

Brake Systems

GENERAL MOTORS SINGLE ANCHOR

Chevrolet (1965-74)
GMC (1965-74)

DESCRIPTION

Single anchor duo-servo type brake assemblies consist of a support plate, two brake shoes, return springs, automatic adjuster components, and a wheel cylinder. Automatic adjusters consist of a connecting link, override lever, override spring, return spring, actuating lever, and an adjusting screw. Normal adjustment is accomplished through movement of actuating lever and secondary shoe during reverse brake application.

ADJUSTMENT & SERVICING

BRAKE SHOE ADJUSTMENT

Recommended Method — With brake drum removed, disengage actuating lever from star wheel. Using suitable brake drum gauge, measure diameter of drum clearance surface. Adjust brake shoes by turning star wheel until gauge just slides over shoes. Rotate gauge around shoes to assure proper clearance. Install brake drum and wheel, and make several forward and reverse stops to complete adjustment.

Alternate Method — With brake drum removed, disengage actuating lever from star wheel. Using the brake drum as a gauge, adjust brake shoes until drum slides over shoes with a slight drag. Turn adjuster $1\frac{1}{4}$ turns to retract shoes. Install drum and wheel, and make several forward and reverse stops to complete adjustment.

PARKING BRAKE ADJUSTMENT

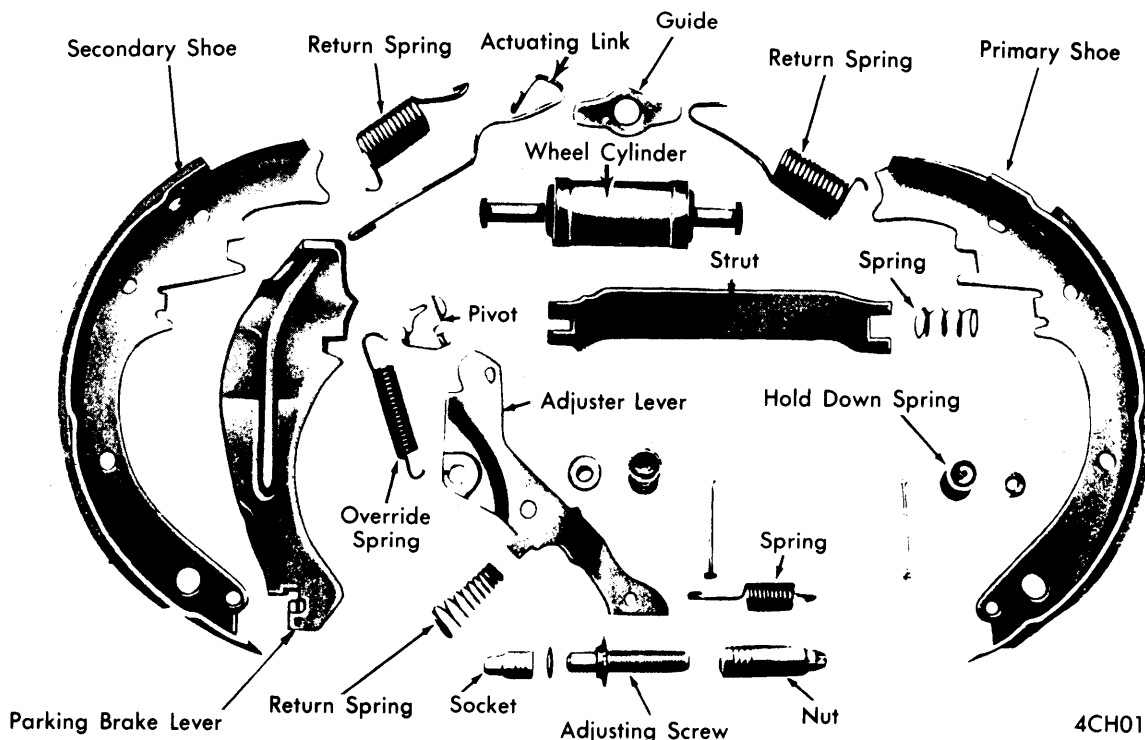
Rear Wheel Type (Foot Pedal Actuated) — With service brakes in proper adjustment, raise vehicle until both rear wheels are off ground. Apply parking brake one notch from fully released and loosen equalizer lock nut. Tighten adjusting nut until a slight drag is felt when wheels are rotated forward. Tighten lock nut, release parking brake, and check that no drag is present when wheels are rotated.

Rear Wheel Type (Orscheln Lever Actuated) — With service brakes in proper adjustment, turn adjusting knob on lever counterclockwise to stop. Apply parking brake and raise vehicle until both rear wheels are off ground. Loosen intermediate cable equalizer lock nut and adjust front nut until slight drag is felt when rear wheels are rotated forward. Tighten lock nut. Readjust lever adjusting knob to obtain definite snap-over-center feel. Release parking brake and check that no drag is present when wheels are rotated.

Transmission Mounted (External Contracting Band Type)

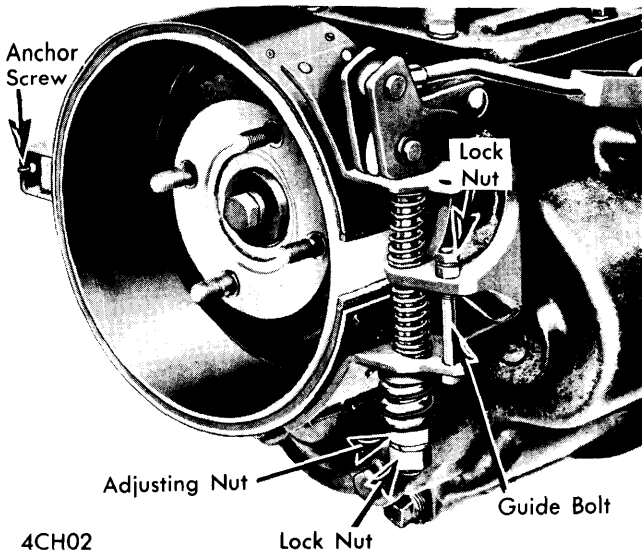
— 1) **NOTE** — One vehicle with parking brake controlled by hand lever mounted under instrument panel, adjust clevis on pull rod extending downward from lever to obtain clearance of $1\frac{1}{16}$ " between end of rod and centerline of clevis hole. Place hand brake lever in fully released position and disconnect brake pull rod from operating cams by removing cotter pin and clevis pin.

2) Set brake cam rest flat on upper band bracket and loosen adjusting nuts. Remove lock wire from anchor screw and adjust anchor screw to obtain clearance of .010-.015" between lining and drum at anchor screw. Tighten guide bolt until there is .020" clearance between drum and lower end of brake band. Tighten guide bolt lock nut.



AUTOMATIC ADJUSTER BRAKE ASSEMBLY

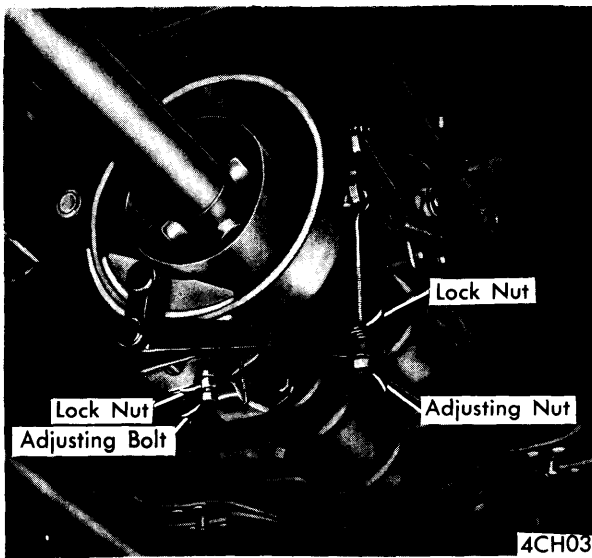
GENERAL MOTORS SINGLE ANCHOR (Cont.)



CONTRACTING BAND PARKING BRAKE ASSEMBLY

3) Tighten adjusting nut until there is .020" clearance between drum and upper end of brake band. Tighten lock nut. Adjust brake pull rod so that clevis pin can be installed in cams with cams resting flat on upper brake band bracket. Install clevis pin and cotter pin, then tighten pull rod lock nut. Install new lock wire in anchor screw and recheck clearances.

Transmission Mounted (Internal Shoe Type) – With hand brake lever fully released, loosen adjusting bolt lock nut. Turn adjusting bolt to obtain .010-.015" clearance between drum and outer shoe at a point directly above adjusting bolt. Tighten lock nut. Loosen adjusting nut lock nut and turn adjusting nut until clearance between drum and inner shoe is .010-.015". Tighten lock nut. Recheck clearances.



INTERNAL SHOE PARKING BRAKE ASSEMBLY

BLEEDING SYSTEM

See Hydraulic Brake Bleeding in this Section.

REMOVAL & INSTALLATION

BRAKE SHOES

Removal – With vehicle raised off floor, loosen lock nut(s) at forward end of parking brake cable and remove brake drum. Remove brake shoe return springs and actuating link from anchor pin. Remove actuator return spring. Remove hold down springs and pins from shoes, and remove actuator assembly. *NOTE* – It is not recommended that actuator assemblies be disassembled unless parts are broken. Remove adjusting screw and spring, separate shoes, and remove parking brake lever from secondary shoe.

Installation – To install, reverse removal procedure, making sure all parts are clean and free of burrs, adjusting screw is properly lubricated, and contact points on support plate are lightly lubricated with high temperature grease. Adjust brakes.

WHEEL CYLINDER

Removal & Installation – Remove wheel, drum and brake shoes. Remove cylinder connecting links and disconnect hydraulic brake line from cylinder. Remove brake cylinder retaining bolts and remove cylinder from support plate. To install, reverse removal procedure.

OVERHAUL

WHEEL CYLINDER

Disassembly – Remove rubber boots from ends of cylinder. Remove piston return spring, cylinder cups, and pistons from cylinder. Remove bleeder screw and inspect bore for damage.

Reassembly – If bore of cylinder is lightly pitted or scratched, hone or replace as necessary. Soak rubber cylinder cups in suitable brake fluid or assembly lubricant and reverse disassembly procedure. *NOTE* – It is not necessary to clamp cylinder ends, as lips of wheel cylinder boots will retain pistons.

TIGHTENING SPECIFICATIONS

Application	Fr. Lbs.
Brake Hose Attaching Nut	18
Parking Brake Cable Nut.....	20
Equalizer Nut.....	18
Rear Brake Anchor Pin.....	140
Application	Inch Lbs.
Brake Line Nut.....	150
Support Plate Attaching Bolts	140
Wheel Cylinder Attaching Bolts	50
Brake Line Clips.....	150

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GENERAL MOTORS SINGLE ANCHOR (Cont.)

1965 BRAKE SYSTEM SPECIFICATIONS				
Application	Drum Diam.	Wheel Cylinder Diameter		Master Cylinder
		Front	Rear	Diameter
Chevrolet				
C, K10	11"	1 1/8"	1"	1"
G10	9 1/2"	1 1/16"	7/8"	1"
P10	11"	1 1/8"	13/16"	1"
C20	11 1/8"	1 1/8"	1 1/8"	1"
K20	12"	1 1/8"	1 1/8"	1"
P20	11 1/8"	1 3/16"	1"	1"
C30	① 11 1/8"	1 1/8"	1 1/4"	② 1 1/8"
P30	① 12"	1 1/8"	1 1/4"	1"
GMC				
C, K1000	11"	1 1/8"	1"	1"
P1000	11"	1 1/8"	13/16"	1"
C1500	11 1/8"	1 1/8"	1 1/8"	1"
K1500	12"	1 1/8"	1 1/8"	1"
P1500	11 1/8"	1 3/16"	1"	1"
C2500	① 11 1/8"	1 1/8"	1 1/4"	1 1/8"
P2500	① 12"	1 1/8"	1 1/4"	1"

① — Rear brake drum diameter is 13".

② — If equipped with power brakes, bore diameter is 1".

1966 BRAKE SYSTEM SPECIFICATIONS				
Application	Drum Diam.	Wheel Cylinder Diameter		Master Cylinder
		Front	Rear	Diameter
Chevrolet				
C, K10	11"	1 1/8"	1"	1"
G10	9 1/2"	1 1/8"	1"	1"
P10	11"	1 1/8"	13/16"	1"
C20	11 1/8"	1 1/8"	1 1/8"	1"
K20	12"	1 1/8"	1 1/8"	1"
P20	11 1/8"	1 13/16"	1"	1"
C30	① 11 1/8"	1 1/8"	1 1/4"	② 1 1/8"
P30	① 12"	1 1/8"	1 1/4"	1"
GMC				
C, K1000	11"	1 1/8"	1"	1"
P1000	11"	1 1/8"	13/16"	1"
C1500	11 1/8"	1 1/8"	1 1/8"	1"
K1500	12"	1 1/8"	1 1/8"	1"
P1500	11 1/8"	1 3/16"	1"	1"
C2500	① 11 1/8"	1 1/8"	1 1/4"	1 1/8"
P2500	① 12"	1 1/8"	1 1/4"	1"

① — Rear brake drum diameter is 13".

② — If equipped with power brakes, bore diameter is 1".

Brake Systems

GENERAL MOTORS SINGLE ANCHOR (Cont.)

1967 BRAKE SYSTEM SPECIFICATIONS				
Application	Drum Diam.	Wheel Cylinder Diameter		Master Cylinder
		Front	Rear	Diameter
Chevrolet				
C, K10	11"	1 1/8"	1"	1"
G10	9 1/2"	1 1/8"	1"	1"
P10	11"	1 1/8"	1 3/16"	1"
C20	11 1/8"	1 1/8"	1 1/8"	1"
G20	11"	1 1/8"	1"	1 1/8"
K20	12"	1 1/8"	1 1/8"	1"
P20	11 1/8"	1 3/16"	1"	1"
C30	⓪ 11 1/8"	1 1/8"	1 1/4"	1 1/8"
P30	⓪ 12"	1 1/8"	1 1/4"	1"
GMC				
C, K1500	11"	1 1/8"	1"	1"
G1500	9 1/2"	1 1/8"	1"	1"
P1500	11"	1 1/8"	1 3/16"	1"
C2500	11 1/8"	1 1/8"	1 1/8"	1"
G2500	11"	1 1/8"	1"	1 1/8"
K2500	12"	1 1/8"	1 1/8"	1"
P2500	11 1/8"	1 3/16"	1"	1"
C3500	⓪ 11 1/8"	1 1/8"	1 1/4"	1 1/8"
P3500	⓪ 12"	1 1/8"	1 1/4"	1"

⓪ — Rear brake drum diameter is 13"

1968 BRAKE SYSTEM SPECIFICATIONS				
Application	Drum Diam.	Wheel Cylinder Diameter		Master Cylinder
		Front	Rear	Diameter
Chevrolet				
C, K10	11"	1 1/8"	1"	1"
G10	9 1/2"	1 1/8"	1"	1"
P10	11"	1 1/8"	1 3/16"	1"
C20	11 1/8"	1 1/8"	1 1/8"	1"
G20	11"	1 1/8"	1"	1 1/8"
K20	12"	1 1/8"	1 1/8"	1"
P20	11 1/8"	1 3/16"	1"	1"
C30	⓪ 11 1/8"	1 1/8"	1 1/4"	1 1/8"
P30	⓪ 12"	1 1/8"	1 1/4"	1"
GMC				
C, K1500	11"	1 1/8"	1"	1"
G1500	9 1/2"	1 1/8"	1"	1"
P1500	11"	1 1/8"	1 3/16"	1"
C2500	11 1/8"	1 1/8"	1 1/8"	1"
G2500	11"	1 1/8"	1"	1 1/8"
K2500	12"	1 1/8"	1 1/8"	1"
P2500	11 1/8"	1 3/16"	1"	1"
C3500	⓪ 11 1/8"	1 1/8"	1 1/4"	1 1/8"
P3500	⓪ 12"	1 1/8"	1 1/4"	1"

⓪ — Rear brake drum diameter is 13"

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GENERAL MOTORS SINGLE ANCHOR (Cont.)

1969 BRAKE SYSTEM SPECIFICATIONS				
Application	Drum Diam.	Wheel Cylinder Diameter		Master Cylinder Diameter
		Front	Rear	
Chevrolet				
C, K10	11"	1 1/8"	1"	1"
G10	9 1/2"	1 1/8"	1"	1"
P10	11"	1 1/8"	1 3/16"	1"
C20	11 1/8"	1 1/8"	1 1/8"	1"
G20	11"	1 1/8"	1"	1 1/8"
K20	12"	1 1/8"	1 1/8"	1"
P20	11 1/8"	1 3/16"	1"	1"
C30	⓪ 11 1/8"	1 1/8"	1 1/4"	1 1/8"
P30	⓪ 12"	1 1/8"	1 1/4"	1"
GMC				
C, K1500	11"	1 1/8"	1"	1"
G1500	9 1/2"	1 1/8"	1"	1"
P1500	11"	1 1/8"	1 3/16"	1"
C2500	11 1/8"	1 1/8"	1 1/8"	1"
G2500	11"	1 1/8"	1"	1 1/8"
K2500	12"	1 1/8"	1 1/8"	1"
P2500	11 1/8"	1 3/16"	1"	1"
C3500	⓪ 11 1/8"	1 1/8"	1 1/4"	1 1/8"
P3500	⓪ 12"	1 1/8"	1 1/4"	1"

⓪ — Rear brake drum diameter is 13".

1970 BRAKE SYSTEM SPECIFICATIONS				
Application	Drum Diam.	Wheel Cylinder Diameter		Master Cylinder Diameter
		Front	Rear	
Chevrolet				
C, K10	11"	1 1/8"	1"	1"
G10	9 1/2"	1 1/8"	1"	1"
P10	11"	1 1/8"	1 3/16"	1"
C20	11 1/8"	1 1/8"	1 1/8"	1"
G20	11"	1 1/8"	1"	1 1/8"
K20	12"	1 1/8"	1 1/8"	1"
P20	11 1/8"	1 3/16"	1"	1"
C30	⓪ 11 1/8"	1 1/8"	1 1/4"	1 1/8"
G30	⓪ 11 1/8"	1 1/8"	1"	1 1/8"
P30	⓪ 12"	1 1/8"	1 1/4"	1"
GMC				
C, K1500	11"	1 1/8"	1"	1"
G1500	9 1/2"	1 1/8"	1"	1"
P1500	11"	1 1/8"	1 3/16"	1"
C2500	11 1/8"	1 1/8"	1 1/8"	1"
G2500	11"	1 1/8"	1"	1 1/8"
K2500	12"	1 1/8"	1 1/8"	1"
P2500	11 1/8"	1 3/16"	1"	1"
C3500	⓪ 11 1/8"	1 1/8"	1 1/4"	1 1/8"
G3500	⓪ 11 1/8"	1 1/8"	1"	1 1/8"
P3500	⓪ 12"	1 1/8"	1 1/4"	1"

⓪ — Rear brake drum diameter is 13"

Brake Systems

GENERAL MOTORS SINGLE ANCHOR (Cont.)

1971 BRAKE SYSTEM SPECIFICATIONS				
Application	Drum Diam.	Wheel Cylinder Diameter		Master Cylinder Diameter
		Front	Rear	
Chevrolet				
C, K, P10	11"	①	1"	1 1/8"
G10	9 1/2"	①	② 7/8"	1 1/8"
C20	11 1/8"	①	1 1/8"	1 1/8"
K20	12"	①	1 1/8"	1 1/8"
P20	11 1/8"	①	1"	1 1/8"
G20	11"	①	1"	1 1/8"
C30	13"	①	1 1/8"	1 1/8"
G30	13"	①	1"	1 1/8"
P30	③ 12"	1 1/8"	1 1/8"	1 1/8"
GMC				
C, K, P1500	11"	①	1"	1 1/8"
G1500	9 1/2"	①	② 7/8"	1 1/8"
C2500	11 1/8"	①	1 1/8"	1 1/8"
G2500	11"	①	1"	1 1/8"
K2500	12"	①	1 1/8"	1 1/8"
P2500	11 1/8"	①	1"	1 1/8"
C3500	13"	①	1 1/8"	1 1/8"
G3500	13"	①	1"	1 1/8"
P3500	③ 12"	1 1/8"	1 1/8"	1 1/8"

- ① — Front disc brakes are standard equipment.
- ② — Diameter is 1" on vehicle equipped with 3000 lb. axle.
- ③ — Rear brake drum diameter is 13".

1972 BRAKE SYSTEM SPECIFICATIONS				
Application	Drum Diam.	Wheel Cylinder Diameter		Master Cylinder Diameter
		Front	Rear	
Chevrolet				
C, K, P10	11"	①	1"	1 1/8"
G10	9 1/2"	①	② 7/8"	1 1/8"
C20	11 1/8"	①	1 1/8"	1 1/8"
K20	12"	①	1 1/8"	1 1/8"
P20	11 1/8"	①	1"	1 1/8"
G20	11"	①	1"	1 1/8"
C30	13"	①	1 1/8"	1 1/8"
G30	13"	①	1"	1 1/8"
P30	13"	①	1 1/8"	1 1/8"
GMC				
C, K, P1500	11"	①	1"	1 1/8"
G1500	9 1/2"	①	② 7/8"	1 1/8"
C2500	11 1/8"	①	1 1/8"	1 1/8"
G2500	11"	①	1"	1 1/8"
K2500	12"	①	1 1/8"	1 1/8"
P2500	11 1/8"	①	1"	1 1/8"
C3500	13"	①	1 1/8"	1 1/8"
G3500	13"	①	1"	1 1/8"
P3500	13"	①	1 1/8"	1 1/8"

- ① — Front disc brakes are standard equipment.
- ② — Diameter is 1" on vehicle equipped with 3000 lb. axle.

Brake Systems

GENERAL MOTORS SINGLE ANCHOR (Cont.)

1973 BRAKE SYSTEM SPECIFICATIONS				
Application	Drum Diam.	Wheel Cylinder Diameter		Master Cylinder Diameter
		Front	Rear	
Chevrolet				
C, K, P10	11"	⊙	1"	1 1/8"
G10	9 1/2"	⊙	1"	1 1/8"
C20	11 1/8"	⊙	1 1/8"	1 1/8"
G20	11"	⊙	1"	1 1/8"
K20	12"	⊙	1 1/8"	1 1/8"
P20	11 1/8"	⊙	1"	1 1/8"
C, P30 ^②	13"	⊙	1 1/8"	1 1/8"
G30	13"	⊙	1"	1 1/8"
GMC				
C, K, P1500	11"	⊙	1"	1 1/8"
G1500	9 1/2"	⊙	1"	1 1/8"
C2500	11 1/8"	⊙	1 1/8"	1 1/8"
G2500	11"	⊙	1"	1 1/8"
K2500	12"	⊙	1 1/8"	1 1/8"
P2500	11 1/8"	⊙	1"	1 1/8"
C, P3500 ^②	13"	⊙	1 1/8"	1 1/8"
G3500	13"	⊙	1"	1 1/8"

⊙ — Front disc brakes are standard equipment.

② — Except vehicles with 11,000 lb. rear axle. Vehicles with 11,000 lb. rear axle use front disc brakes and dual cylinder rear brakes.

1974 BRAKE SYSTEM SPECIFICATIONS				
Application	Drum Diam.	Wheel Cylinder Diameter		Master Cylinder Diameter
		Front	Rear	
Chevrolet				
C, K, P10	11"	⊙	1"	1 1/8"
G10	9 1/2"	⊙	1"	1 1/8"
C20	11 1/8"	⊙	1 1/8"	1 1/8"
G20	11"	⊙	1"	1 1/8"
K20	12"	⊙	1 1/8"	1 1/8"
P20	11 1/8"	⊙	1"	1 1/8"
C, P30 ^②	13"	⊙	1 1/8"	1 1/8"
G30	13"	⊙	1"	1 1/8"
GMC				
C, K, P1500	11"	⊙	1"	1 1/8"
G1500	9 1/2"	⊙	1"	1 1/8"
C2500	11 1/8"	⊙	1 1/8"	1 1/8"
G2500	11"	⊙	1"	1 1/8"
K2500	12"	⊙	1 1/8"	1 1/8"
P2500	11 1/8"	⊙	1"	1 1/8"
C, P3500 ^②	13"	⊙	1 1/8"	1 1/8"
G3500	13"	⊙	1"	1 1/8"

⊙ — Front disc brakes are standard equipment.

② — Except vehicles with 11,000 lb. rear axle. Vehicles with 11,000 lb. rear axle use front disc brakes and dual cylinder rear brakes.