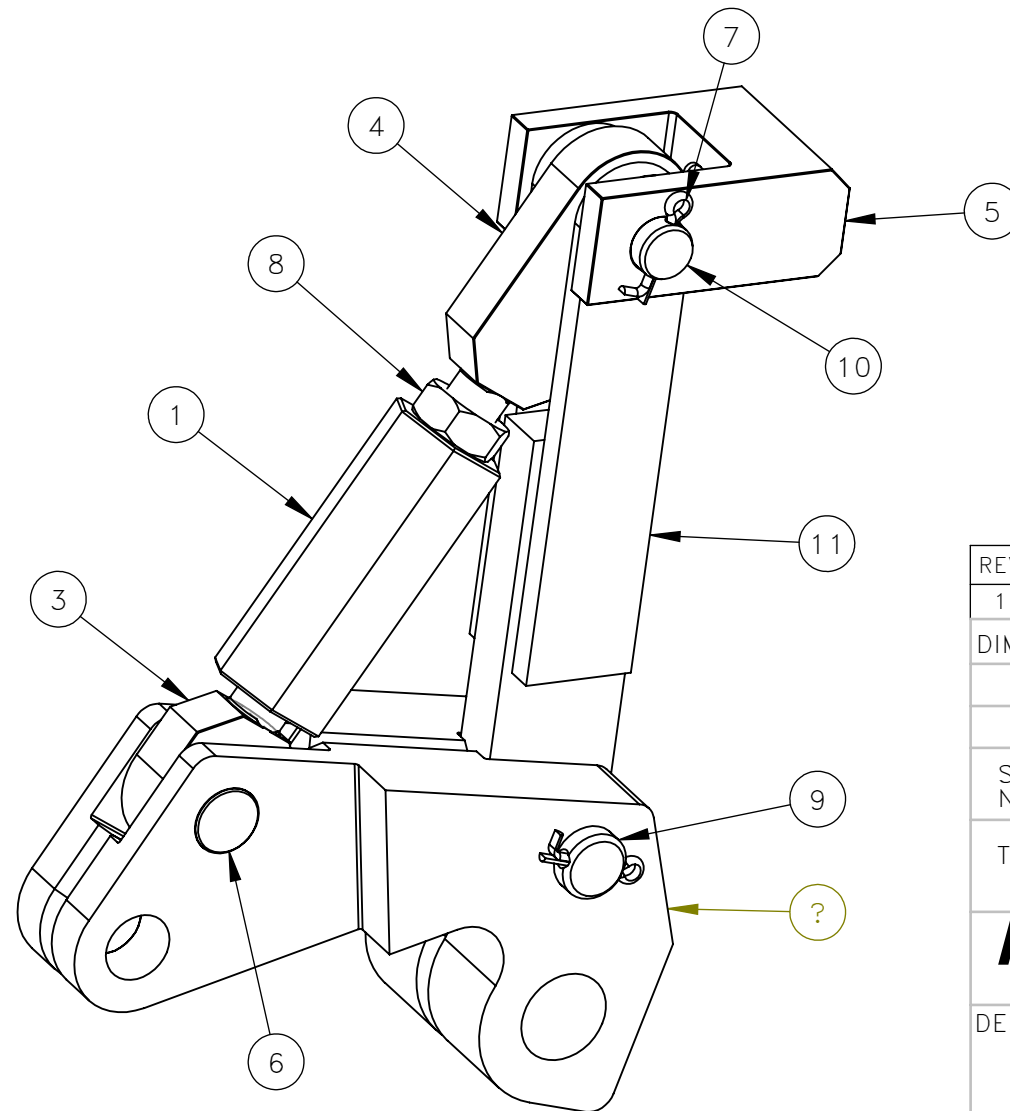


INSTALLATION

1. Install right eye stud (4) into jam nut (8) and run nut to end. Apply light lubricant to both coupler (1) ends and along eye stud threads (3 & 4). Insert right eye stud into R coupler end and fully drive inward. Do same to left eye stud (3) into L coupler end, then set assembly aside.
2. At wheel brake chamber, install T-bolt and lock into brake chamber receiver. Install T-bolt flat washer and hex nut onto T-bolt thread and run hex nut and flat washer to brake chamber. Use wrench on hex nut and rotate hex nut CW to fully retract brake arm.
3. Pry retaining collar from clevis to allow clevis pin removal and disengage brake arm from clevis. At lower pivot pin, retract it enough to allow brake arm and attached shoe removal. Remove brake shoe to attach on new brake arm (2). Discard old brake arm.
4. At brake chamber clevis, use wrench on jam nut to rotate CCW, unlocking clevis. Unscrew clevis to remove from thread and discard. **Measure 3.13" from chamber face and mark on thread surface. Cut-off** excess thread and file cut end burr. Turn jam nut CCW to chase threads in making end uniform again. Run jam nut CW about 1.38 from end and follow with clevis (5). Stop turning clevis when threaded rod is flush with inside face.
5. Select brake arm (2) and install link (11) single end into back cavity and align holes. Install pin (9) thru holes and install cotter pin (7). Move both to frame pivot pin and force pivot pin into arm and link holes to pass into frame ear hole. Install its cotter pin, but do not spread legs. Move link double ends between clevis arms.
6. Install assembly left eye stud (3) into brake arm front cavity and install link pin (6) thru brake arm and eye stud holes and center pin in holes. Install brake shoe bracket onto arm, install pivot pin, and follow with its cotter pin. Note that shoe bracket sides cover link pin.
7. Move right eye stud end between link and clevis arms, align all holes and insert pin (10) thru all. Insert cotter pin without spreading legs. Check all connections to be secure and allow simple pivoting. Spread all cotter pin ends to prevent removal and tighten jam nut against clevis.

ADJUSTMENT

1. Each brake adjustment requires a 15/16 and 1 1/4 open-end wrenches.
2. At each wheel, begin adjustment with the 15/16 wrench on the jam nut (8) and the 1 1/4 wrench on the coupler (1). Loosen the jam nut a half **revolution to release the coupler and remove the wrenches. Have two 1/8" spacers, such as paint stirring sticks, and place one at each brake shoe end between the shoe and the wheel.**
3. By hand, rotate the coupler CCW to move the shoe toward the wheel. When the coupler is harder to turn, the brake shoe should be just clamping **the 1/8" spacers to the wheel. Check the 1/8" spacers being slightly held in place and air gap clearance between the brake shoe and wheel is about 1/8".**
4. Hold the coupler with one hand and tighten the jam nut with the other to meet the coupler. Place the 1 1/4 wrench on the coupler and the 15/16 wrench on the jam nut. Lock the jam nut with 15-20 foot-pounds torque against the coupler.
5. When all adjustments are completed, apply vehicle brake system and observe each brake operation. Correct any adjustment(s) as described above procedure. Observe and note any related parts in the system for immediate or future attention.



NO.	QTY	DESCRIPTION	PART NO.
1	1	COUPLER	319123
2	1	BLOCK	319294
3	1	STUD, LEFT EYE	319295
4	1	STUD, RIGHT EYE	319296
5	1	CLEVIS	319348
6	1	LINK PIN	319370
7	2	PIN, COTTER: .12 X 1	400900
8	1	NUT, HEX JAM: .62-11 HVY	401027
9	1	PIN, CLEVIS: .75 X 2.75	466032
10	1	PIN, CLEVIS: .62 X 2.25	491418
11	1	LINK	781527
12	1	INSTRUCTIONS, BRAKE LINKAGE	800310

REV	EN	DESCRIPTION	DATE	DRN
1	3792	NEW RELEASE	12-18	NR
DIMENSION TOLERANCES UNLESS OTHERWISE SPECIFIED				
LINEAR	.XX=±.03	.XXX=±.010		
ANGULAR	X°=±1°	X.X°=±.5°		
SURFACE FINISH		125/✓	SMOOTH ALL SHARP EDGES CLEAN ALL WELDS	
NOT TO EXCEED				
THIS PRINT AND ALL INFORMATION WITHIN BELONGS TO RACINE RAILROAD PRODUCTS				
RACINE RAILROAD PRODUCTS RACINE, WISCONSIN USA				
DESCRIPTION				
KIT, BRAKE LINKAGE				
MATERIAL				
SEE BOM				
USED ON		718828	SCALE	DATE
			1:2	12-19-18
DRN	CHK	APP	JOB NO	SHEET
NR			RD150003	1 OF 1
DWG SIZE		CATALOG	DWG NO	
B		N	718795	