



MGM Brakes

A Division of Indian Head Industries, Inc.

TECHNICAL BULLETIN

SUBJECT: BREATHER TUBE EXTENSION PROCEDURE USING CLAMPS

1.0 Purpose:

To provide a procedure to add a tube section to lengthen a breather tube in the field when the replacement actuator needs to be modified to replicate the breather tube, and/or port positions as per the currently installed OEM actuator.

2.0 Scope:

All MGM Brakes models with an external breather tube.

3.0 Material required:

8081128 Rubber Extension Tube or 3/8 Inch I.D. Rubber Vacuum/Washer Hose
8052021 3/8 Inch Hose Clamp (2) or Adhesive

NOTE: If rubber extension tube and hose clamps unavailable, use appropriate length of 3/8 Inch I.D. rubber vacuum/washer hose and appropriate adhesive. (Recommend Loctite #414 "Superbond" or equivalent.)

4.0 Procedure:

4.1 Cut the 3/8" O.D. breather tube approximately half way between the rubber elbows.

4.2 Using the recommended procedure in the MGM Brakes Service Manual (Ref Form 5044 – J-Series, Form 5011 – TR, Form 5042 – LTR, Form 5065 – Wedge) loosen the service chamber clamp and rotate the spring side to the desired position. Tighten service chamber clamp. **NOTE: Units designed for air disc applications are not to be rotated.**

4.3 If necessary, cut the 8081128 rubber extension tube, or the 3/8" vacuum/washer hose, to a length that will insure a minimum of 1/2 inch engagement over both ends of the cut 3/8" O.D. nylon breather tube.

4.4 Install the 8052021 hose clamps (2) over each end of the nylon breather tube, or apply Loctite #414 "Superbond" adhesive, or equivalent, to both ends of the nylon breather tube.

4.5 Insert the section of 8081128 rubber extension tube over both ends of the cut breather tube a minimum of 1/2 inch.

4.6 If hose clamps are used, compress clamp with pliers and place one over each end of the rubber extension tube. The edge of the clamp should be approximately .050 ±.015 from the edge of the rubber tube when installed. If adhesive is being used, wait for adhesive to dry before proceeding.

5.0 Using the recommended procedure in the MGM Brakes Service Manual (Ref Form 5044 – J-Series, Form 5011 – TR, Form 5042 – LTR, Form 5065 – Wedge), check the service chamber clamp for leaks.