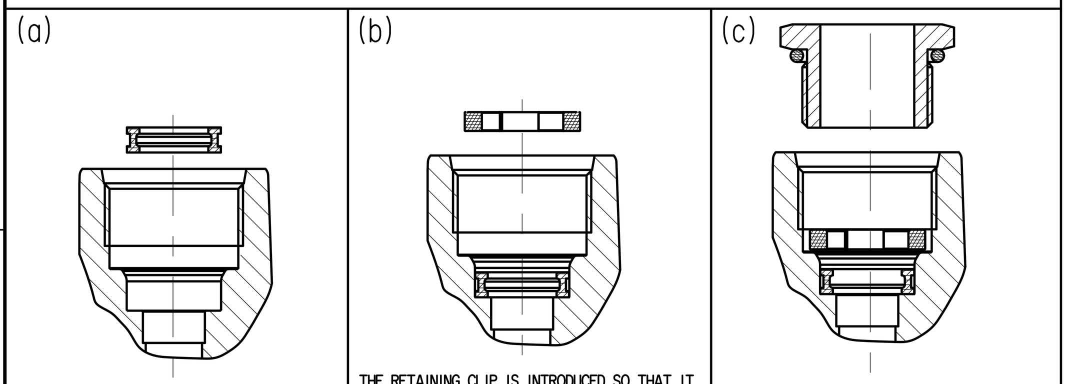
ASSEMBLY PROCEDURE FOR VOSS ASSEMBLY

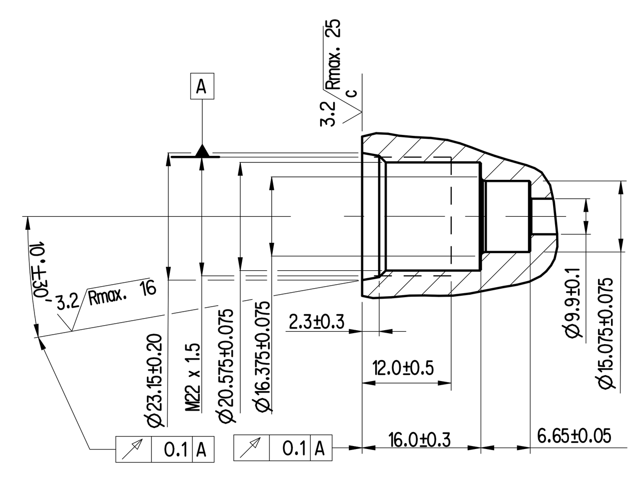


THE SPRING ELEMENT IS INSERTED INTO THE CHAMBER UNDER THE THREAD ROOT OF THE CONNECTION BORE (a) AND (b).

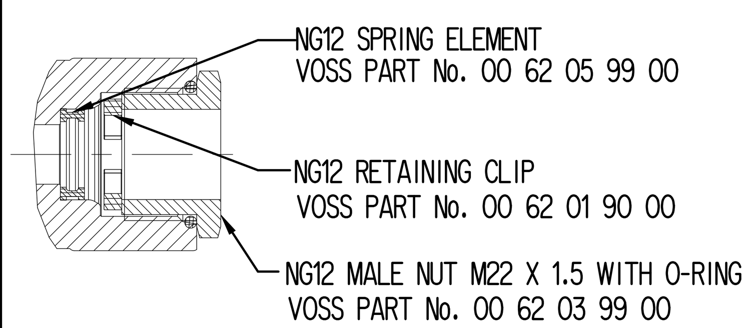
THE RETAINING CLIP IS INTRODUCED SO THAT IT RESTS FLAT ON THE THREAD ROOT (b) AND (c).

THE SPRING ELEMENT AND RETAINING CLIP ARE SYMMETRICAL.

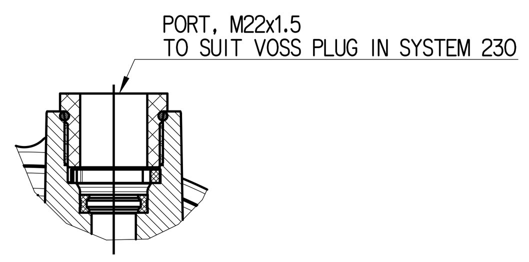
THE MALE FITTING PRE-ASSEMBLED WITH THE PRE-GREASED O-RING TO SEAL THE THREAD IS SCREWED BY HAND INTO THE TAPPED BORE (c) AND TIGHTENED.



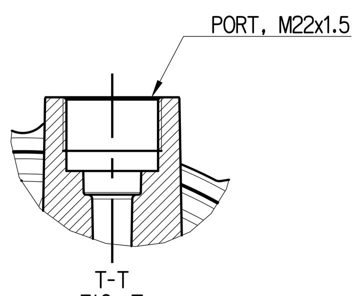
DETAILS OF PORT MACHINING FOR M22x1.5



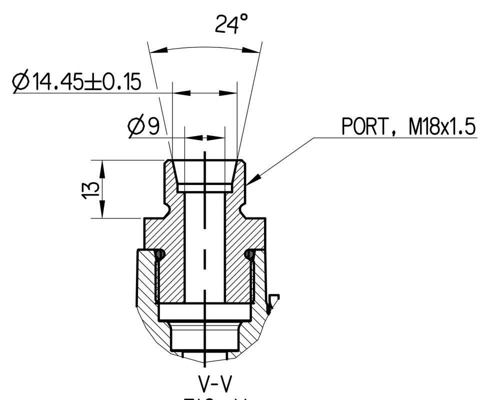
ASSEMBLY PART No.	PORT 11 DETAILS	PORT 12 DETAILS	LH/RH LABEL (8)	DIM X (9)	SLEEVE (10)	MASS (Kg)
925 490 004 0	FIG. V	FIG. U	NA	72	NA	8.11
925 490 007 0	FIG. U	FIG. U	NA	72	NA	8.11
925 490 017 0	FIG. V	FIG. V	LH	72	NA	8.11
925 490 024 0	FIG. V	FIG. V	RH	72	NA	8.11
925 490 160 0	FIG. T	FIG. V	NA	72	NA	7.91
925 490 047 0	FIG. V	FIG. V	LH	72	NA	8.11
925 490 048 0	FIG. V	FIG. V	RH	72	NA	8.11
925 490 073 0	FIG. U	FIG. U	NA	300	FIG. W	8.36



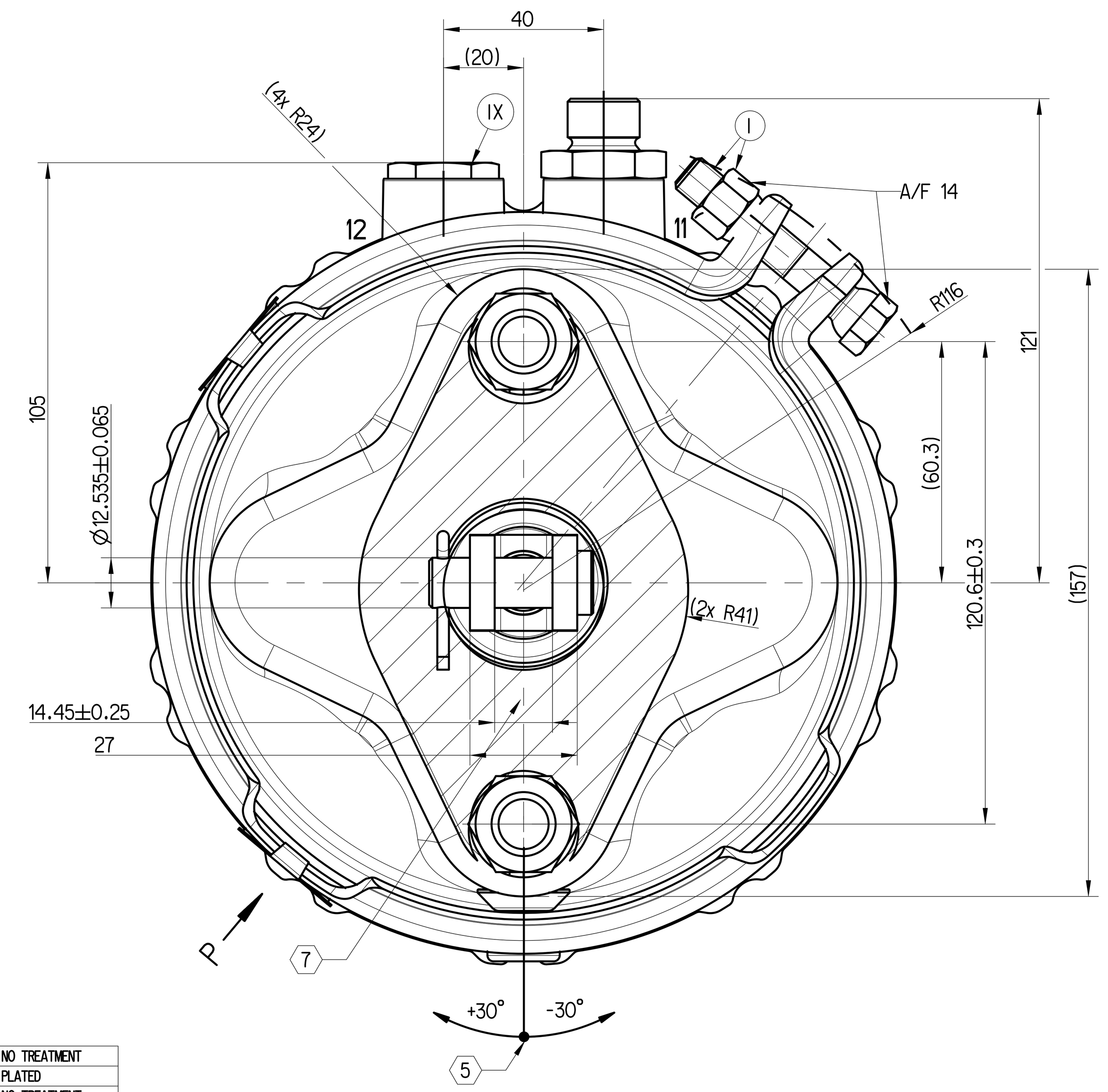
U-U
FIG. U

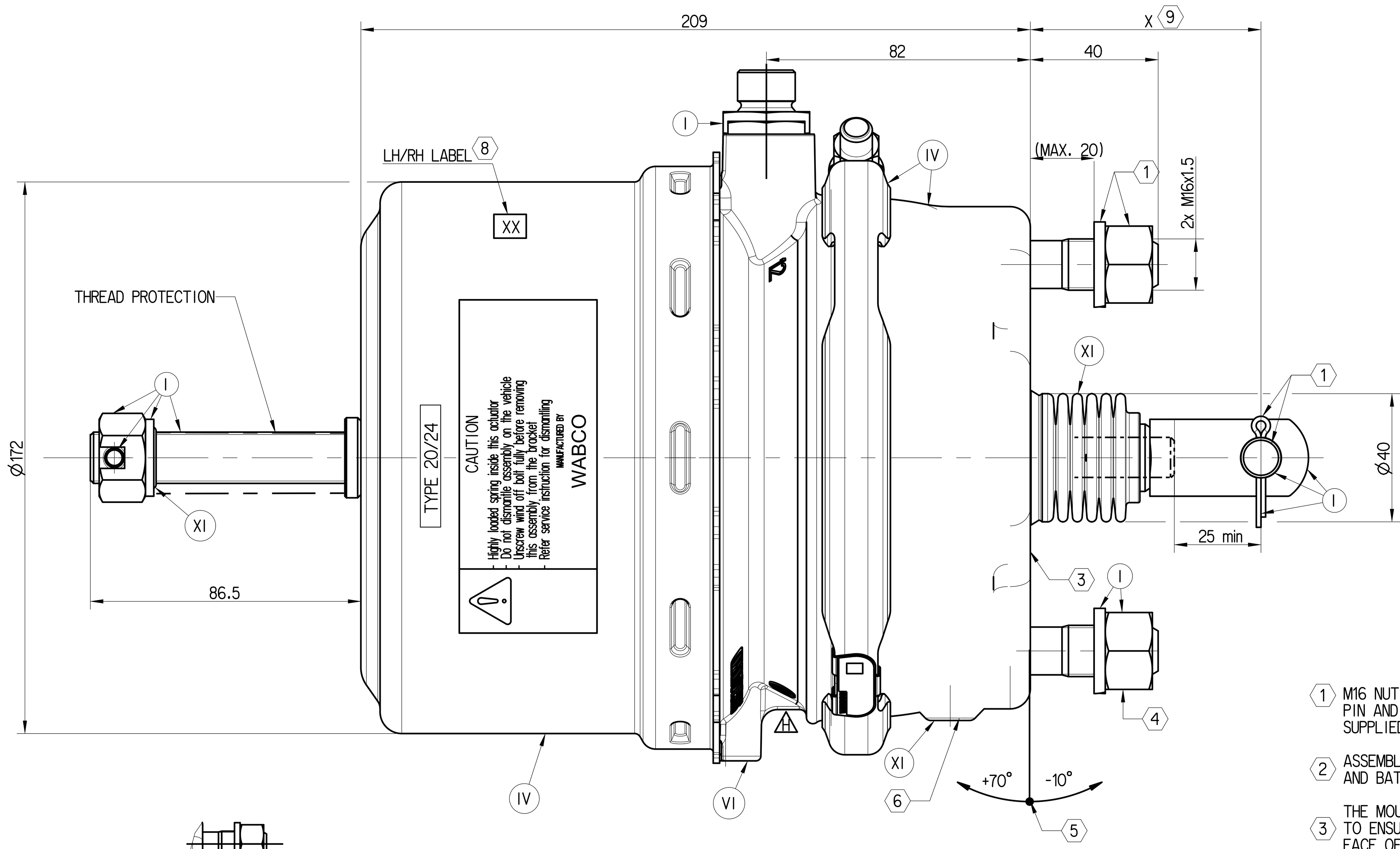


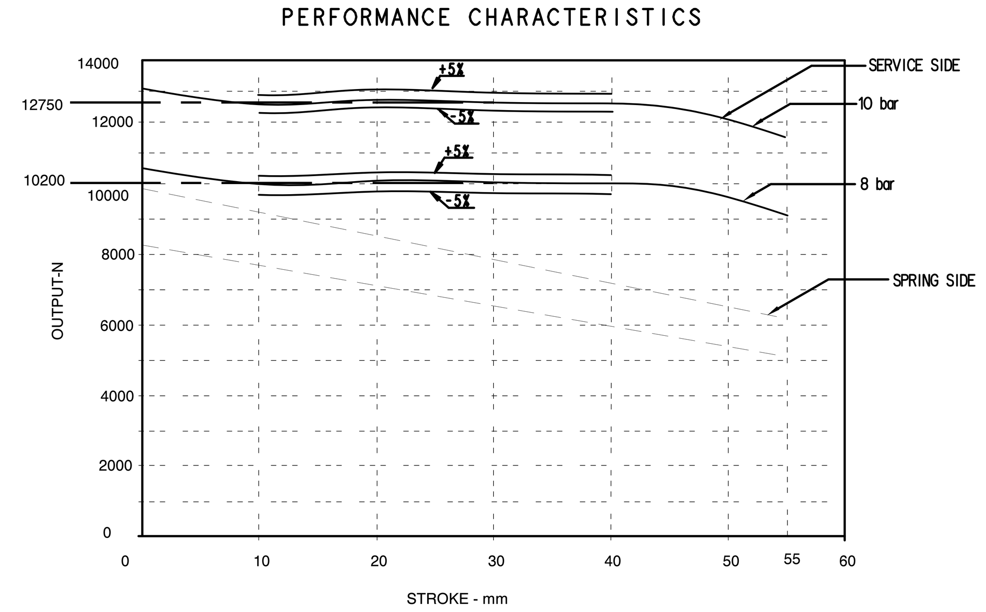
T-T
FIG. T



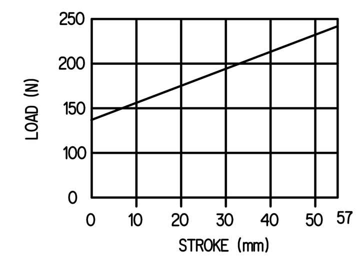
V-V
FIG. V

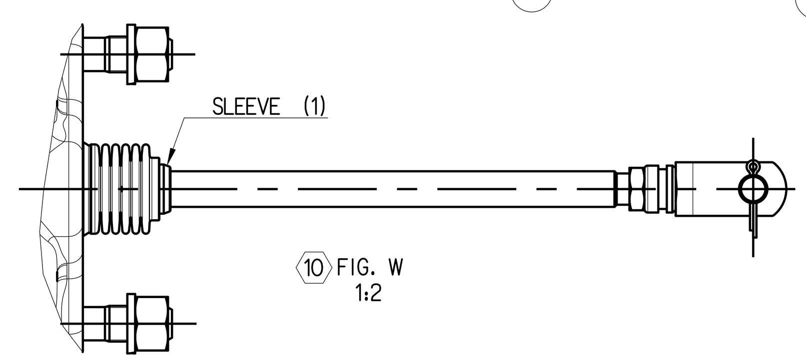




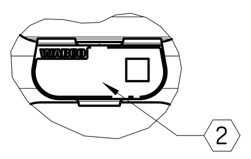


TOLERANCE BAND - ±5% FOR STROKE - 10 mm TO 40 mm





(10) FIG. W
1:2

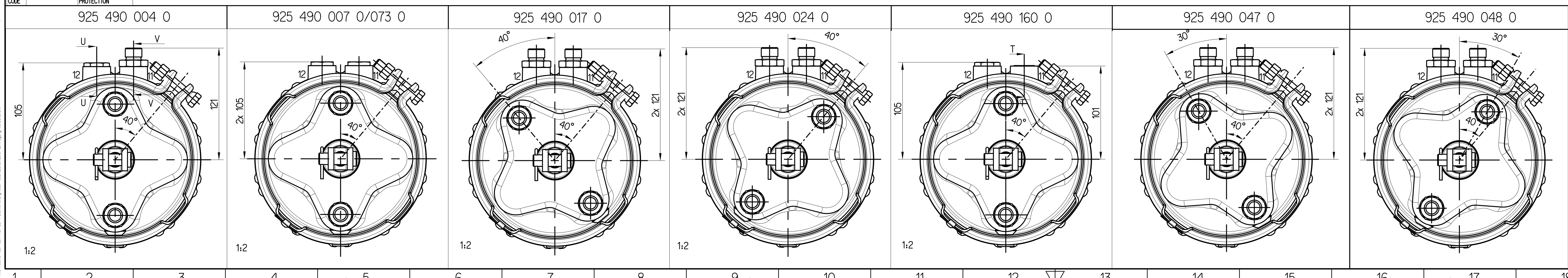


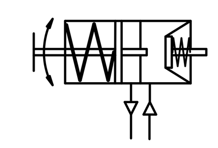
P

1. M16 NUT, SPRING WASHER - 2 OFF EACH PIN AND SPLIT PIN - 1 OFF EACH ARE SUPPLIED AS LOOSE PARTS
2. ASSEMBLY PART No. CUSTOMER PART No. AND BATCH No. TO BE SHOWN HERE
3. THE MOUNTING BRACKET SHOULD BE FLAT TO ENSURE FULL CONTACT WITH MOUNTING FACE OF ASSEMBLY
4. A/F 24
5. RECOMMENDED INSTALLATION POSITION
6. TO BE INSTALLED WITH CHECK VALVE AT THE BOTTOM
7. RECOMMENDED CONTACT AREA FOR MOUNTING BRACKET

SL.No.	NOTES	
1	PRODUCT FUNCTION AND RELIABILITY	
1.1	WORKING MEDIUM	AIR
1.2	NORMAL WORKING PRESSURE	10 bar
1.3	MAXIMUM WORKING PRESSURE (TEMPORARILY)	13 bar
1.4	SERVICE SIDE STROKE	57 mm min.
1.5	SPRING SIDE STROKE	57 mm min.
1.6	PRESSURE AT WHICH PUSH ROD STARTS MOVING	<0.3 bar (LIFT OFF PRESSURE AT 0 mm STROKE)
1.7	PRESSURE AT WHICH PUSH ROD IS FULLY OUT	<0.5 bar (LIFT OFF PRESSURE AT 57 mm STROKE)
1.8	THERMAL RANGE OF APPLICATION	- 40°C TO +80°C
1.9	INSTALLATION POSITION	AS DRAWN
1.10	CORROSION RESISTANCE	240 HOURS OF NSS.
2	ASSEMBLY WILL BE SUPPLIED WITH SPRING SIDE IN FULLY WOUND OUT CONDITION. SPRING SIDE TO BE WOUND IN AFTER INSTALLATION	
3	OPEN PORTS/MALE THREADS ARE FITTED WITH CLOSURE PLUGS/SLEEVE FOR STORAGE AND TRANSIT PURPOSE	
4	UNIT DRAWN WITH PRESSURE APPLIED AT PORT 12	

PART CODE	MATERIAL	SURFACE PROTECTION
XVII	STEEL	NO TREATMENT
XVI	CAST IRON	PLATED
XV	CAST IRON	NO TREATMENT
XIV	STEEL	ZINC IRON PLATED
XII	ZINC ALLOY	ANODISED
XII	PLASTIC	NO TREATMENT
XI	RUBBER	NO TREATMENT
X	STAINLESS STEEL	NO TREATMENT
IX	BRASS	NO TREATMENT
VIII	ZINC ALLOY	CHROMATED
VII	ALUMINIUM ALLOY	ANODISED
VI	ALUMINIUM ALLOY	CHROMATED
V	CAST IRON	PAINTED
IV	STEEL	POWDER COATED
III	STEEL	PAINTED
II	STEEL	PHOSPHATED
I	STEEL	ZINC PLATED




CIRCUIT DIAGRAM

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General Specification: ISO 8015, JED-334-1, Size ISO 14405 LP						
Further Technical Data:						
Doc. Code:			Sheet: To			
General Tolerances JED-261						
Class 1)		≤ 50	> 50 ≤ 180	> 180 ≤ 400	> 400	∢
Fine		±0.5	±1	±1.5	±2	±3°
Medium	X	±1	±2	±3	±4	
Coarse		±2	±3.5	±5	±6.5	
Tapped Holes acc.						
1) Tolerance Class Applied Crossmarked						

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Date	Signature
Drawn	
2026-05-06	GANESH KUMAR
Checked	
2026-05-06	Arangarasan

Dimensions in mm

SPRING BRAKE ACTUATOR TYPE 20/24

Mass	Scale	Material No.	Date of first issue: 2012-09-20		
REFER TABLE kg	1:1 (1:2)	925 490 004 0	Doc.Code 053	Language EN	Sheet 1/1
Size A 0	CAD System CREO	ECN-No. 520290	Revision 9 H	Techn. Resp. 5380_WIN	Replacement for /

100mm