Machining a Brake Drum

Meets NATEF Task: (A5-C-2) Refinish brake drum; measure final drum diameter. (P-1)

Name _____ **Date** _____ **Time on Task** _____

Make/Model/Year _____ **VIN** _____ **Evaluation: 4 3 2 1**

_____ **1.** Measure the drum and double check that the brake drum can be safely machined.

- Maximum allowable inside diameter = _____
- Actual measurement of the drum = _____ left = _____ right = _____

OK to machine ☐ **discard** ☐

_____ **2.** Select the proper tapered centering cone and face supporting plate.

_____ **3.** Install a self-aligning spacer (SAS) and tighten the spindle nut.

_____ **4.** Perform a scratch cut.

_____ **5.** Stop the lathe, loosen the spindle nut, and rotate the brake drum 180° (one-half turn) and retighten the spindle nut.

_____ **6.** Perform a second scratch cut.

- If the second cut is in the same location, proceed with machining.
- If the second cut is on the opposite side of the drum, clean or repair the lathe before machining.

_____ **7.** Install a silencer band (vibration damper).

_____ **8.** Machine the drum.

_____ **9.** The measurement of the drum after machining = _____.

Does this allow 0.030" or more for wear?

Yes ☐ (install on the vehicle) **No** ☐ (replace the drum)