Friction Material
-N	5024-LSN5	non-sparking
-C	5024-LSC5	low COF (.12-.15)
-E	5024-LSE5	mid COF (.25-.28)

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## 6 REVISION HISTORY

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Document Revision	Release Date	CO	Author	Revision Summary
C	2026-01-20	01389	GG	<ul style="list-style-type: none"><li>• Added 2.1.1: Rigging</li><li>• Section 2.2: Added warning about keeping brake discs clean</li><li>• Section 5.3.4: Revised shoe bolt torque, was 200in.lbs, added Loctite 243.</li></ul>

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## 7 WARRANTY

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Kobelt Manufacturing Co. Ltd. (“Kobelt”) warrants the Products and Parts manufactured by Kobelt to be free from defects in workmanship or material and that said products are designed mechanically and functionally to perform to specifications.

This warranty is effective providing:

- The equipment is used within the intended operating conditions and in accordance with Kobelt recommendations
- The equipment is installed according to equipment diagrams, specifications and recommendations which Kobelt has provided

This warranty becomes invalid if the factory supplied serial number has been removed or altered on the product. This warranty does not cover cosmetic damage or damage caused by an act of God, accident, misuse, abuse, negligence or modification of any part of the product. This warranty does not cover damage due to improper operation or maintenance, connection to inappropriate equipment or attempted repair by anyone other than an authorized Kobelt representative.

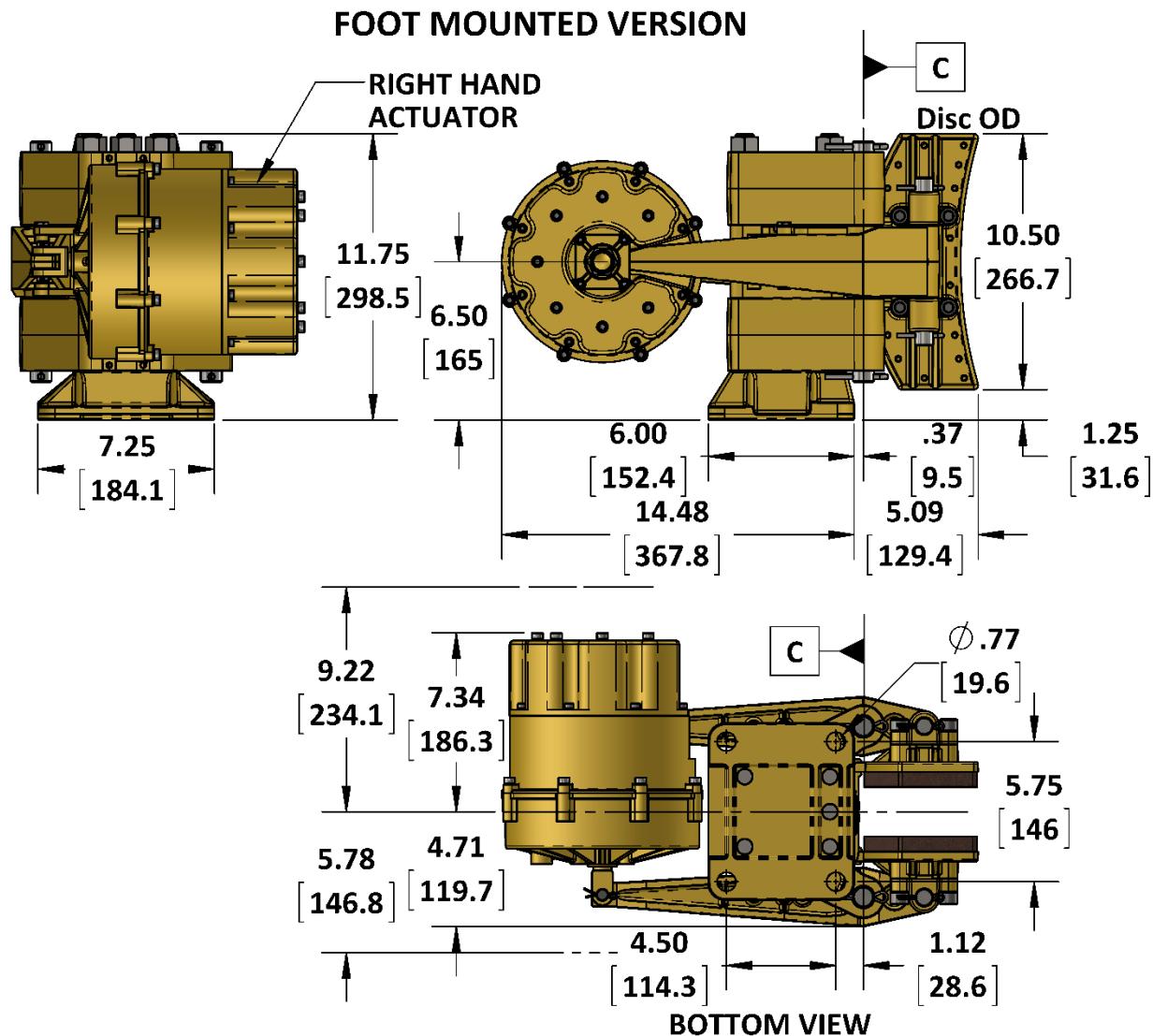
Upon identification of a potential issue or defect with a Kobelt Product or Part, the Warranty Applicant (“Applicant”) must immediately contact Kobelt and describe the issue in writing, by letter, fax, email or other electronic conveyance. Kobelt will then assess the cause of the defect, and determine warranty applicability and appropriate remediation.

If any part is found to be defective, Kobelt will replace said part FOB the Kobelt factory provided that any such defective part is returned by the Buyer with freight and applicable forwarding charges prepaid by the Buyer. Kobelt’s sole obligation to the Applicant will be to repair or replace the defective part with same or similar product, to a maximum value of the list price of the product or part. The Kobelt warranty does not cover labour charges, travel or any other associated expenses.

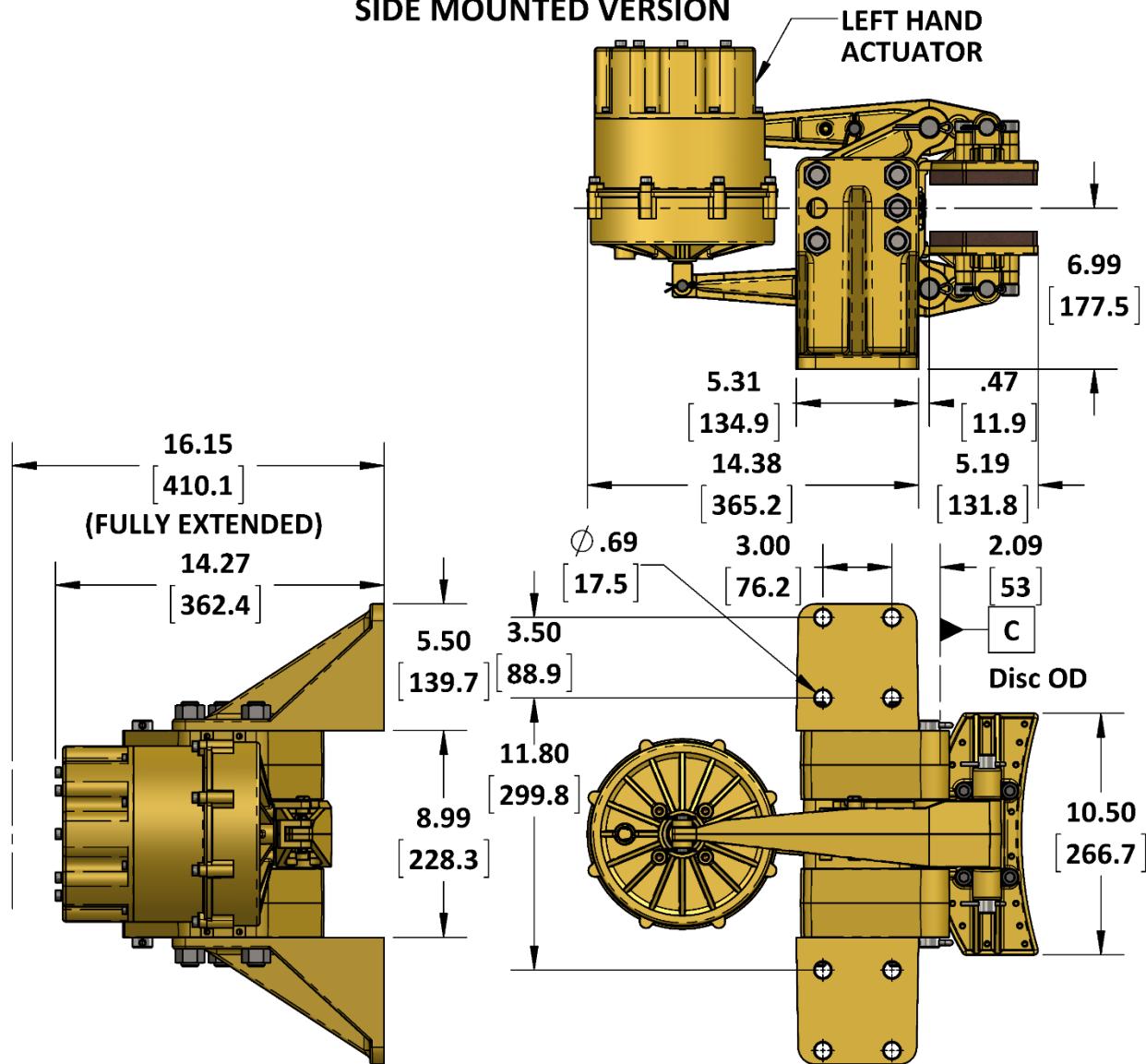
All Products and Parts manufactured by Kobelt, with the exception of brake discs and pads, are subject to a warranty against manufacturer’s defects in materials or workmanship for a period of two (2) years from the date of purchase. Brake discs are subject to a one (1) year warranty period, and brake pads and linings are not covered by warranty.

Kobelt will be responsible for all Products or Parts sold by Kobelt but manufactured by 3<sup>rd</sup> party manufacturing companies. However, these products and parts are subject to applicable 3<sup>rd</sup> party warranties, and may not be the same as the Kobelt warranty.

## 8 APPENDIX A: TECHNICAL DRAWINGS



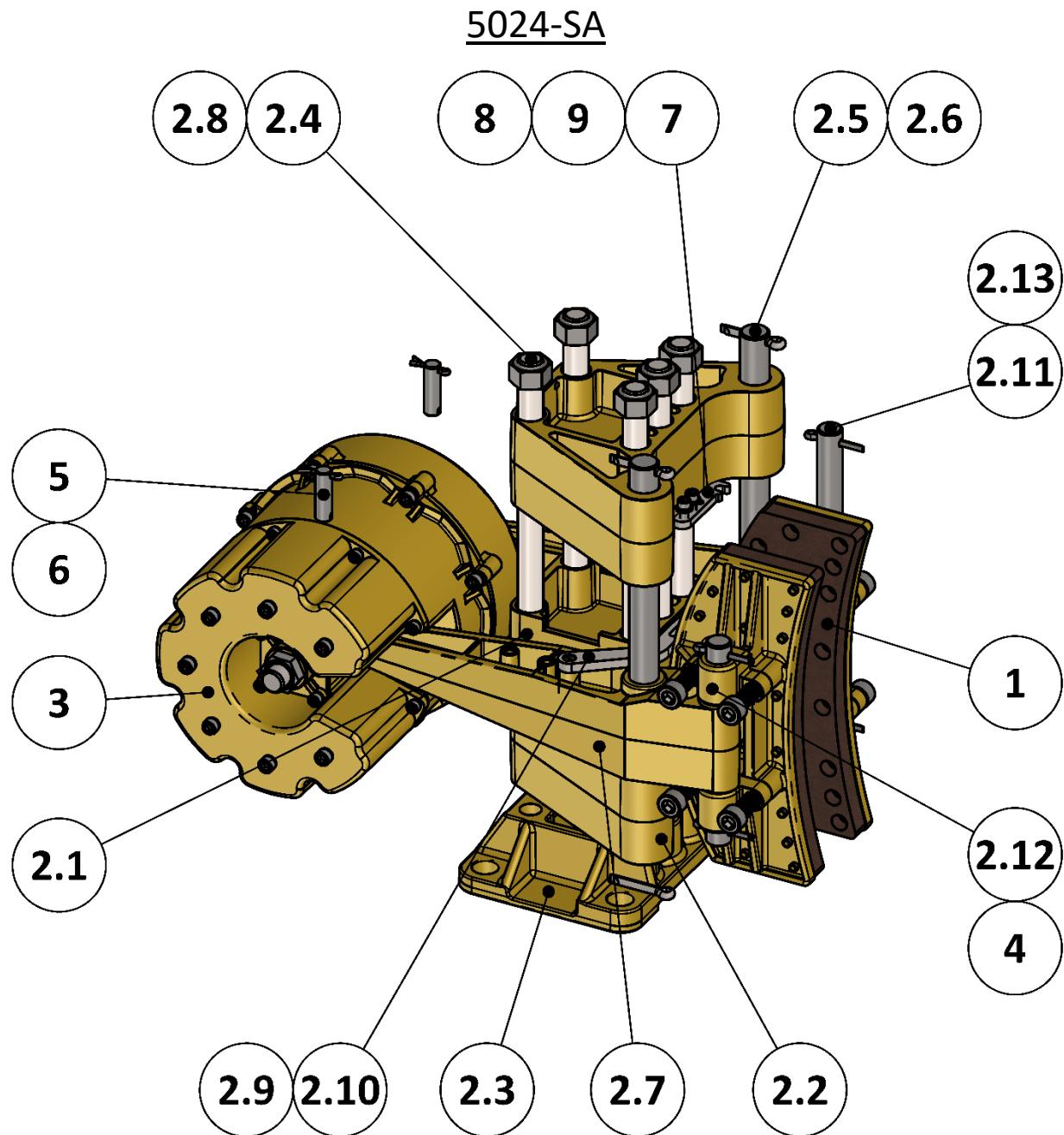
SIDE MOUNTED VERSION



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## 9 APPENDIX B: PARTS LIST DRAWINGS

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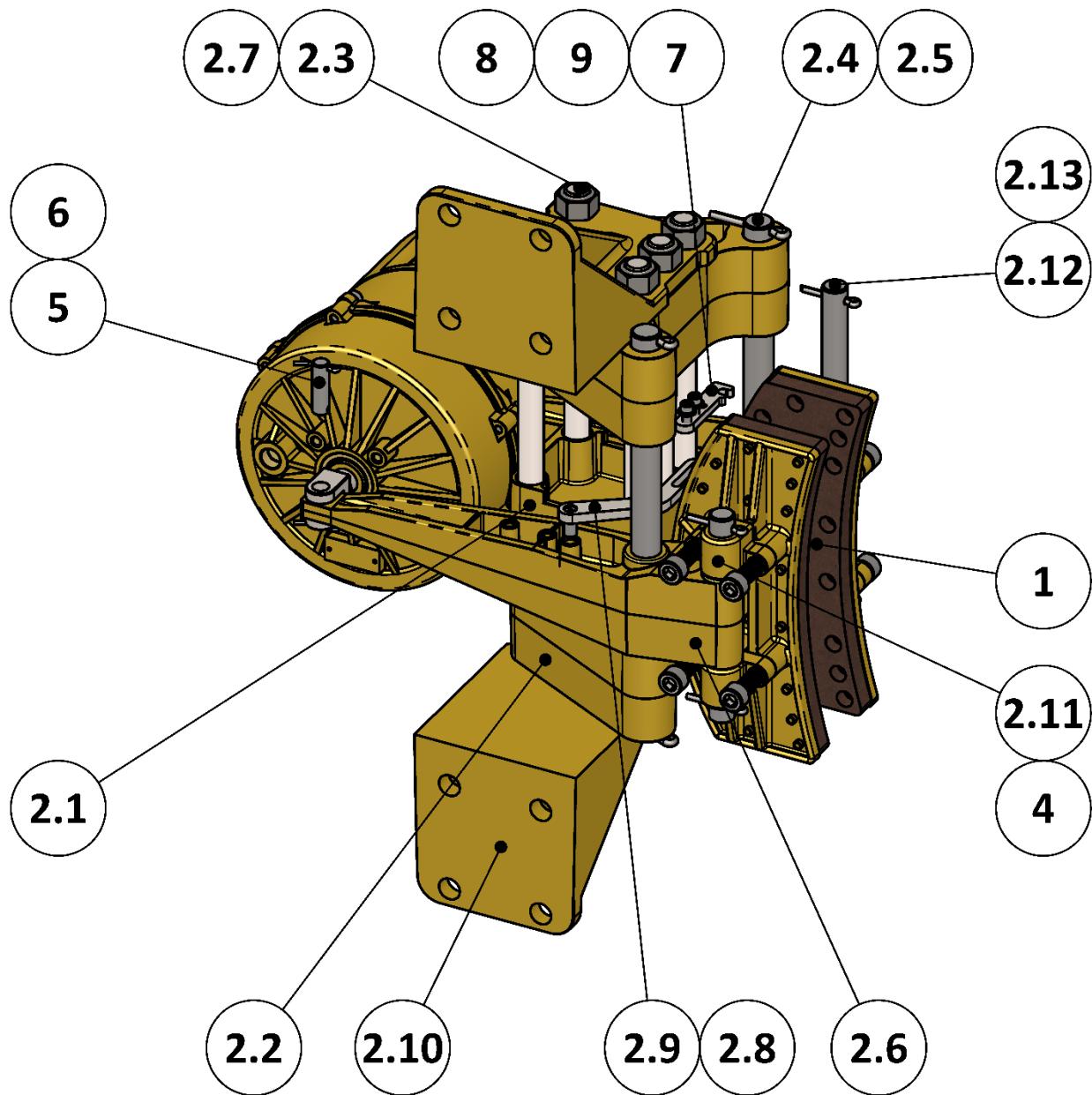
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**ITEM QTY. PART NUMBER DESCRIPTION**

1	2	5024-LS	SHOE ASSEMBLY, 5024 CALIPER, 5/8" K5
2	1	5024-SUB-A	5024 CALIPER SUB-ASSEMBLY
2.1	1	5024-0003	SPACER, 5024 CALIPER
2.2	2	5024-0002	SADDLE, 5024 CALIPER
2.3	1	5024-0001	FOOT, 5024 CALIPER
2.4	5	5024-0023	TIE ROD, 5024/25 CALIPERS
2.5	2	5024-0022	SADDLE PIN, 5024/25 CALIPERS
2.6	4	1026-1024	COTTER PIN, 1/4" X 1 1/2", SS
2.7	2	5024-0004	LEVER, 5024 CALIPER
2.8	5	1022-0117	NUT, HEX, 3/4-10 UNC, Gr 18-8
2.9	2	5024-0026	LINK PIN, 5024 - 5026 CALIPERS
2.1	2	5024-0011	BALANCING LINK NO. 1, 5024 CALIPER
2.11	2	5024-0021	SHOE PIN, 5024/25 CALIPERS
2.12	4	5024-0006	PIVOT BLOCK, 5024 CALIPER
2.13	4	1026-0824	Cotter Pin_S.S.: 3/16 x 1 1/2*
3	1	6233	SPRING APPLIED / AIR RELEASED ACTUATOR
4	8	1002-1420	SCREW, SKT HD, 1/2-13 UNC X 1-1/4, SS
5	2	6230-0010	CLEVIS PIN, 1/2" DIA
6	4	1026-0516	COTTER PIN, 1/8" X 1", SS
7	2	5024-0012	BALANCE LINK NO. 2, 5024 CALIPER
8	4	1023-0216	FLAT WASHER, 1/4, TYPE B, NARROW
9	4	1002-1010	SCREW, SKT HD, 1/4 UNC X 5/8 LG, 18-8 SS

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5024-SAW

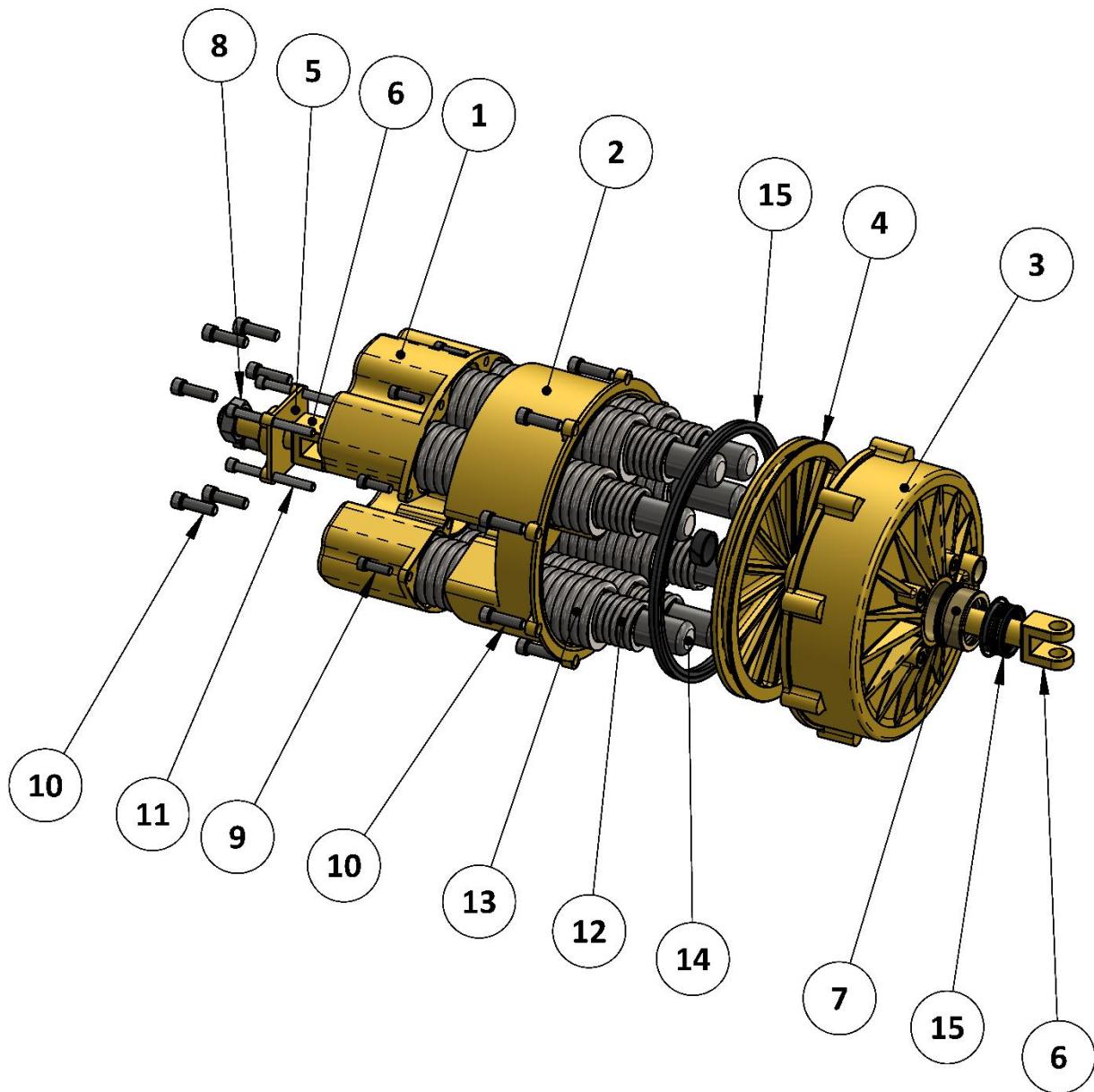


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<b>ITEM</b>	<b>QTY.</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	2	5024-LS	SHOE ASSEMBLY, 5024 CALIPER, 5/8" K5
2	1	5024-SUB-AW	SUB-ASSEMBLY, 5024 CALIPER
2.1	1	5024-0003	SPACER, 5024 CALIPER
2.2	2	5024-0002	SADDLE, 5024 CALIPER
2.3	5	5024-0023	TIE ROD, 5024/25 CALIPERS
2.4	2	5024-0022	SADDLE PIN, 5024/25 CALIPERS
2.5	4	1026-1028	COTTER PIN, 1/4 X 1 3/4
2.6	2	5024-0004	LEVER, 5024 CALIPER
2.7	10	1022-0117	NUT, HEX, 3/4-10 UNC, Gr 18-8
2.8	2	5024-0026	LINK PIN, 5024 - 5026 CALIPERS
2.9	2	5024-0011	BALANCING LINK NO. 1, 5024 CALIPER
2.1	2	5027-0200	SIDE MOUNT FOOT, 5027 CALIPER
2.11	4	5024-0006	PIVOT BLOCK, 5024 CALIPER
2.12	2	5024-0021	SHOE PIN, 5024/25 CALIPERS
2.13	4	1026-0824	Cotter Pin_S.S.: 3/16 x 1 1/2*
3	1	6233	SPRING APPLIED / AIR RELEASED ACTUATOR
4	8	1002-1420	SCREW, SKT HD, 1/2-13 UNC X 1-1/4, SS
5	2	6230-0010	CLEVIS PIN, 1/2" DIA
6	4	1026-0516	COTTER PIN, 1/8" X 1", SS
7	2	5024-0012	BALANCE LINK NO. 2, 5024 CALIPER
8	4	1023-0216	FLAT WASHER, 1/4, TYPE B, NARROW
9	4	1002-1010	SCREW, SKT HD, 1/4 UNC X 5/8 LG, 18-8 SS

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## 6233 Actuator

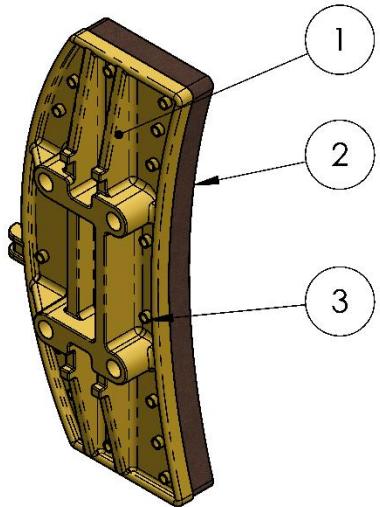


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<b>ITEM</b>	<b>QTY.</b>	<b>PART NUMBER</b>	<b>DESCRIPTION</b>
1	1	6233-0001	SPRING HOUSING, COVER
2	1	6233-0101	SPRING HOUSING, CENTRE
3	1	6233-0002	ACTUATOR HEAD, 6233 ACTUATOR
4	1	6233-0003	PISTON, AIR, 6233 ACTUATOR
5	1	6233-0004	BRACKET, 6233 ACTUATOR
6	2	6233-0005	CLEVIS, 6233 ACTUATOR
7	1	6230-PHB	SEAL CARRIER, 6230 ACTUATOR
8	1	1022-0217	NUT, JAM, 3/4-10 UNC, SS
9	8	1002-1012	SCREW, SCKT HD, 1/4-20 UNC X 3/4, SS
10	15	1002-1116	SCREW, SCKT HD, 5/16-18 UNC X 1, SS
11	4	1002-1036	SCREW, SKT HD, 1/4-20 UNC X 2-1/4, S/S
12	7	1201-0229	SPRING, COMPRESSION, 1.45 OD X .177 WIRE X 12.31 LG
13	7	1201-0230	SPRING, COMPRESSION, 2.00 OD X .250 WIRE X 13.0 LG
14	7	6230-0011	SPRING GUIDE, 1"
15	1	6233-RK	SEAL KIT, 6233 ACTUATOR

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## 5024-LS



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ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	5024-0005	BRAKE SHOE
2	1	5024-0007	BRAKE LINING, 5/8 INCH K5
3	20	1033-1007	RIVET, 1/4 X 7/16 (10-7), BRASS



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