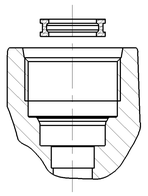
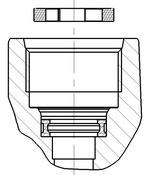
ASSEMBLY PROCEDURE

(a)



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

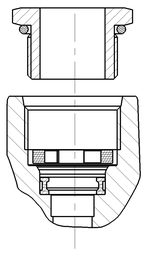
(b)



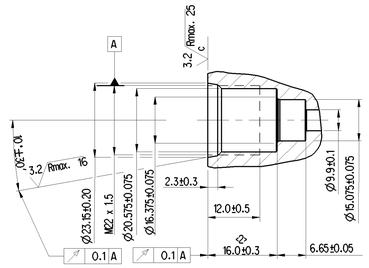
THE RETAINING CLIP IS INTRODUCED SO THAT IT RESTS FLAT ON THE THREAD ROOT (b) AND (c).

THE SPRING ELEMENT AND RETAINING CLIP ARE SYMMETRICAL.

(c)



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.



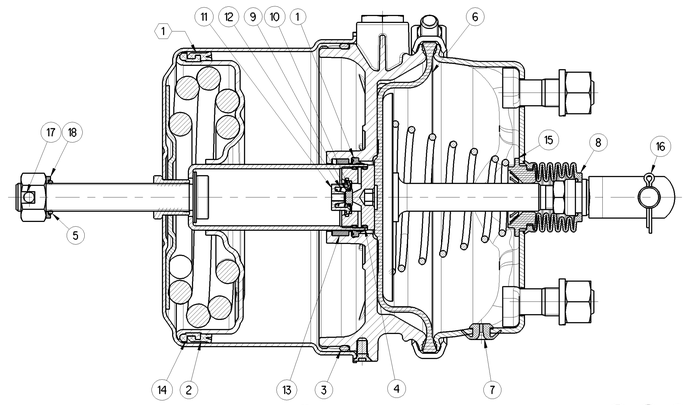
DETAILS OF PORT MACHINING FOR M22x1.5

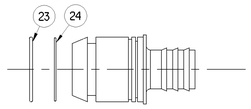
REPAIR KIT MSP 25/118				
S.No.	PART No.	VECV PART No.	DESCRIPTION	QTY
1	8971500834	IC340766	LIP SEAL	1
2	3250190084	IC394208	INTEGRAL SEAL	1
3	8979801034	IC323342	O-RING	1
4	8979801734	IC323339	O-RING	2
5	8979802014	IC340769	O-RING	1
6	M843331	IA237188	DIAPHRAGM	1
7	9254915204	IC306968	CLOSING VALVE	1
8	M275040	IA237191	GAITER	1
9	9254912514	IC323335	DIAPHRAGM	1
10	9254912624	IC323336	RING	1
11	9259051404	IC323338	VALVE SEAT	1
12	M339990	IC323337	SPRING	1
13	M270130	IA206898	BEARING	1
14	3250190074	IC394209	BEARING	1
15	9259216534	IA237198	DUST SHIELD	1
16	8105110274	IC323401	SPLIT PIN	1
17	8920100094	IC323402	KNURL PIN	1
18	8951800034	IC340770	SPECIAL WASHER	1
19	M919910	IC319464	GREASE SACHET	4

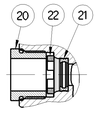
PART No. 8995000074 PROVIDED IN THE KIT TO STANDARDISE THE REPAIR KIT FOR SPRING BRAKE ACTUATOR VARIANTS

REPAIR KIT MSP 3/130 (2 OFF)				
S.No.	PART No.	VECV PART No.	DESCRIPTION	QTY
20	8932204272	IC319112	PRESSURE SCREW	1
21	8953700044	IA236638	SPRING RETAINER	1
22	8952266974	IC319100	RETAINING CLIP	1
23	8979801534	IC323517	O-RING	1
24	8979801464	IC323518	O-RING	1

REPAIR KIT MSP 3/124 (2 OFF)				
S.No.	PART No.	VECV PART No.	DESCRIPTION	QTY
21	8953700044	IA236638	SPRING RETAINER	1
22	8952266974	IC319100	RETAINING CLIP	1
23	8979801534	IC323517	O-RING	1
24	8979801464	IC323518	O-RING	1





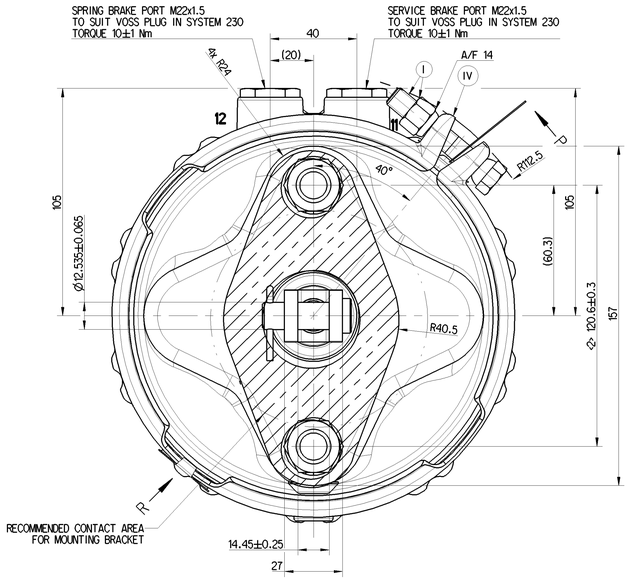


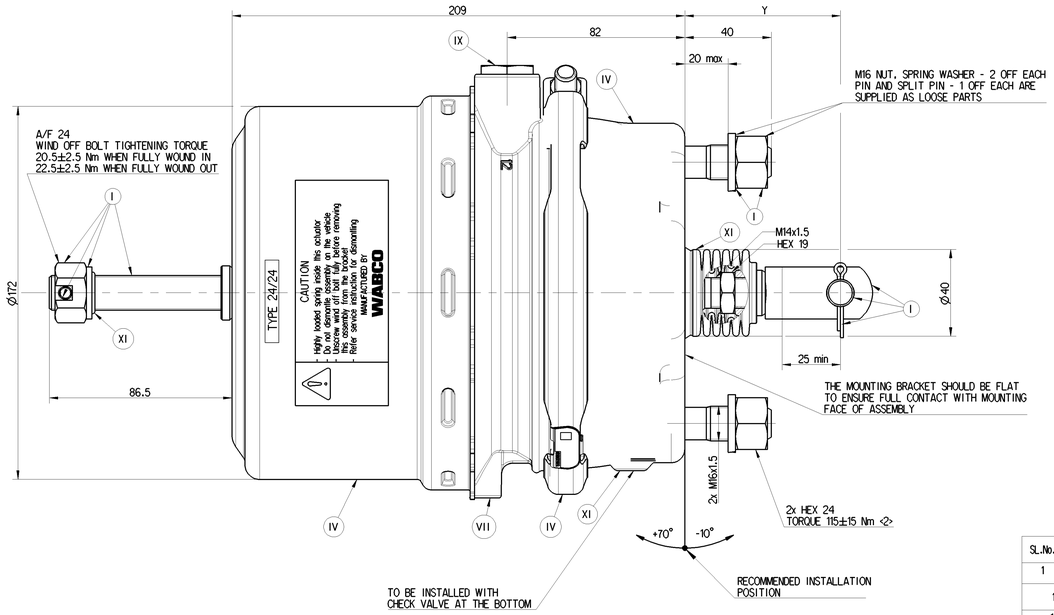
CUSTOMER END DETAIL

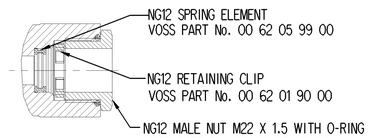
NAME PLATE WITH CUSTOMER LOGO AND CUSTOMER PART No. SHOWN HERE

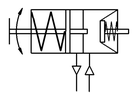
P
1:1

‹1› SAFETY CHARACTERISTICS	0
‹2› SIGNIFICANT CHARACTERISTICS	3



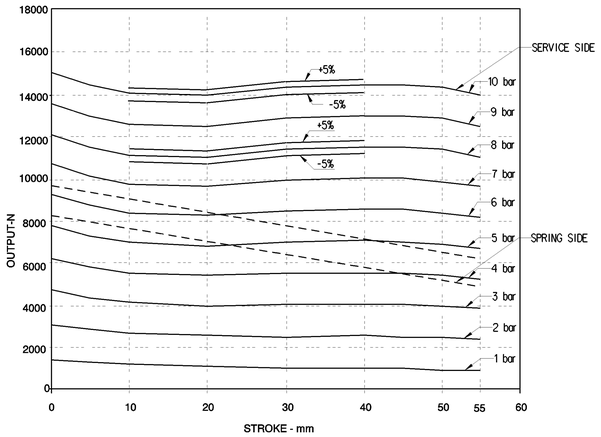






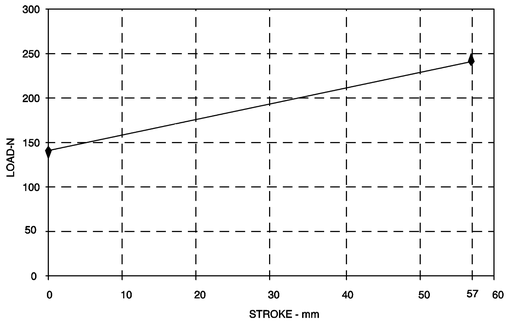
CIRCUIT DIAGRAM

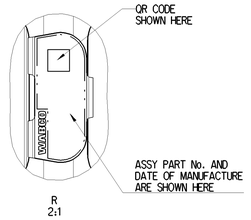
PERFORMANCE CHARACTERISTICS



NOMINAL VALUES GIVEN FOR SERVICE SIDE
TOLERANCE BAND - ±5% FOR STROKE - 10 mm TO 40 mm

RETURN SPRING CHARACTERISTICS





R
2:1

	ASSEMBLY P.No	CUSTOMER P.No.	DIM Y	MASS (kg)
				Ⓒ
	925 491 076 0	IC340932	72	8.43
Ⓒ	925 491 414 0	IC413619	101	8.48

SL.No.	NOTES	
1	PRODUCT FUNCTION AND RELIABILITY	
1.1	PRODUCT SPECIFICATION No.	925 491 017 0
1.2	WORKING MEDIUM	AIR
1.3	NORMAL WORKING PRESSURE	10 bar
1.4	MAXIMUM WORKING PRESSURE (TEMPORARILY)	13 bar
1.5	SERVICE SIDE STROKE	57 mm min.
1.6	SPRING SIDE STROKE	57 mm min.
1.7	INNER DIA OF THE SERVICE CHAMBER	155.85
1.8	INNER DIA OF THE SPRING CHAMBER	168.15
1.9	HOLD OFF PRESSURE	4.3±0.4 bar
1.10	RELEASE PRESSURE	4.7±0.4 bar
1.11	PRESSURE AT WHICH PUSH ROD STARTS MOVING	<0.3 bar (LIFT OFF PRESSURE AT 0 MM STROKE)
1.12	PRESSURE AT WHICH PUSH ROD IS FULLY OUT	<0.5 bar (LIFT OFF PRESSURE AT 57 MM STROKE)
1.13	THERMAL RANGE OF APPLICATION	- 40°C TO +80°C
1.14	INSTALLATION POSITION	AS DRAWN
1.15	CORROSION RESISTANCE	240 HOURS OF NSS.
2	QUALITY COMPLIANCE TESTS WILL BE CARRIED OUT REGULARLY AS PER CLAUSE No.14 OF 925 491 017 0	
3	ASSEMBLY WILL BE SUPPLIED WITH SPRING SIDE IN FULLY WOUND OUT CONDITION. SPRING SIDE TO BE WOUND IN AFTER INSTALLATION	
4 ▲	SERVICE LIFE TO FIRST OVERHAUL IF FITTED AS PER RECOMMENDED LAYOUT 3 YEARS / 300 000 KM WHICHEVER IS EARLIER FOR CITY BUS APPLICATION	
5	OPEN PORTS ARE FITTED WITH CLOSURE PLUGS FOR STORAGE AND TRANSIT PURPOSES	
6	UNIT DRAWN WITH PRESSURE APPLIED AT PORT 12	

(1) SEAL AND BEARING DESIGN CHANGED

▲ KEY INSTRUCTION

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

General Specification: JED-334-1 , Size ISO 14405 LP
Further Technical Data: 925 491 017 0
Doc. Code: 035 | Sheet: 1 To 6

General Tolerances JED-261

Class 1)	Range of Nominal Dimensions (in mm) ≥ 50	> 50 ≥ 180	> 180 ≥ 400	> 400	
Fine	0.5	1.0	1.5	2.0	±3°
Medium X	1.0	2.0	3.0	4.0	
Coarse	2.0	3.5	5.0	6.5	

Tapped Holes acc. JED-152
1) Tolerance Class Applied Crossmarked

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Date	Signature	
Drawn 2019-07-12	Elayaraj S	
Checked 2019-07-12	Senthilkumar	
Project Senthilkumar		

WABCO

SPRING BRAKE ACTUATOR- TYPE 24 / 24

Mass REFER TABLE	Scale 1:1	Material No. 925 491 076 0	Date of first issue. 2013-08-02	Doc.Code 053	Language EN	Sheet 1/1
Size A 0	CAD System CREO					

Drawing No.	Revision	Name Prev.	Replaced by
502036	2 C	5380.WIN	/

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