

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

### Data

		Tandem main cylinder		Stepped tandem main cylinder USA-version only – model year 1976	
		Push rod circuit	Floating circuit	Push rod circuit	Floating circuit
Cylinder dia.	Inch	15/16		15/16	3/4
	mm	23.81		23.81	19.05

### Tightening torque

	Nm	(kpm)
Hex. nuts for attaching tandem main cylinder to brake unit	15	(1.5)

### Conventional tool

Open double box wrench 9 x 11 mm	e.g. made by Hazet, D-5630 Remscheid Order no. 612
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### Note

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

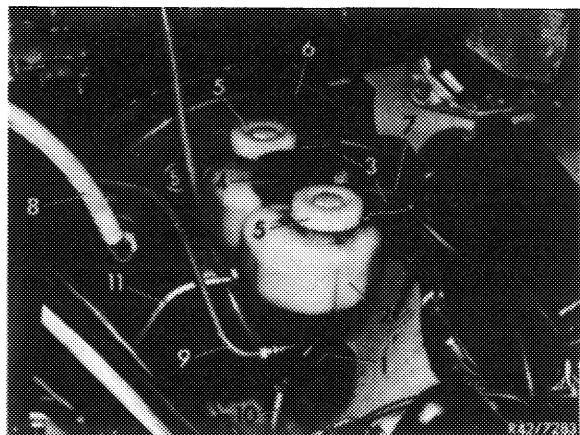
### Removal

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

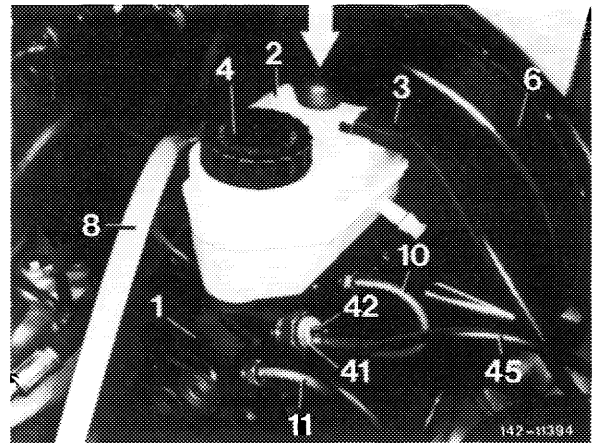
2 Loosen plug connections (3) on contact inserts of warning device by lifting the holding lugs with a small screwdriver.

3 Disconnect both brake lines (9 and 10) and brake line (11) to rear wheel brake on tandem main cylinder.

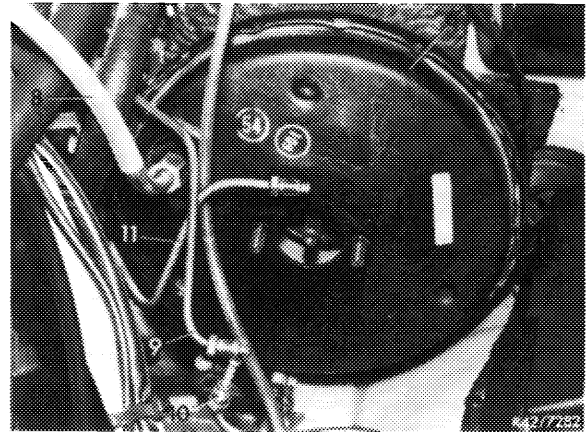
Immediately close all brake lines with rubber caps and close connections on tandem main cylinder with blind plugs.



4 On tandem main cylinder with pressure difference warning indicator (DDW on USA model year 1976 only), pull cable (45) from switch (41).



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

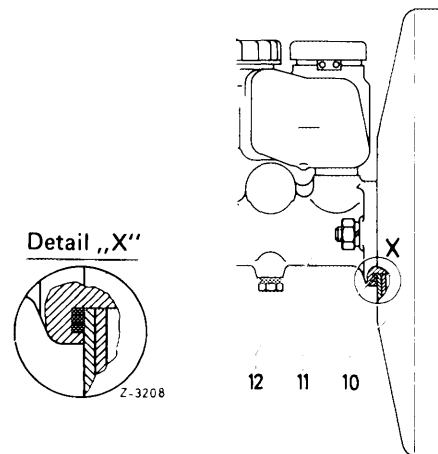


## Installation

### Attention!

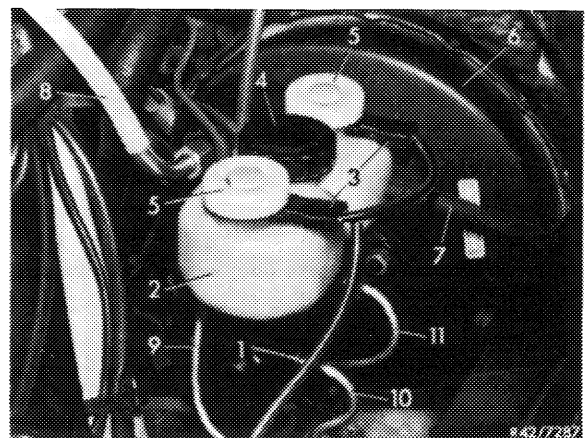
The O-ring between the tandem main cylinder and the brake cylinder should always be renewed, since the connection must be **completely vacuum-tight**.

6 Insert O-ring (11) into groove of tandem main cylinder (12) and attach main cylinder to brake unit (10). Tighten hex nuts to 15 Nm (1.5 kpm).



**Note:** On vehicles with engine 110 the connections for the brake lines on tandem main cylinder are at the left.

On stepped tandem main cylinder (installed in USA model year 1976 only) the brake circuits are interchanged. The front wheel brake is connected to push rod 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).