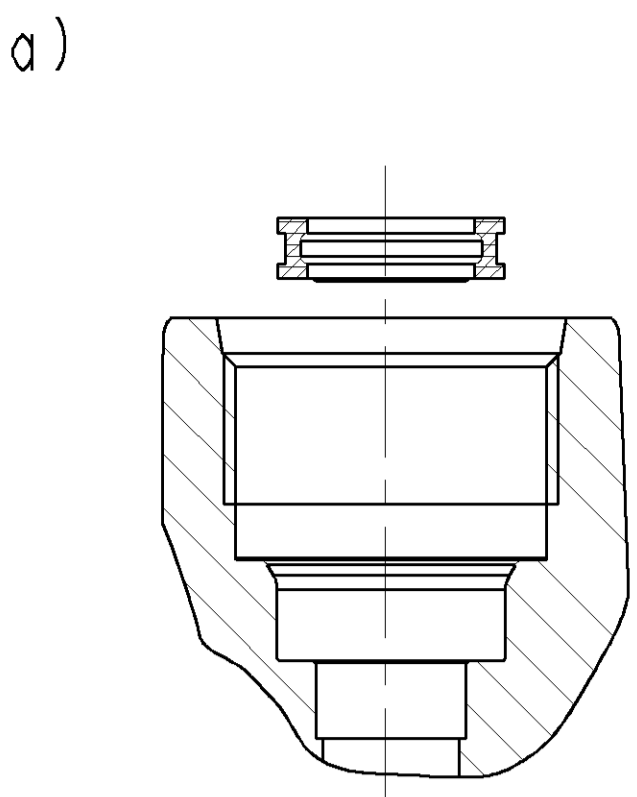
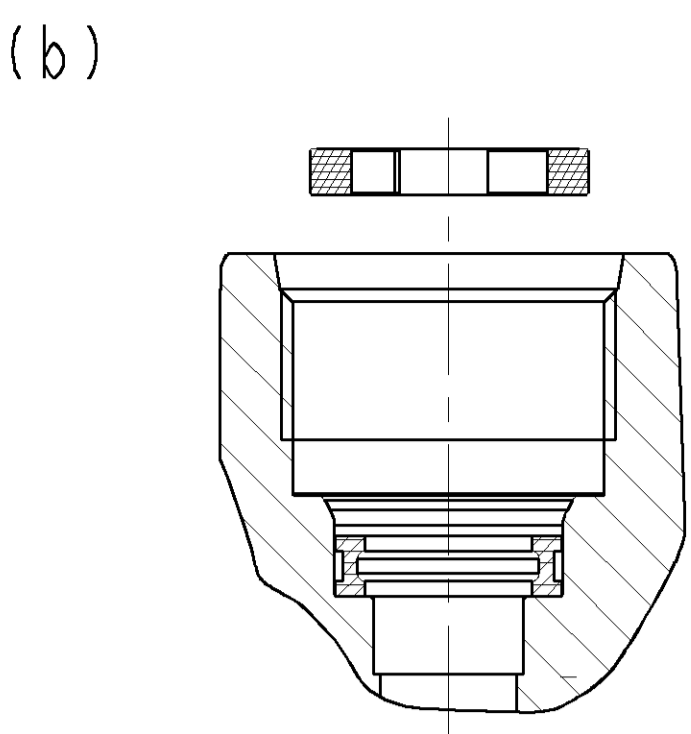


PART NO.		M252640	GA
ENGINEERING CHANGES			
ECR NO.	DATE	REV	SIGN
10764	29.05.07	New	ASK
11374	08.02.09	1	RBS
Is Name plate ad Caution sticker Company name changed from Sundaram Clayton Ltd to WABCO- TVS (INDIA) Ltd. Drawing redrawn			
11848	12.04.10	2	VPS
Surface protection for flange updated. DIM 84 was 83.9. Drawing redrawn.			
12083	16.03.11	3	RBS
Drawing template WABCO was WABCO-TVS (INDIA) Ltd. Drawing pictorially modified inline with parts. Drawing redrawn.			

ASSEMBLY PROCEDURE

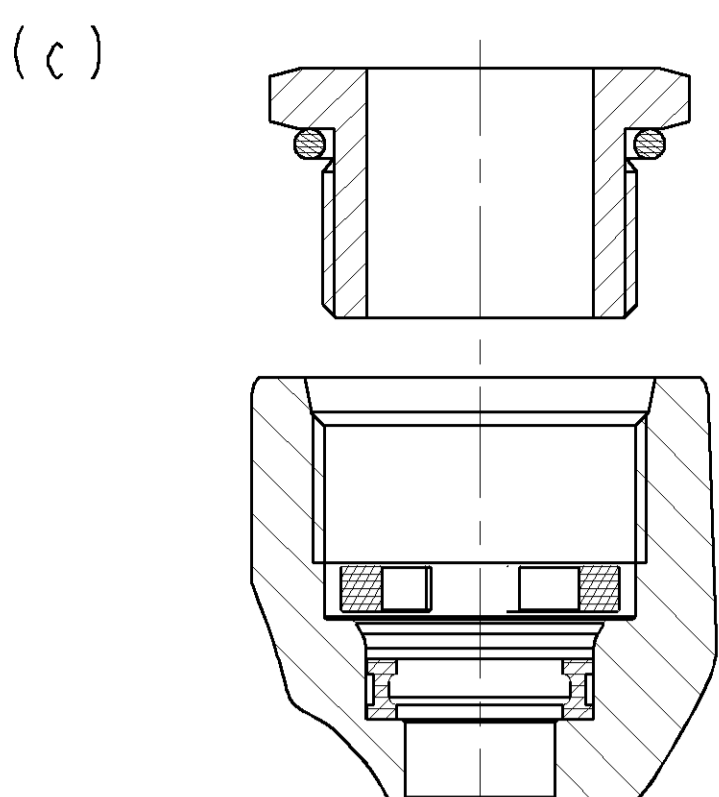


THE SPRING ELEMENT IS INSERTED INTO THE CHAMBER UNDER THE THREAD ROOT OF THE CONNECTION BORE (a) AND (b).

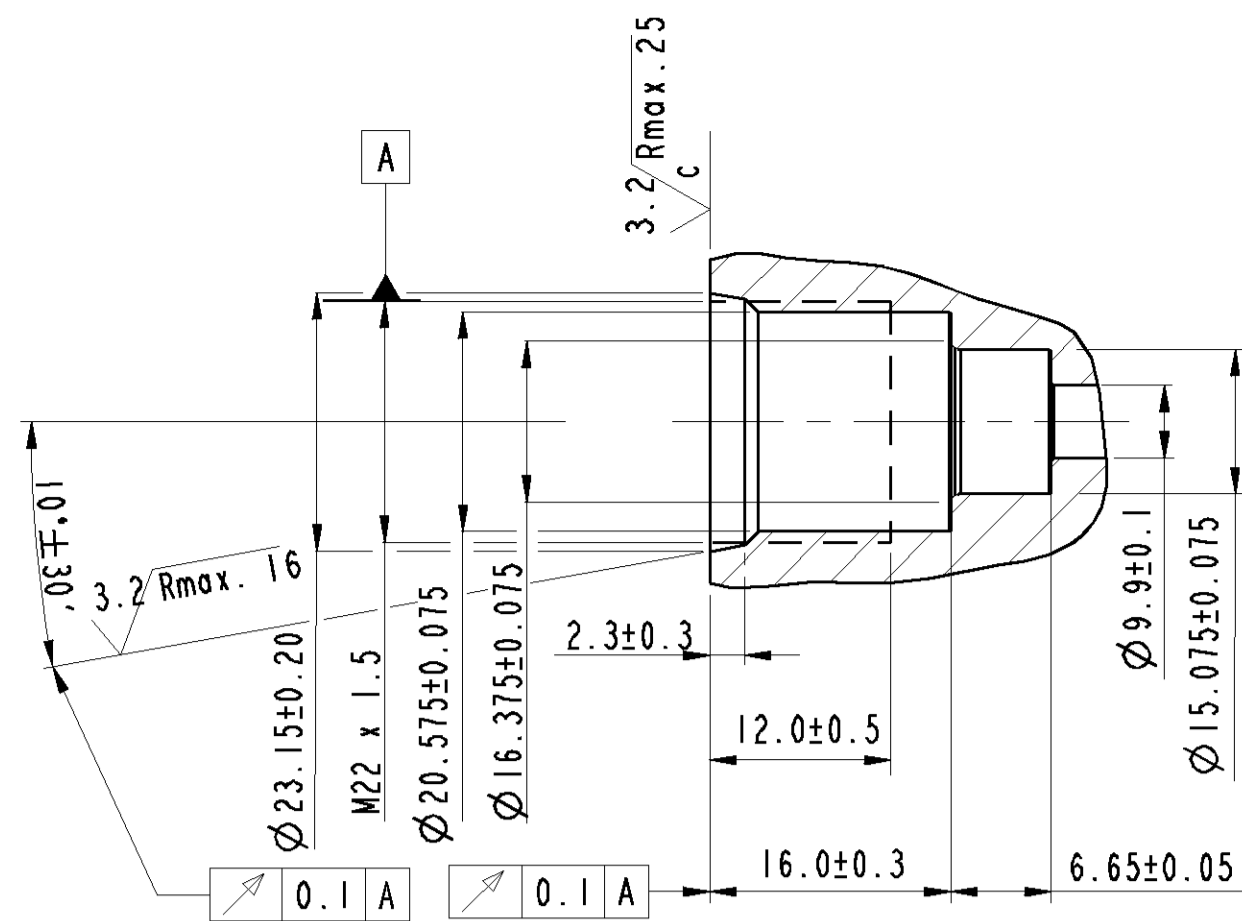


THE RETAINING CLIP IS INTRODUCED SO THAT IT RESTS FLAT ON THE THREAD ROOT (b) AND (c).

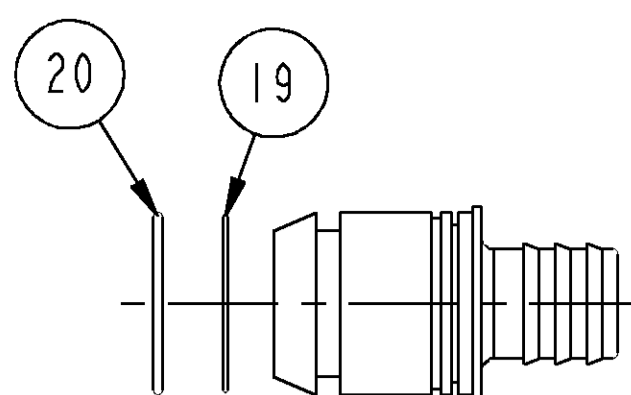
THE SPRING ELEMENT AND RETAINING CLIP ARE SYMMETRICAL.



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

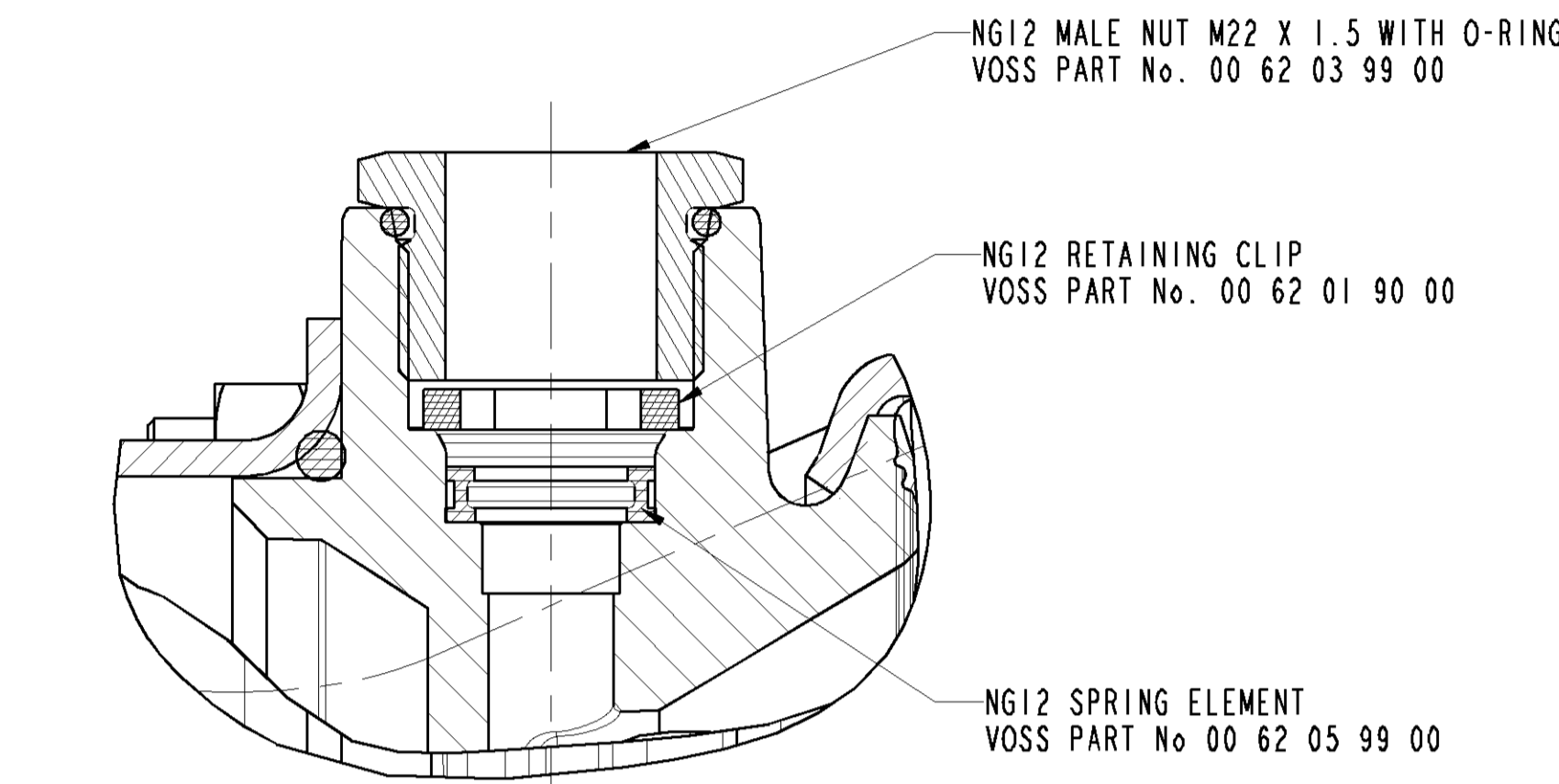
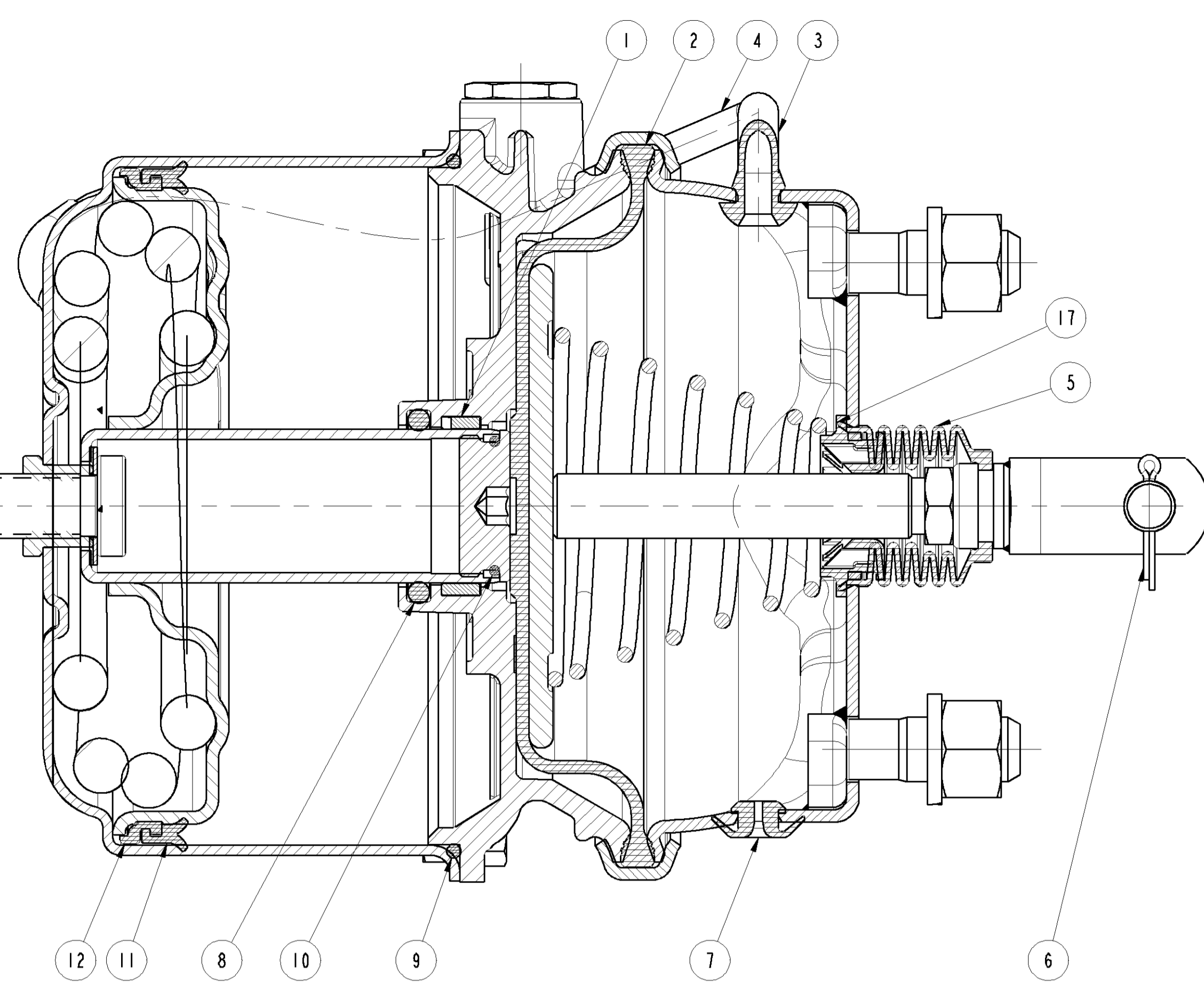
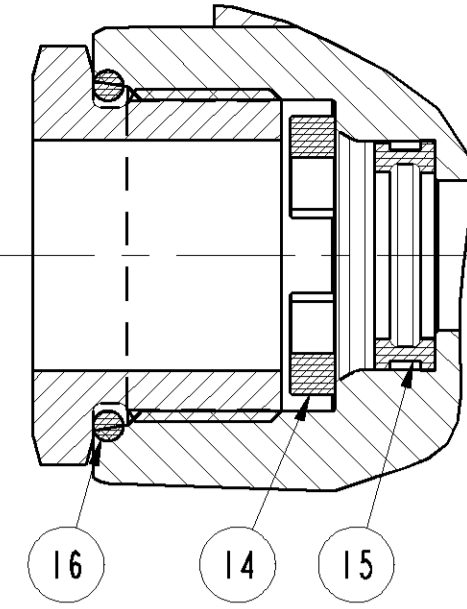


CUSTOMER END DETAIL

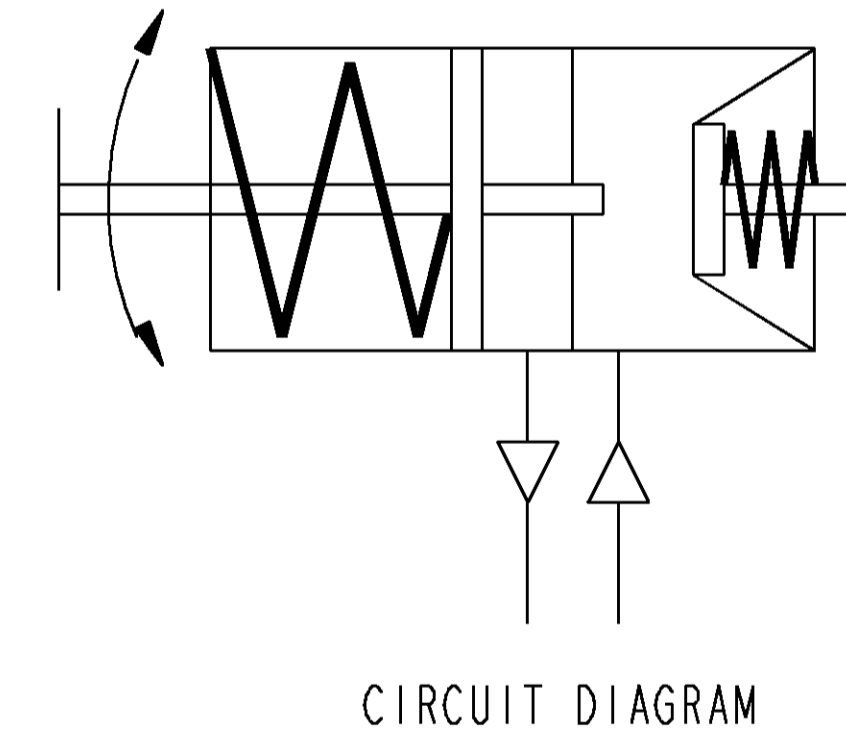
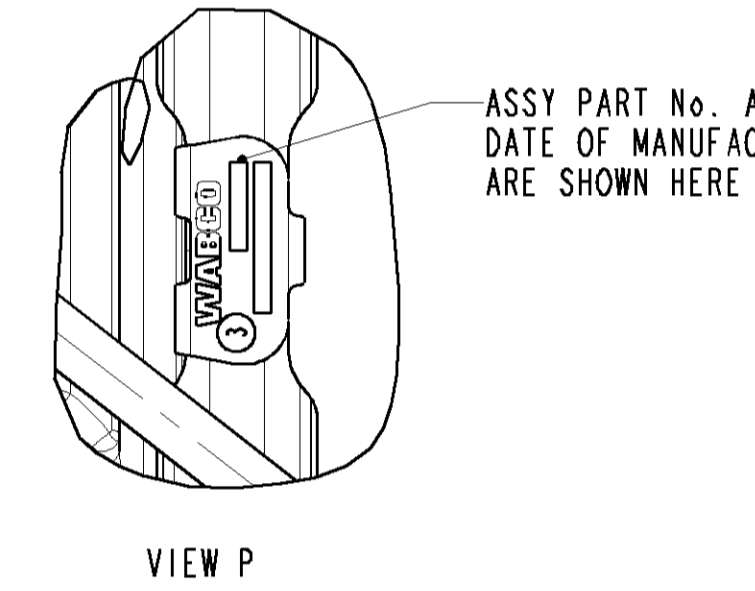
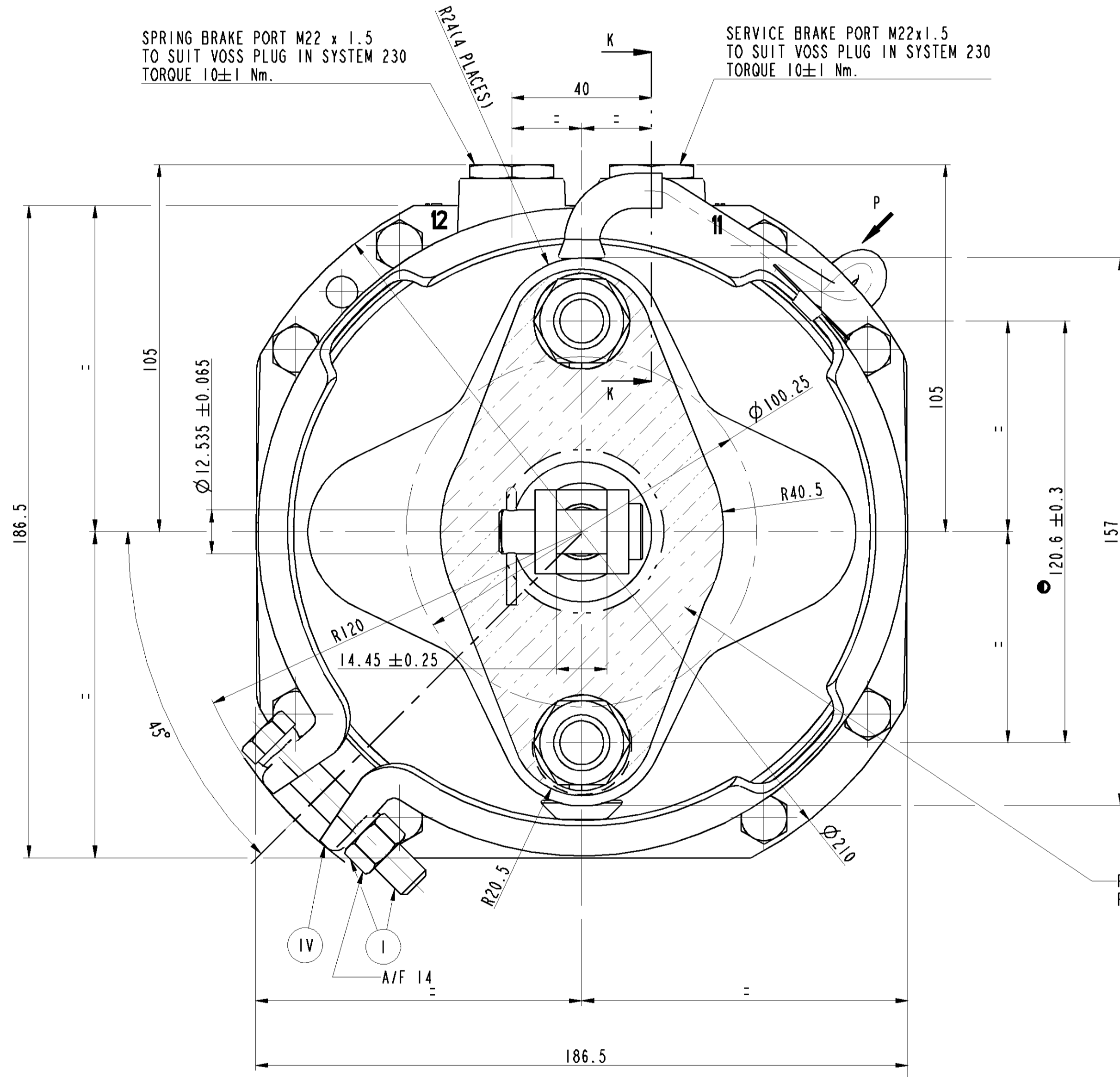
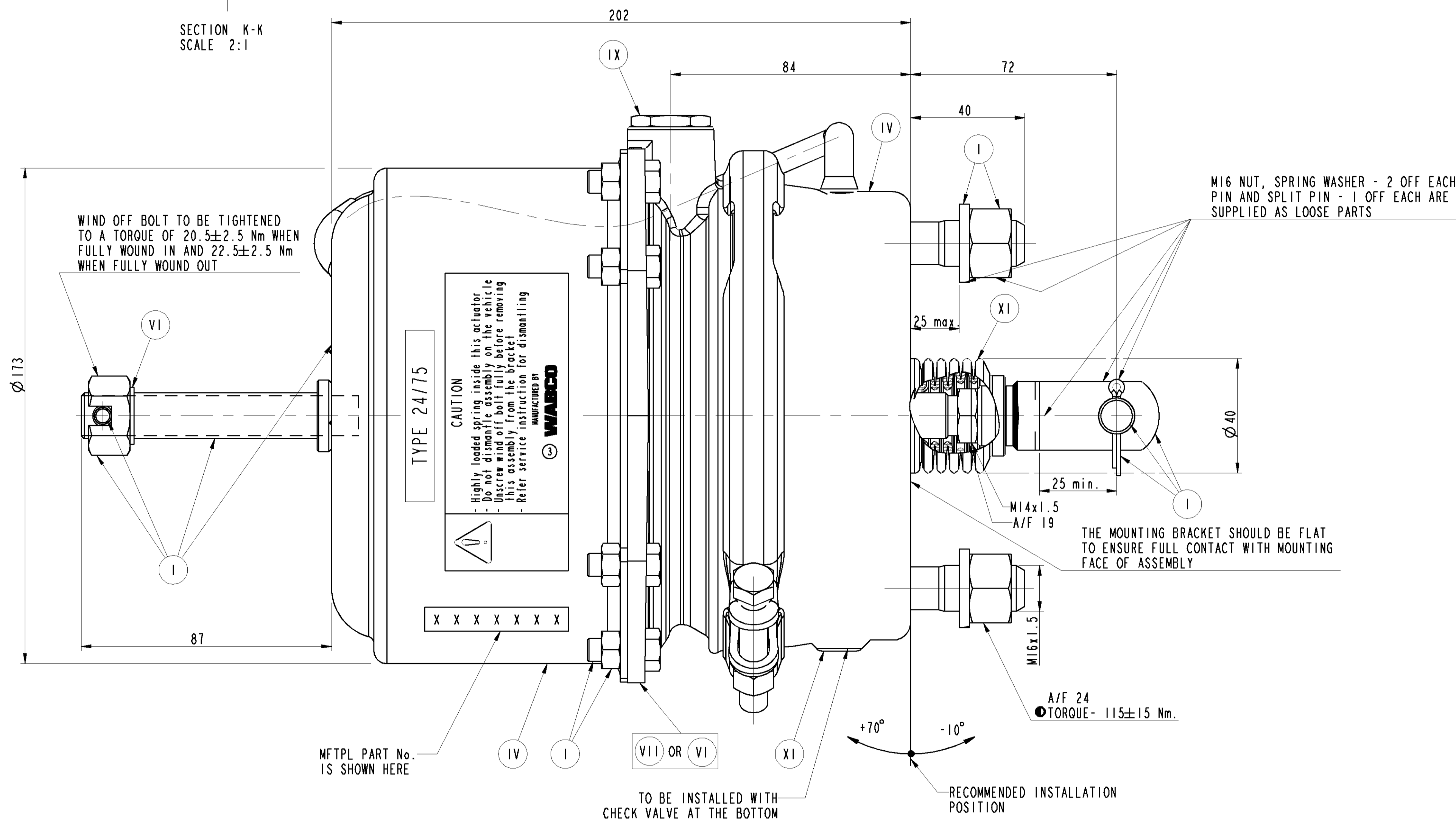
REPAIR KIT MSP 25/33 CONSISTS OF ITEMS MARKED

Sl.No	SCL	PART No.	DESCRIPTION	QTY
1		M270130	BEARING	1
2		M843331	DIAPHRAGM	1
3		M273660	ELBOW	2
4		M273690	TUBE	1
5		M275040	GAITER	1
6		M911880	SPLIT PIN	1
7		M275530	CHECK VALVE	1
8		M852060	SEALING RING	1
9		M925510	SEALING RING	1
10		M925560	SEALING RING	1
11		M275020	SEAL	1
12		M275010	BEARING	1
13		M274070	KNURL PIN	1
14		M932730	RETAINER NG-12	2
15		M932720	SPRING ELEMENT NG-12	2
16		M932700	SEALING RING NG-12	2
17		M275030	DUST SEAL	1
18		M910120	WASHER	1
19		M935980	SEALING RING NG-12	2
20		M935990	SEALING RING NG-12	2
21		M919910	GREASE SACHET	4

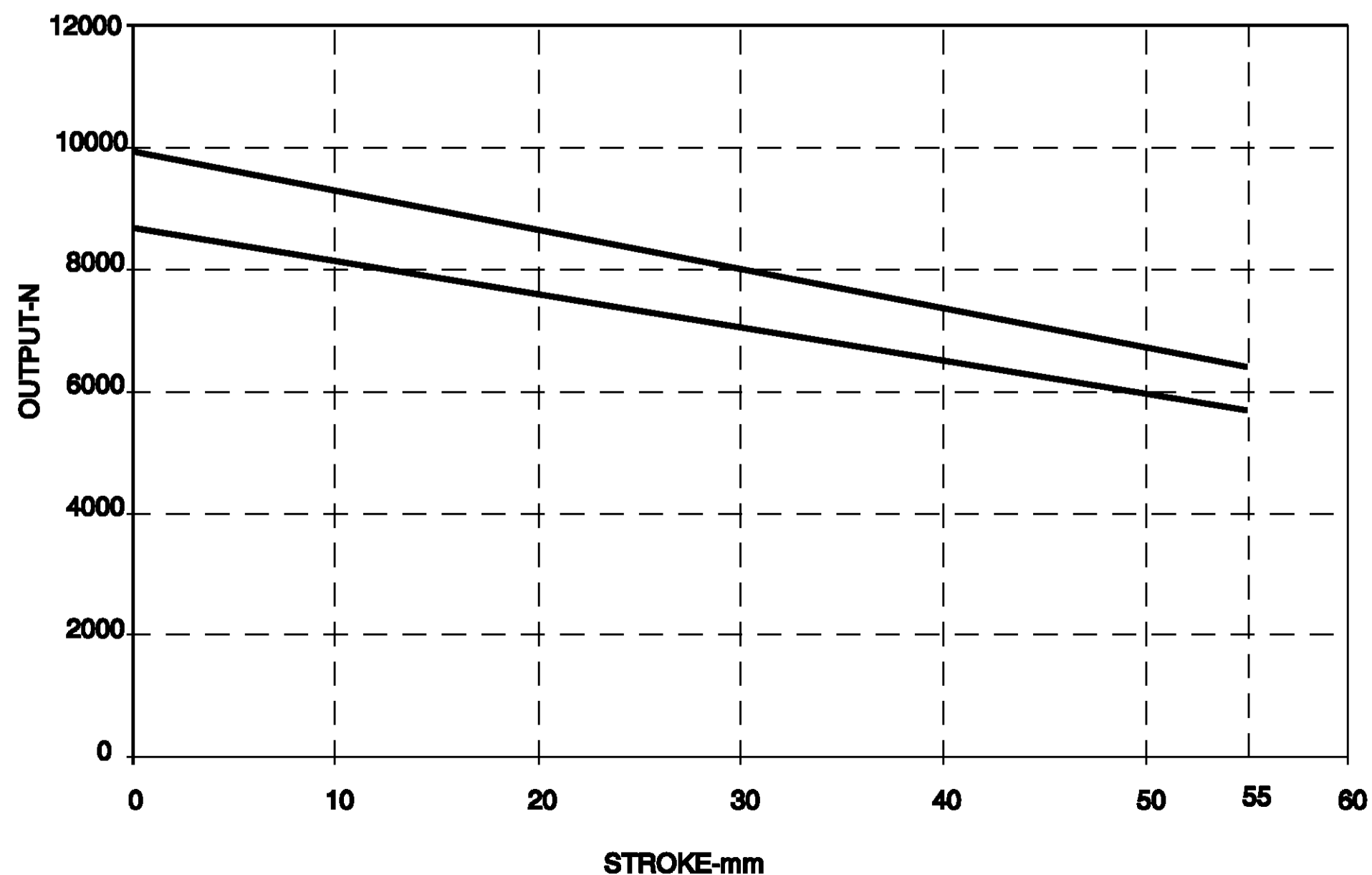
PART No. M925940 AND M912620 PROVIDED IN THE KIT TO STANDARDISE THE REPAIR KIT FOR SPRING BRAKE ACTUATOR VARIANTS.



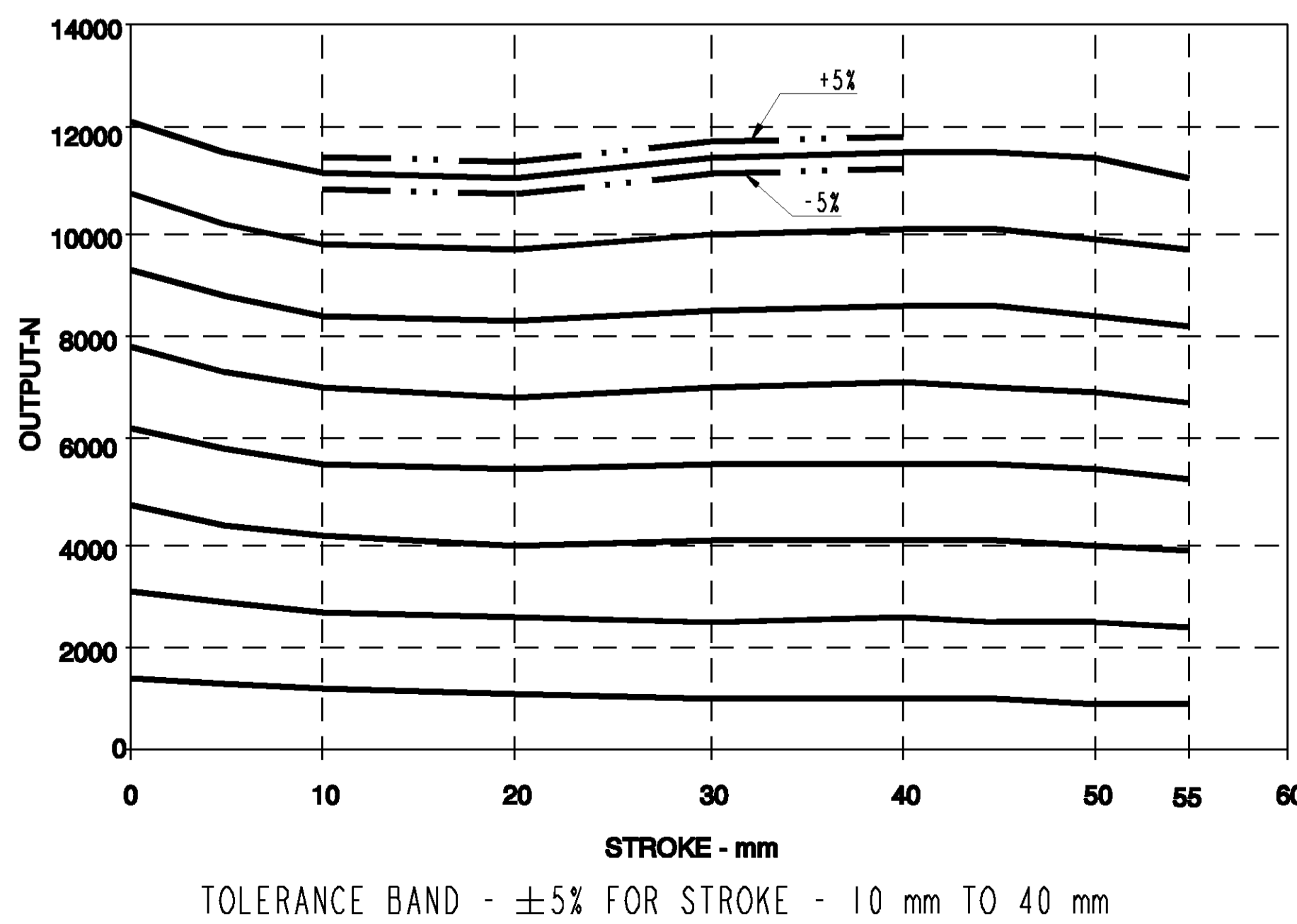
SECTION K-K
SCALE 2:1



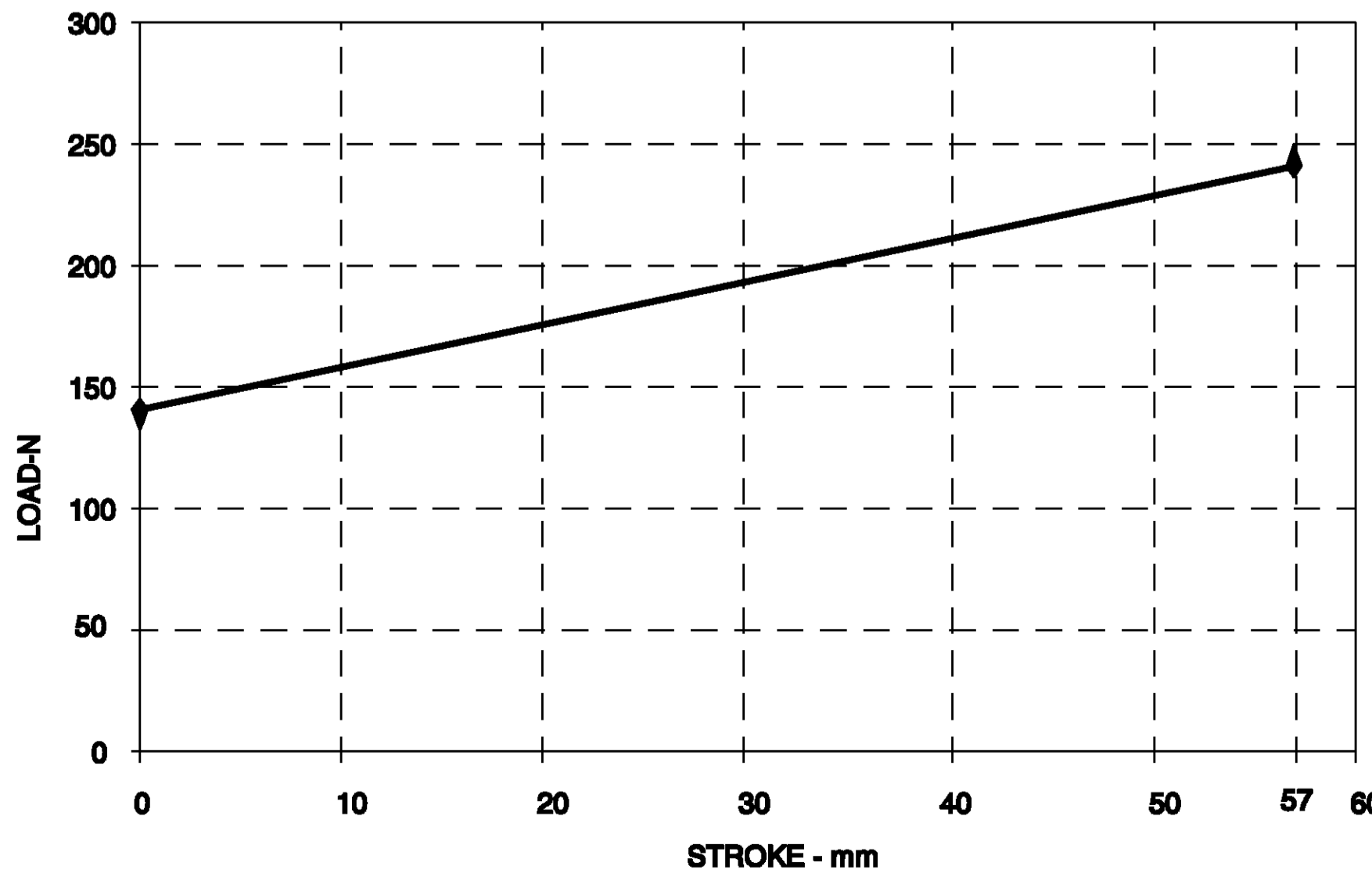
PERFORMANCE CHARACTERISTICS- SPRING SIDE



PERFORMANCE CHARACTERISTICS - SERVICE SIDE



RETURN SPRING CHARACTERISTICS



XVII	STEEL	NO TREATMENT
XVI	CAST IRON	PLATED
XV	STEEL	ZINC IRON PLATED
XIV	CAST IRON	NO TREATMENT
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

SIGN	DATE	MATERIAL	---
DRN	RNK	15.03.11	ALTERNATE MATERIAL
CRD	RBS	15.03.11	SURFACE PROTECTION
APD	SN	15.03.11	RAW PART No.

CONFIDENTIAL DRAWING

THIS DRAWING IS THE SOLE PROPERTY OF WABCO. IT SHOULD NOT BE COPIED OR COMMUNICATED TO ANY PERSON WITHOUT THE WRITTEN APPROVAL OF WABCO.

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS IN mm

REMOVE BURRS AND SHARP EDGES FROM FINISHED PARTS
ALL DIMENSIONS ARE AFTER SURFACE PROTECTION / TREATMENT
MALE THREAD TO IS 14992 (PART3) 6H - 2001
FEMALE THREAD TO IS 14992 (PART3) 6H - 2001

GENERAL TOLERANCES

RANGE OF NOMINAL DIMENSIONS	±
≤ 50	± 0.1
> 50 ≤ 100	± 0.15
> 100 ≤ 400	± 0.2
> 400 ≤ 1000	± 0.3
> 1000	± 0.5

SCALE

1:1

WABCO
AMBATTUR, CHENNAI - 600058, INDIA

SPRING BRAKE ACTUATOR
TYPE 24/75

PART No.
M252640

MFTPL PART No. 64.52130-6013