

When replacing components in clutches and brakes several guidelines are appropriate. In all cases, when replacing worn friction surfaces both the components need to be replaced. In many cases, the splined hubs should be inspected and replaced if worn.

Common Replacement practices:

EM/UM/EUM clutches

- Replace rotor and armature
- Inspect splined hub

EM/UM/EUM clutch/brakes

- Replace clutch rotor and armature
- Replace brake magnet and armature
- Inspect splined hub

EC clutches

- Replace clutch rotor and armature

EB brakes

- Replace magnet and armature

ATC clutches

- Replace clutch rotor facing and armature facing
- Inspect splined hub

ATB brakes

- Replace magnet facing and armature facing
- Inspect splined hub

Electro-Pack clutch/brake

- Replace clutch rotor and armature
- Replace brake magnet and armature
- Inspect splined hub

Electrically released brakes

- On all Electrically released brakes the magnet and armature are only sold as a matched set and must be replaced as a set.

A note on burnishing:

When new friction surfaces are installed it will be necessary to burnish the unit prior to returning to full production rates. Burnishing is the act of wearing in the friction faces to ensure full engagement and therefore full torque. Burnishing is achieved by simply cycling the unit under less than full load (machine empty, if possible). Most units will achieve full torque in less than 100 cycles. Refer to the service manual for more details.