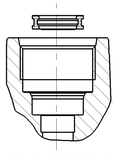
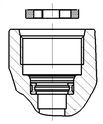
ASSEMBLY PROCEDURE

(a)



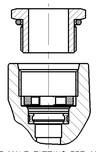
THE SPRING ELEMENT IS INSERTED INTO THE CHAMBER UNDER THE THREAD ROOT OF THE CONNECTION BORE (a) AND (b).

(b)

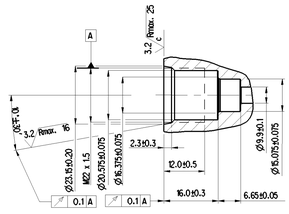


THE RETAINING CLIP IS INTRODUCED SO THAT IT RESTS FLAT ON THE THREAD ROOT (b) AND (c).
THE SPRING ELEMENT AND RETAINING CLIP ARE SYMMETRICAL.

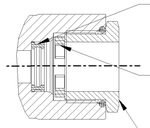
(c)

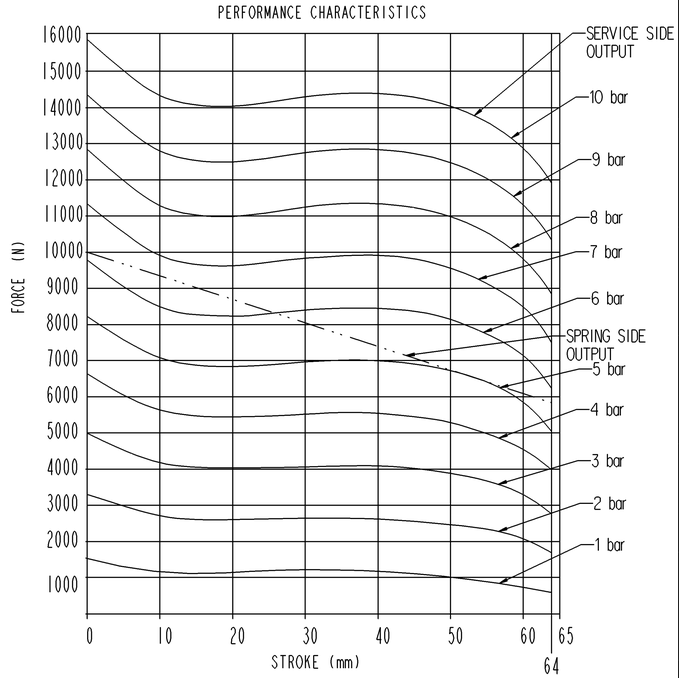


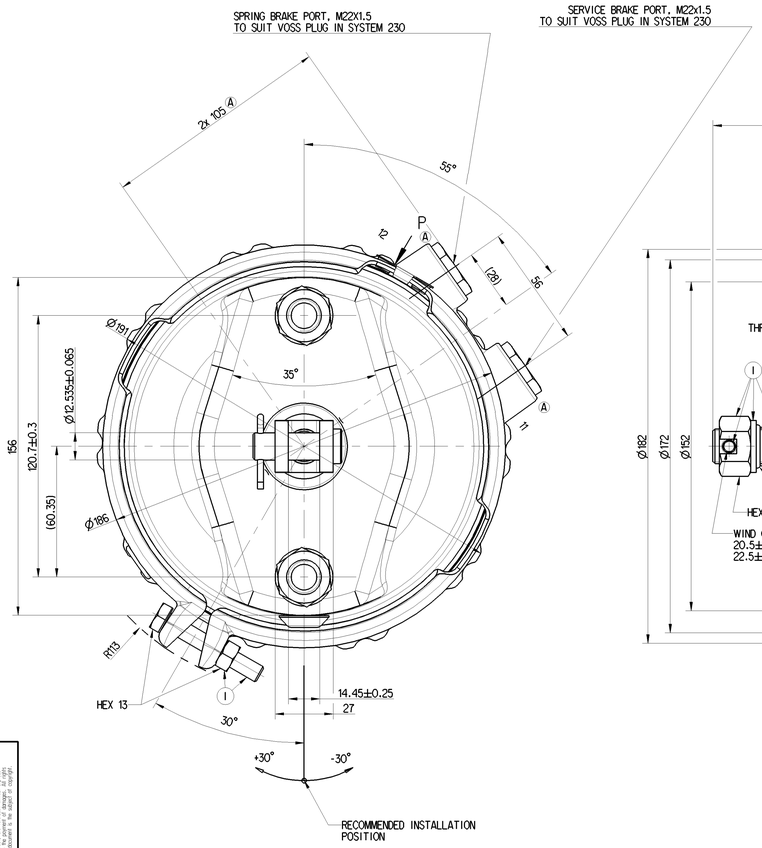
THE MALE FITTING PRE-ASSEMBLED WITH THE PRE-GREASED O-RING TO SEAL THE THREAD IS SCREWED BY HAND INTO THE TAPPED BORE (c) AND TIGHTENED.

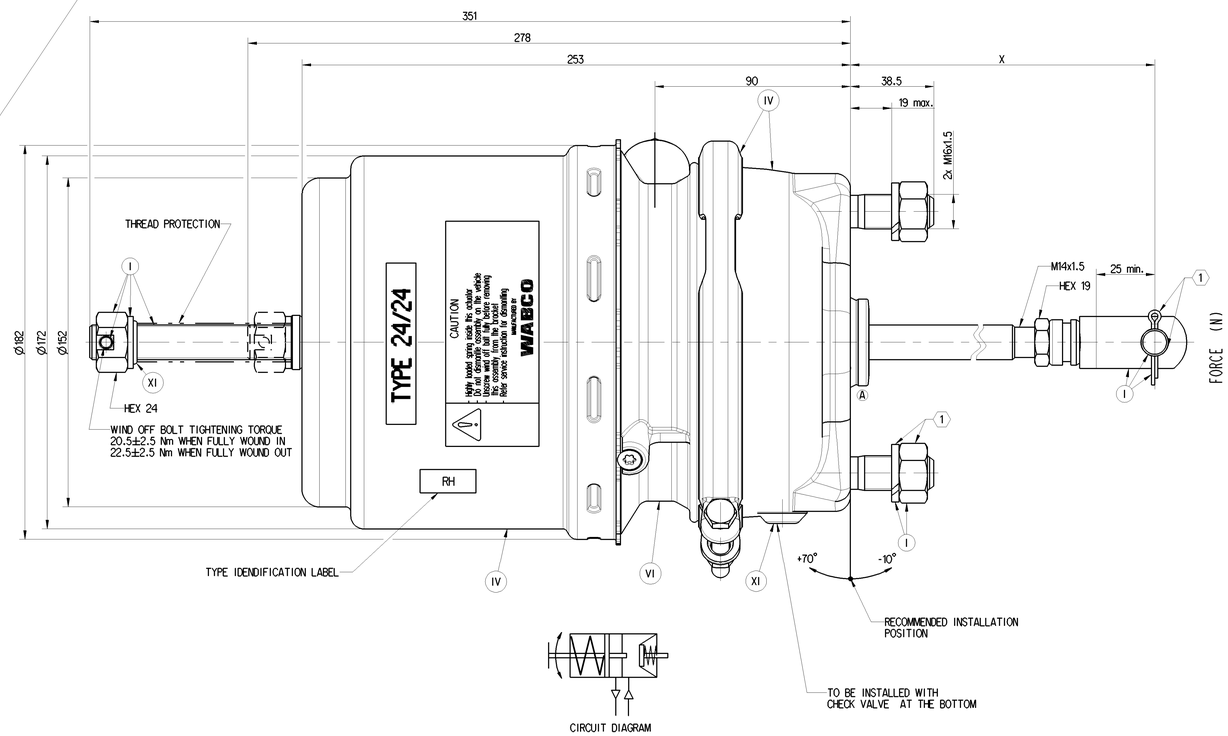


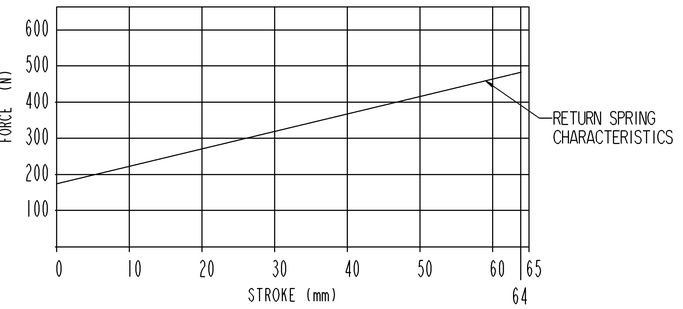
DETAILS OF PORT MACHINING FOR M22x1.5









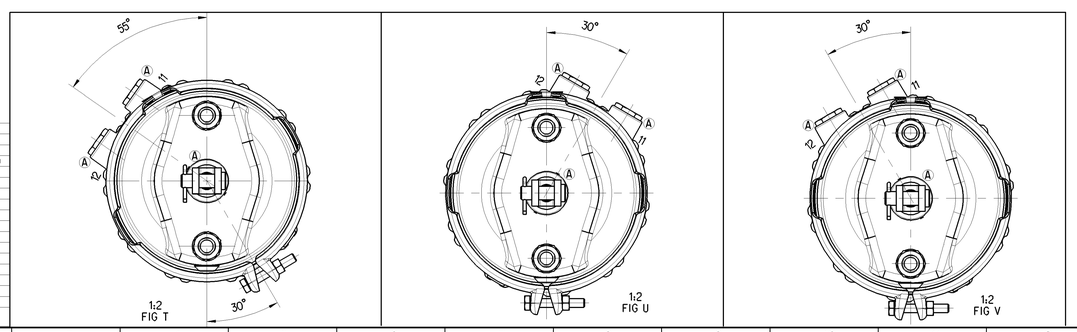


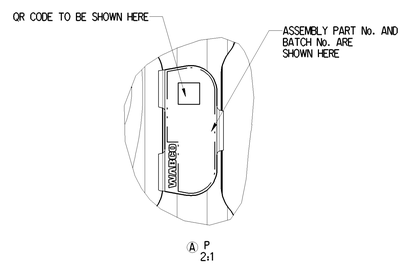
NOMINAL VALUES GIVEN
TOLERANCE BAND- ±5% FROM 1/3rd TO 2/3rd STROKE

CIRCUIT DIAGRAM

ASSEMBLY PART No.	PORT & CLAMP RING ORIENTATION	LH/RH LABEL	STAND OUT 'X'	MASS (kg)
925 491 343 0	BASIC DRAWING	RH	200	~10.22 Ⓐ
925 491 344 0	FIG T	LH	200	~10.22 Ⓐ
925 491 345 0	FIG U	RH	72	~9.93 Ⓐ
925 491 346 0	FIG V	LH	72	~9.93 Ⓐ

1	PRODUCT FUNCTION AND RELIABILITY	
1.1	WORKING MEDIUM	AIR
1.2	PORT 11, SERVICE BRAKE SYSTEM, WORKING PRESSURE	10 bar
1.3	PORT 12, SPRING BRAKE CYLINDER, WORKING PRESSURE	10 bar
1.4	PORT 11, MAXIMUM WORKING PRESSURE(TEMPORARILY)	13 bar
1.5	PORT 12, MAXIMUM WORKING PRESSURE(TEMPORARILY)	13 bar
	UNIT DRAWN WITH PRESSURE APPLIED AT PORT 12	
1.6	SERVICE BRAKE STROKE	64 min
1.7	SPRING BRAKE STROKE	64 min
1.8	THERMAL RANGE OF APPLICATION	-40°C TO +80°C
1.9	PRESSURE AT WHICH PUSH ROD STARTS MOVING (LIFT-OFF PRESSURE AT 0 STROKE)	< 0.3 bar
1.10	PRESSURE AT WHICH PUSH ROD IS FULLY OUT (LIFT-OFF PRESSURE AT 64 STROKE)	< 0.5 bar
2	ASSEMBLY WILL BE SUPPLIED WITH SPRING SIDE IN FULLY WOUND OUT CONDITION SPRING SIDE TO BE WOUND IN AFTER INSTALLATION	





(1) M16 NUT, SPRING WASHER- 2 OFF EACH. PIN AND SPLIT PIN - 1 OFF EACH ARE SUPPLIED IN SEPERATE POUCH

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
XIII	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

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General Specification: JED-334-1 , Size ISO 14405 LP							
Further Technical Data:							
Doc. Code:				Sheet:		To	
General Tolerances JED-261							
		Range of Nominal Dimensions (in mm)					
Class	1)	≥ 50	> 50 ≥ 180	> 180 ≥ 400	> 400		
Fine		0.5	1.0	1.5	2.0		
Medium	X	1.0	2.0	3.0	4.0	±3°	
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 2021-07-19	Protheesh	
Checked 2021-07-20	Senthilkumar	
Expert Senthilkumar		

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SPRING BRAKE ACTUATOR — TYPE 24/24

Mass	Scale	Material No.	Date of first issue	
REFER TABLE	1:1 (2:1,1:2)	925 491 343 0	-	
Size A 0	CAD System CREO		Doc.Code 053	Language EN	Sheet 1/1
CDRefs. 506644	Revision 18 A	Tmfm. Wen. 5380.WIN	Replaced for -	

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