



TECHNICAL SERVICE BULLETIN # 12-001

## GUIDELINES FOR BRAKE DRUM REPLACEMENT

Webb Wheel Products Inc. • [www.webbwheel.com](http://www.webbwheel.com)

08/28/2012

Brake drum replacement is required if any of the following conditions exist:

1. The brake drum is cracked.
2. The brake surface has heavy heat check.
3. The backing plate is cracked.
4. The bolt holes are elongated.
5. The brake drum is out-of-round.
6. The brake surface is grooved or worn beyond the maximum diameter.
7. The brake drum is known to have been severely overheated.

**NOTICE:** Brake drums should be replaced in pairs to achieve the same braking power on the axle.

The following are detailed descriptions for some common replacement conditions.



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## Light Heat Check

Heat check is **1.5" or less in length**. Heat check is sporadic across the braking surface. No propagation. No crevices.



**GOOD – Keep running**



## Medium Heat Check

Heat check is **no longer than 3" in length**. Heat check is not apparent across the entire width of braking surface. Check is beginning to propagate. No crevices.



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## Heavy Heat Check

Heat check in **excess of 3" in length**. High frequency of propagated heat check. Crevices appear in braking surface cracks.



**REPLACE DRUM**



**NOTICE:** These classifications are made based on the worst area of the brake drum that is affected by heat check. It does not need to be visible completely around the braking surface. *For example: If a drum has localized heavy heat check in an area that is approximately 6 In. across, but the rest of drum has no apparent heat check; the classification of this drum would be HEAVY.*



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**REPLACE DRUM**

**Severe  
Overheating**

**Hot-spotting** is typically caused by brake drag or torque imbalance. These dark colored spots are the result of martensite forming in the cast iron braking surface.



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**Severe  
Overheating**

**Bluing** is typically caused by excessive heat from dragging brakes or brake imbalance. Braking system should be checked for balance and properly adjusted slacks. **Replace** brake drum if heavy heat check develops.





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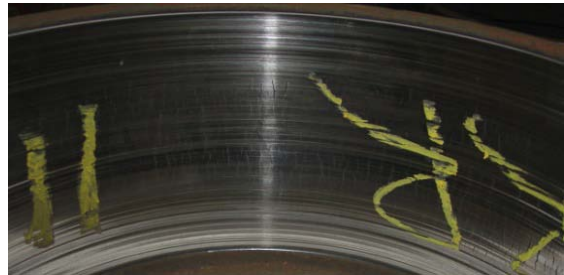
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**Grooving**

Grooves are usually caused by foreign material between the drum and lining. Deep grooves can cause a localized section of the drum braking surface to be worn beyond the wear out limit.

**Replace** brake drum if beyond worn out limit.



For additional information on proper brake drum installation and replacement please visit:

[http://www.webbwheel.com/aftermarket/training\\_toolbox.html](http://www.webbwheel.com/aftermarket/training_toolbox.html)

For additional questions and application support, please contact Webb's Technical Support Team at:

Webb Aftermarket 1-800-633-3256

Webb OE 1-866-824-8753

Webb Severe Duty 1-800-256-2270