



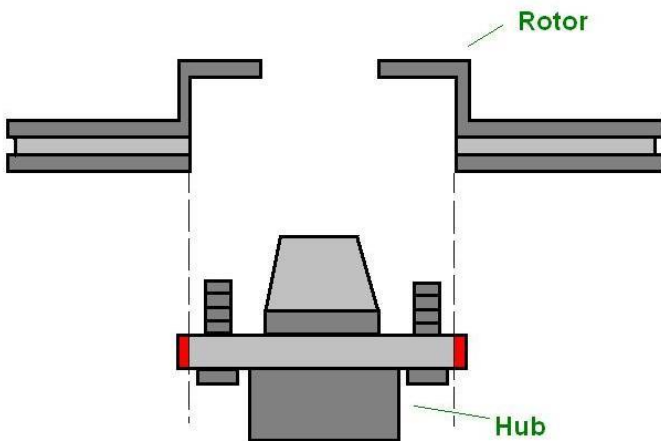
1963-73 Ford-Mercury Front Disc Brake Conversion Fairlane, Falcon, Mustang, Cougar, Comet, Cyclone and Montego Models Installation Instructions

1. Break front wheel nuts loose and chock rear wheels to secure vehicle in place.
2. Jack up front end of car and support vehicle with appropriately-rated jackstands.
3. Remove front wheels followed by the drum/hub assemblies.
4. Take drum/hub assembly and trim outer diameter to fit inside rotor. This can be done with an engine lathe or brake lathe. Do NOT use a grinder or sander! Outer dimension should be approx. 5.650".
5. Trim the base of the existing studs to fit rotor. Best way to do this is with a swage cutter - **or** -replace studs with Moser or ARP studs - **or** - drill out rotor stud holes to fit over studs (5/8"+).
6. Disconnect brake flexible line at frame by unscrewing hardline nut with flare wrench, then removing clip. Undo and remove drum retaining bolts. Remove drum backing plate, hose and all drum hardware in one assembly. Clean off spindle assembly well.
7. Place adapter plate over spindle with caliper bolt retaining nut welds facing inward and caliper forward of the axle. Make sure no dirt is lodged between spindle and plate. Replace OEM bolts and tighten to 42 ft-lbs.
8. Clean and repack wheel bearings. Install new seal (same as drum seal). Assemble machined hub onto spindle, tighten outer nut to spec, then secure with keeper, new cotter pin and dust cap.
9. Place rotor onto hub, and run two or three lug nuts down finger tight to retain rotor. Wipe down rotor with alcohol, lacquer thinner or other cleaner. Wash hands! Rotor must be squeaky clean.
10. Test fit caliper onto bracket. Lubricate caliper contact point of brackets. Slide assembly into caliper bracket. Make sure bleed screw faces upward- if not, reverse sides. Some calipers have a small nub that interferes with fitment - remove this nub. If outer edge of caliper interferes with bracket, file caliper to remove burrs. Tighten caliper bolts to 35 foot-pounds. Check fitment and rotate rotor to check clearance.

- 11.** Test fit and install hose with new copper crush washers. The smaller models (Mustangs, Falcons, Cougars etc....) usually like a 17" hose, while the intermediates (Fairlane, Cyclone etc....) seem to prefer 15" hoses. If in doubt, use a piece of 3/8" fuel line to test run before buying hose.

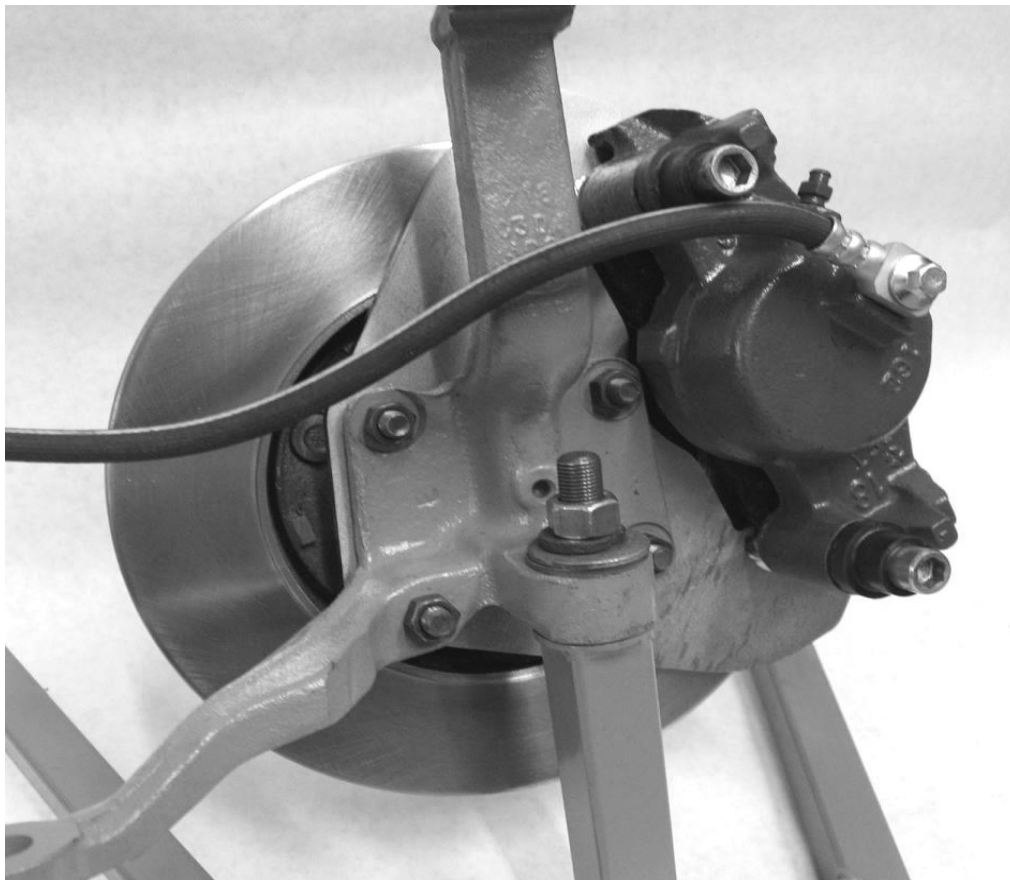
If you are using a 17" hose, remove bracket by cutting a slot as shown in the second picture in the bracket 80% in, then bending away bracket. You may need to file a slot in hardline retainer for hose fitment. Some hardlines are 7/16"- you will need to change the hardline nut or order custom hoses or use Weatherhead adapter #7828 or equivalent.

- 12.** Master cylinder and proportioning valve specs are quite varied. I would recommend NAPA 1974 Maverick manual disc master cylinder for best. Plumb in an adjustable proportioning valve in the line going to the rear cylinders, or use a disc proportioning valve
- 13.** Bench bleed disc master cylinder. Mount MC on car, then gravity bleed entire system first to eliminate most of the air, then pump bleed and test, otherwise your distribution block may jam from a pressure imbalance. Another method is to use a suction device at the caliper, both Griot's and Harbor Freight have air-powered units for less than \$40 that work very well.
- 14.** Replace wheels, install lug nuts, lower car and torque nuts to spec. Test drive carefully- no hard stops, a series of smooth stops will help bed in the pads properly.



| Part | Application | NAPA | Wagner | Raybestos |
|------------------------------------|---|-------------|----------------|------------------|
| Rotor | 1991-94 Toyota Previa front rotor w/ rear drum option | 48-86174 | BD125058 | 96174 |
| Caliper, LH | 1990 Chevy Celebrity | N4746 | L107084 | RC4234 |
| Caliper, RH | 1990 Chevy Celebrity | N4745 | L107085 | RC4233 |
| Brake Hose* | 1979-82 Eldorado front | 36959/36960 | F98914/98914 | BH36959/36960 |
| Brake pads | 1990 Chevy Celebrity | TS7136M | MX215 | |
| If using our custom aluminum hubs: | | | | |
| Dust Cap | 1983 Ranger 2WD rotor | 7351424 | Dorman 618-503 | |
| Wheel Seal | 1978-83 Fairmont front | 19221 | 6815 | |

Parts supplied with kit: caliper brackets, (2) hose locks, (2) metric banjo bolts, (2) cotter pins



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