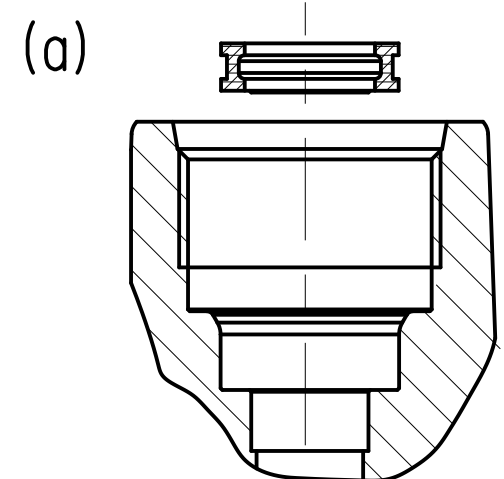
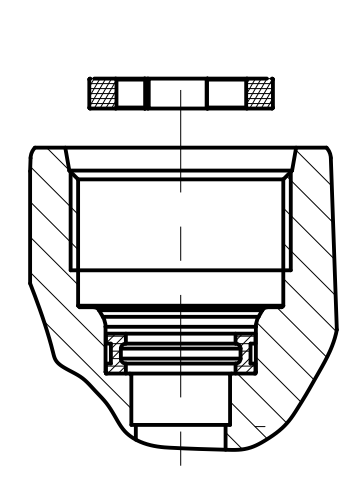


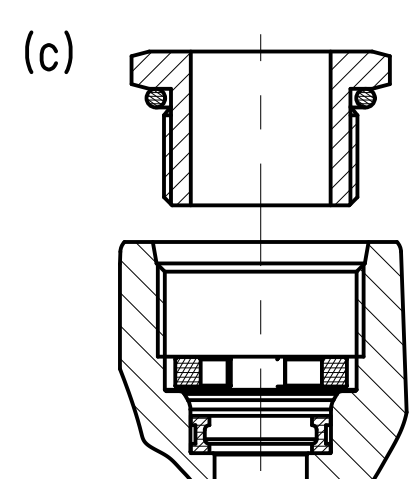
ASSEMBLY PROCEDURE



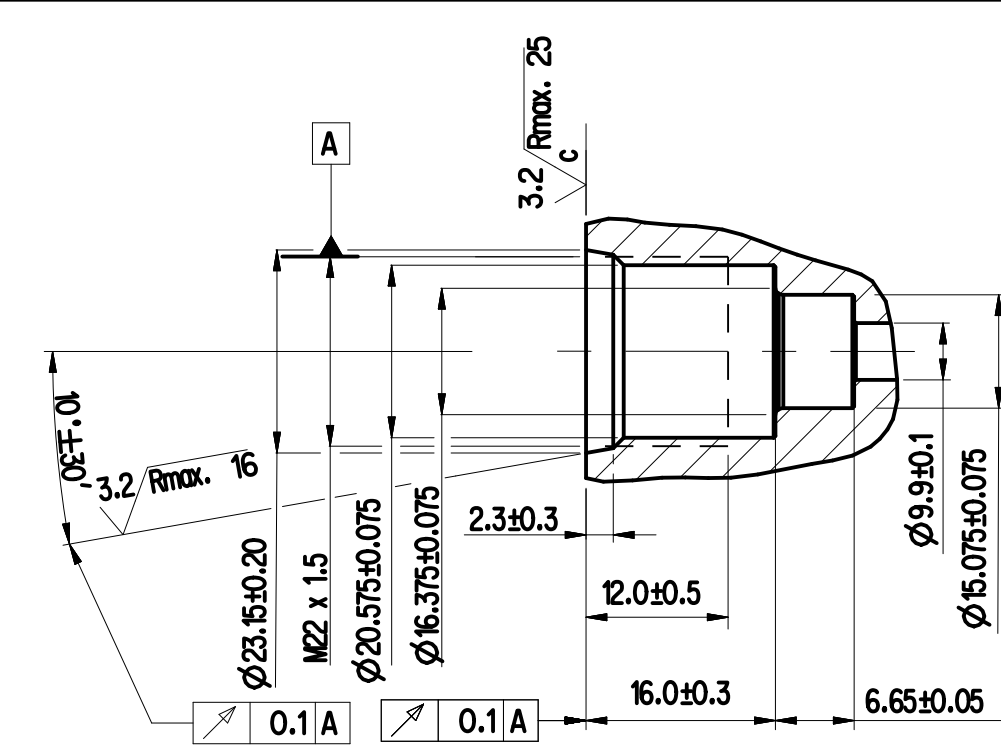
THE SPRING ELEMENT IS INSERTED INTO THE CHAMBER UNDER THE THREAD ROOT OF THE CONNECTION BORE (a) AND (b).



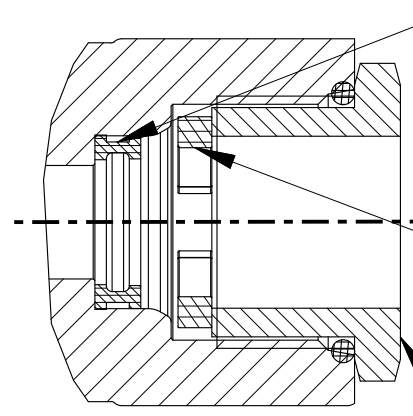
THE RETAINING CLIP IS INTRODUCED SO THAT IT RESTS FLAT ON THE THREAD ROOT (b) AND (c).
THE SPRING ELEMENT AND RETAINING CLIP ARE SYMMETRICAL.



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.



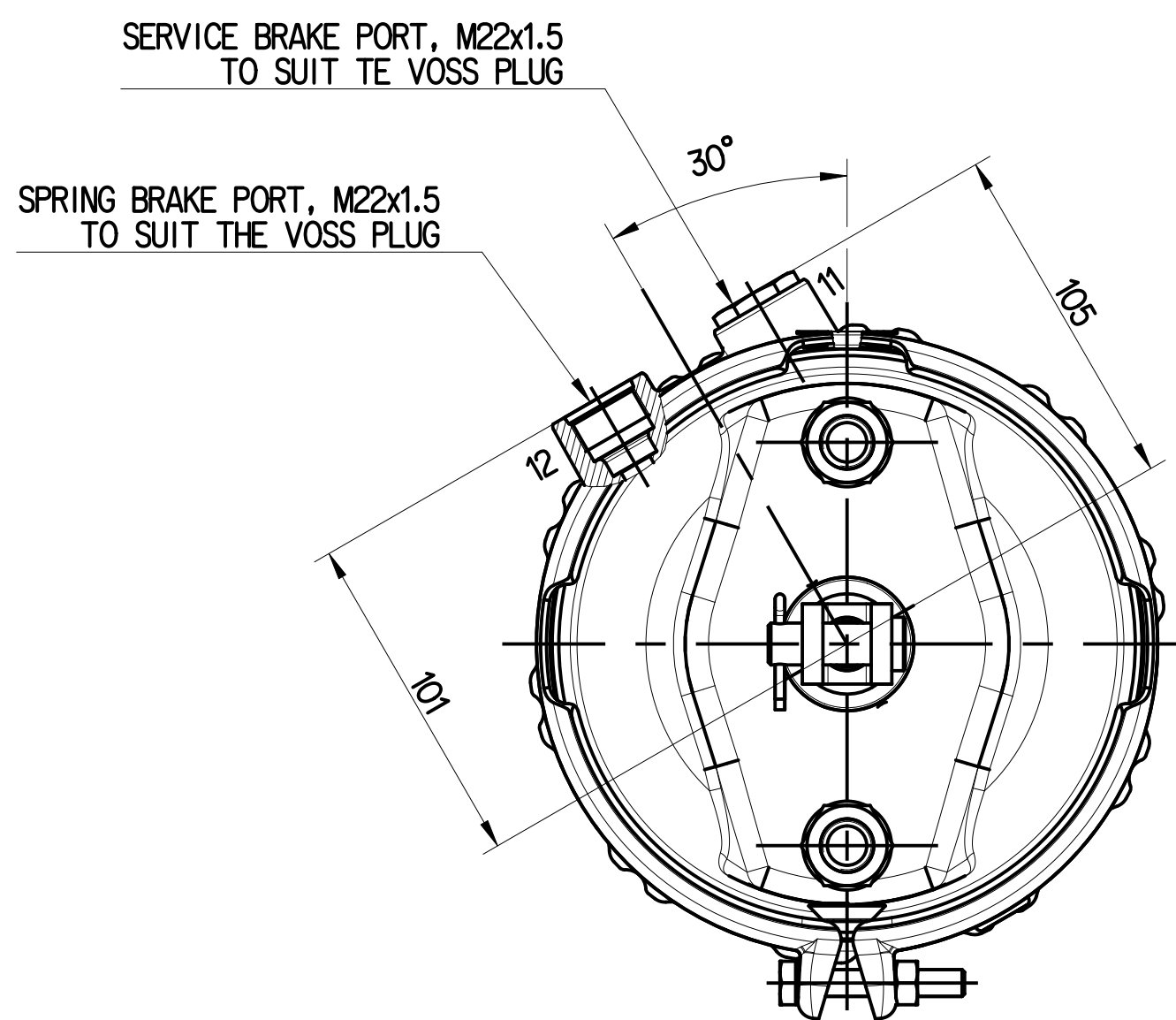
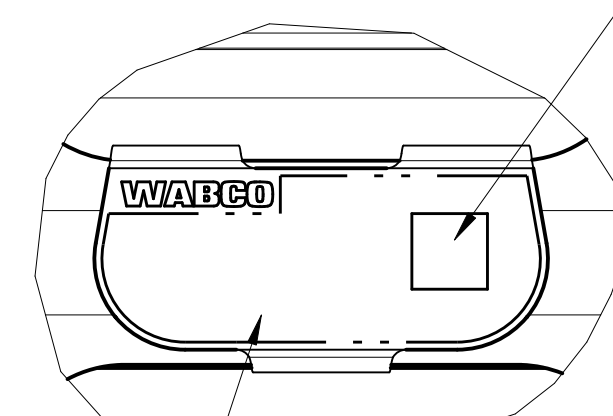
DETAILS OF PORT MACHINING FOR M22x1.5



NG12 SPRING ELEMENT
VOSS PART No. 00 62 05 99 00

NG12 RETAINING CLIP
VOSS PART No. 00 62 01 90 00

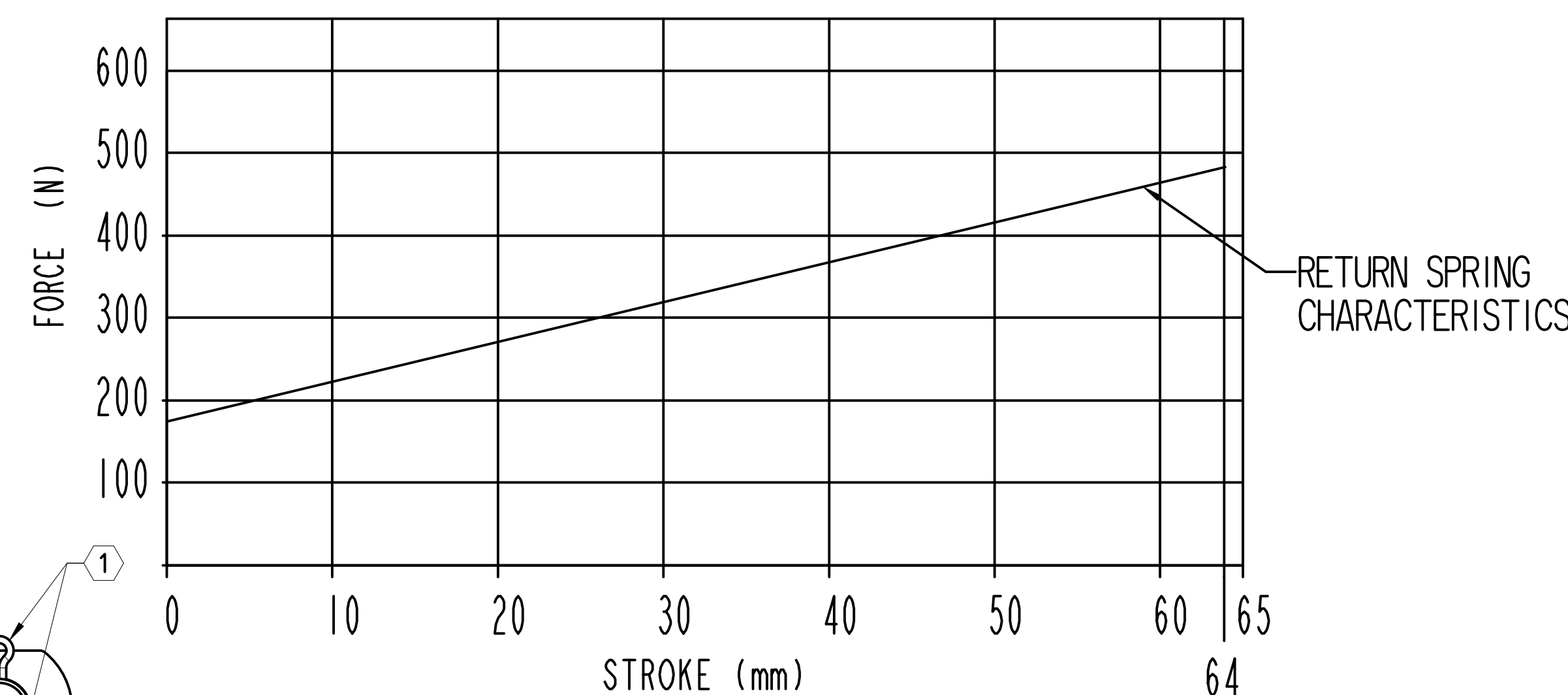
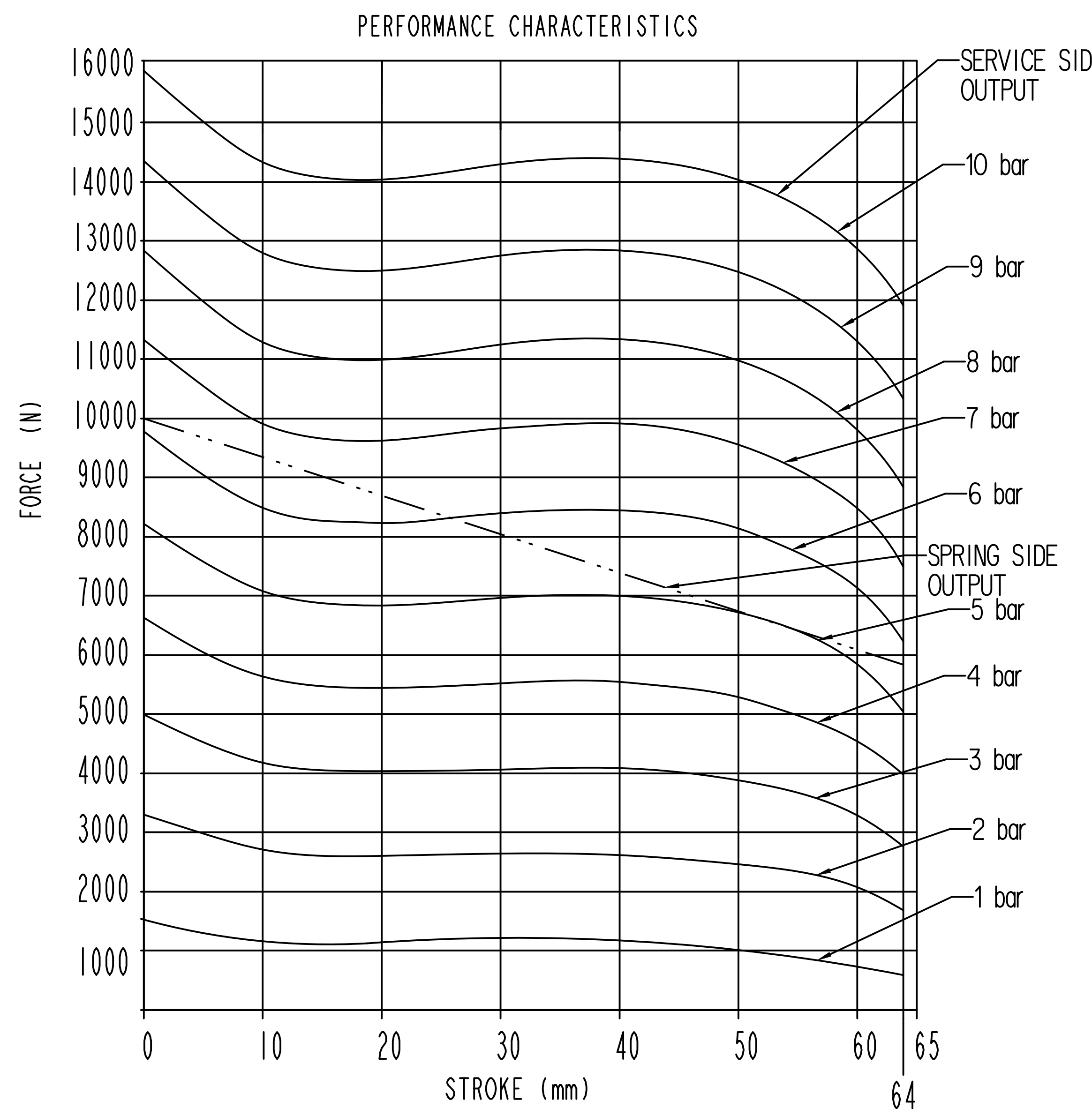
NG12 MALE NUT M22 X 1.5 WITH O-RING
VOSS PART No. 00 62 03 99 00

FIG W
1:2

—QR CODE TO BE SHOWN HERE

ASSEMBLY PART No. AND
BATCH No. ARE
SHOWN HERE

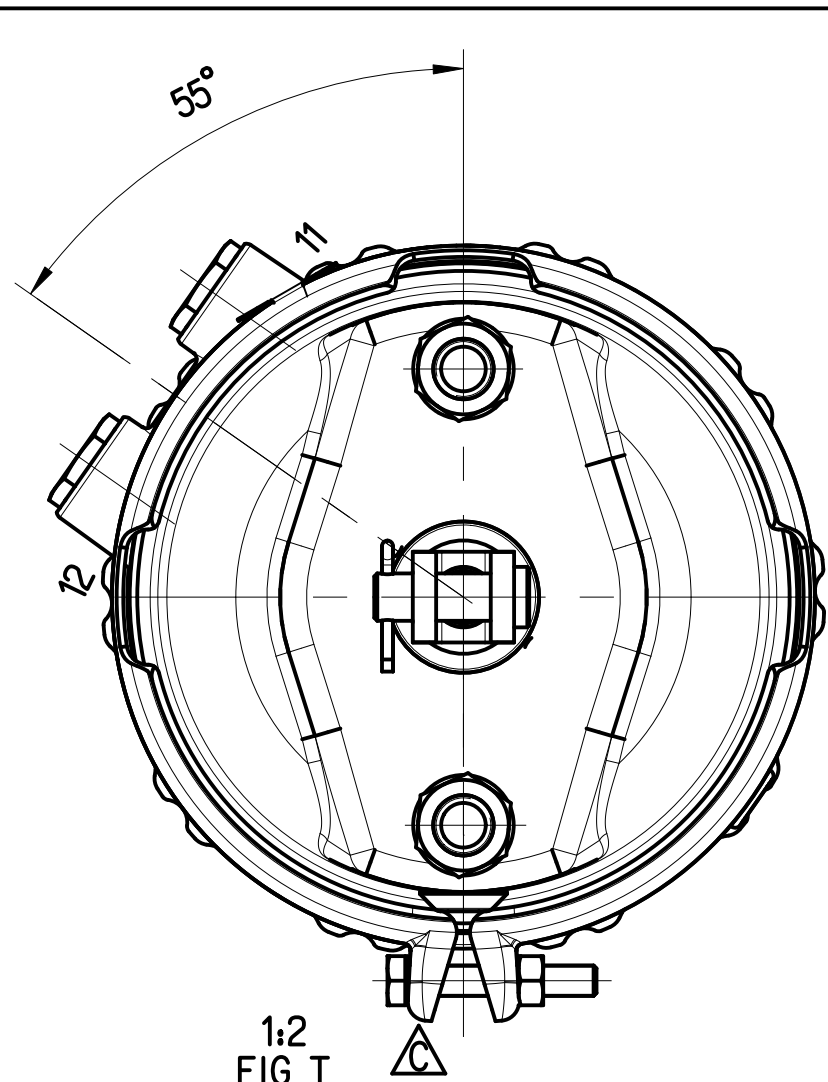
P
2:1



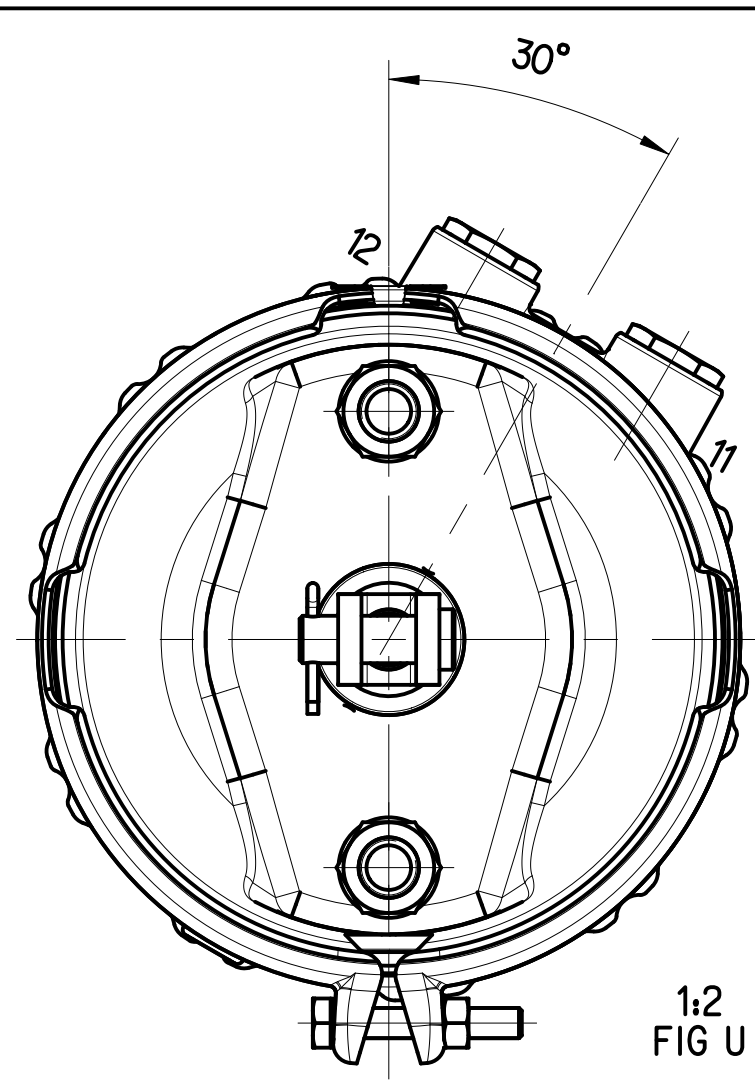
NOMINAL VALUES GIVEN
TOLERANCE BAND- $\pm 5\%$ FROM 1/3rd TO 2/3rd STROKE

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 mm
1.7	SPRING BRAKE STROKE	64 mm
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.	

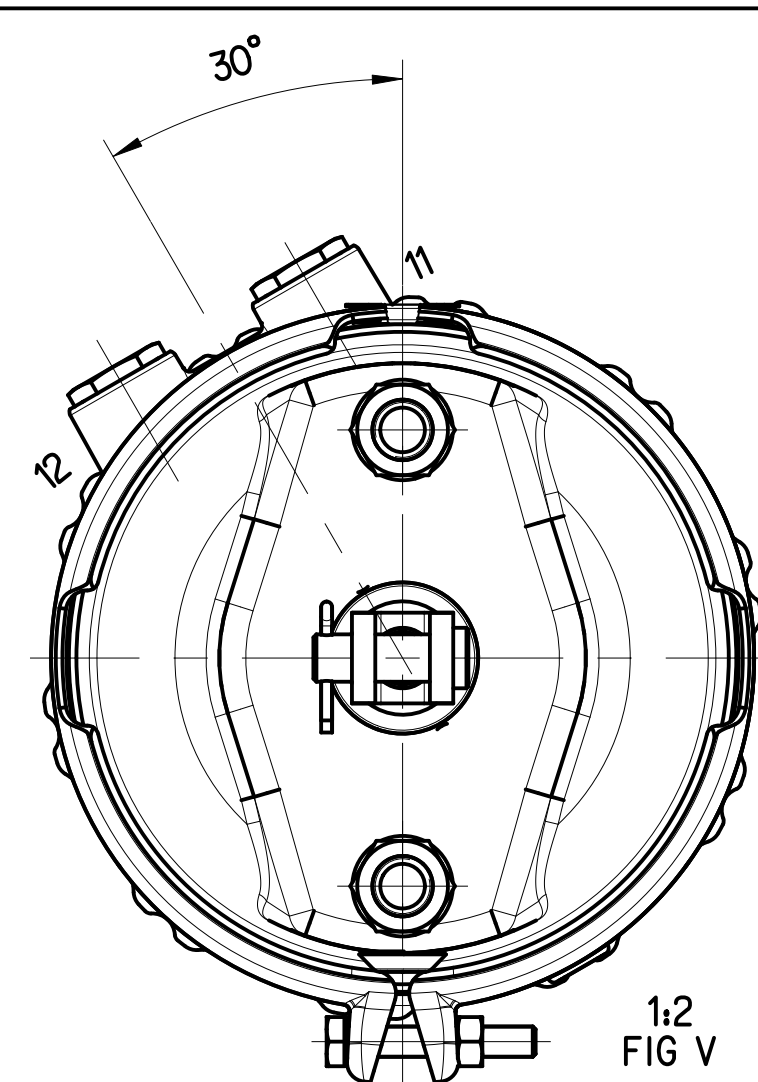
XVXI	STEEL	NO TREATMENT
XV	CAST IRON	PLATED
XV	CAST IRON	NO TREATMENT
XIV	STEEL	ZINC IRON PLATED
XIII	ZINC ALLOY	ANODISED
XII	PLASTIC	NO TREATMENT
XI	RUBBER	NO TREATMENT
X	STAINLESS STEEL	NO TREATMENT
IX	BRASS	NO TREATMENT
VIII	ZINC ALLOY	CHROMATED
VII	ALUMINIUM ALLOY	ANODISED
VI	ALUMINIUM ALLOY	CHROMATED
V	CAST IRON	PAINTED
IV	STEEL	POWDER COATED
III	STEEL	PAINTED
II	STEEL	PHOSPHATED
I	STEEL	ZINC PLATED
PART CODE	MATERIAL	SURFACE PROTECTION
1	1	2



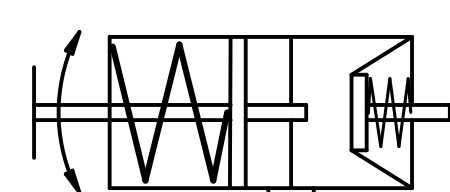
1:2
FIG. 1



1:2
FIG U



1:2
FIG V



CIRCUIT DIAGRAM

ASSEMBLY PART No.	PORT & CLAMP RING ORIENTATION	PORT DETAILS	LH/RH LABEL	STAND OUT 'x'	MASS (kg)
925 491 343 0	BASIC DRAWING	BASIC DRAWING	RH	200	-10.22
925 491 344 0	FIG T	BASIC DRAWING	LH	200	-10.22
925 491 345 0	FIG U	BASIC DRAWING	RH	72	-9.93
925 491 346 0	FIG V	BASIC DRAWING	LH	72	-9.93
925 491 351 0	FIG W	FIG W	LH	72	-9.90

[illegible]