

Brake Pole Module Replacement for Magstop Clutch Brakes

**P-1428-WE
819-0394**

Replacement Instructions

⚠ WARNING Failure to follow these instructions may result in product damage, equipment damage, and serious or fatal injury to personnel.

1. Turn engine off and remove key to prevent accidental starting of engine and possible injury.
2. Remove clutch from tractor.
3. Use right angle grinder or suitable substitute to grind off 5 (five) rivet heads from brake pole pads. Do not grind on field shell side of rivets, unless rivets cannot be removed by grinding on the brake pole side of clutch. (See Figure 1)

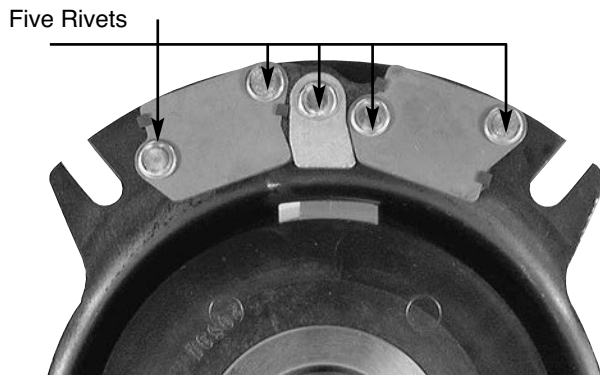


Figure 1

4. Use appropriate sized punch to drive rivet from factory brake components. Discard old brake components. (See Figure 2)

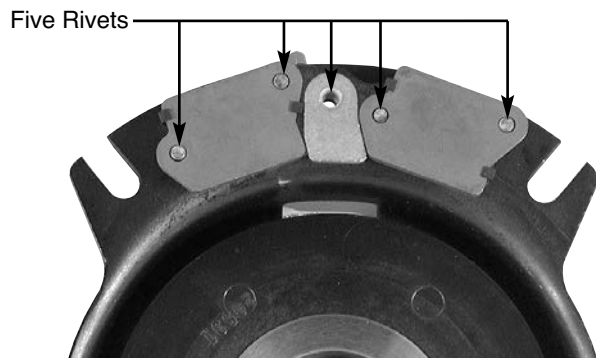
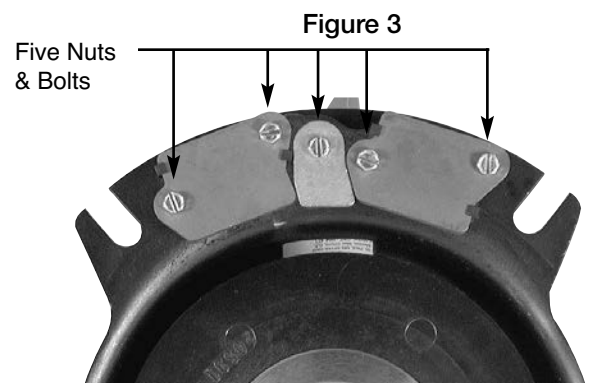


Figure 2

5. Magnets are marked with a white dot on face that should contact clutch brim. Replace old components with new brake pole components: 2 brake poles & 2 magnets, mid pole, 5 nuts and 5 bolts. (See Figure 3) Install with bolt, nut and lockwasher. Tighten bolts by hand, and then tighten bolts evenly with wrench.



6. Torque brake module mounting bolts to specified value of 20 in.lb. plus or minus 1 in.lb. (See Figure 4)

Figure 4



7. Reinstall clutch per owner's manual, care should be taken so that anti-rotation device does not bind the clutch. Torque mounting bolt to specified torque. 50-55 ft.lbs. for 7/16" bolt, and 42-45 ft.lbs. for 3/8" bolt (Grade 8).
8. Reconnect power leads to clutch.
9. Burnish the brake poles by cycling the clutch about ten times at full engine rpm, letting load brake to full stop and accelerating to full rpm on each cycle. Cycle rate should be approximately 20 seconds on and 20 seconds off.

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