



It is recommended to read and comprehend this install guide BEFORE beginning the disc brake conversion. This set was tested for use on a Volkswagen Type 2 Bay Bus

#### INSTALLATION INSTRUCTIONS:

1. Break all front wheel nuts free approximately 1/2 turn with tires on the ground.
2. Jack up the front end and place on jack stands. Remove wheels and place under the vehicle as an additional fail safe.
3. The dust cap will be reused with these disc brakes so you will need to remove with care. On the driver's side, you will need to remove the circlip holding the speedo cable and save. There are several techniques in removing these dust caps, our favorite is with an oversized set of channel locks. Grab each edge and rock the cap up and down until it falls off. Repeat on the passenger side.
4. The spindle nut has an Allen pinch bolt. Loosen and remove the nut.
5. Once removed, it is time to pull off the old drum. Do not try and pry it off. Tap the drum on the edge with a rubber mallet until the drum falls off.
6. Make sure you have a container to catch the brake fluid once you start this step. On the back side of the backing plate, remove the bleeder and loosen and remove the brake line. Remove the 4 bolts on each side and remove the backing plates.

7. If you are using the stock spindle it is now time to clean wire brush and repaint the spindle and knuckle. Lightly chamfer/ steel wool the spindle to remove any light rust. Clean all grease/ residue with a quality brake parts cleaner. If your kit came with drop spindles you will need to coat them with a finish of your choice.
8. If you are using a stock spindle attach the caliper mounting plate to the backing plate holes with the supplied flat head allen hardware. Torque to 35 ft. lbs after initial tightening in a cross pattern. Using Blue lock tite is recommended.
9. Install the inner bearing spacer on the spindle.
10. Check the fit of the inner (large) bearing on the spindle. It should fit snugly. Once the proper bearing fit has been verified make sure that the bearing race seats in the hub are clean and free of any dirt or shavings from machining. Clean/ chamfer as necessary then start the bearing races and press them home to the bottom of the seats thin side up. Be careful not to damage the races. A large socket of appropriate outside diameter is a good tool for driving the races home. Extreme force should not be necessary. Pay attention that the races press/ drive in straight as a cocked race can damage the hub. If a race wants to press in unevenly STOP! Find and correct the cause of the problem. Even a tiny shaving in the race seat can cause rotor "wobble" if not detected and removed and will result in unsatisfactory braking performance or wheel wobble. As of Sept. 2016, we offer the service of installing the races, packing the bearings and seals.
11. Once the races are properly installed and seated to the bottom of the seat, it's time to pack the bearings with grease and install them in the races. Once placed in the rotors, remove any grease or oily residue on the rotors. Scan the code above to watch a video on how to hand pack bearings.



12. Tap the seal in dry. Once the seal is in and is not popping back out, grease the seal, both inner and outer. This will prevent the seal from burning off. Scan the code



below to watch a video of what happens if grease has not been cleaned off a BAD Series Rotor.

13. Now install the rotor with bearings on the spindle. Install the notched washer and then the clamp nut (as originally supplied with your drum brakes). Adjust wheel bearing end play per VW repair procedure and spin hub/ rotor to check for looseness or binding. A recommended procedure is to spin the rotor while tightening the spindle nut. Once you are not able to spin the rotor any longer, back the nut off 1/4 turn.
14. Tighten the Allen head screw. Install the dust caps and speedo cable to finish off the hub installation.
15. You are now ready to test fit the brake caliper. There is an assortment of washers/ shims supplied with the kit. It is of **UTMOST IMPORTANCE** that the caliper is fitted so that A the rotor rides in the exact center of the caliper cutout on both the top and bottom of the caliper and B the pads contact the rotor dead flat to surface; IE it doesn't contact the top of the pad to the rotor while not contacting at the bottom of the pad or vice versa. Thus the brake caliper must be installed in parallel with the brake disc.
16. Once it is determined that the caliper is spaced such that this has been achieved the caliper can be fixed to the mounting plate with the appropriate shims using a high-temperature thread locker and torqued to 9Mkp (35 foot pounds). Pay attention that the caliper fixing screws (8mm Allen head) neither sticks out the opposite side of the mounting plate and contact the rotor nor do too few threads go into the mounting plate to hold the caliper securely. Too far in is easily corrected with a washer under the bolt head not in far enough to be safe requires a longer fixing screw of the same type which should be easily available at any local parts or hardware store in a pinch. Be sure to use fasteners of the "hardened" type as supplied with the kit.
17. Prepare and install the brake pads. Using a file or a bench grinder and wearing a protective dust mask slightly bevel the edges of the friction material on the brake pads. Apply a coating of "Silicone Adhesive" to the **BACKS** of the brake pads. These steps will greatly reduce "ringing" and "squealing" from the disc pads contacting the rotor.
18. Slip the cotter pin out of the caliper. Install the pads into the calipers (friction sides facing the rotor of course!) and reinstall the pin assembly making sure it's in all the holes in both caliper and pads. Bend the end outwards to each side.

19. Next, it's time to address the brake lines. If you did not get the installation kit, a brass fitting adapter is supplied to use original hoses. With teflon tape/pipe dope or something similar, coat the fitting and install into the caliper. There is a sticker over the hole where the fitting needs to be installed. Then install the factory hose. If you purchased the installation kit, it came with stainless steel brake hoses. For Wilwood applications, the correct fitting will be apart of the hose. You will need to place the same thread tape on the fitting to ensure proper sealing properties.
20. Fill with dot 3 brake fluid and leave the cap off while bleeding the brakes.
21. Common knowledge in bleeding disc brakes tells you to bleed the furthest away. When working with a disc brake master, like the one supplied, you need to bleed the first circuit to be able to bleed the second circuit completely. Start with the right side front, left side front, right side rear and finish with left side rear. Remember to check and top off the fluid frequently. \*NOTE\*: Wilwood calipers are designed for "either side" fitment; therefore ONLY the TOP bleeder valves are used.
22. When only installing front disc brake application, properly adjusting the rear brakes will give you an even nicer pedal feel. Tip - Tighten the adjustment stars until the rear drums do not move. Pump up the brakes 3-5 times and you will notice that the drum will turn again. Adjust them tighter until the drum does not move again. Then pump them up again. Repeat these step until the drum does not move after pumping them up. Then back them off so that the drum will turn and not drag. Doing this process will center the shoe in the drum and allow the shoe to wear evenly. After doing these steps to correctly adjust your brake shoes make sure to adjust your e-brake cable as well.
23. Install the front tire/ wheel assemblies. Once the road wheels are installed and torqued remove the car from the Jack stands. \*IMPORTANT: BEFORE DRIVING OFF press the brake pedal slowly to the floor and release repeating until the caliper pistons have moved out of their bore into driving position (firm brake pedal at or about normal height)

#### Pad and Rotor Bedding:

Bedding is a "real conditions" heat cycle and the final step in preparing the pads and rotors for service. All pads especially cast iron rotors that will be operated at sustained high temperatures will provide longer service life and smoother braking when properly bedded. Bedding can be done either in the vehicle or on a special bedding dyno that can realistically duplicate the torque loads pressure and temperature that will be realized in the vehicle.

#### Rotor Bedding:

Rotor bedding is an essential element to high level performance and durability. It is most critical with cast iron rotors. Cast iron is extremely well suited to use as a brake rotor but it can be susceptible to thermal stress distortion and even cracking if subjected to rapid changes in temperature when it's new. The cracking sound that you may hear when pouring a favorite beverage over a glass of ice is thermal shock. A proper bedding cycle will gradually bring the rotors up to temperature and then allow them to cool slowly and completely in order to "season" and relieve any remaining stresses from the casting and machining processes. With some compounds a layer of pad material may also be

embedded onto the rotor face. It is important that this "transfer layer" be deposited slowly and smoothly. Otherwise pedal pulsing and compromised friction values can result.

#### Pad Bedding:

The bedding process is the final "heat cure" for the pads. This final bedding cure differs from an oven heat cure in such that the oven heat cure does not include the pressure torque and elevated surface temperatures that are necessary to properly condition the pad for service. As it is with the rotors new pads must be gradually brought up to temperature and then slowly cooled. If the pads are put into hard service right from the start damage from fractures or accelerated deterioration due to extreme temperature variations between the surface and the body of the pad can occur. Overall poor performance with the potential for rotor damage are often the results.

#### Bedding Steps:

1. Once the brake system has been tested and determined safe to operate the vehicle follow these steps for bedding of all pad materials and rotors.
2. Begin with a series of 8-10 light stops from approximately 30 MPH down to 15 MPH allowing 20-30 seconds for cooling between each stop.
3. Progress to series of 8-10 moderate stops from around 45 MPH down to 30 MPH allowing the 20-30 second cool down period between each stop.
4. Proceed with a series of 8-10 hard stops from 55-65 MPH down to 25 MPH allowing 20-30 seconds of cool down time between each stop.
5. Drive at a moderate cruising speed with the least amount of brake contact possible until most of the heat has dissipated from the brakes. Avoid sitting stopped with the brake pedal depressed to hold the car in place during this time. Park the vehicle and allow the brakes to cool to ambient air temperature.

#### Notes:

During the bedding process a more positive feel from the brakes should develop. This is an indication that the bed in process is working. If any level of brake fade is observed during the hard stops it may be an indication that the brakes have been more than adequately heated. Begin cooling the brakes with light driving and without brake contact immediately.

#### Tips

You get done installing your brand new disc brake kit bleed it out and the pedal is just not there. Pump it up a few times and gets harder and harder. Guess what? It still has air in the system. Here are some things to check when you have a spongy pedal with disc brakes.

Make sure your bleeders are on top of the brake lines. Air rises to the top and can not be bled out the bottom

Loose connections with your new stainless brake hoses