

RERAIR INSTRUCTIONS

RE [510] & DR [610] SERIES MOTOR BRAKE (B MOUNT HOUSING)

For Use With Seal Kit(s): 500444500

dimensions: mm [in]

NOTE: When servicing the RE & DR series motor brakes, it is recommended that the brake section be serviced separately. Although the brake section of the RE and DR Series Motors are identical, the motor sections do differ. After determining which motor you have, follow the appropriate motor section service instructions below.

All internal seals on products manufactured after July 1, 2016 are o-ring seals. Prior to this date the internal seals were square cut seals. It is recommended that if the product being serviced has square seals to replace with the square seals in this kit, likewise if the product has o-ring seals, replace with the o-ring seals in this kit.

RE & DR BRAKE SECTION DISASSEMBLY

- A) Remove all shaft related components from shaft (40) (i.e. keys, wire rings, nuts). To aid in reassembly of the brake/motor assembly, make a "V" shaped set of lines from the endcover to the front housing section using either paint or a marker. With shaft end facing up, secure motor in vise by clamping onto rotor assembly (34). Loosen and remove bolts (15) and nuts (16). (**NOTE:** Depending on application, there may be two, four or six bolts and nuts to be removed. Make note of how many bolts are used and direction bolts are inserted in housing.)
- B) Carefully remove front housing section (18) and piston (24) from brake assembly and turn over with dust seal (1) side down. Remove piston (24) from front housing section (18). Remove large piston seal (7) and large O-ring piston seal (8) from piston (24). Discard seals. Lay piston (24) aside. Remove the eleven outer springs (23) and the eleven inner springs (22) and lay aside. Remove shaft seal (4), backup seal (3) and metal backup shim (2). Discard these seals and shim. Remove small piston seal (6) and small piston O-ring seal (5) and discard both. Lay front housing section (18) aside. (**NOTE:** "LB" option Brakes do not contain seal 5-8).
- C) Carefully remove shaft (40) with thrust bearing (21) and thrust washers (20) and brake disk assembly from center housing section (29). Remove thrust washers (20) and thrust bearing (21) from shaft (40). Remove disk stampings (25) and friction disks (26) from shaft (40). Lay parts aside. **NOTE: The brake disk stackup is different for the "LB" option brake motors. If you are unsure of which model you have, it is recommended that the disks be kept in order to insure correct stackup when reassembling the motor.**
- D) Remove housing seal (9) from center housing section (29). Remove center housing section (29) from rear housing section (30). Remove housing seal (9) from bottom of center housing section (29). Discard housing seals.
- E) At this point, all parts should be cleaned in an oil-based solvent and dried using compressed air (For safety, observe all OSHA guide lines). All new seals should be lightly coated in clean oil prior to installation.

RE & DR BRAKE SECTION REASSEMBLY

- F) Place housing seal (9) in groove on both sides of center housing section (29). Using alignment marks for correct orientation, place center housing section (29) onto rear housing section (30). Place shaft (40) over drive link (31 or 51) and into assembled housing sections (29 & 30).

HOUSING DISK STACKUP

- G) Place one friction disk (26) over shaft (40), followed by one disk stamping (25). Continue alternating disks until all eight friction disks (26) and eight disk stampings (25) are on shaft (40). Place one thrust washer (20) over shaft, then thrust bearing (21) and remaining thrust washer (20).

"LB" HOUSING OPTION DISK STACKUP

- H) Place three friction disks (26) over shaft (40) followed by three disk stampings (25). Next, place two friction disks (26) over shaft (40) followed by two disk stampings (25). Place remaining three friction disks (26) over shaft followed by one disk stamping (25). Lastly, place remaining thick disk stamping (25) over shaft.
- I) With front housing section laying on work surface with dust seal (1) side down, place metal backup shim (2), backup seal (3) and shaft seal (4) in shaft seal container section of pilot using Figure 1 for correct seal orientation.
- J) **NOTE: "LB" housing option motors do not use piston O-Ring and piston seals (5-8). If repairing an "LB" housing option motor, skip to step K.** Place small O-Ring piston seal (5) in groove in front housing section (18) followed by small piston seal (6). To allow piston to be pressed into place, the small piston seal (6) must be compressed. **NOTE: An automotive hose clamp can be used to compress the small piston seal as long as care is taken not to damage the sealing surface with the clamp.** Place large O-Ring piston seal (7) and then large piston seal (8) in groove in piston (24).

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- K)** Place eleven outer springs (23) in front housing section and then one inner spring (22) inside each outer spring (23). **NOTE: The "LB" housing option motors do not use inner springs (22).** Place piston (24) in front housing section (18) with smaller end of piston (24) facing springs (22 & 23). While holding piston (24) in place, carefully pick up front housing assembly and turn it over with dust seal (1) side facing up. With a slight twisting motion, gently place front housing assembly over shaft (40). Once front housing assembly (24) is seated on shaft (40), align bolt holes and check to make sure alignment line is correct. **(NOTE: Small port in front housing section (18) should face same direction as housing ports in rear housing section.)**
- L)** Install bolts (15) and nuts (16) in same orientation and location as noted in step A. Tighten nuts by hand until snug. Using an arbor press and sleeve, carefully press down on front housing section until all three housing sections are compressed. Tighten nuts with wrench until snug. Remove motor from arbor press and torque all nuts to 136 Nm [100 ft. lbs.]
- M)** Using a thin bladed screwdriver, carefully pry dust seal (1) from front of housings and replace with new dust seal (1). Replace all shaft related components (i.e. keys, wire rings, nuts, etc.) at this time.

RE MOTOR SECTION DISASSEMBLY (FOR DR MOTORS, USE STEPS U-AA)

- N)** If no alignment marks were made on motor section when servicing brake, make a "V" shaped set of lines from the endcover (37) to the rear housing section (30) using either paint or a marker. With shaft facing down, secure motor in vise by clamping onto housing (18, 29 & 30). Loosen and remove seven bolts (39) holding motor assembly together. Remove endcover (37). Remove endcover seal (12) and discard.
- O)** Remove balance plate (35) and lay aside, taking care not to drop the three steel balls (36) located in the three holes in the balance plate. Remove rotor assembly (34), manifold (32), drive link (31), spacer (33) (if applicable) and thrust bearing (28). Remove body seals (11) from rotor assembly (34) and rear housing seal (10) from housing (30) and discard seals.

At this point, all parts should be cleaned in an oil-based solvent and dried using compressed air (For safety, observe all OSHA safety guidelines). All new seals should be lightly coated in clean oil prior to installation.

RE MOTOR SECTION ASSEMBLY

- P)** Place drive link (31) into shaft (40) making sure that end of drive link with crowned splines goes into shaft (40). Install thrust bearing (28) onto end of shaft. If all pieces are seated properly, thrust bearing (28) will be flush with rear face of housing (30). Install housing seal (10) into groove in rear housing section (30).
- Q)** Place manifold (32) onto housing (30) aligning bolt holes. **(NOTE: Manifold side with only seven valving holes goes toward housing.)**
- R)** Install a body seal (11) into the seal groove in both sides of rotor assembly (34). Place rotor assembly (34) on manifold (32) engaging drive link splines. Turn rotor assembly (34) to align bolt holes and alignment marks.
- S)** If motor came with spacer (33), place spacer on end of drive link (31). Using alignment marks as a guide, place balance plate (35) onto the rotor assembly (34) with three holes for steel balls (36) facing up. Install three steel balls (36) into the holes in the balance plate (35).
- T)** Install endcover seal (12) into endcover (37). Place endcover (37) onto the balance plate (35) and align bolt holes. Insert seven bolts (39) into motor assembly. Pre-torque bolts to 10 ft. lbs. Using the bolt torque pattern in Figure 2, final torque all bolts to 68 Nm [50 ft. lbs.]

DR MOTOR SECTION DISASSEMBLY

- U)** Loosen and remove seven bolts (60) holding motor assembly together. Remove endcover (58) carefully as piston (56) and spring (57) may fall out. If piston does not come out, carefully pry piston (56) out of endcover (58) and lay aside. Remove O-ring seal (49) and backup seal (50) from endcover and discard seals. Remove spring (57) and lay aside.
- V)** Lift commutator container and commutator (55) from motor and lay aside. Place commutator on a flat, clean surface with the seal (48) facing up. Place the tip of a small screwdriver on the seal (48) and gently tap until opposite side of seal lifts from groove. Remove seal (48) and discard.
- W)** Remove manifold (54), rotor set (53) and divider plate (52) from motor. Remove all seals (45, 46, & 47) from components and discard. **(Caution - Do not allow rolls to drop from rotor assembly (53) when removing rotor assembly from motor.)** Remove drive link (51) and thrust bearing (29) from motor and lay aside.
- X)** At this point, all parts should be cleaned in an oil-based solvent and dried using compressed air (For safety, observe all OSHA safety guidelines). All new seals should be lightly coated in clean oil prior to installation.

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DR MOTOR SECTION ASSEMBLY

- Y)** Install housing seal (45) into groove in housing (30). Place divider plate (52) onto housing (30) aligning bolt holes. Place body seals (46) in grooves in both sides of rotor (53). Place rotor (53) onto divider plate (52) with side of rotor with chamfer in splines facing divider plate (52). Place manifold (54) over rotor (53) with seal groove side up. Install manifold seal (47).
- Z)** Install the commutator seal (48) into the commutator (55) with the metal side facing up. Use finger pressure to press the seal down flush with the surface of the commutator. Place the commutator container onto the manifold (54) and then place the commutator onto the protruding end of the drive link (51) making sure that the seal side faces up.
- AA)** Install the remaining body seal (46) in the groove in the face of the endcover (58). Install piston spring (57) into endcover (58), then the white backup seal (50) followed by the O-Ring seal (49). Lining up the alignment pin with the hole in the endcover, press piston (56) into the endcover (58). While holding the piston (56) in the endcover, lower the endcover assembly onto the motor. Check to make sure that the endcover ports are in their original position. Pre-torque bolts (60) to 14 Nm [10 ft. lbs.] Using the bolt torque pattern in Figure 2, final torque all bolts to 68 Nm [50 ft. lbs.]

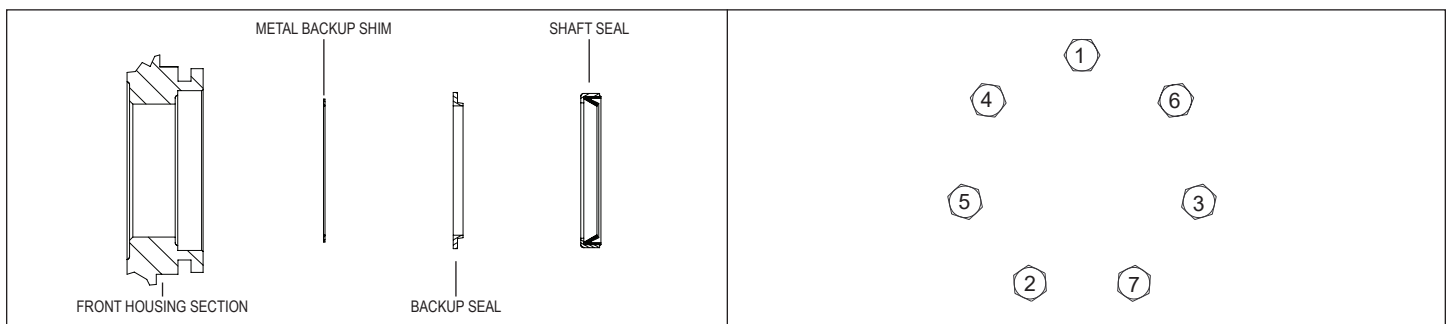


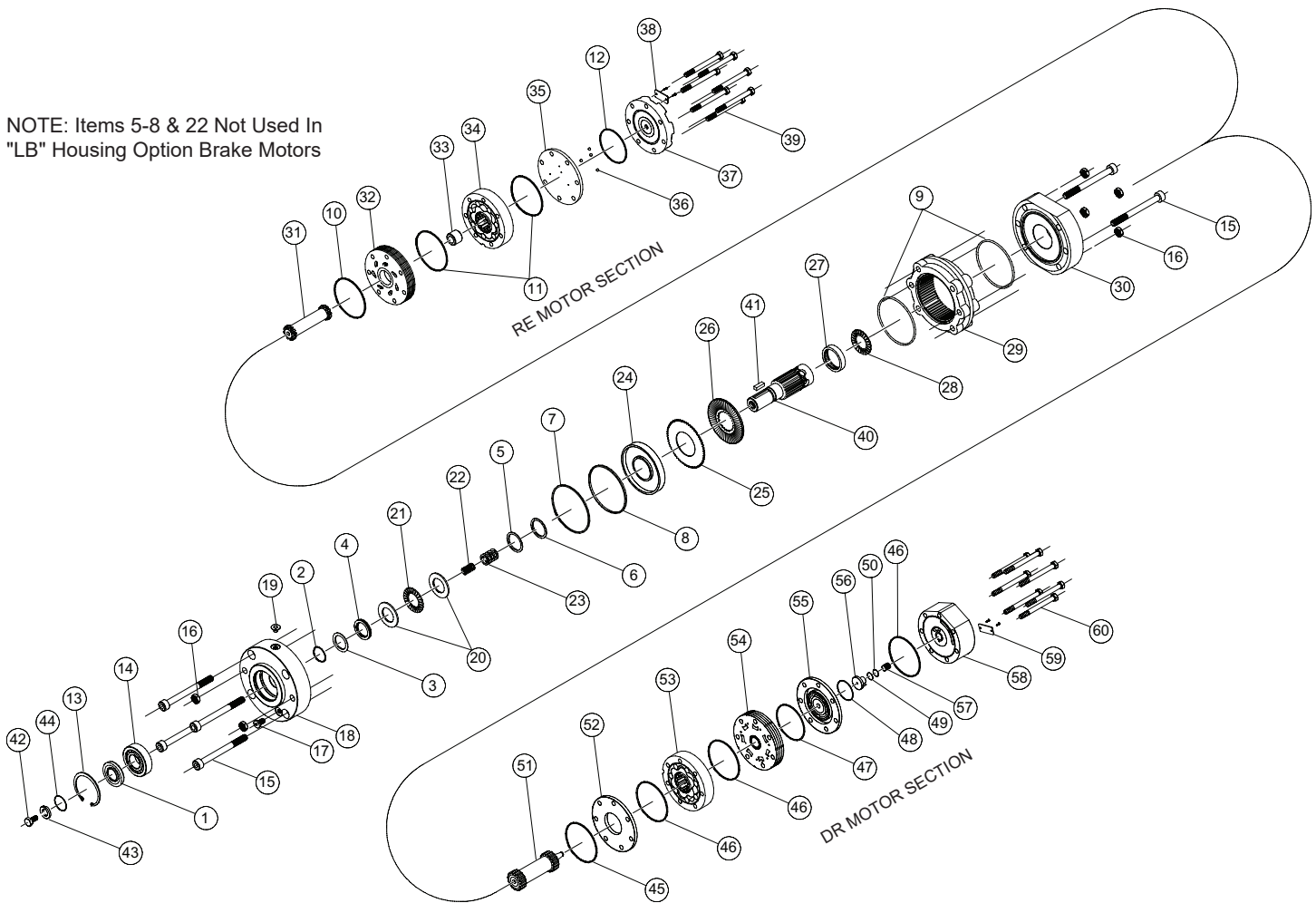
FIGURE 1

FIGURE 2

RERAIR INSTRUCTIONS

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NOTE: Items 5-8 & 22 Not Used In
"LB" Housing Option Brake Motors



EXPLODED VIEW PARTS DESCRIPTION

1. * Dust Seal	17. Port Plug	33. Drive Link Spacer	49. * O-Ring Seal
2. * Metal Backup Shim	18. Front Housing Section	34. Rotor Assembly	50. * Backup Seal
3. * Backup Seal	19. Caplug	35. Balance Plate	51. Drive Link
4. * Shaft Seal	20. Thrust Washers (2)	36. Steel Balls (3)	52. Divider Plate
5. * Small Piston O-Ring Seal	21. Front Thrust Bearing	37. Endcover	53. Rotor Assembly
6. * Small Piston Seal	22. Inner Springs (11)	38. I.D. Tag Assembly	54. Manifold
7. * Large Piston O-Ring	23. Outer Springs (11)	39. Assembly Bolts (7)	55. Commutator
8. * Large Piston Seal	24. Piston	40. Shaft	56. Endcover Piston
9. * Housing Seals (2)	25. Disk Stamping (8)	41. Shaft Key	57. Piston Spring
10. * Rear Housing Seal	26. Friction Disks (8)	42. Shaft Bolt	58. Endcover
11. * Body Seals (2)	27. Rear Shaft Bearing	43. Lock Washer	59. I.D. Tag Assembly
12. * Endcover Seal	28. Rear Thrust Bearing	44. Wire Ring	60. Assembly Bolts (7)
13. Retaining Snap Ring	29. Center Housing Section	45. * Rear Housing Seal	
14. 72mm Bearing	30. Rear Housing Section	46. * Body Seals (3)	
15. Capscrews (6)	31. Drive Link	47. * Manifold Seal	
16. Nuts (6)	32. Manifold	48. * Commutator Seal	

* Contained in seal kit
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