

Cleveland

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SERVICE BULLETIN

CONVERTING PIPER CHIEFTAIN (PA31-350) WHEEL ASSEMBLY (40-102A) BRAKE ASSEMBLIES (30-68A AND 30-68B) TO CURRENT PRODUCTION MODELS(40-130 WHEEL AND 30-95 BRAKE)

PURPOSE: This procedure will outline the steps for converting Piper Chieftain wheel and brake assemblies to current production models.

SCOPE: Conversion kit number 199-66 (Piper P/N 761 063) will convert one aircraft. Each kit will contain the following parts:

<u>Quantity</u>	<u>Part Number</u>	<u>Description</u>
1	30-95A	Brake Assembly LH
1	30-95A	Brake Assembly RH
2	164-05200	Brake Disc
2	166-07600	Decal

PROCEDURE: Most part numbers referred to in this procedure are taken from Piper Aircraft Corporation parts catalog for PA31-350 Chieftain. Piper numbers are shown in brackets ().

A. Removal

1. Block brake pedal in retracted position to prevent brake pedal movement during conversion.
2. Remove six (6) through bolts (751 468) and washers (407 565) to remove back plate assemblies (757 242) from each brake cylinder (758 128 or 551 719).
3. Remove wheel assembly (756 619) from axle.
4. Remove hydraulic line assemblies (42112-00 on LH side and 42112-01 on RH side) from brake cylinders (758 128 OR 551 719).
5. Remove six (6) nuts (404 889) and bolts (401 187) which secure torque plate assembly (757 244) to axle mounting flange.
6. Remove and discard complete brake assembly (758 128 or 551 719).

B. Conversion

1. Deflate tire and remove nine (9) nuts (404 888), nine (9) washers (407 565) and nine (9) bolts (401 330).
2. Remove brake disc assembly (754 574) from inner wheel half assembly (753 219).

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3. Install new 164-05200 brake disc assembly (754 613) into inner wheel half assembly (753 219) aligning holes in brake disc assembly with holes in inner wheel half.
4. Install nine (9) AN4-32A bolts (401 330) and nine (9) AN960-416 washers (407 565). Visually inspect for bolt shank extending beyond face of washer (assembled on thread side of bolt). If shank does not protrude install nine (9) AN365-428 nuts (404 888). Torque each nut (404 888) to 90 in-lbs. If shank of bolt extends beyond face of washer, remove bolt and place one AN960-416L washer (407 585) under head of bolt and reassemble (the AN960-416 washer will remain on the threaded side of the bolt).
5. Apply new 166-07600 nameplate to outer wheel half assembly (753 220) next to existing nameplate.

C. Installation

1. Install 075-11100 torque plate assembly (757 470) on LH axle and 075-11150 torque plate assembly (757 471) on RH axle. Use existing attachment hardware. Six (6) bolts (401 187) plus six (6) nuts (404 888).
2. Install 40-130 wheel assembly (551 769) on axle.
3. Remove eight (8) through bolts (401 319) and washers (407 585) that retain 075-02500 back plate assemblies (757 468) to 061-05000 cylinder (758 077).
4. Slide caliper assembly into torque plate.
5. Install 068-02800 insulator shim (762 250).
6. Reassemble back plate assemblies (757 468) and torque each AN4H-20A bolt (401 319) to 60 in-lbs.
7. Install new 47556-02 hydraulic line and AN815-4D union to each brake assembly (551 723 on LH side and 551 724 on RH side).
8. Check for correct fluid level in brake cylinder reservoir assembly.
9. Bleed all wheel cylinders to remove air from lines. Check to see that brake pedal is solid.
10. With plane on jacks apply and release each brake pedal. Spin each wheel to assure that linings are properly seated.
11. Record log book entry for compliance. Wheel and brake conversion performed in accordance with Piper Service Kit Number 761 064.
 - a. Converted to wheel number 551 769.
 - b. Converted to brake number 551 723 (LH) and 551 724 (RH).