



service bulletin

Date June, 1958

No. 91.2.002

AIRCRAFT SAAB SAFIR 91A, 91B, 91B-2 and 91C.

SUBJECT: Cementing of brake linings for wheel brakes.

REASON: Cemented brake linings have a substantially increased service life as compared to riveted linings.

**PARTS
AFFECTED:**

91A

Friction disc 505010 and brake lining 505011. Spare Parts Catalogue 91.2100/02 item 27 and 28.

91B, 91B-2 and 91C

Friction disc 1080151 and brake lining 1075927. Spare Parts Catalogue 91.2105/02 item 19.

**TIME OF
COMPLIANCE:** At owner's discretion.

**WORK
PROCEDURE:**

Drill out the rivets and remove the brake linings from the friction disc. Clean the friction disc and straighten it if warped. Cement new brake linings to friction disc according to cement manufacturer's instructions, using one of the following cements Bostic 1777 made by the Boston Blacking Chemical Co., Redux 64 made by Aero Research, Duxford Cambridge England. WM35 made by the Permafuse Corp., Waterbury New York, USA.

Most of the brake lining cementing on SAFIRS has up to now been made with Bostic 1777, but the other cements are considered equivalent.

Cemented brake linings may wear down to a minimum thickness of 1 mm (0.04 ") as compared to riveted linings which only may wear down to 2.5 mm (0.1").

If, on 91B, 91B-2 or 91C, the increased wear allowance cannot be utilized owing to interference between brake shield 1027371, Spare Parts Catalogue 91.2105/02 item 13, and wheel, the brake shield may be machined off according to the figure.

Apply two coats of zinc chromate primer and one coat of aluminium lacquer to machined surfaces or re-anodize the brake shield after machining.

