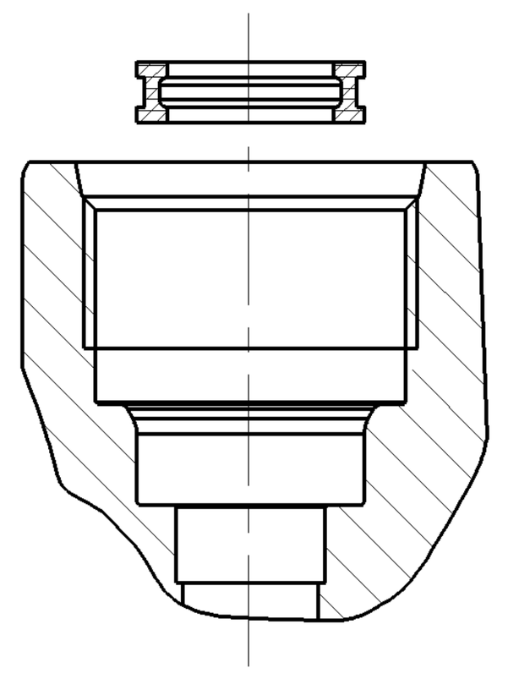
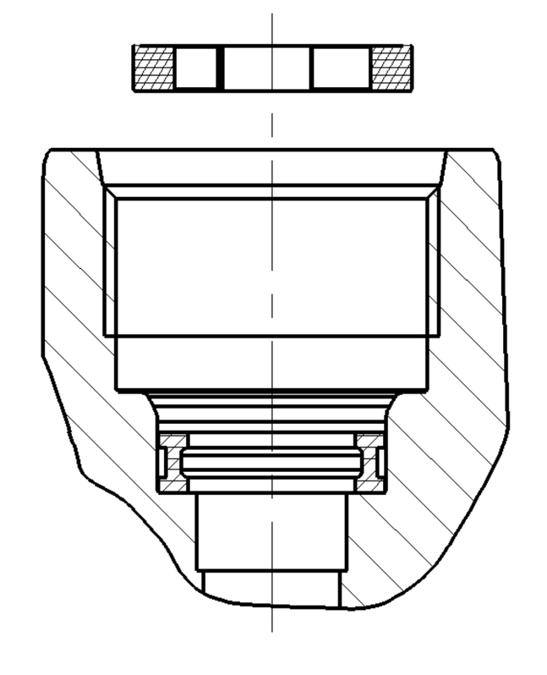
ASSEMBLY PROCEDURE

(a)



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

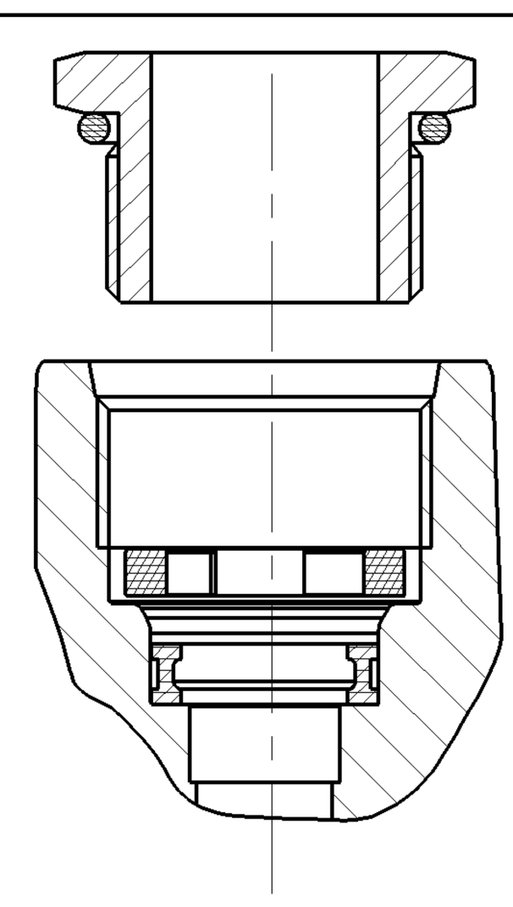
(b)



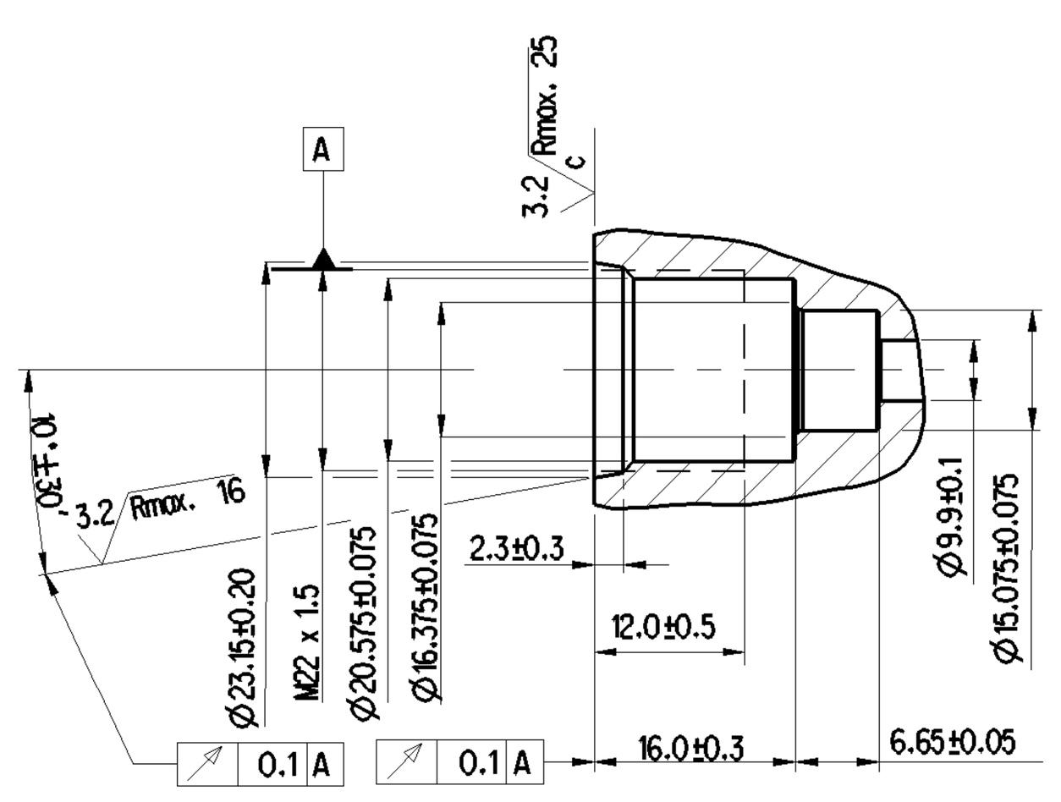
THE RETAINING CLIP IS INTRODUCED SO THAT IT RESTS FLAT ON THE THREAD ROOT (b) AND (c).

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

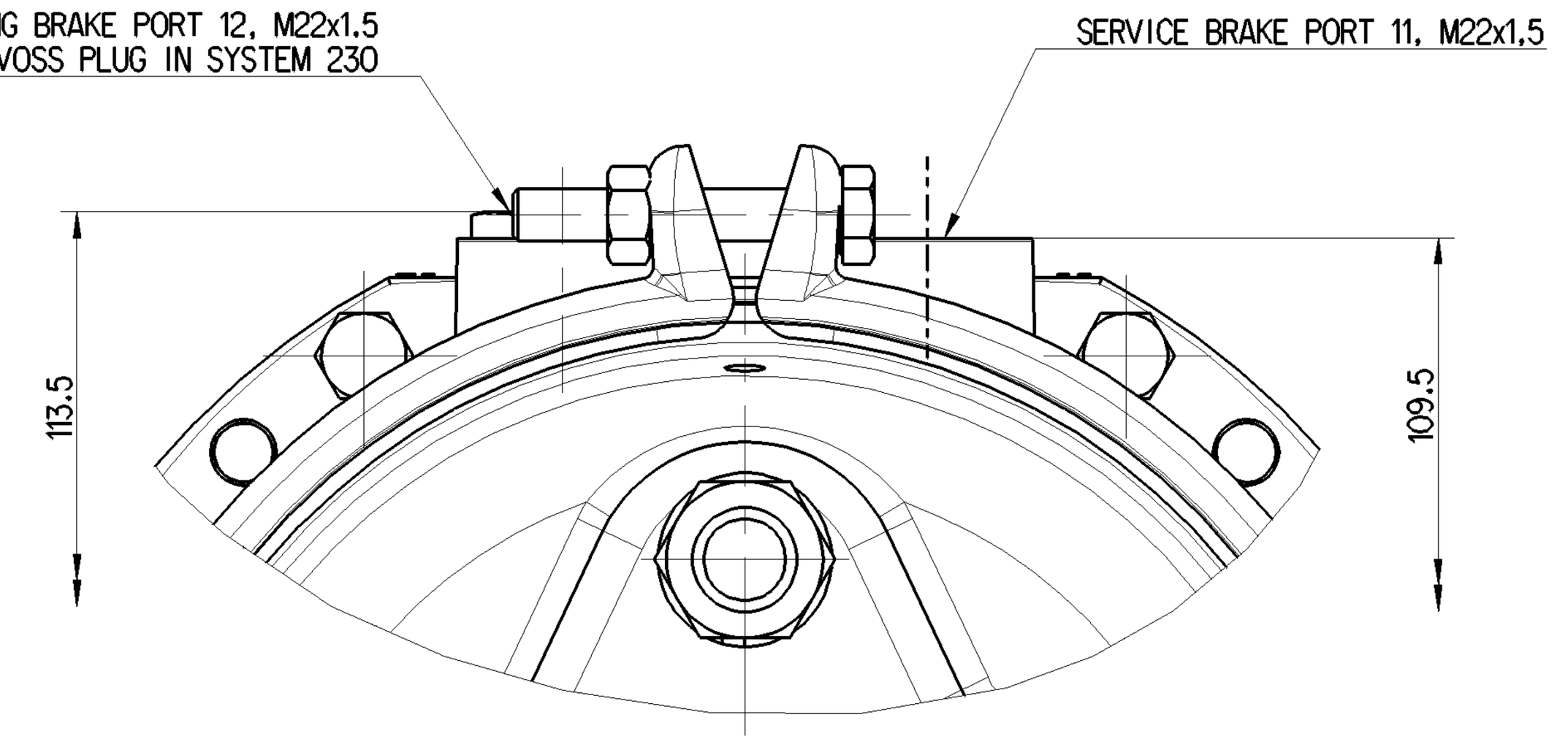
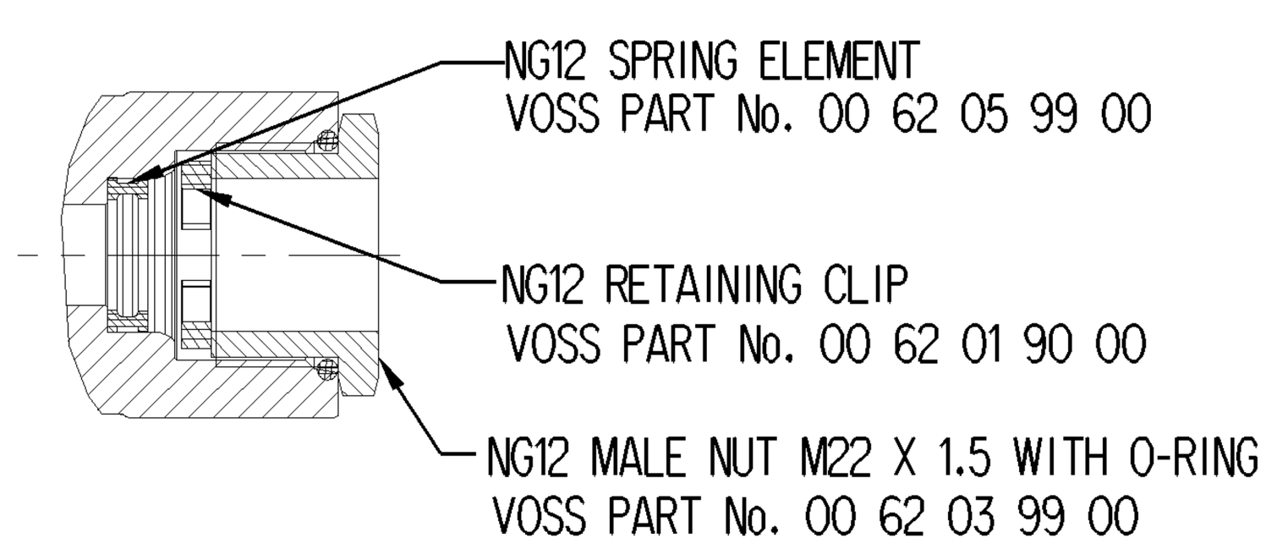
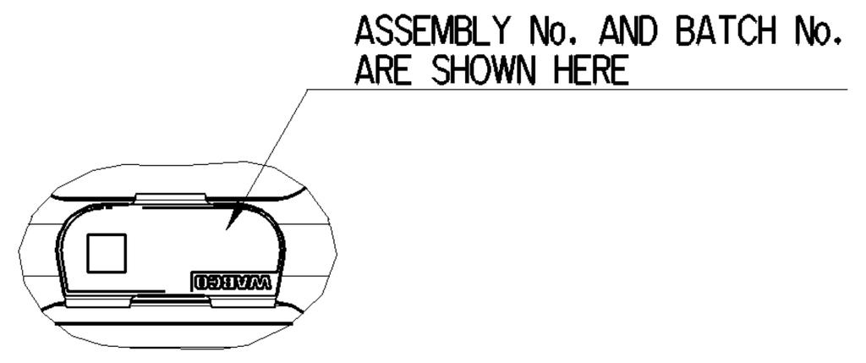
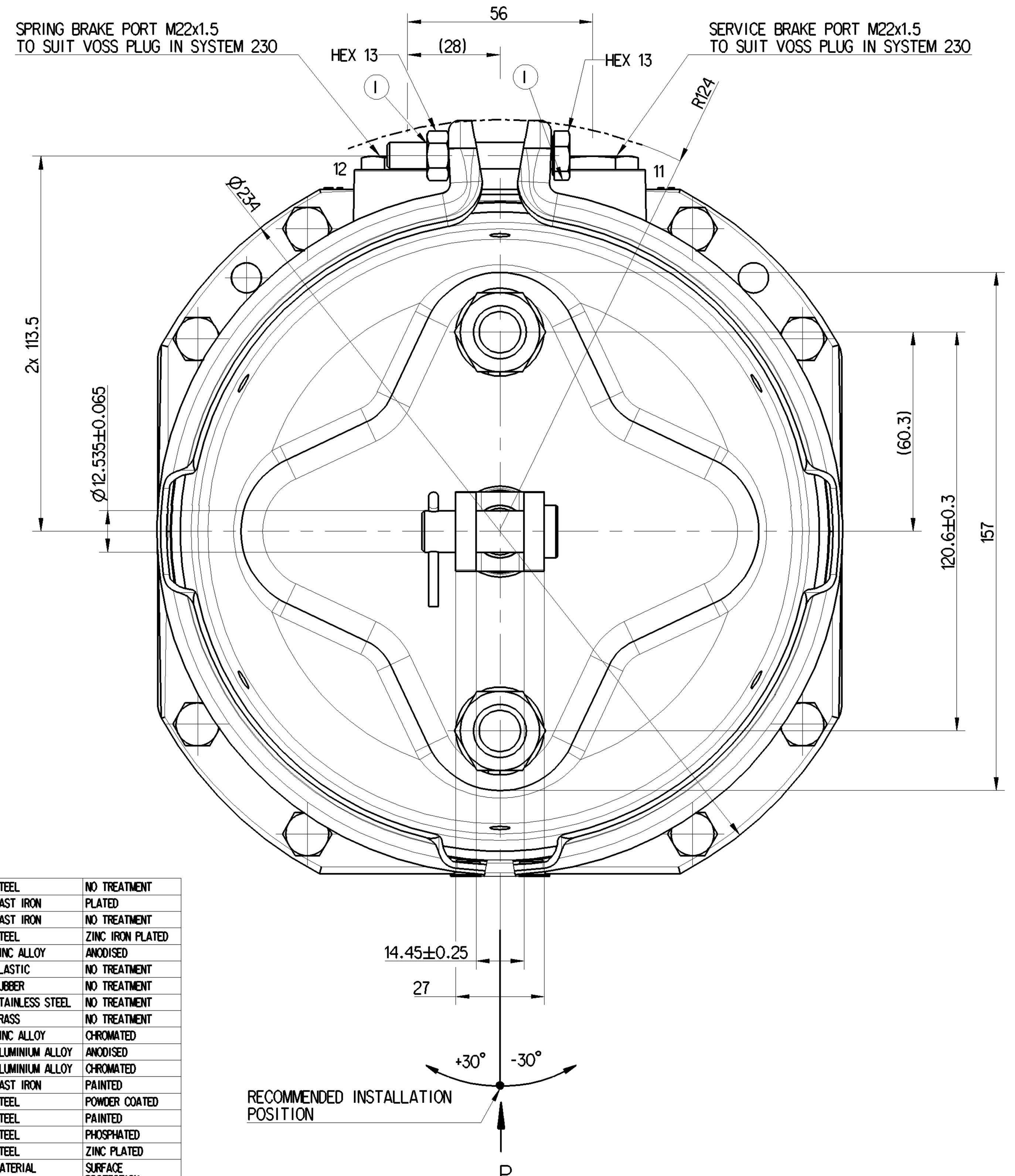
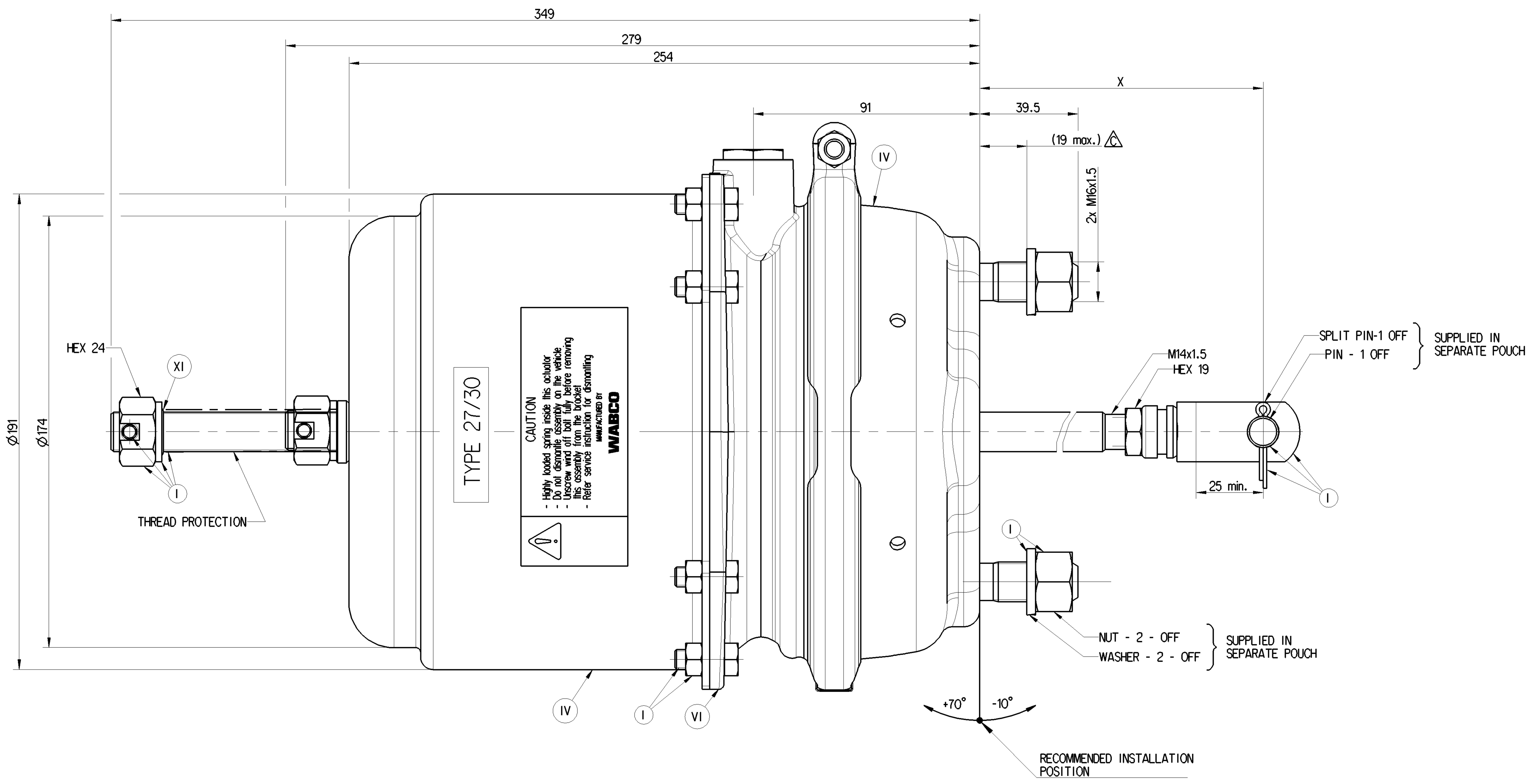


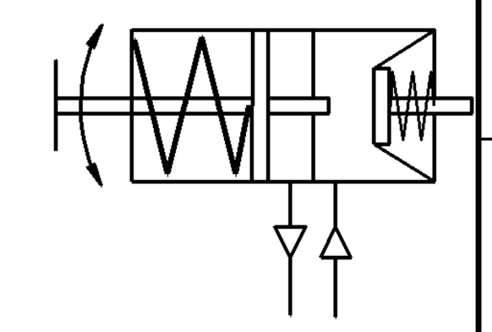
FIG U











CIRCUIT DIAGRAM

1	PRODUCT FUNCTION AND RELIABILITY	
1.1	PRODUCT SPECIFICATION No	925 499 102 0
1.2	WORKING MEDIUM	AIR
1.3	PORT 11, SERVICE BRAKE SYSTEM, WORKING PRESSURE	10 bar
1.4	PORT 12, SPRING BRAKE CYLINDER, WORKING PRESSURE	10 bar
1.5	PORT 11, MAXIMUM WORKING PRESSURE(TEMPORARILY)	13 bar
1.6	PORT 12, MAXIMUM WORKING PRESSURE(TEMPORARILY)	13 bar
	UNIT DRAWN WITH PRESSURE APPLIED AT PORT 12	
1.7	SERVICE BRAKE STROKE	63.5 mm min
1.8	SPRING BRAKE STROKE	63.5 mm min
1.9	THERMAL RANGE OF APPLICATION	-40°C TO +80°C
1.10	PRESSURE AT WHICH PUSH ROD STARTS MOVING (LIFT-OFF PRESSURE AT 0 mm STROKE)	< 0.3 bar
1.11	PRESSURE AT WHICH PUSH ROD IS FULLY OUT (LIFT-OFF PRESSURE AT 63.5 mm 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	

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

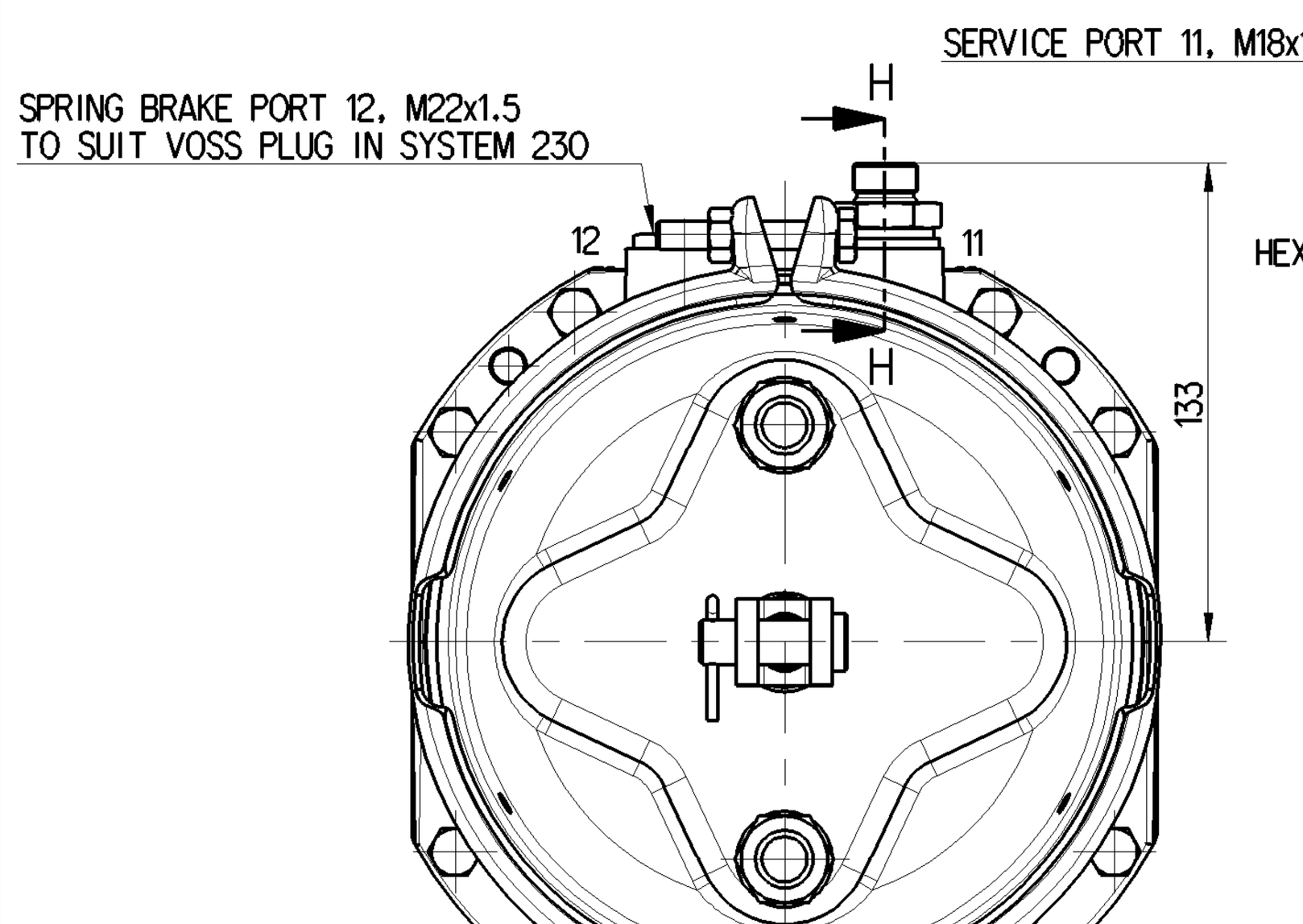
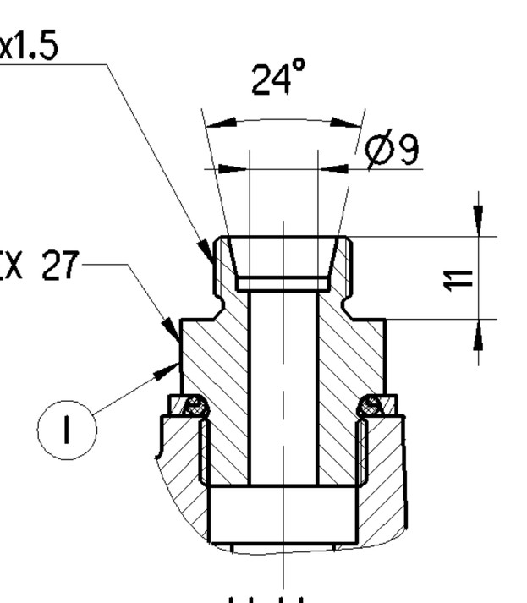
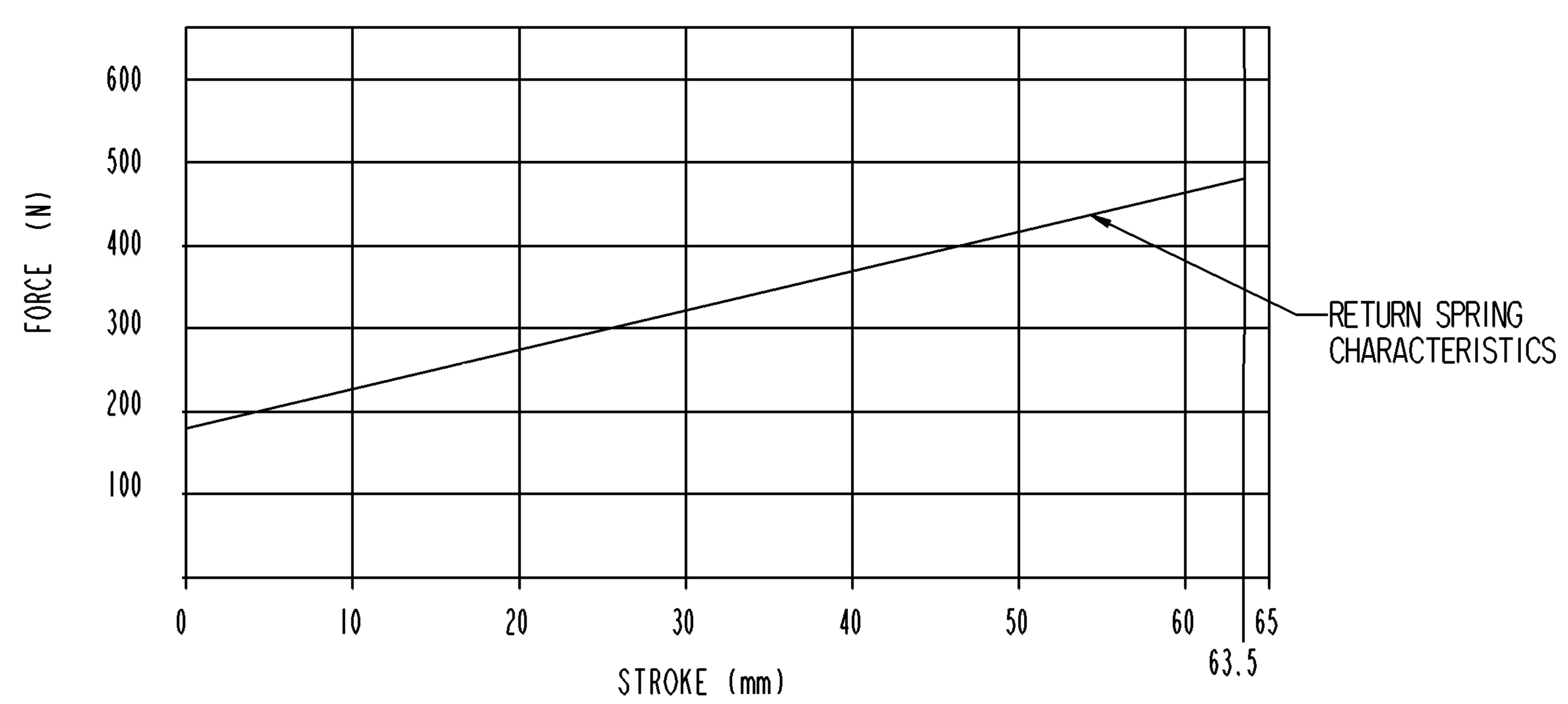


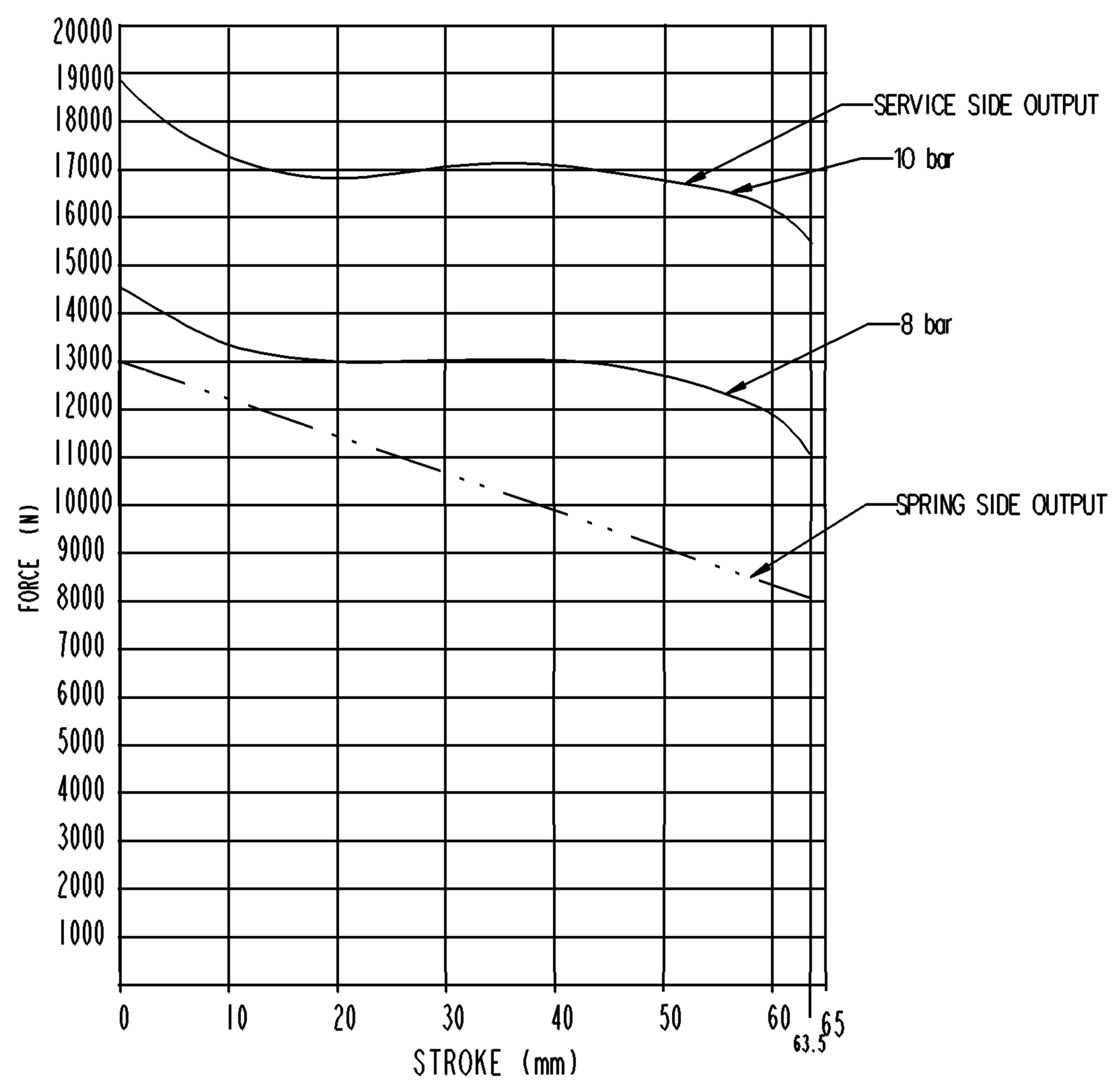
FIG T
SCALE 1:2



H-H
1:1



PERFORMANCE CHARACTERISTICS



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

ASSEMBLY PART No.	PORT DETAILS	STAND OUT 'X' (mm)	MASS (Kg)
925 499 102 0	BASIC DRAWING	300	12.9
925 499 103 0	FIG T	300	12.9
925 499 104 0	BASIC DRAWING	72	12.5
925 499 105 0	FIG T	72	12.5
925 499 174 0	FIG U	72	12.4

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	
Medium X	±1	±2	±3	±4	±3°
Coarse	±2	±3.5	±5	±6.5	

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

Date	Signature	
Drawn		
2023-04-25	GANESH KUMAR	
Checked		
2023-04-26	Arangarasan A	

Dimensions in mm

SPRING BRAKE ACTUATOR - TYPE 27/30

Mass	Scale	Material No.	Date of first issue: 2018-08-31		
REFER TABLE kg	1:1 (1:2)	925 499 102 0	Doc.Code 053	Language EN	Sheet 1/1
Size A 0	CAD System CREO	ECN-No. 512095	Revision 1 C	Techn. Resp. 5380_WIN	Replacement for -