

Technical Bulletin.

MERCEDES BONDED BRAKE DISC

Many new Mercedes vehicles use a two-piece bi-metallic (bonded) brake disc.

The two-piece Duo cast brake disc in the Apec Black range consists of a steel hub cast into a grey cast iron friction ring. The steel hub is a lot thinner than a conventional cast disc. With this complex design, special care must be taken when tightening the wheel bolts to avoid distorting the disc. A distorted disc will cause lateral run-out, resulting in brake judder.

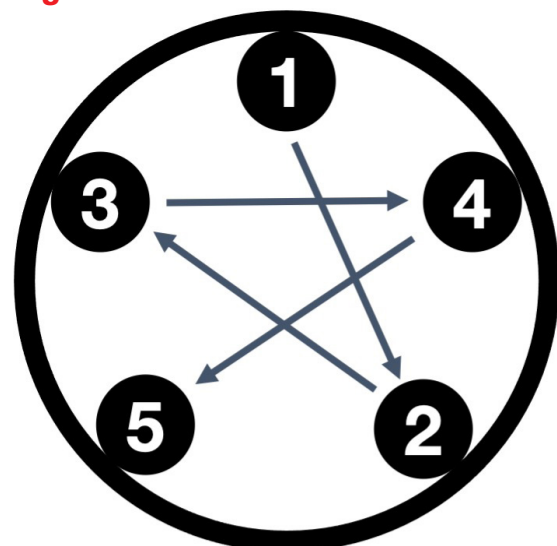
TECHMATE recommend the following procedure:

- 1.** Tighten wheel bolts in the specific order (Figure 1) with a maximum of 20 Nm for unloaded wheels*.
- 2.** Tighten wheel bolts in the specific order (Figure 1) with a maximum of 75 Nm for unloaded wheels*.
- 3.** With the vehicle now on the ground, tighten wheel bolts in the specific order (Figure 1) as specified by the vehicle manufacturer for loaded wheels.

*Unloaded wheels = wheels off the ground.



Figure 1



Failure to follow these instructions may result in a distorted brake disc. As a result, problems may occur during braking including brake judder.