
240116-001 Remove and Replace Active X Brake

- Objective:
- To ensure that an old X brake assembly will be removed and a new X brake assembly will be properly installed.
- Tools Required:
- Standard Tool Kit
 - 5 mil shim
 - Active X Brake P/N 740-677185-00
- Materials Required:
- None specified
- Sequence:
- None specified

Method:

1. Remove the two X brake mounting Allen (4x40) screws.
 2. Disconnect the air line (normally a white air line).
 3. Remove the old active X Brake.
 4. Place the new X Brake on the track in the same position as the removed X Brake was in.
 5. Insert the two Allen screws previously removed from the assembly.
 6. Hold a 5 mil shim under the “Rulon” pad and the referencing tab on the active X Brake.
 7. Push the brake system down so it is snug against the X magnetic bar on the X Stage.
- Result:** This ensures the Rulon pad does not touch the top of the X magnetic bar on the X Stage during inspection.
8. Tighten the two Allen mounting screws (4x40) until they are snug.
 9. Re-connect the air line to the active X Brake.
 10. Remove the 5 mil shim.
 11. Verify the adjustment by performing the “Measure and Adjust X Brake Gap” procedure in “Stage Test, Calibration, and Adjustment Procedures.”
 12. Select <MAIN> <CALIBRATION> <SYS.CALIB> <TDI NDF/FOC> <CAM IMAGE> <TDI IMAGE> to turn the air off to the X Brake and lift the “Rulon” pad.

