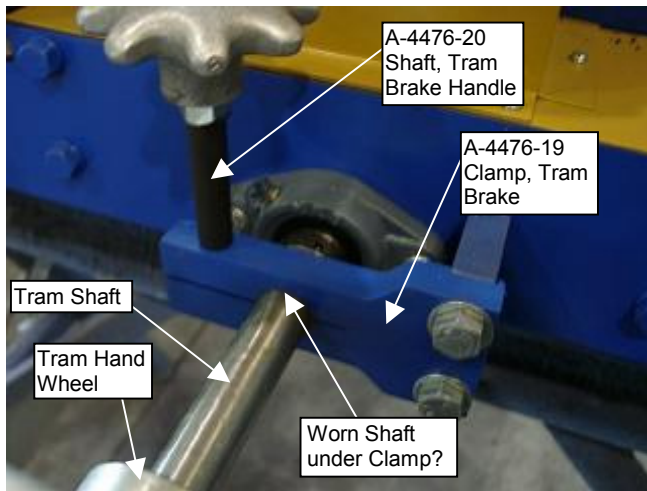
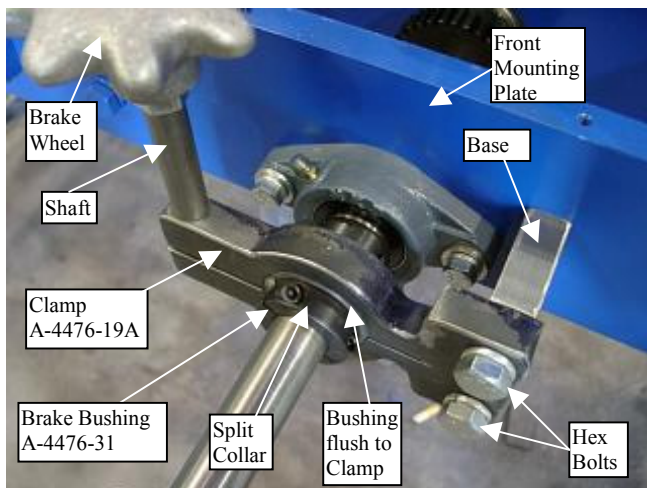




Technical Service Bulletin 04T01  
515 Tram Brake Repair

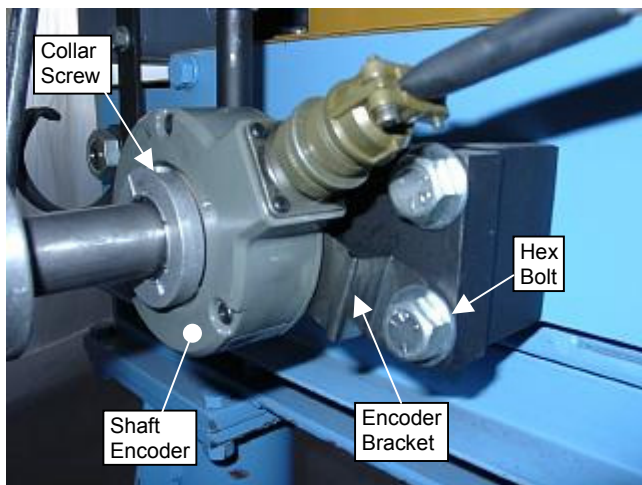


If your tram brake will not hold, it may be due to a worn shaft where the Tram Brake Clamp is applied. The excessive and accelerated wear is the result of incorrectly turning the shaft without fully releasing the brake pressure. The problem is equivalent to riding the brake on your car. There is a repair kit available that does not require the replacement of the costly Tram Shaft.



A worn brake can be repaired by installing a Brake Bushing, A-4476-31 and replacing the original Tram Brake Clamp, A-4476-19, with A-4476-19A as shown at left. To install, remove the Tram Hand Wheel and transfer the Brake Wheel (SA-5000-242) and Shaft (A-4476-20) onto the new Clamp. Insert the bushing into the clamp (note split collar toward front) and tighten the Clamp around the Bushing (as if actuating the brake). With the two locked as a unit, slide the Bushing onto the Tram Shaft. Install the two 1/2" x 3-1/2" Hex Bolts through the Clamp and Base and thread them finger tight into the Front Mounting Plate. Tighten the split collar of the Bushing about the Shaft. Tighten the two Hex Bolts. Reinstall the Tram Hand Wheel. Release the Brake Clamp and turn the Tram Shaft. The brake should

offer little or no resistance when released if installed properly. Always release the brake fully before turning the Tram Shaft.



Note: If your saw is equipped with an optional tram position digital read-out, there will be a Shaft Encoder on the Tram Shaft in front of the Clamp. To remove Encoder, loosen the Collar Screw and remove the Hex Bolt, which anchors the Encoder Bracket. When reinstalling, the rotary position of the collar on the shaft is arbitrary and will not affect the accuracy or performance of the read-out. Slide the back face of the Encoder Collar up to the front face of the Split Collar of the Brake Bushing. If the hole of the Encoder Bracket does not reach the hole in the Clamp, either flatten out some of the 90° bend in the bracket or notch the hole like a fork terminal.