

CLEANING AND INSPECTION (Continued)

Certain brake tube bundles are serviced as complete assemblies. If not serviced, the following service procedure should be used:

1. Obtain the recommended bulk 3/16-inch double wall steel brake tubing and the correct standard tube nuts for 3/16-inch tubing.
2. Cut tubing to length required. Clean burrs after cutting. The correct length may be obtained by measuring the removed tube with a string and adding 1.2mm (1/8 inch) for each flare.
3. Place tube nut onto tube into correct direction and flare the end of the tube with an SAE inverted flare or the metric ISO flare as required, using Brake Line Flaring Tool D81L-2268-A, or equivalent.
4. Repeat on the opposite end of the tube.
5. Bend the replacement tube to match the removed tube using a tubing bender. When the replacement brake tube is installed, maintain adequate clearance to metal edges, and moving or vibrating parts.
6. Install brake tube and torque tube nuts to 16-20 N·m (142-177 lb-in) with Lb-Inch Torque Wrench D81L-600-A, or equivalent.
7. Bleed the serviced primary or secondary circuit.

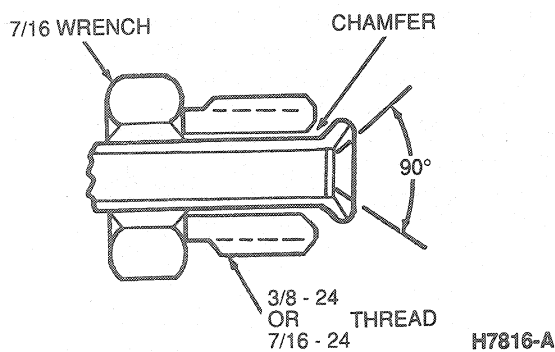
If either end of the Tube to Tube Connection requires replacement, replace both ends with the SAE double 45 degree union connection.

All brake tubing should be flared properly to provide good leakproof connections. Clean brake tubing by flushing with clean brake fluid before installation.

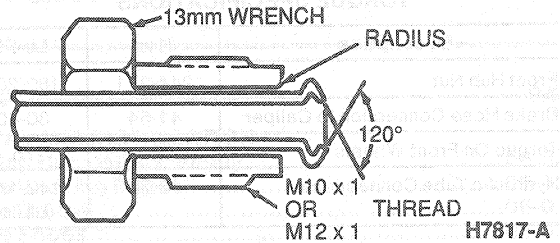
When connecting a tube to a hose, tube connector, or brake cylinder, tighten the tube fitting nut to specification with Lb-In Torque Wrench D81L-600-A or equivalent.

Commonly used types of brake line flared connection:

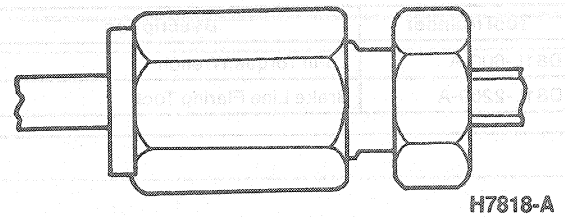
1. SAE double 45 degree flare.



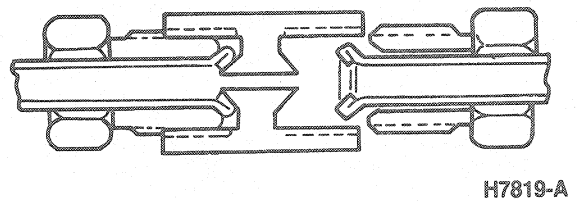
2. ISO Metric flare.



3. Tube to tube connection.



4. SAE double 45 Union (repair).



Brake Hose

A flexible brake hose should be replaced if it shows signs of softening, cracking or other damage.

When installing a new front brake hose, two new sealing washers should be used. Positioning of the front hose is controlled by a self-indexing brass block. When attaching brake hose connection to caliper, tighten bolt to 41-54 N·m (30-40 lb-ft). Attach intermediate bracket to shock strut and tighten screw. Engage the opposite end of hose to bracket on the body. Install the horseshoe-type retaining clip and connect tube to hose with tube nut. Inspect position of installed hose for clearance to other chassis components.

Positioning of rear brake hose is controlled by self-indexing end fittings.

Engage either end of hose to the bracket on the body. Install the horseshoe-type retaining clip and connect tube to hose with the tube fitting nut. Engage opposite end of hose to bracket on rear spindle. Install the horseshoe-type retaining clip and connect tube to hose with tube fitting nut.

Inspect position of installed hose for contact with other chassis parts.