

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.

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

DEVICE EXTREME POSITIONS WHEN BLEEDING

75 MAX.
ADJUSTMENT OF WEAR INDICATOR

11±1
POSITION WHEN DELIVERED

QUICK RESPONSE CODE LABEL TO BE PASTED HERE
(PRINTING DETAILS AS PER DOC. CODE 922)

250±2

85±1.5
STROKE

66

A/F 19 mm

M4x1.5 (2)

Ø4

31.3

M2x1

Ø4

47

X

⊕ (12 MIN.)

⊖ (13 MIN.)

1 M22x1.5
NG12 VOSS PLUG IN SYSTEM 230

3 M16x1.5
JED464

78.5

163.5

277

NAME PLATE DETAILS

WEEK NO. AND YEAR OF MANUFACTURE SHOWN HERE

SERIAL NO. SHOWN HERE

WABCO PART NO. SHOWN HERE

CUSTOMER PART NO. SHOWN HERE

QR CODE INFORMATION SHOWN HERE

PRI CODE SHOWN HERE

MISALIGNMENT OF PUSH ROD IN ANY DIRECTION

A/F 18mm

M2x1.5

7.9±0.1

15° MAX

5° MAX

TORQUE 13.5±1.5 Nm

FORK DETAIL

53

44

5

9

30.25±0.2

PIN SPLIT PIN SUPPLIED IN SEPARATE POUCH

MARKING OF PORTS

Port	Description
11	AIR INLET
1-4	OIL INLET
31	AIR EXHAUST
32	BLEED SCREW

TORQUE FOR CONNECTIONS

Connection	Torque
1	10±1 Nm
2	22.5±2.5 Nm
3	31.5±2.5 Nm

SYMBOL

32

11

31

CUSTOMER LOGO DETAIL

Z

MARKED ACCORDING TO STD 5051.16

◇ MET 3.2-30-D15

FORCE OUTPUT

NORMAL USE

EXCEPTIONAL USE

(N) 4000N MAX.

P11 (bar)

THEORETICAL CURVE

4000

3000

2000

1000

0

10

20

30

40

50

60

70

80

90

P1-4 (bar)

NOTES

No.	Description	Value
1	PRODUCT SPECIFICATION No.	PS 9700514940
2	OIL VOLUME INPUT	V=(SH+C)*K
K	ABSORPTION AT 90 bar for C=0	K<1.5 cm³
SH	HYDRAULIC SECTIONAL AREA	4.89 cm²
C	GEAR DISENGAGING STROKE	
3	HYDRAULIC SECTION DIAMETER	Ø25 ±0.05 mm
4	HYDRAULIC FLUID	DOT3,DOT4 SAE J 1703
5	THERMAL RANGE	-40°C...+100°C
6	SUPPLY PRESSURE	10 bar MAX.
7	NO STROKE LIMITER IN THE DEVICE	
8	CAUTION : DO NOT ACTUATE THE DEVICE IF NOT FITTED ON ITS MOUNTING BRACKET	
9	OPEN PORTS ARE FITTED WITH CLOSURE PLUG FOR STORAGE AND TRANSIT PURPOSE	

General Specification: JED-334-O , Size ISO 14-40S-1 E

Further Technical Data:

Doc. Code	Sheets	To
2021-09-20	1	2021-09-20

Range of Nominal Dimensions (± mm)

Class	1)	≤ 50	> 50 ≤ 180	> 180 ≤ 400	> 400
Fine	×	0.5	1.0	1.5	2.0
Medium	×	1.0	2.0	3.0	4.0
Coarse	×	2.0	3.5	5.0	6.5

Tapped Holes acc. IS 14962

1) Tolerance Class Applied Crossmarked

Copyright WABCO®

Date: 2021-09-20

Signature: Saravanan N

Object: Kalimuthu P S

Expert: Kalimuthu P S

Mass: 2.2 kg

Scale: 1:1 1:2

Size: A1 CREO

Material No.: 970 051 631 0

Date of first issue: 2014-05-15

Doc.Code: 509205

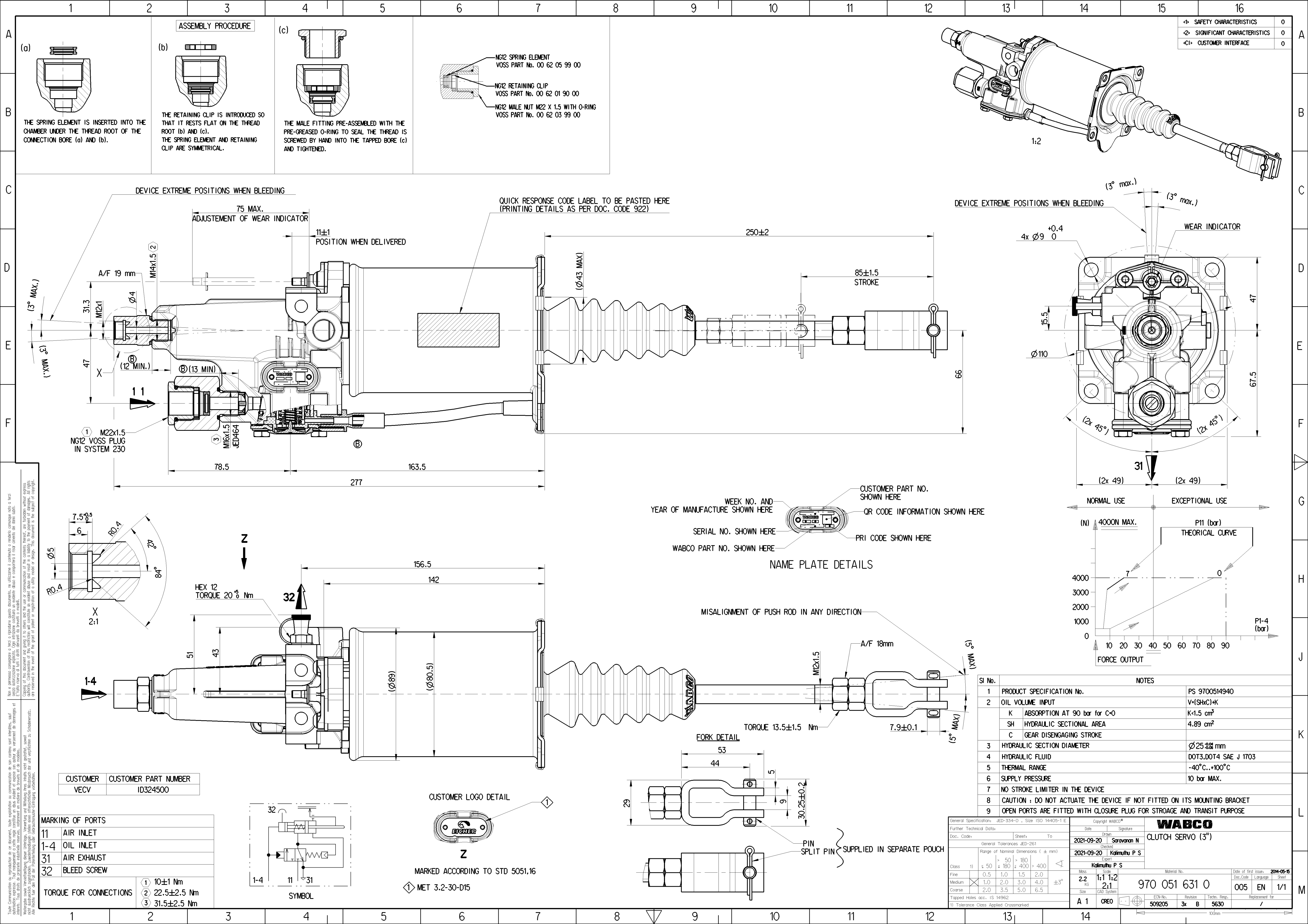
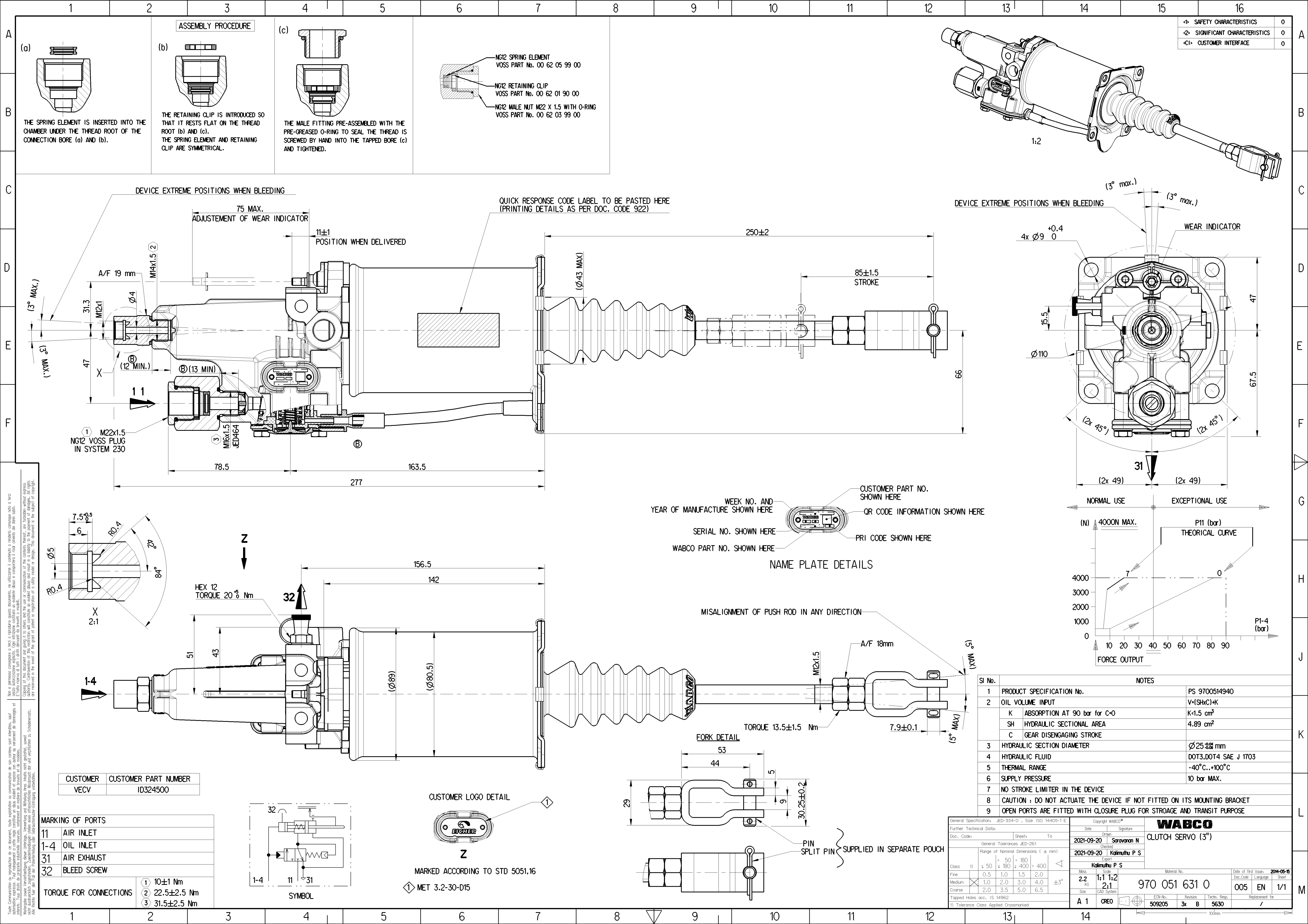
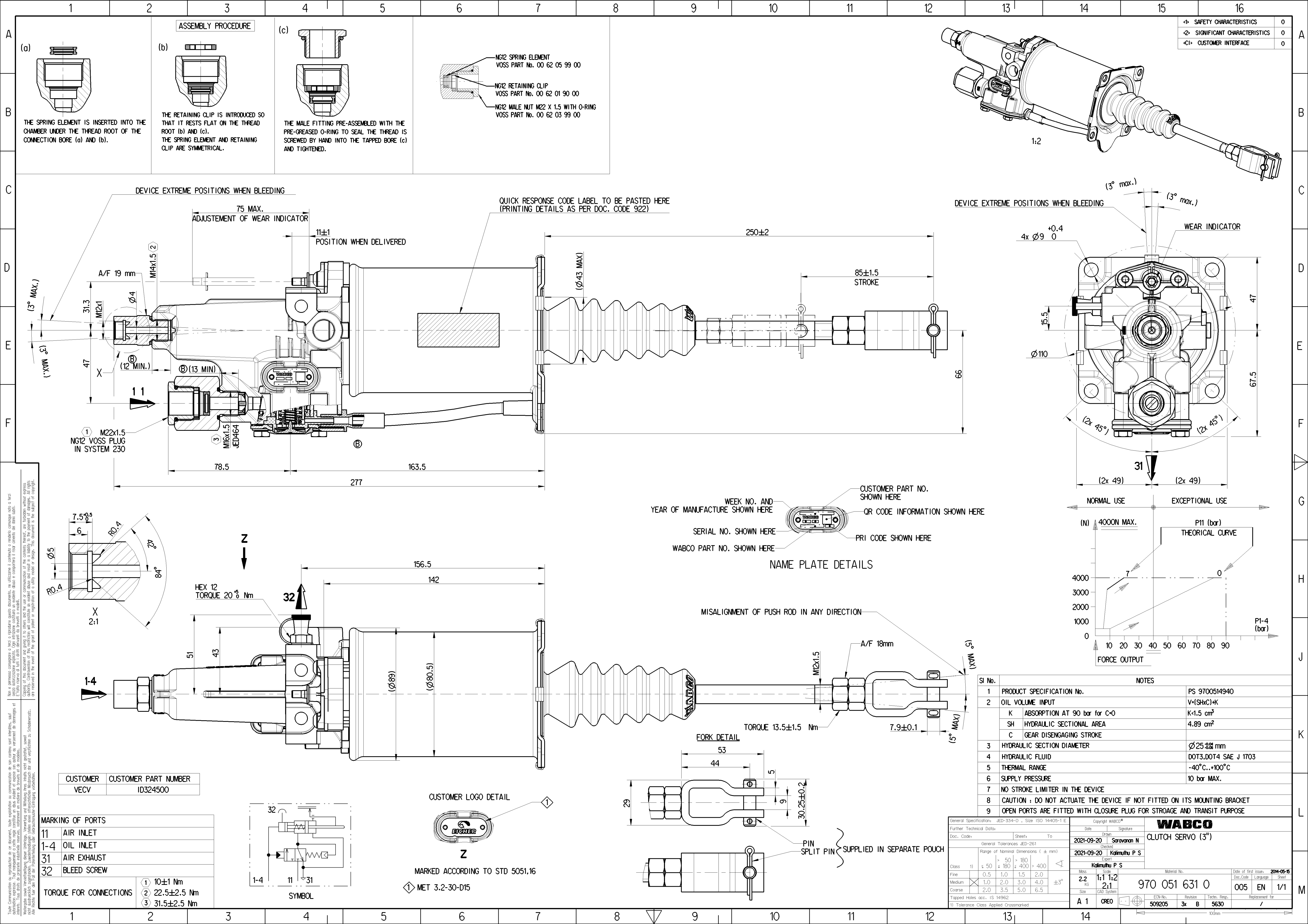
Revision: 3x

Techn. Resp.: B

Replacement for: /

Sheet: 1/1

Language: EN



Technical drawing of a WABCO Clutch Servo (3rd) showing assembly procedure, dimensions, and specifications.

ASSEMBLY PROCEDURE

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

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VOSS PART No. 00 62 05 99 00

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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

DEVICE EXTREME POSITIONS WHEN BLEEDING

75 MAX. ADJUSTMENT OF WEAR INDICATOR

11±1 POSITION WHEN DELIVERED

QUICK RESPONSE CODE LABEL TO BE PASTED HERE (PRINTING DETAILS AS PER DOC. CODE 922)

250±2

85±1.5 STROKE

66

78.5

163.5

277

11±1

7.5±0.5

6

R0.4

2°

84°

Ø5

X 2:1

Z

156.5

142

51

43

32

HEX 12 TORQUE 20 ± 5 Nm

Ø89

Ø80.5

MISALIGNMENT OF PUSH ROD IN ANY DIRECTION

A/F 18mm

M22x1.5

7.9±0.1

15° MAX

5° MAX

53

44

5

9

30.25±0.2

PIN SPLIT PIN SUPPLIED IN SEPARATE POUCH

NAME PLATE DETAILS

WEEK NO. AND YEAR OF MANUFACTURE SHOWN HERE

SERIAL NO. SHOWN HERE

WABCO PART NO. SHOWN HERE

CUSTOMER PART NO. SHOWN HERE

QR CODE INFORMATION SHOWN HERE

PRI CODE SHOWN HERE

MARKING OF PORTS

11 AIR INLET

1-4 OIL INLET

31 AIR EXHAUST

32 BLEED SCREW

TORQUE FOR CONNECTIONS

1 10±1 Nm

2 22.5±2.5 Nm

3 31.5±2.5 Nm

CUSTOMER LOGO DETAIL

MARKED ACCORDING TO STD 5051.16

MET 3.2-30-D15

SYMBOL

FORCE OUTPUT

4000N MAX.

P11 (bar)

THEORETICAL CURVE

P1-4 (bar)

10 20 30 40 50 60 70 80 90

0 1000 2000 3000 4000

NOTES

1 PRODUCT SPECIFICATION No. PS 9700514940

2 OIL VOLUME INPUT V=(SHxC)*K

SH ABSORPTION AT 90 bar for C=0 K<1.5 cm²

HYDRAULIC SECTIONAL AREA 4.89 cm²

C GEAR DISENGAGING STROKE

3 HYDRAULIC SECTION DIAMETER Ø25 ± 0.05 mm

4 HYDRAULIC FLUID DOT3,DOT4 SAE J 1703

5 THERMAL RANGE -40°C...+100°C

6 SUPPLY PRESSURE 10 bar MAX.

7 NO STROKE LIMITER IN THE DEVICE

8 CAUTION : DO NOT ACTUATE THE DEVICE IF NOT FITTED ON ITS MOUNTING BRACKET

9 OPEN PORTS ARE FITTED WITH CLOSURE PLUG FOR STORAGE AND TRANSIT PURPOSE

General Specification: JED-334-O, Size ISO 14-40S-1 E

Further Technical Data:

Doc. Code: Sheets: To:

General Tolerances JED-261

Range of Nominal Dimensions (± mm)

Class 1) ≤ 50 > 50 > 180 > 400 > 400

Fine 0.5 1.0 1.5 2.0

Medium 1.0 2.0 3.0 4.0

Coarse 2.0 3.5 5.0 6.5

Tapped Holes acc. IS 14962

1) Tolerance Class Applied Crossmarked

Copyright WABCO®

Date: 2021-09-20

Drawn: Saravanan N

Checked: Kalimuthu P S

Expert: Kalimuthu P S

Mass: 2.2 kg

Scale: 1:1 1:2 2:1

Size: A 1 CREO

Material No. 970 051 631 0

Date of first issue: 2014-05-15

Doc. Code: 005

Language: EN

Sheet: 1/1

Revision: 509205

Revise: 3x

Techn. Resp.: B

Replacement for: 5630

100mm

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16

A

B

C

D

E

F

G

H

J

K

L

M

ASSEMBLY PROCEDURE

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

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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

1:2

DEVICE EXTREME POSITIONS WHEN BLEEDING

75 MAX.
ADJUSTMENT OF WEAR INDICATOR

11±1
POSITION WHEN DELIVERED

QUICK RESPONSE CODE LABEL TO BE PASTED HERE
(PRINTING DETAILS AS PER DOC. CODE 922)

250±2

85±1.5
STROKE

66

78.5

163.5

277

11

1

2

3

4

5

6

7

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250±2

85±1.5
STROKE

66

A/F 19 mm

M4x1.5 (2)

Ø4

31.3

M2x1

Ø4

47

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⊕ (12 MIN.)

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5° MAX

TORQUE 13.5±1.5 Nm

FORK DETAIL

53

44

5

9

30.25±0.2

PIN SPLIT PIN SUPPLIED IN SEPARATE POUCH

MARKING OF PORTS

11	AIR INLET
1-4	OIL INLET
31	AIR EXHAUST
32	BLEED SCREW

TORQUE FOR CONNECTIONS

①	10±1 Nm
②	22.5±2.5 Nm
③	31.5±2.5 Nm

CUSTOMER LOGO DETAIL

Z

MARKED ACCORDING TO STD 5051.16

◇ MET 3.2-30-D15

SYMBOL

32

11

31

1-4

FORCE OUTPUT

NORMAL USE

EXCEPTIONAL USE

(N) 4000N MAX.

P11 (bar)

THEORETICAL CURVE

4000

3000

2000

1000

0

10

20

30

40

50

60

70

80

90

P1-4 (bar)

NOTES

SI No.	PRODUCT SPECIFICATION No.	PS 9700514940
2	OIL VOLUME INPUT	V=(SH+C)*K
K	ABSORPTION AT 90 bar for C=0	K<1.5 cm ³
SH	HYDRAULIC SECTIONAL AREA	4.89 cm ²
C	GEAR DISENGAGING STROKE	
3	HYDRAULIC SECTION DIAMETER	Ø25 ±0.05 mm
4	HYDRAULIC FLUID	DOT3,DOT4 SAE J 1703
5	THERMAL RANGE	-40°C...+100°C
6	SUPPLY PRESSURE	10 bar MAX.
7	NO STROKE LIMITER IN THE DEVICE	
8	CAUTION : DO NOT ACTUATE THE DEVICE IF NOT FITTED ON ITS MOUNTING BRACKET	
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General Specification: JED-334-O , Size ISO 14-40S-1 E

Further Technical Data:

Doc. Code	Sheets	To
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Class	1)	< 50 > 50 < 180 > 180 < 400 > 400
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Medium	1.0	2.0 3.0 4.0
Coarse	2.0	3.5 5.0 6.5
Tapped Holes acc. IS 14962		
1) Tolerance Class Applied Crossmarked		

Copyright WABCO®

Date: 2021-09-20

Signature: Saravanan N

Object: Kalimuthu P S

Expert: Kalimuthu P S

Mass: 2.2 kg

Scale: 1:1 1:2 2:1

Size: CAD System

Material No.: 970 051 631 0

Date of first issue: 2014-05-15

Doc.Code: 005 EN 1/1

Revision: 509205

Techn. Resp.: 5630

Replacement for: /

WABCO

CLUTCH SERVO (3")

100mm