

PART No.

M401090

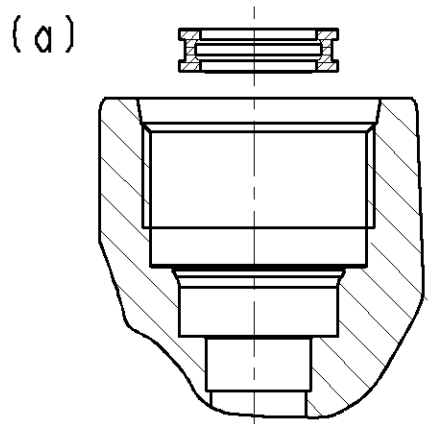
GA

ENGINEERING CHANGES

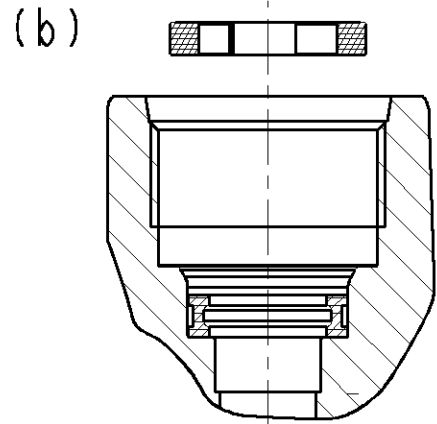
ECN No.	DATE	REV	SIGN
11442	24.04.09	New	PSK
12083	16.03.11	1	RBS

Drawing template WABCO was WABCO-TVS (INDIA) Ltd. Drawing pictorially modified inline with parts. Drawing redrawn.

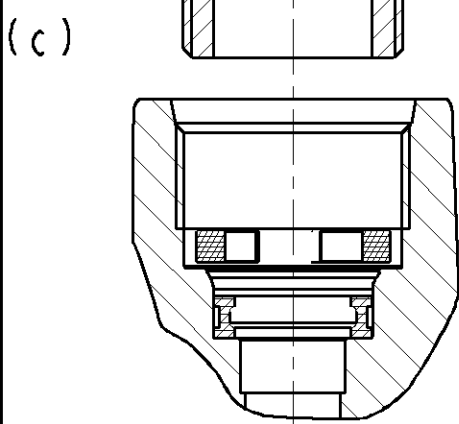
ASSEMBLY PROCEDURE



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

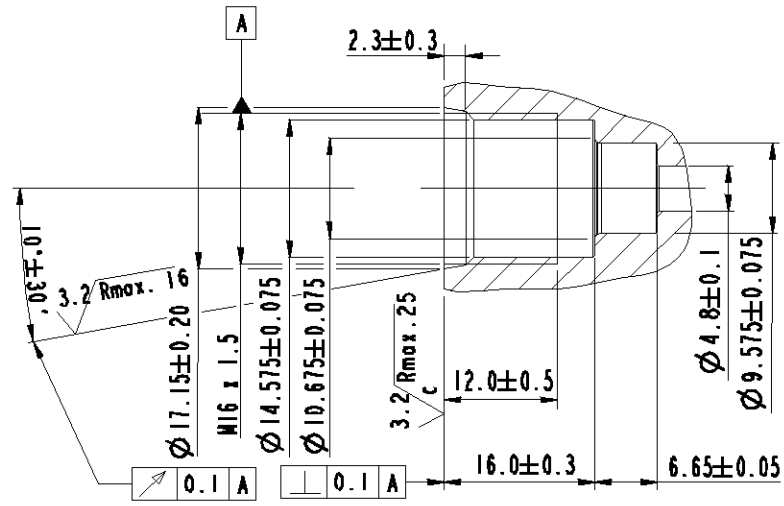
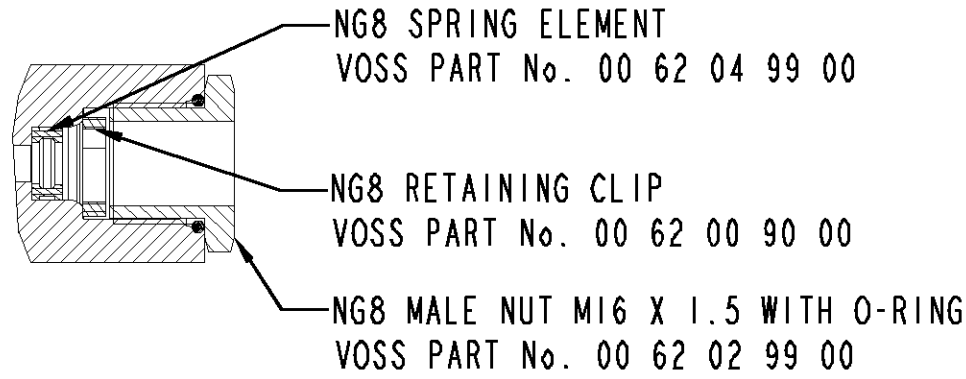


THE RETAINING CLIP IS INTRODUCED SO THAT IT RESTS FLAT ON THE THREAD ROOT (b) AND (c). THE SPRING ELEMENT AND RETAINING CLIP ARE SYMMETRICAL.

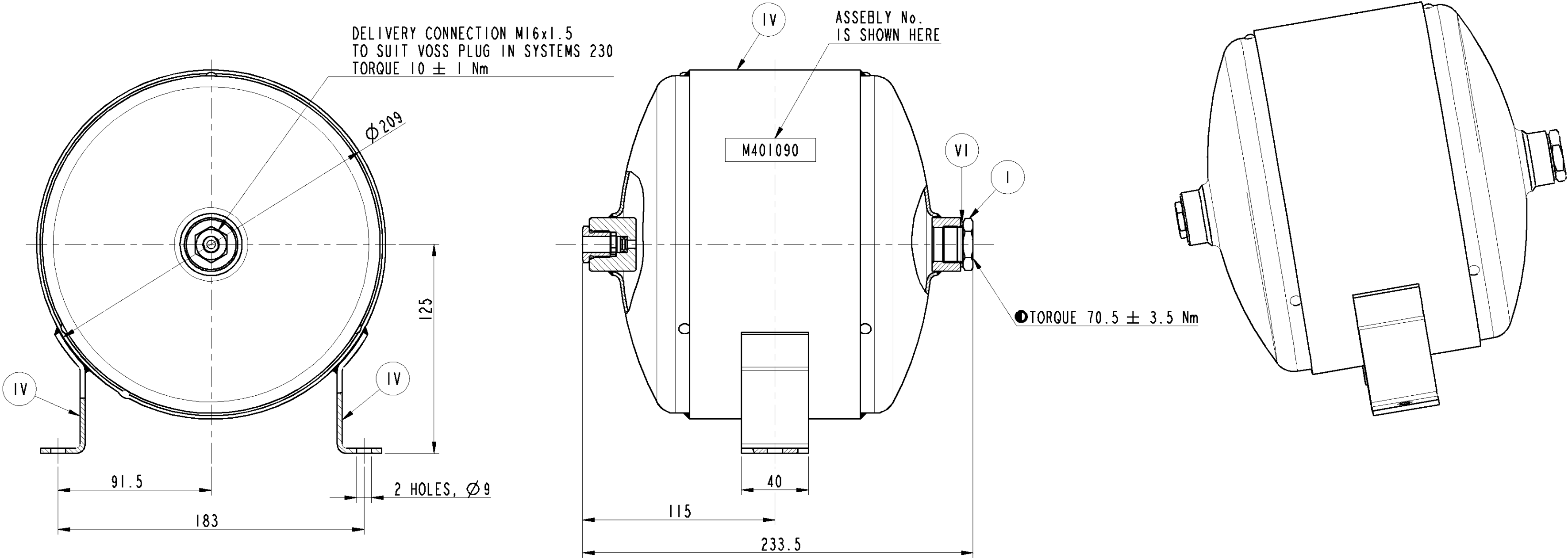


THE MALE FITTING PRE-ASSEMBLED WITH THE PRE-GREASED O-RING TO SEAL THE THREAD IS SCREWED BY HAND INTO THE TAPPED BORE (c) AND TIGHTENED.

DO NOT SCALE IF IN DOUBT ASK



DETAILS OF PORT MACHINING FOR M16x1.5



● CRITICAL  
● MAJOR  
NO SYMBOL - MINOR

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
PART CODE	MATERIAL	SURFACE PROTECTION

NOTES:		
1	PRODUCT FUNCTION AND RELIABILITY	
1.1	PRODUCT SPECIFICATION No. (ISSUE No.2, DATE: 18.05.02)	PSSC 93C
1.2	CAPACITY	5 LITERS
1.3	WORKING PRESSURE	10 bar
2	WEIGHT	3.2 Kg
3	OPEN PORTS ARE FITTED WITH CLOSURE PLUGS FOR STORAGE AND TRANSIT PURPOSES.	

**WABCO**  
AMBATTUR, CHENNAI - 600058, INDIA

	SIGN	DATE	MATERIAL	----
DRN	KA	15.03.11	ALTERNATE MATERIAL	----
CHD	RBS	15.03.11	SURFACE PROTECTION	REFER TABLE
APD	SN	15.03.11	RAW PART No.	----

CONFIDENTIAL DRAWING

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UNLESS OTHERWISE SPECIFIED ALL DIMENSION IN mm. REMOVE BURRS AND SHARP EDGES FROM FINISHED PARTS. ALL DIMENSIONS ARE AFTER SURFACE PROTECTION / TREATMENT

MALE THREAD TO IS 14962 (PART3) 6H : 2001

FEMALE THREAD TO IS 14962 (PART3) 6H : 2001

GENERAL TOLERANCES				
RANGE OF NOMINAL DIMENSIONS (± mm)				FORCE, POWER, PRESSURE etc. (± %)
≤ 50	≤ 50	≤ 180	≤ 400	± 0.1
1	2	3	4	3
100 mm				10

SCALE 1:2

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PURGE TANK

PART No. M401090

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