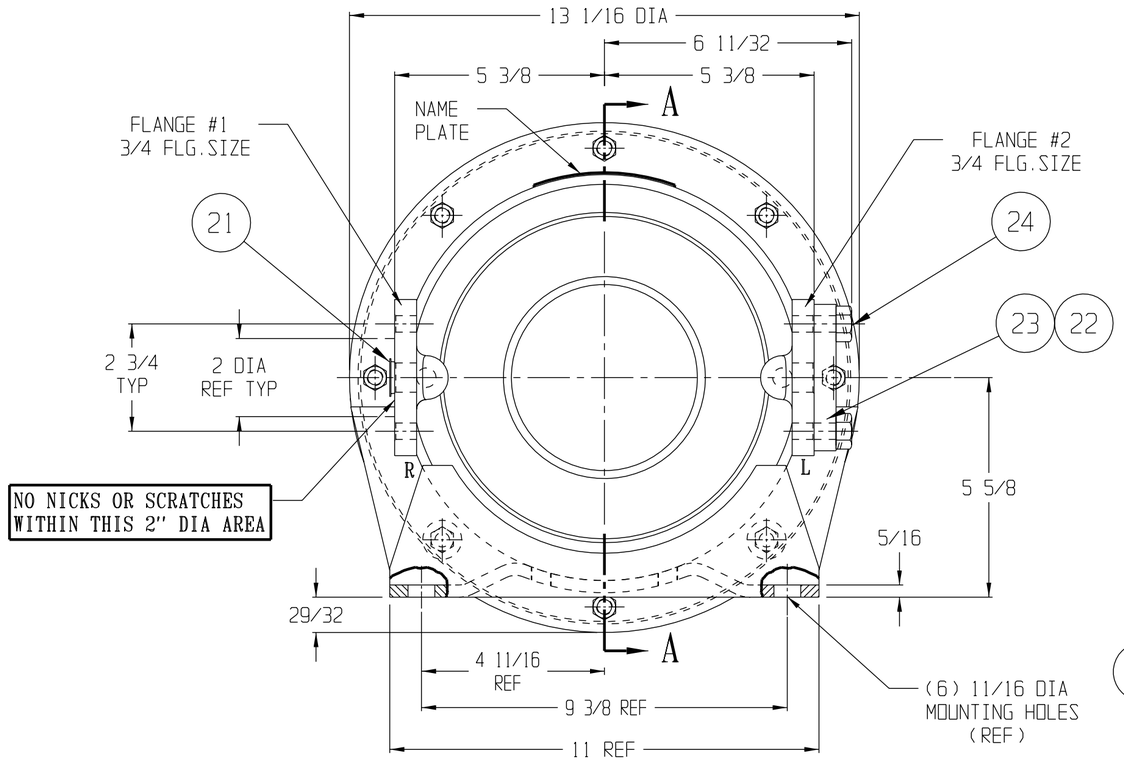
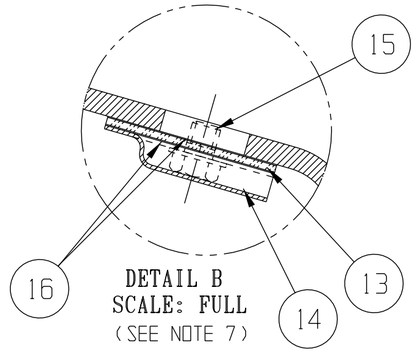
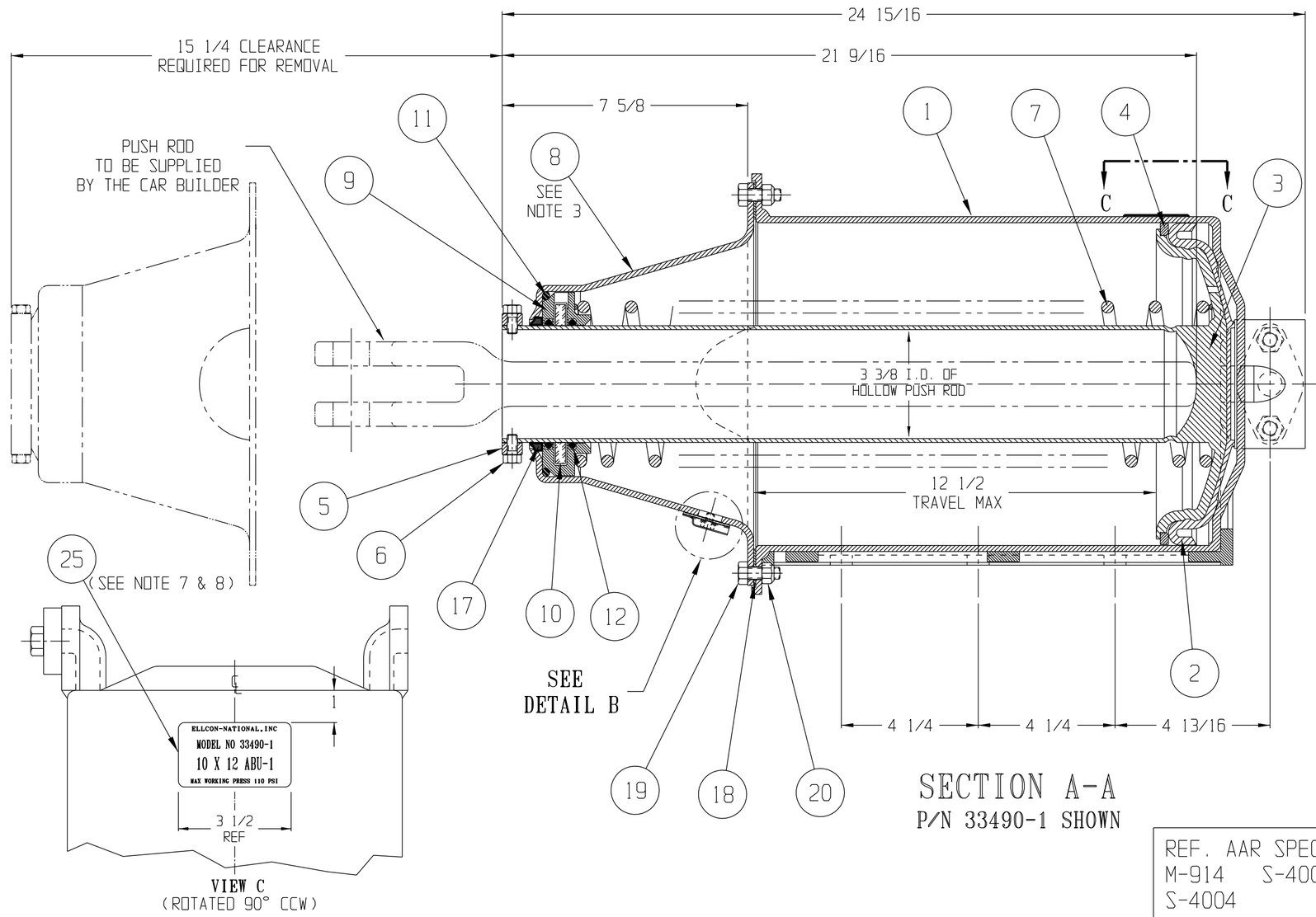


NOTES:
1- INTERIOR MUST BE CLEAN & FREE OF DIRT, GRIT, METAL CHIPS & FOREIGN MATTER.
2- APPLY BRAKE CYLINDER GREASE PER (AAR SPEC. M-914) TO ALL INTERIOR SURFACES OF CYLINDER WELDMENT (ITEM 1) AND TO SURFACES OF SPRING (ITEM 7) BEFORE ADDING PISTON ASSY (IT.2-4).
3- AFTER BOLTING TOGETHER, NON-PRESSURE HEAD (ITEM 8) MUST SEAT TIGHT INTO C'BORE OF CYLINDER WELDMENT (ITEM 1). TORQUE NUTS (IT. 20) TO 30-35 FT. LBS.
4- ALL DIMENSIONS ARE NOMINAL.
5- FINISH: A)- CYLINDER AND PISTON ARE ELECTROLESS NICKEL COATED.
B)- NON-PRESSURE HEAD IS BLACK EPOXY ELECTROSTATIC SPRAY COATED.
6- FOR ASSEMBLY ORIENTATION OF P/N'S 33490-1 THRU -6 SEE DWG C-34080 AND FOR P/N'S 33490-7 THRU -12 SEE DWG C-34630.
7- CARBUILDER TO REMOVE PROTECTIVE TAPE FROM NAME PLATE AND VENT AFTER SANDBLAST AND PAINT.
8- ABU MANUFACTURED BY FTIL-INDIA WILL HAVE A DIFFERENT NAME PLATE (IT. 25) P/N 35316-3, -4, -5, -6, -7, -8.



DETAIL B
SCALE: FULL
(SEE NOTE 7)

REVISIONS			
LTR	DATE	DESCRIPTION	BY
M	06/03/05	ADDED 2" DIA "NO NICKS OR SCRATCHES..."AREA AND NOTE. PER ECN #6286	PS
N	12-20-05	ADDED NOTE 7. PER ECN 6669	RAL
P	06/05/06	REMOVED STAMPING "E-N 33480" FROM PART (END VIEW). ECN #6991	PS
Q	10-30-06	ADDED TORQUE SPEC TO NOTE 3, NOTE 8 & REF. AAR SPECS. MOVED DATE BUILT LOCATION TO FOOT PER ECN 7321	RAL
R	04/21/08	ITEM 1 (P/N 35230) WAS 33480. MOVED NAME PL LOCATION TO BACK OF CYLINDER. ECN #8435	PS
S	04/30/08	REMOVED THE "DATE BUILT STAMP LOCATION". PER ECN #8506.	PS



SECTION A-A
P/N 33490-1 SHOWN

	-6	-5	-4	-3	-2	-1	PART No.	DESCRIPTION	ITEM
	QTY								
**	1	-	-	-	-	-	33053-8	NAME PLATE ALUMINUM	-
**	-	1	-	-	-	-	33053-7	NAME PLATE ALUMINUM	-
**	-	-	1	-	-	-	33053-6	NAME PLATE ALUMINUM	-
**	-	-	-	1	-	-	33053-5	NAME PLATE ALUMINUM	-
**	-	-	-	-	1	-	33053-4	NAME PLATE ALUMINUM	-
**	-	-	-	-	-	1	33053-3	NAME PLATE (SHOWN) ALUMINUM	25
	-	-	2	2	2	2	3442-169	CAP SCREW 1/2-13 X 1 1/4 W/PATCH STEEL GR 5	24
	-	-	1	1	1	1	33193	BLANKING PAD 3/4 STEEL	23
	-	-	1	1	1	1	32721	GASKET 3/4" PIPE NEOPRENE	22
	2	2	1	1	1	1	4087-15	PLASTIC PROTECTOR (FOR SHIPPING) PLASTIC	21
	8	8	8	8	8	8	31076-4	STOVER LOCKNUT 3/8-16 ZINC PLTD	20
	8	8	8	8	8	8	3442-204	BOLT 3/8-16x1 FULL THRD GR 5 CAD PLTD	19
	1	1	1	1	1	1	33478	GASKET NEOPRENE	18
	1	1	1	1	1	1	34274	WIPER MOLYTHANE	17
	2	2	2	2	2	2	9324	SCREENING ALUMINUM	16
	2	2	2	2	2	2	3978-1	SCREW 1/4-20 X 9/32 ZINC PLTD	15
	1	1	1	1	1	1	31564	VENT PLATE ALUMINUM	14
	1	1	1	1	1	1	9323	FELT FELT	13
	-	-	-	-	-	-	31855	VENT ASSEMBLY -	-
	2	2	2	2	2	2	3918-44	O-RING BUNA N	12
	1	1	1	1	1	1	3918-45	O-RING BUNA N	11
	1	1	1	1	1	1	31607	FELT FELT	10
	1	1	1	1	1	1	31606	RETAINER DELRIN	9
	-	-	-	-	-	-	31608	SEAL ASSEMBLY -	-
	1	1	1	1	1	1	34872	NON-PRESSURE HEAD STEEL	8
	-	-	-	-	-	-	33670	NON-PRESSURE HEAD ASSEMBLY -	-
	1	1	1	1	1	1	33046	SPRING STEEL	7
	2	2	2	2	2	2	3442-72	BOLT 5/16-18x5/8 W/PATCH GR 5 ZINC PLTD	6
	1	1	1	1	1	1	33553	COLLAR STEEL	5
	1	1	1	1	1	1	9821	WEAR RING DELRIN	4
	1	1	1	1	1	1	33039	PISTON STEEL	3
	1	1	1	1	1	1	5098	PACKING CUP RUBBER	2
	-	-	-	-	-	-	33044	PISTON ASSEMBLY -	-
	-	-	-	-	-	-	34086	NON-PRESSURE HEAD/HOLLOW ROD/SPRING/PISTON	-
	1	1	1	1	1	1	35230	CYLINDER WELDMENT STEEL	1
*	X	-	-	-	-	-	33490-6	10X12 ABU-3 CYL ASSY (NO BLANKED FLG OPP MOUNT-5)	
*	-	X	-	-	-	-	33490-5	10X12 ABU-3 CYL ASSY (NO BLANKED FLG)	
*	-	-	X	-	-	-	33490-4	10X12 ABU-2 L.H.CYL ASSY (BLANKED FLG#1 OPP MOUNT-2)	
*	-	-	-	X	-	-	33490-3	10X12 ABU-1 R.H.CYL ASSY (BLANKED FLG#2 OPP MOUNT-1)	
*	-	-	-	-	X	-	33490-2	10X12 ABU-2 R.H.CYL ASSY (BLANKED FLG #1)	
*	-	-	-	-	-	X	33490-1	10X12 ABU-1 L.H.CYL ASSY (BLANKED FLG #2) AS SHOWN	

BILL OF MATERIAL

* - SEE NOTE 6
** - SEE NOTE 8

EST. WT.= 90 lbs.

REF. AAR SPEC:
M-914 S-400
S-4004

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ELLCON NATIONAL GROUP
50 BEECHTREE BLVD. GREENVILLE, S.C. 29605

10 x 12 ABU-1 BRAKE CYLINDER ASS'Y WITH SIDE INLETS

SCALE	1/3	DATE	11-28-95	REV.
DRAWN	D. CARROLL	C-33490		S
CHECKED	P.SOPT			

C-33490 S