

INSTALLATION INSTRUCTIONS



Retrofit Kit for 6K and 8K Nev-R-Lube® Hydraulic Disc Brakes

K71-647-00 Disc Brake Retrofit Kit for 6K Nev-R-Lube® - LH
K71-648-00 Disc Brake Retrofit Kit for 6K Nev-R-Lube® - RH
K71-646-00 Disc Brake Retrofit Kit for 8K Nev-R-Lube®

Notice to Buyer

It is recommended that all brakes be replaced at the same time to insure balanced braking performance. Parts within this kit should include:

6K Disc Brakes

Qty	Part No.	Description
5	006-193-00	Hex Nut
1	008-404-80	6K Hub
1	021-085-00	Grease Cap
1	070-009-02	Rotor
1	088-023-00	Thread Locker Sealant
1	090-006-01/-02	Yoke Assembly LH/RH
2	091-004-00	Brake Pad
1	K71-636-00	Caliper Kit

This kit includes the necessary hub assembly.

8K Disc Brakes

Qty	Part No.	Description
4	005-058-00	Lock Washer
4	006-129-01	Hex Nut
4	007-097-00	Hex Bolt
1	070-007-02	Rotor
4	007-097-00	Hex Bolt 1/2-20
1	088-023-00	Thread Locker Sealant
1	090-007-01	Anchor Yoke
2	091-004-00	Brake Pad
1	K71-630-00	Caliper Kit

This kit also requires one of the following hub kits:

008-402-90	3/8" Stud
008-402-91	1/2" Stud

Remove the old brake

1. Jack up trailer and secure on adequate capacity jack stands. Follow trailer manufacturers recommendations for lifting and supporting the unit.

CAUTION

Do not lift or support the trailer on any part of the axle or suspension system. Never go under any trailer unless it is properly supported on jack stands which have been rated for the load. Improperly supported vehicles can fall unexpectedly and cause serious injury or death.

2. Remove the wheel from the hub, leaving the brake exposed.
3. Disable the brake actuation system. Check that the hydraulic system has zero pressure and that the hub and drum rotate freely.
4. Remove the grease cap to gain access to the spindle nut. Remove the torque label and snap ring, spindle nut and washer, and save for reinstalling the new hub later. Remove old hub assembly.
5. Disconnect old brake and remove it from the brake flange. Clean and inspect the spindle.

Installing the new disc brake

1. First verify that all components needed are present and in operable condition. Replace any component as needed (or desired) per manufacturer recommendations.
2. Bolt the anchor yoke in place with the caliper mounting tabs facing outward and to the rear of the axle. For 6K brakes, apply Loctite® Threadlocker Blue 242®, or equivalent removable threadlocker and torque 3/8" mounting hardware with the lock washers and nuts, onto the inward side of the brake flange, to **25-50 Ft. Lbs.** For 8K brakes, apply Loctite® Threadlocker Blue 242®, or equivalent removable threadlocker and torque 1/2" mounting hardware with the lock washers and nuts, onto the inward side of the brake flange, to **55-80 Ft. Lbs.**
3. Install the new hub assembly onto the axle spindle with the spindle washer and nut. Refer to your Operation Maintenance Service Manual for proper torque procedures.
4. Ensure the torque label and snap ring are in place. Install new grease cap.
5. Install the new brake rotor by fitting it onto the hub flush with the hubface.
6. Assemble the new caliper assembly.
Note: Use two lug nuts to secure the rotor against the hub face when assembling the calipers. After the brake is assembled, remove the lug nuts.
7. One caliper will be used on the inboard side, with the hydraulic line fitting adapter installed on the top side of the piston boss. The other caliper will be used on the outboard side, with the bleed screw

installed at the top of the piston boss. Install both of these calipers onto the attaching bracket. Make sure that the bleed screw points up and is located on the outboard caliper. torque the $\frac{3}{8}$ " mounting bolts to **25-35 Ft. Lbs.**

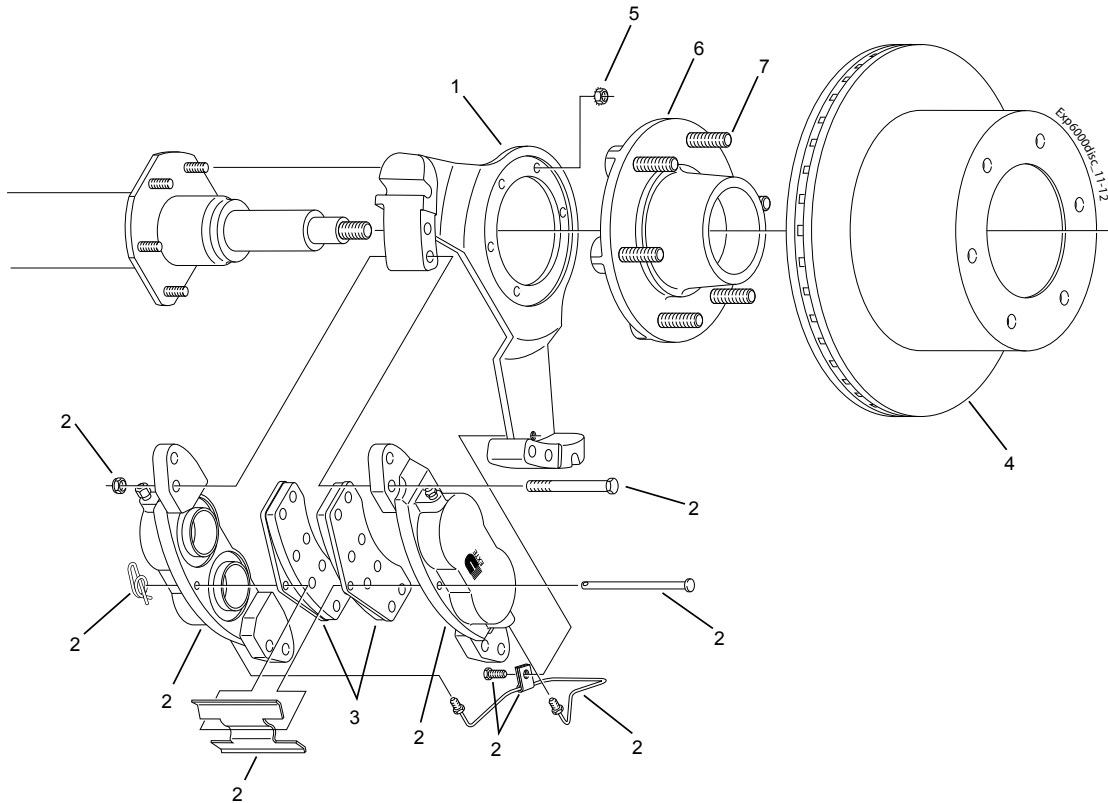
8. Connect the crossover brake line on the bottom sides of the piston boss on both calipers. Torque the crossover line to **12-15 Ft. Lbs.**
9. The crossover brake line also attaches to the inboard side of the caliper mounting bracket using the metal tube clamp. Slide the clamp over the crossover brake line and bend it to the closed position. Apply anti-seize or similar thread lubricant to the $\frac{1}{4}$ -20, $\frac{1}{2}$ " length bolt. Attach the tube clamp to the threaded hole in the caliper mounting bracket using the $\frac{1}{4}$ -20, $\frac{1}{2}$ " length bolt. Torque to **85-100 Inch Lbs.**
10. Connect the hydraulic line from the trailer to the adapter on the top of the inboard caliper. Torque the bleed screw and the hydraulic line to **60-75 Inch Lbs.**
11. Assemble the brake pads into the disc brake. Make sure to locate the brake lining side of the pads toward the rotor surface, and the steel side of the pads toward the calipers. Align the holes in the brake pads with the ones in the calipers. Insert two

(2) brake pad retaining pins into each caliper half as shown in the illustration (see **Figure 1**). Place the anti-rattle spring against the brake pads and press the center toward the rotor while you slide the outboard pad retaining pin toward the inner lining. Continue sliding the pad retainer pin until it engages both pads and pushes the second pin out of the inboard caliper half. Install the cotter ring in the hole of retaining pin.

12. Follow the same procedure with appropriate kits on opposite end of axle.
13. Reconnect the brake actuation system. Refer to your actuation systems Operation Maintenance Service Manual for proper operation.
14. Bleed and flush brake system per your actuation systems Operation Maintenance Service Manual.
15. Remount the wheel. Refer to your Operation Maintenance Service Manual for proper wheel nut torque procedures.
16. Spin wheel to ensure proper clearance between the wheel, brake lines, rotor, and the calipers.

Note: The Dexter Operation Maintenance Service Manual is available for downloading at www.dexteraxle.com.

Disc Brake for 6,000 Lb. Axles



Disc Brake 6000#

Item	Part No.	Qty/Brk	Description
1	090-005-01	1	LH Anchor Yoke
1	090-005-02	1	RH Anchor Yoke (shown)
2	K71-636-00	1	Caliper Assembly Kit for LH or RH Contains:
	4 006-045-00		Caliper Mounting Nut
	4 007-254-00		Caliper Mounting Bolt
	1 019-019-00		Cotter Ring
	1 027-060-00		Tube Clamp
	1 046-145-00		Anti-Rattle Spring
	1 054-092-00		Bleeder Screw
	1 054-094-00		Adapter Fitting
	1 056-038-00		Pad Retaining Pin
	1 071-513-00		Cross Over Hydraulic Line (yokes without notch)
	1 071-517-00		Cross Over Hydraulic Line (yokes with notch)
	1 087-002-00		Hex Bolt
	2 089-005-02		Assembled Caliper Half
3	K71-629-00	1	Brake Pad Kit (axle set)
4	K71-637-00	1	Rotor Kit
5	006-193-00	5	3/8" Brake Mounting Nut-Washer Assembly

Disc Brake Hubs & Studs

Item	Part No.	Qty/Brk	Description
6	008-403-05	1	Grease 1/2" Studs 6 on 5.50
7	007-262-00	6	1/2-20 x 2.70" Press-in Stud (hubs after 2/09)

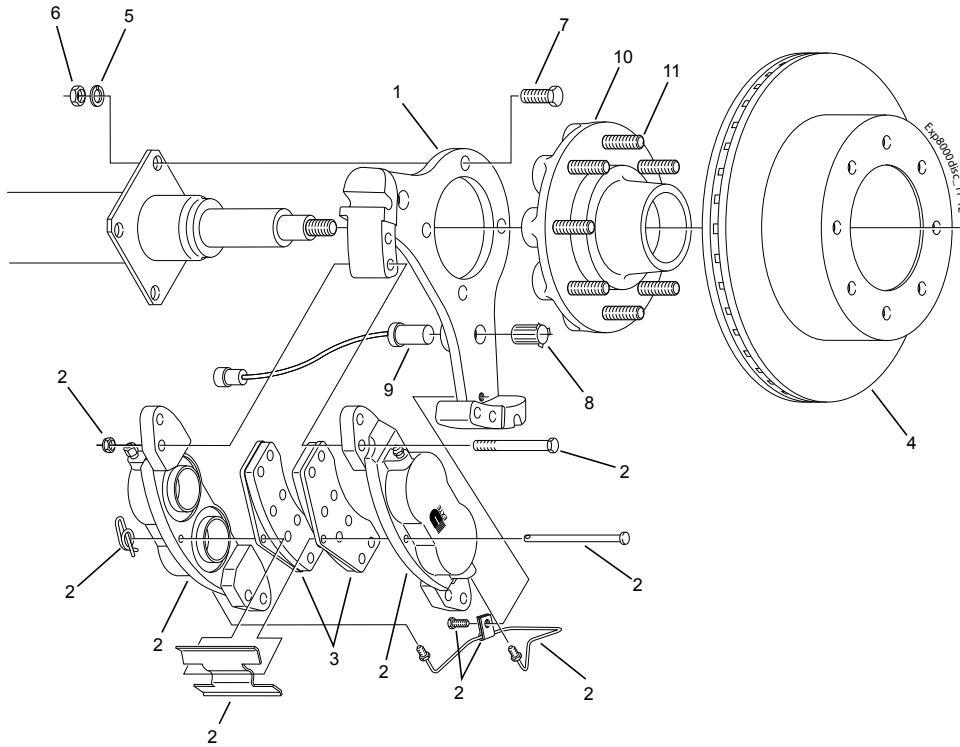
Disc Brake 6000# With 42MM Nev-R-Lube®

Item	Part No.	Qty/Brk	Description
1	090-006-01	1	LH Anchor Yoke
1	090-006-02	1	RH Anchor Yoke
2	K71-636-00	1	Caliper Assembly Kit for LH or RH Contains:
	4 006-045-00		Caliper Mounting Nut
	4 007-254-00		Caliper Mounting Bolt
	1 019-019-00		Cotter Ring
	1 027-060-00		Tube Clamp
	1 046-145-00		Anti-Rattle Spring
	1 054-092-00		Bleeder Screw
	1 054-094-00		Adapter Fitting
	1 056-038-00		Pad Retaining Pin
	1 071-513-00		Cross Over Hydraulic Line (yokes without notch)
	1 071-517-00		Cross Over Hydraulic Line (yokes with notch)
	1 087-002-00		Hex Bolt
	2 089-005-02		Assembled Caliper Half
3	K71-629-00	1	Brake Pad Kit (axle set)
4	K71-637-00	1	Rotor Kit
5	006-193-00	5	3/8" Brake Mounting Nut-Washer Assembly

Nev-R-Lube® Disc Brake Hubs

Item	Part No.	Qty/Brk	Description
6	008-404-80	1	1/2" Studs, 42mm 6 on 5.50
7	007-262-00	6	1/2-20 x 2.70" Press-in Stud (hubs after 2/09)

Disc Brake for 8,000 Lb. Axles



Disc Brake 8000#

Item	Part No.	Qty/Brk	Description
1	090-003-01	1	Anchor Yoke
2	K71-630-00	1	Caliper Assembly Kit for LH or RH Contains:
			4 006-045-00 Caliper Mounting Nut
			4 007-254-00 Caliper Mounting Bolt
			1 019-019-00 Cotter Ring
			1 027-060-00 Tube Clamp
			1 046-145-00 Anti-Rattle Spring
			1 054-092-00 Bleeder Screw
			1 054-094-00 Adapter Fitting
			1 056-038-00 Pad Retaining Pin
			1 071-513-00 Cross Over Hydraulic Line (yokes without notch)
			1 071-518-00 Cross Over Hydraulic Line (yokes with notch)
			1 087-002-00 Hex Bolt
			2 089-003-02 Assembled Caliper Half
3	K71-629-00	1	Brake Pad Kit (axle set)
4	K71-631-00	1	Rotor Kit
5	005-058-00	4	1/2" Lock Washer
6	006-129-01	4	1/2" Hex Nut
7	007-097-00	4	1/2" Brake Mounting Bolt
8	097-002-00	1	ABS Sensor Retaining Clip
9	097-004-00	1	ABS Sensor (straight)

Disc Brake Hubs & Studs

Item	Part No.	Qty/Brk	Description
10	008-399-05	1	Grease 3/16" Studs 8 on 6.50
10	008-399-06	1	Oil 3/16" Studs 8 on 6.50
10	008-399-07	1	Grease 5/8" Studs 8 on 6.50
10	008-399-08	1	Oil 5/8" Studs 8 on 6.50
11	007-257-00	8	3/16-18 x 2.50" Press-in Stud
11	007-115-00	8	5/8-18 x 3.16" Press-in Stud

Disc Brake 8000# With 50MM Nev-R-Lube®

Item	Part No.	Qty/Brk	Description
1	090-007-01	1	Anchor Yoke
2	K71-630-00	1	Caliper Assembly Kit for LH or RH Contains:
			4 006-045-00 Caliper Mounting Nut
			4 007-254-00 Caliper Mounting Bolt
			1 019-019-00 Cotter Ring
			1 027-060-00 Tube Clamp
			1 046-145-00 Anti-Rattle Spring
			1 054-092-00 Bleeder Screw
			1 054-094-00 Adapter Fitting
			1 056-038-00 Pad Retaining Pin
			1 071-513-00 Cross Over Hydraulic Line (yokes without notch)
			1 071-518-00 Cross Over Hydraulic Line (yokes with notch)
			1 087-002-00 Hex Bolt
			2 089-003-02 Assembled Caliper Half
3	K71-629-00	1	Brake Pad Kit (axle set)
4	K71-631-00	1	Rotor Kit
5	005-058-00	4	1/2" Lock Washer
6	006-129-01	4	1/2" Hex Nut
7	007-097-00	4	1/2" Brake Mounting Bolt
8	097-002-00	1	ABS Sensor Retaining Clip
9	097-004-00	1	ABS Sensor (straight)

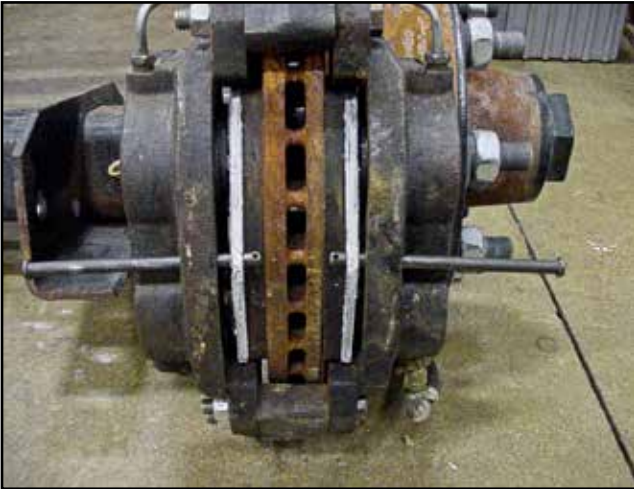
Nev-R-Lube® Disc Brake Hubs

Item	Part No.	Qty/Brk	Description
10	008-402-80	1	3/16" Studs, 50mm 8 on 6.50
10	008-402-81	1	5/8" Studs, 50mm 8 on 6.50
11	007-257-00	8	3/16-18 x 2.50" Press-in Stud
11	007-115-00	8	5/8-18 x 3.16" Press-in Stud

Figure 1

Insert two (2) brake pad retaining pins into each caliper half as shown in the illustration. Place the anti-rattle spring against the brake pads and press the center toward the rotor while you slide the outboard pad retaining pin toward the inner lining. Continue sliding the pad retainer pin until it engages both pads and pushes the second pin out of the inboard caliper half.

Step 1



Step 4



Step 2



Step 5



Step 3

