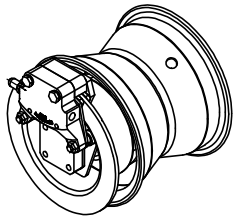
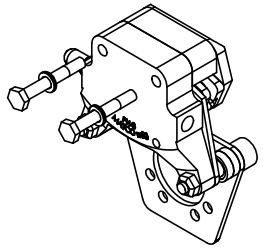
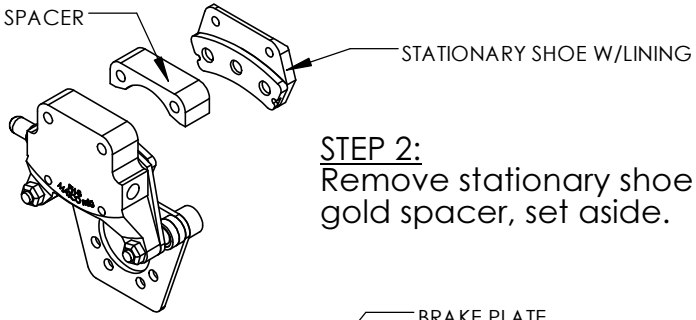


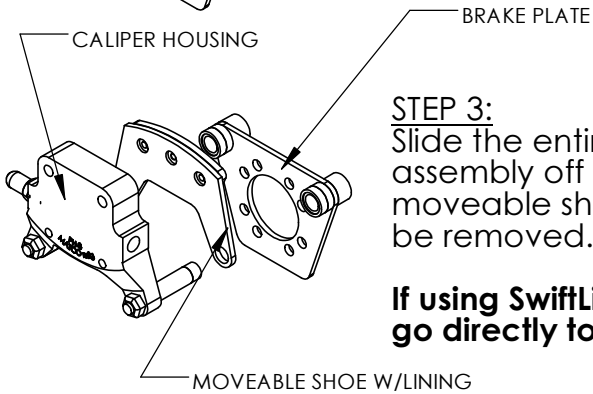
ENTIRE ASSEMBLY:
Wheel and Brake shown here Wheel not shown below for clarity. Hydraulics are connected and system bled free of air.
THERE IS NO NEED TO BREACH THE HYDRAULIC SYSTEM during Reline process



STEP 1:
Remove both (AN4) bolts and set aside. Thecaliper is no longer trapping the brake disc.

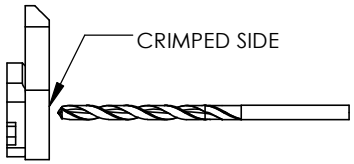



STEP 2:
Remove stationary shoe w/lining and gold spacer, set aside.

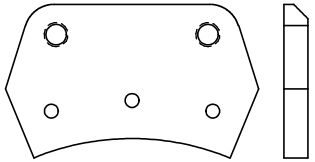



STEP 3:
Slide the entire caliper housing assembly off the brake plate. The moveable shoe w/lining can now be removed.

**If using SwiftLine Reline Program, go directly to Step 7 and go flying!**

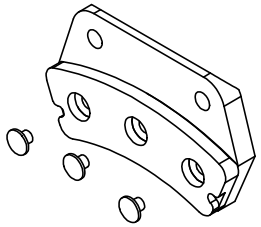



STEP 4:
Remove spent linings by drilling the crimped side of the rivet (or rivet removal tool). Using a #25 drill (0.1495 dia), drill through the rivet, taking care to avoid damaging the rivet hole.



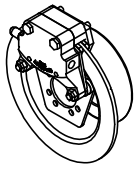
STEP 5:
After all rivets and linings have been removed, inspect the brake shoe for any bending* or other damage which may have occured during service, and the rivet holes for any damage from removal.

*A shoe with more than a 0.010" bend should be replaced



STEP 6:
Using a brake relining tool* or pneumatic press, replace the linings using the brass rivets shown on the illustrated parts list. Be sure formed head is below plate surface (fully inside the countersink) on moveable brake shoe.

*MATCO recommends a threaded screw action such as the W404 from Aircraft Tool Supply Co



STEP 7:
Reassemble by completing steps 3 through 1 ( reverse order from disassembly)
Set bolt torque as specified (100 in-lb if using NL1/4 Nordlock washer)
Verify caliper floats freely in brake plate

| | | | | | |
|---|---|---|---|---|---|
| MATCO mfg<br>2361 S. 1560 West<br>Woods Cross, Utah 84087 USA | NOMENCLATURE<br>Wheel w E-Series Caliper | PART NUMBER<br>E Series Caliper Rmoval | SCALE<br>1:4 | TOLERANCES<br>(EXCEPT AS NOTED)<br>DO NOT SCALE DRAWING<br>LINEAR .XX = ± .03<br>.XXX = ± .01<br>ANGULAR ± 1/2<br>CONCENTRIC ± .01 | |
| | MATERIAL<br>VARIES | DRAWING NO.<br>BRAKE/E Series CALIPER REMOVAL | REVISION<br>NC | Est Wt. (lb)<br>7.31 | |
| DRAWN BY<br>Sally Christensen | FINISH | DATE<br>10/20/2021 | CHECKED BY | SHEET 1 OF 1<br>SHEET SIZE A | |