

## 42-310 Removal and installation of tandem main cylinder

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### Data

		Tandem main cylinder up to fall 1975		Stepped tandem main cylinder starting fall 1975	
		Push rod circuit	Floating circuit	Push rod circuit	Floating circuit
Cylinder dia.	inches	15/16		15/16	3/4
	mm	23.81		23.81	19.05

### Tightening torque

Hex nuts for attaching tandem main cylinder to brake unit

Nm

15

### Conventional tool

Open double box wrench 9 x 11 mm

e.g. made by Hazet, D-5630 Remscheid  
order no. 612

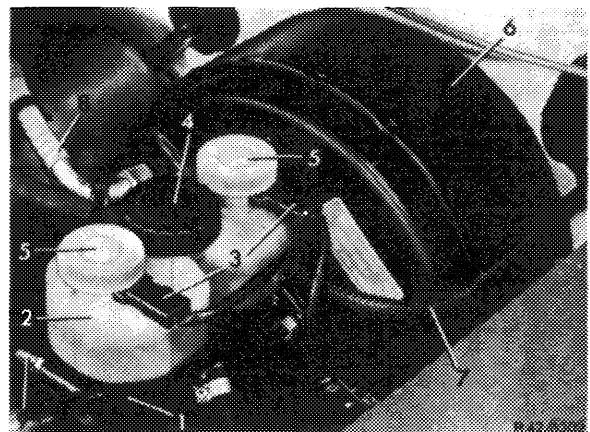
### Note

**For loosening and tightening brake lines use conventional open double box wrench only.**

### Removal

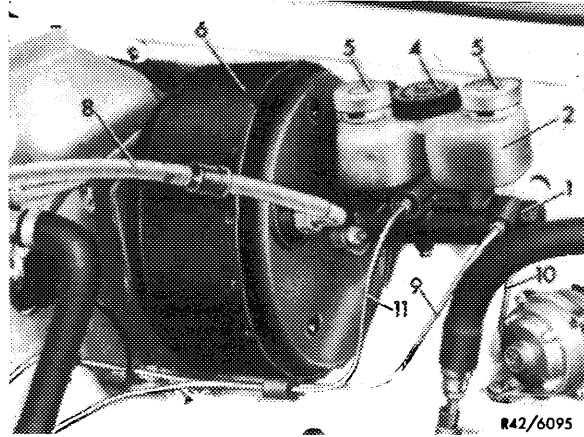
1 Pump out brake fluid via an open bleeder plug of the front axle and rear axle brake circuit. Make sure that both chambers of the expansion tank are drained.

2 Loosen plug connections (3) on contact inserts of warning device by lifting the holding lugs with a small screwdriver.



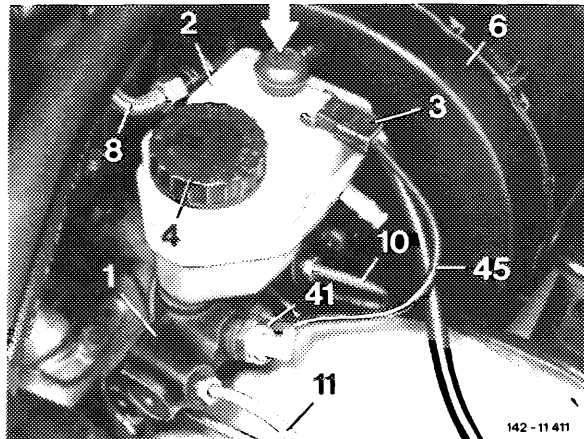
3 Disconnect both brake lines to front wheel brake and brake line to rear wheel brake on tandem main cylinder.

Immediately close all brake lines with rubber caps and close connections on tandem main cylinder with blind plugs.

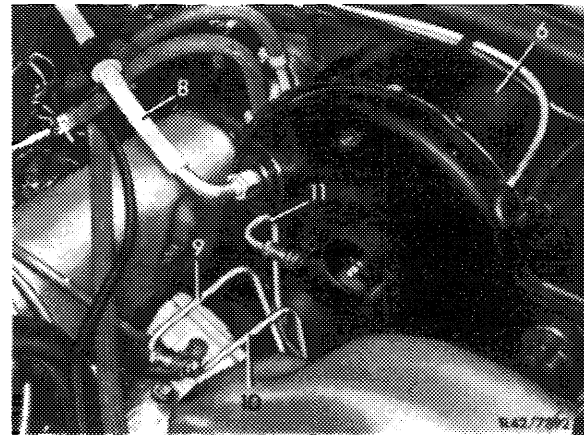


4 On tandem main cylinder with pressure difference warning indicator (DDW) pull cable (45) from switch (41).

5 Loosen tandem main cylinder on brake unit and remove, while paying attention to sealing ring located in groove of tandem main cylinder flange.



5 Loosen tandem main cylinder on brake unit and remove, while paying attention to O-ring located in groove of tandem main cylinder flange.



## Installation

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### Attention!

The sealing ring between the tandem main cylinder and the brake unit should always be renewed, since the connection must be completely **vacuum-tight**.

6 Insert sealing ring (11) into groove of tandem main cylinder (12) and attach main cylinder to brake unit (10). Tighten hex. nuts to 15 Nm.

**Note:** On stepped tandem main cylinder (installed starting fall 1975) the brake circuits are interchanged. The front wheel brake is connected to pushrod circuit (piston dia. 23.81 mm) and the rear wheel brake to floating circuit (piston dia 19.05 mm).

7 Connect brake lines to tandem main cylinder.

8 Fill expansion tank with brake fluid. Make sure that the individual chambers are filled.

9 Connect plug connection to contact inserts of warning device.

10 On tandem main cylinder with pressure difference warning indicator, plug cable (45) on switch (41).

11 Bleed brakes and check for leaks (42–010 and 42–015).

