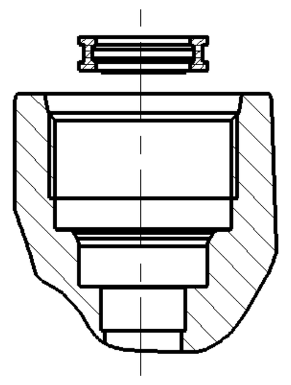
<1> SAFETY CHARACTERISTICS	0
<2> SIGNIFICANT CHARACTERISTICS	0
<CI> CUSTOMER INTERFACE	0

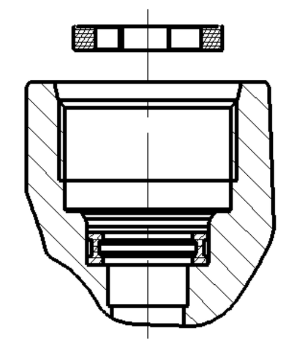
ASSEMBLY PROCEDURE

(a)



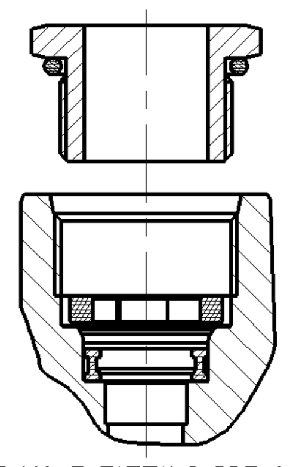
THE SPRING ELEMENT IS INSERTED INTO THE CHAMBER UNDER THE THREAD ROOT OF THE CONNECTION BORE (a) AND (b).

(b)

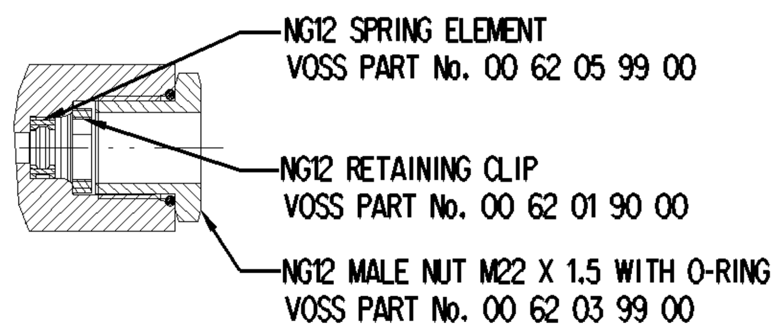


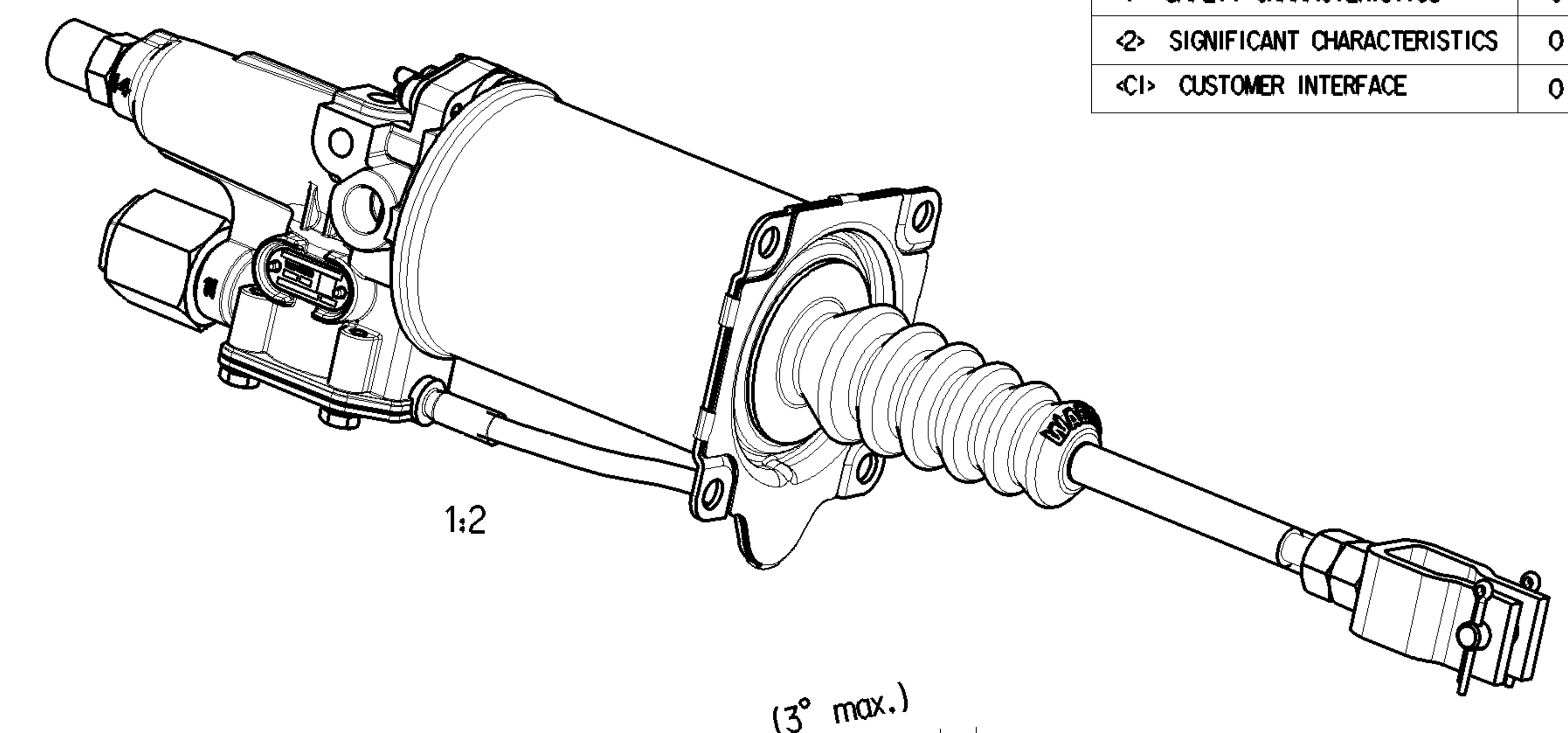
THE RETAINING CLIP IS INTRODUCED SO THAT IT RESTS FLAT ON THE THREAD ROOT (b) AND (c).
THE SPRING ELEMENT AND RETAINING CLIP ARE SYMMETRICAL.

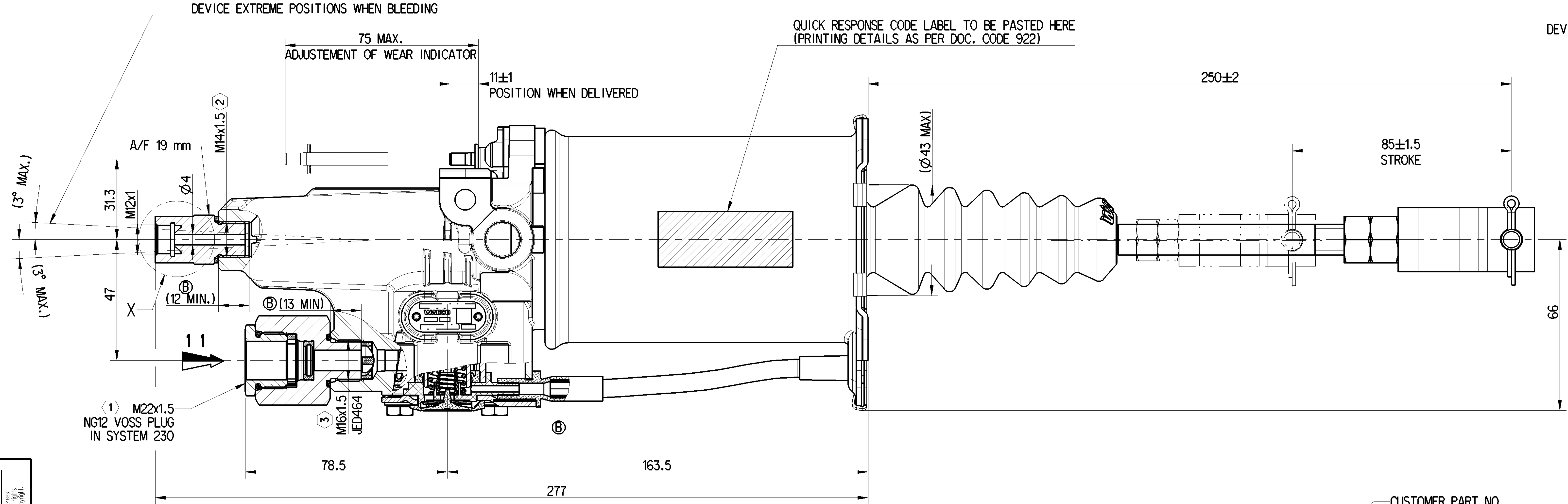
(c)

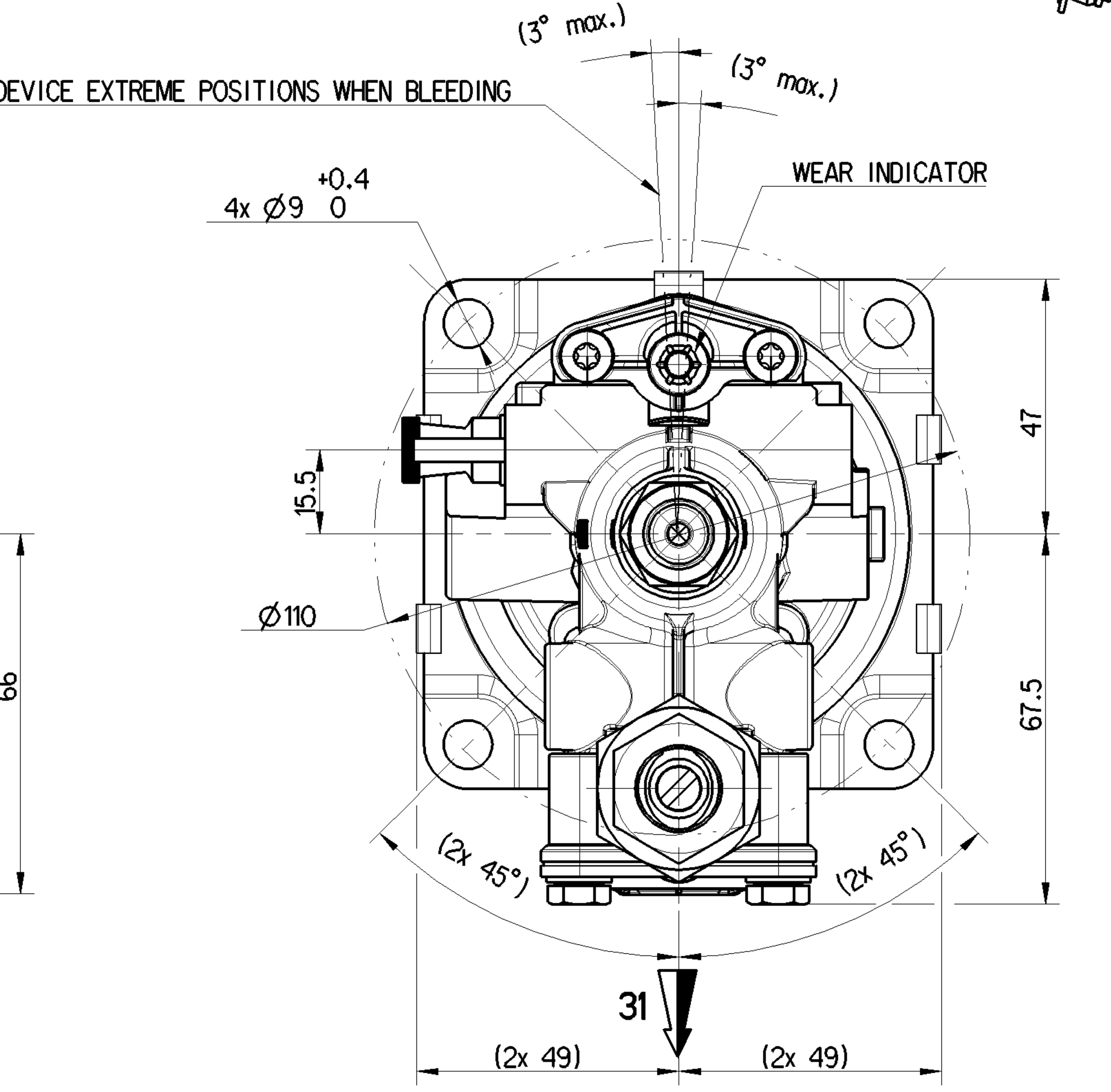


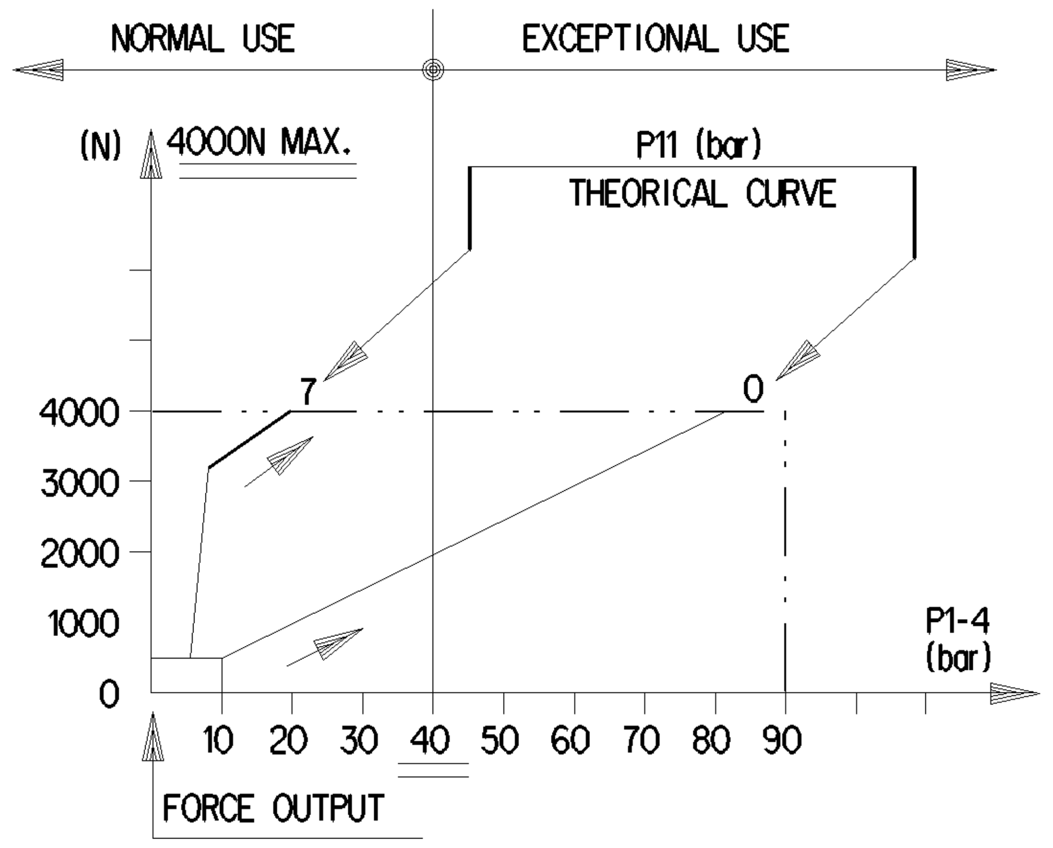
THE MALE FITTING PRE-ASSEMBLED WITH THE PRE-GREASED O-RING TO SEAL THE THREAD IS SCREWED BY HAND INTO THE TAPPED BORE (c) AND TIGHTENED.

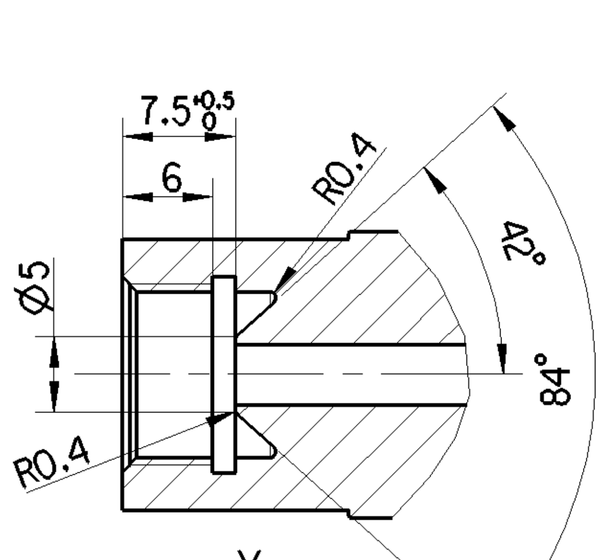




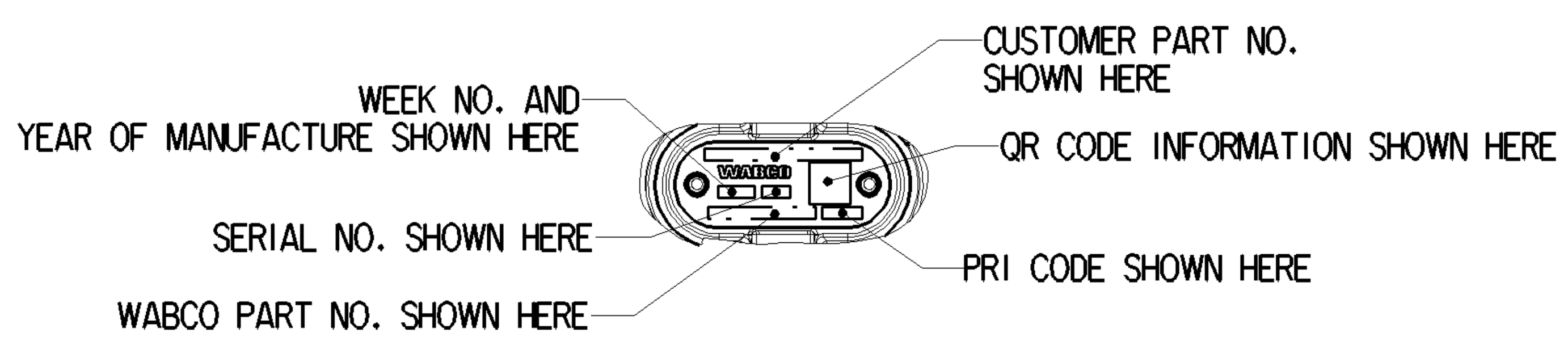




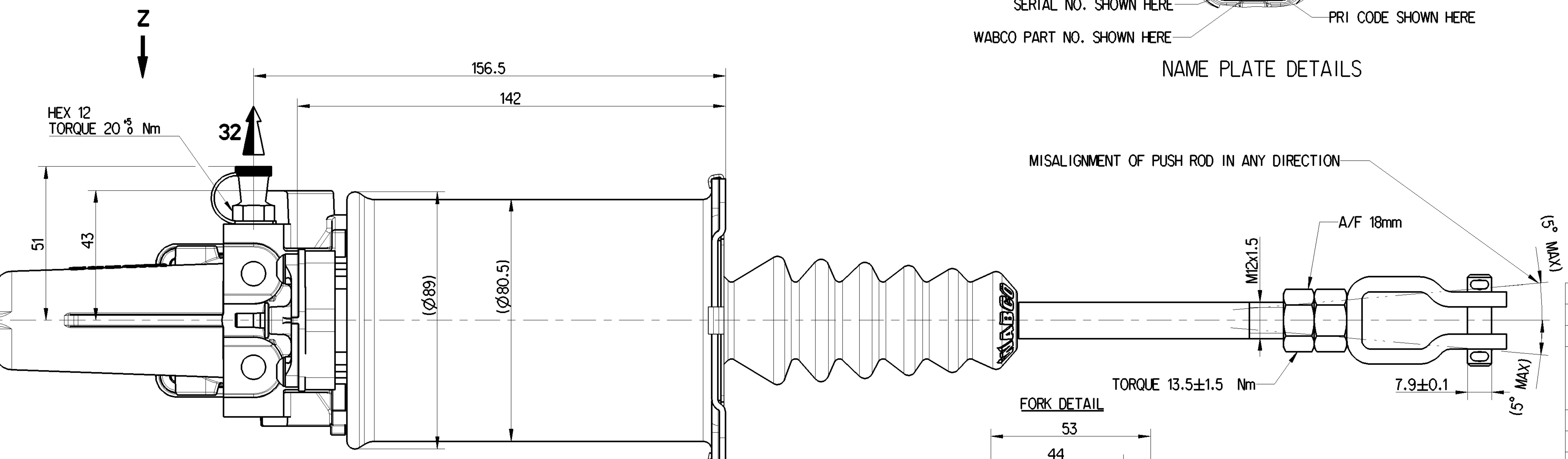




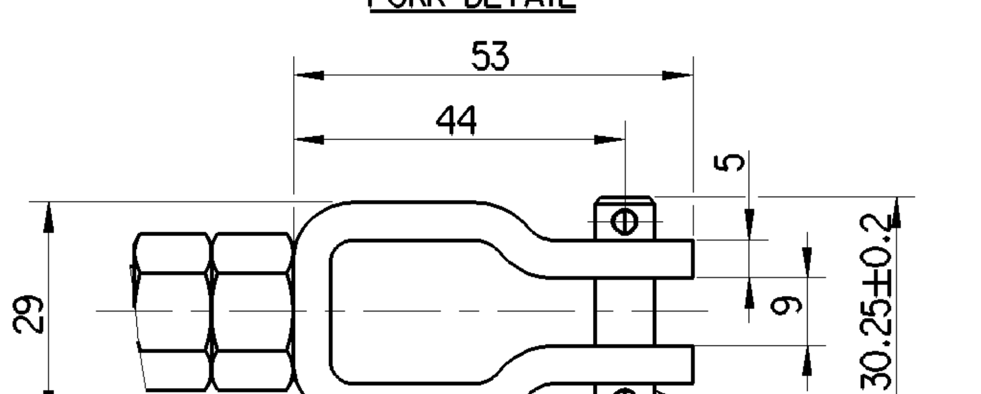
X
2:1

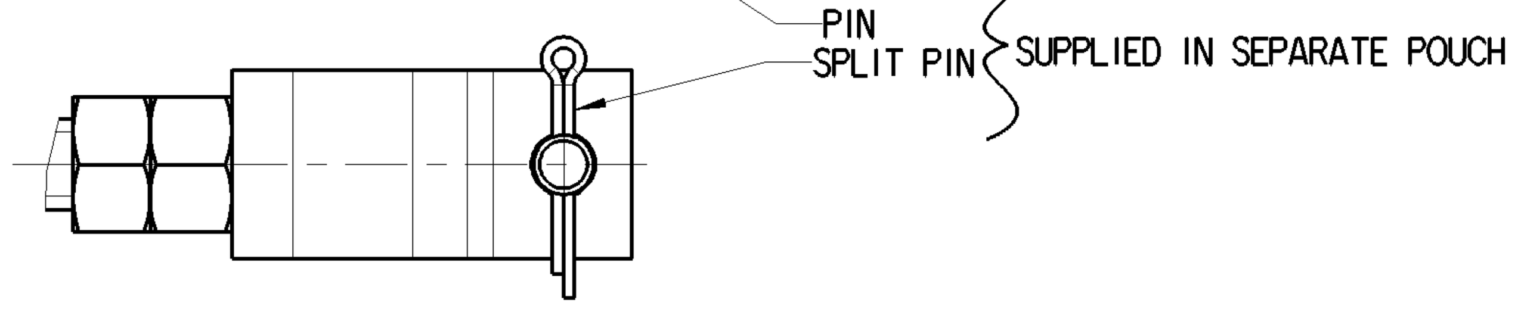


NAME PLATE DETAILS



FORK DETAIL

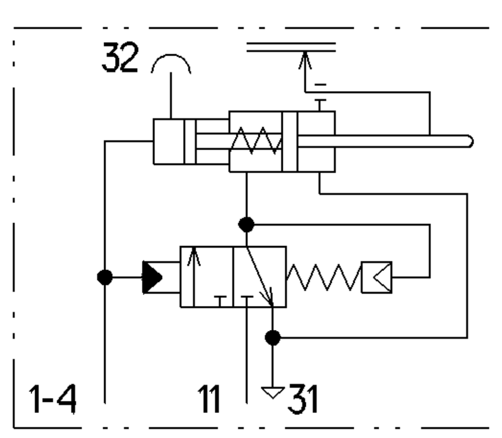




CUSTOMER	CUSTOMER PART NUMBER
VECV	ID324500

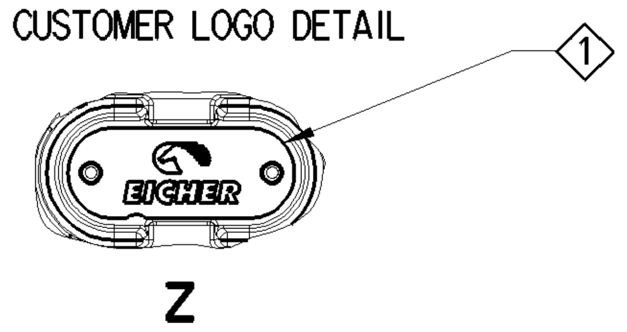
MARKING OF PORTS	
11	AIR INLET
1-4	OIL INLET
31	AIR EXHAUST
32	BLEED SCREW

TORQUE FOR CONNECTIONS	
	1 10±1 Nm
	2 22.5±2.5 Nm
	3 31.5±2.5 Nm



SYMBOL

CUSTOMER LOGO DETAIL



Z

MARKED ACCORDING TO STD 5051,16

1 MET 3.2-30-D15

Sl No.	NOTES		
1	PRODUCT SPECIFICATION No.		PS 9700514940
2	OIL VOLUME INPUT		V=(SHxC)+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 -0.02 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 STROAGE AND TRANSIT PURPOSE		

General Specification: JED-334-0 , Size ISO 14405-1 E
Further Technical Data:
Doc. Code: Sheet: To
General Tolerances JED-261

Class 1)		≤ 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. IS 14962
1) Tolerance Class Applied Crossmarked

Date	Signature
Drawn	
2021-09-20	Saravanan N
Checked	
2021-09-20	Kalimuthu P S
Expert	
Kalimuthu P S	

WABCO

CLUTCH SERVO (3")

Mass	Scale	Material No.	Doc.Code	Language	Sheet
2.2 KG	1:1 1:2 2:1	970 051 631 0	005	EN	1/1

Date of first issue: 2014-05-15

Size	CAD System	ECN-No.	Revision	Techn. Resp.	Replacement for
A 1	CREO	509205	3x B	5630	/

100mm