



Product Information

EPIC ENTERPRISES, INC.



REPAIR OF BRAKE AIR PRESSURE CYLINDERS

*FOR VOLKMANN 05 BA3/BA4/BA5/BA8
OEM 120329, 132316, 425785 OR 476614*



EE440004

Repair Kit for
05 Brake Pressure Cylinder



EE401850

Tip, Repair, for
Air Brake Cylinder, 05



OEM 120329,
132316, 425785

OEM 476614

REPAIR OF VOLKMANN BRAKE AIR PRESSURE CYLINDER 120329, 132316, 476614 or 425785:

The plastic plunger tip of these brake cylinder assemblies is subject to breakage. The cylinder can't be disassembled to replace only the plunger, so it has been necessary to replace the entire cylinder-- a costly part. Epic offers a low-cost replacement aluminum plunger tip (EE401850) and a permanent kit (EE440004) of tools with easy to follow instructions on repair.



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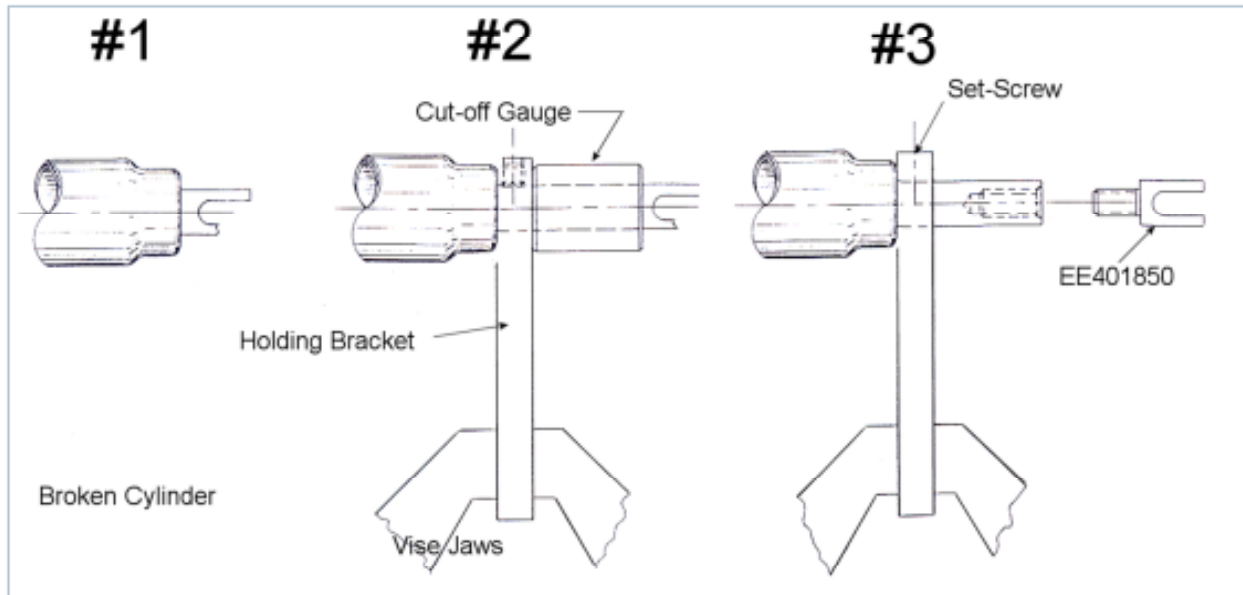
Epic products are intended as replacements for worn or damaged parts in OEM products. OEM Part numbers in (parenthesis) indicate either 1) improved design 2) the part serves the same function as the OEM part, but may differ from the OEM design, 3) it is a component of an assembly where no OEM reference number is available, or 4) it is a repair service for the referenced part.

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AIR CYLINDER REPAIR INSTRUCTIONS FOR VOLKMANN 120329, 132316, 425785, OR 476614 Using Epic Repair Tip (Clevis) EE401850 and Repair Kit EE440004



1. Clamp the holding bracket into vise.
2. Fully extend cylinder shaft and insert through hole in holding bracket.
3. With shaft completely extended and face of cylinder housing firmly against the face of the holding bracket, secure the shaft using the set screw in the holding bracket.
4. Slip the cut-off gauge over the shaft, and using a saw, cut the broken end of the shaft flush with the outer face of the gauge.
5. Using the 17/64 slow spiral drill bit, open the cylinder rod hole to a depth of 5/8" to 3/4".
6. Tap the hole to a depth of 1/2" to 5/8" full threads using the M8X1.25P tap provided.
7. Using the 3/8" x 82° countersink tool, countersink to the full 3/8" diameter.
8. Deburr or sand rough edges and screw the repair tip into place. The cylinder shaft should seat firmly against the shoulder of the repair tip.
9. Holding the repair tip or cylinder shaft, loosen the set screw and examine the set screw mark on the cylinder shaft. If needed, file or sand the mark to remove any burrs. You can now remove the cylinder from the holding bracket.

Note: The drill bit provided in the repair kit is specially designed for this application.

IMPORTANT: Do not remove the cylinder from the holding bracket until the repair tip (clevis) is firmly in place.



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