

SECTION AT-AA

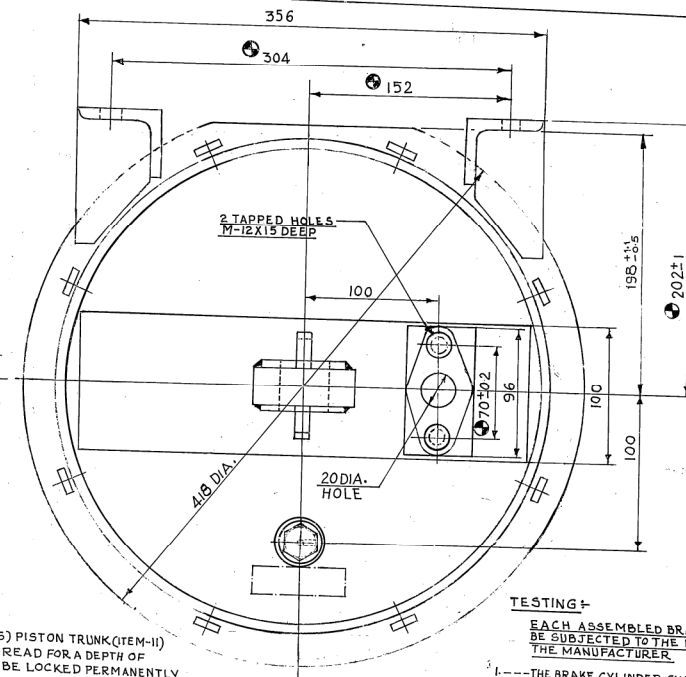
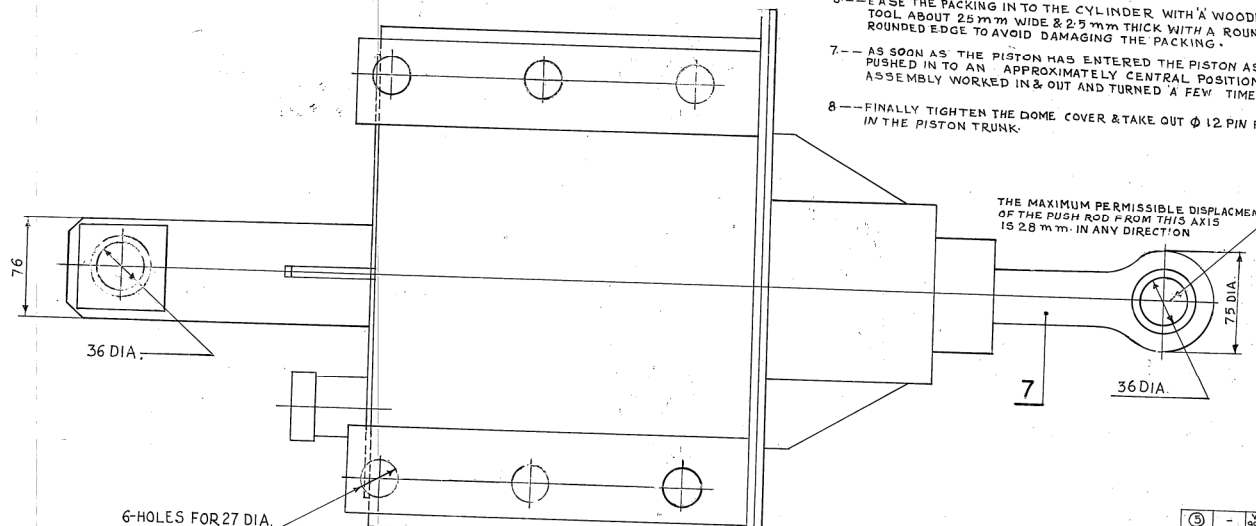
#### ASSEMBLY:-

1. AFTER ASSEMBLY OF PISTON ROD (ITEM-7) PIN (ITEM-6) PISTON TRUNK (ITEM-11) ON PISTON (ITEM-3) DRILL 18 mm DEEP & TAP M-6 FINE THREAD FOR A DEPTH OF 11 mm & CSK  $\phi 12 \times 90^\circ$  AT TWO LOCATIONS THE SCREWS TO BE LOCKED PERMANENTLY BY DEFORMING TUBE IN TO THE SLOT IN SCREW HEAD.
2. ASSEMBLE THE PISTON RETURN SPRING ON TO THE PISTON HEAD & INSERT THE DOME COVER OVER THE PISTON TRUNK.
3. PUT ONE  $\phi 12 \times 25$  mm LONG HEADED PIN IN TO THE HOLES PROVIDED IN THE EXTENDED PORTION OF PISTON TRUNK.
4. FIT THE PISTON PACKING & BEAR RING.
5. SMEAR THE PISTON HEAD & IN SIDE OF CYLINDER BODY WITH SMALL AMOUNT OF MP-2 GREASE & INTER THE LOWEST PART OF THE PISTON & PACKING OBLIQUELY.
6. EASE THE PACKING IN TO THE CYLINDER WITH A WOODEN SPATULA TYPE TOOL ABOUT 25 mm WIDE & 2.5 mm THICK WITH A ROUNDED NOSE AND ROUNDED EDGE TO AVOID DAMAGING THE PACKING.
7. AS SOON AS THE PISTON HAS ENTERED THE PISTON ASSEMBLY SHOULD BE PUSHED IN TO AN APPROXIMATELY CENTRAL POSITION & THE WHOLE ASSEMBLY WORKED IN & OUT AND TURNED A FEW TIME TO DISTRIBUTE THE GREASE.
8. FINALLY TIGHTEN THE DOME COVER & TAKE OUT  $\phi 12$  PIN FROM THE HOLE IN THE PISTON TRUNK.

#### NOTE:-

1. PISTON STROKE 203 mm.
2. WEIGHT 70 KG APPROX. (WITH FABRICATED BODY)
3. DIMENSIONS MARKED THUS  $\phi$  SHALL BE GAUGED.
4. FOR ALL OTHER REQUIREMENTS REFER LATEST REVISION OF R.D.S.O SPECIFICATION NO. 02-ABR APPENDIX-1
- \* 5. ITEM NO-16 SHALL BE PROVIDED ON BRAKE CYLINDER FOR PASSENGER STOCK ONLY.
6. DRAWING WD-92051-S-07 & WD-94048-S-01 ARE PERMISSIBLE ALTERNATIVES THE ASSEMBLY SHOWN IN THIS DRAWING IS WITH FABRICATED CYLINDER BODY. NO SEPARATE DRAWING IS AVAILABLE FOR ASSEMBLY WITH CAST IRON BODY.
7. FULCRUM BRACKET ON CYLINDER BODY IS NOT REQUIRED FOR PASSENGER STOCK SEE NOTE NO 8 OF DRAWING NO. WD-92051-S-07.

THE MAXIMUM PERMISSIBLE DISPLACEMENT OF THE PUSH ROD FROM THIS AXIS IS 28 mm. IN ANY DIRECTION



#### TESTING:-

EACH ASSEMBLED BRAKE CYLINDER SHALL BE SUBJECTED TO THE FOLLOWING TEST BY THE MANUFACTURER

1. THE BRAKE CYLINDER SHALL BE MOUNTED ON A FIXTURE TO LIMIT THE STROKE TO 85 mm & TESTED FOR LEAK AT  $0.7 \text{ Kg/cm}^2$  THE LEAKAGE SHOULD NOT EXCEED  $0.1 \text{ Kg/cm}^2$  IN 10 MINUTES
2. THE PISTON STROKE SHALL BE ADJUSTED TO 130 mm AND BRAKE CYLINDER TESTED FOR LEAK AT  $3.8 \text{ Kg/cm}^2$  THE LEAKAGE SHOULD NOT EXCEED  $0.1 \text{ Kg/cm}^2$  IN 10 MINUTES

COMPR BY	SIG.	DATE
M.Y.A.L.	MA	5/96

GY. NO.	N1	N2	N3	N4	N5	N6	N7	N8	N9	N10	N11	N12
Rd 14M	0.05	0.05	0.1	0.2	0.4	0.8	0.6	3.2	6.3	12.5	25	50
SYMBOL	▼	▼	▼	▼	▼	▼	▼	▼	▼	▼	▼	▼

SURFACE ROUGHNESS VALUE TO IS: 3073

REVISED	DATE
1	3/99
2	5/06
3	12/99
4	11/94
5	2/74
6	12/03

ALT. ITEM AUTHY DESCRIPTION DATE ASSLY. DRGS.

ITEM	DESCRIPTION	NO. OF	REF. DRG.	NTAF	MATLS SPEC	REMARKS
17.	LEATHER WASHER	1	WD-92051-S-02			
* 16.	ANTI RATTLE RING	1	WD-92051-S-09			
15.	30° CSK SCREW M-6 X 10	2			15:1365	
14.	BOLT	8	WD-92051-S-09			
13.	SCREW	2				
12.	HEX NUT & SPRING WASHER M-12	8			15:1365 15:3665	
11.	PISTON TRUNK	1	WD-92051-S-09			
10.	SPRING	1	WD-92051-S-09			
9.	DOME COVER	1	WD-92051-S-09			
8.	NAME PLATE	1	WD-92051-S-09			
7.	PISTON ROD ASSEMBLY	1	WD-92051-S-08			
6.	PIN	1	WD-92051-S-09			
5.	WEAR RING	1	WD-92051-S-09			
4.	PISTON PACKING	1	WD-92051-S-10			
3.	PISTON	1	WD-92051-S-08			
2.	DRAIN PLUG	1	WD-92051-S-09			
1.	CYLINDER BODY	1	WD-92051-S-07			
ITEM	DESCRIPTION	NO. OF	REF. DRG.	NTAF	MATLS SPEC	REMARKS
1:2	CHECKED BY	DATE				
	SCALE	PASSED	DATE			
	DRAWN	AS SHOWN	DATE			
	TRACED	S. PLANT	DATE			
	J. SHEET					

FOR AIR BRAKE ON FREIGHT AND PASSENGER STOCK

BRAKE CYLINDER 355 mm

B.G. R.D.S.O. GROUP (W) WD-92051-S-06