



# New Product Information

EPIC ENTERPRISES, INC.

## REPAIR OF VOLKMANN 05 BA3/BA4/BA5 BRAKE AIR PRESSURE CYLINDER 120329 OR 132316 OR 476614



**EE440004**

Repair Kit for  
05 Brake Pressure Cylinder



REPAIR OF VOLKMANN BRAKE AIR PRESSURE CYLINDER 120329 or 132316 or 476614: The plastic plunger tip of this assembly is subject to breakage. Because the cylinder can not be disassembled to replace the plunger, 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.



**EE401850**

Tip, Repair, for  
Air Brake Cylinder, 05

**EPIC**  
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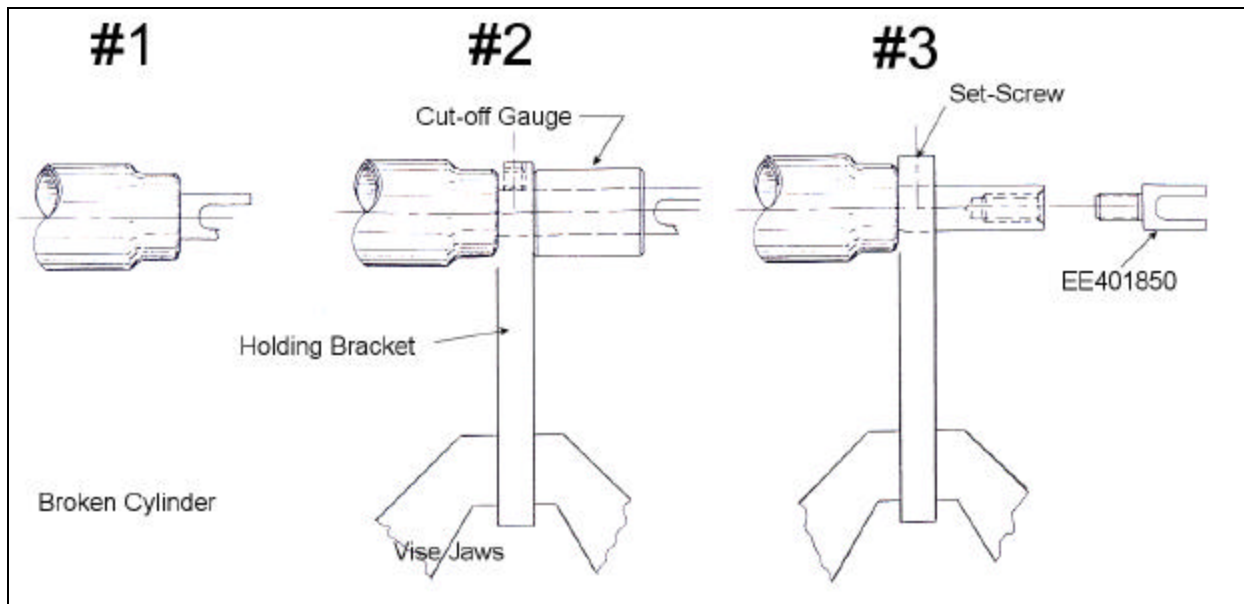
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# EPIC ENTERPRISES, INC.

## AIR CYLINDER REPAIR INSTRUCTIONS FOR VOLKMANN 120329 OR 132316 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.

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

5. Using the 17/64 slow spiral drill bit, open the cylinder rod hole to a depth of 5/8" to 3/4".

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

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.



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