

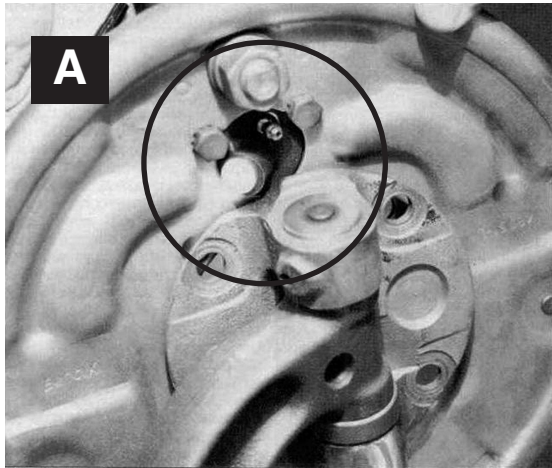
INSTRUCTIONS

916-31934

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F-100 BRAKES ON EARLY FORD SPINDLES

Installing the '53 to '56 Ford F100 brakes on '37 to '48 Ford passenger spindles is a simple task. Other than substituting the pickup parts for the originals, the only modification is minor grinding on the passenger spindle for brake line clearance. Standard master cylinders are adequate for this application; however a dual master cylinder or power booster may also be used.



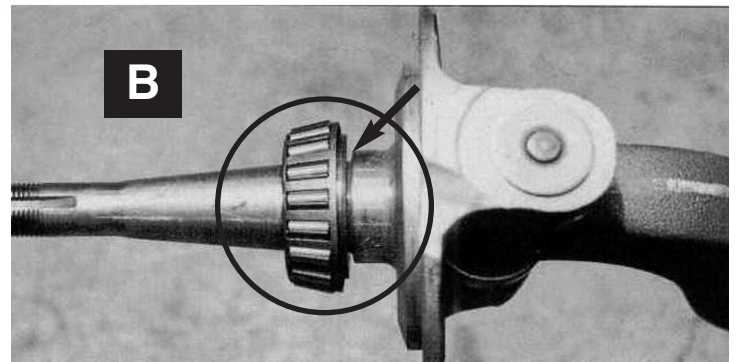
The parts needed for the update from the donor ½ ton pickup are the drums, hubs, and complete backing plate assemblies. These parts should be inspected, refurbished, or replaced as necessary prior to installation. Remove the original bearing races from the hubs and install the new races supplied with the Speedway bearing and seal kit.

Begin by placing the backing plate on the spindle. The bolt holes should line up without modification. Place two bolts through the backing plate and spindle, but do not tighten. Check for adequate clearance between the brake line fitting of the wheel cylinder and the aft side of the top kingpin boss (see figure A). Grind a small crescent shaped relief as required for the brake line fitting to clear

the spindle boss. When grinding is complete the backing plate should sit flush on the spindle mounting flange. Install all 4 bolts and torque to spec.

Prior to packing the wheel bearings with grease and installing the hub check the fit of the inner (large) wheel bearing on the spindle. The bearing should slide onto the spindle and seat firmly on the seal shoulder at the base of the spindle. Check closely to make sure that the bearing does not bind up on the radius at the base of the spindle. (Figure B shows a bearing incorrectly installed). If necessary, gently polish the spindle fillet or bearing as required until the bearing seats firmly without binding.

Clean wheel bearings thoroughly and pack with approved wheel bearing grease. Install the inner bearing into the hub, install the supplied grease seal. Install hub on spindle, install outer wheel bearing, key washer, and spindle nut. Torque spindle nut to 50 in lbs, and back off to first cotter pin hole. Install cotter pin, dust cap, and brake drum. Repeat for other side of vehicle, connect brake hoses, adjust shoes, and bleed system.



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