



Technical Bulletin 043

Taper Lock Brake Disc

Page 1 of 5

It has been noted that in certain circumstances the jockey wheel locking collar (0801-LOCK01-35) can work loose over time, allowing the jockey wheel brake disc to separate and potentially allow the jockey wheel to fall away from its housing. This can cause extensive damage to the machine. This Technical Bulletin describes the process to replace the current brake disc assembly with a new design which will prevent this failure from occurring.

THIS REPLACEMENT MUST BE CARRIED OUT IN ORDER TO MAINTAIN THE WARRANTY ON YOUR MACHINE. THE ATTACHED DECLARATION MUST BE COMPLETED AND RETURNED TO KELLY ENGINEERING.

Animations on how to conduct this Technical Bulletin can be found by using the below QR code



Taper Lock Brake Disc

Page 2 of 5

Removal of old disc

1. Undo brake caliper, and remove bolt and spring completely.
2. Raise top brake pad to expose disc (see below).
3. Undo 12x M6 bolts from locking collar using a 5mm hexagonal wrench, and remove brake disc, locking collar and dust cap from shaft.



Taper Lock Brake Disc

Page 3 of 5

Preparation

Ensure that shaft and dust cap are free from any dirt, paint or rust, and replace dust cap on shaft.

Installation

1. The new brake disc will arrive factory-assembled. Loosen the 2x grub screws and remove the taper lock.
2. Place the brake disc onto the shaft as per the below diagram.



3. Coat the inside of the taper lock with Loctite 680 Retaining Compound™ or equivalent.
4. Insert the taper lock over the shaft into the collar
5. Rotate the brake disc until the 3 threaded holes on the disc and the 3 threaded holes on the taper lock are aligned (NOTE: The slotted hole on the taper lock should NOT have a matching hole – see below).

Taper Lock Brake Disc

Page 4 of 5



6. Sparingly oil both grub screws and the screw threads in the outer disc
7. Insert the 2x grub screws loosely into the oiled threaded holes
8. Using a 5mm hexagonal wrench to tighten the grub screws (clockwise), alternating evenly between both until the required torque of **20Nm (14.8ft/lb)** has been achieved.
9. Tap the outer rim of the disc with a block of wood or soft-faced mallet. Re-torque the grub screw if any adjustment is required – repeat as necessary.
10. Replace brake caliper and tighten to the required tension.
11. Re-torque the grub screws after the machine has been working for 1 hour.
12. Check daily before using the machine.

Taper Lock Brake Disc

Page 5 of 5

Dis-assembling a Taper Lock Brake Disc

1. Undo both grub screws using a 5mm hexagonal wrench.
2. Oil one of the grub screws, and the thread opposite the taper lock split (see below diagram).
3. Place a grub screw into this threaded hole, and tighten.
4. This will push the taper lock up and away from the disc. Remove locking bush and disc from shaft.



Parts Breakdown

Item No.	Description	Number	Qty
1	Taper Lock Brake Disc	0810-TBD	1
2	Dome Set Screw	0211-3,8 x 16TPI	2
3	35mm Taper Lock Bush	0801-1610T-35mmTLB	1

