

**TITAN**  
TECHNICAL BULLETIN # 1B&A

SUBJECT: 2374400 master cylinder and orifice connector

We have updated part number 2374400, master cylinder for drum brake used in the Model 10 and 20 Surge – O – Matic actuators.

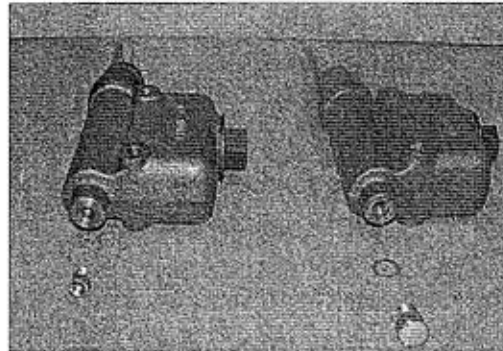
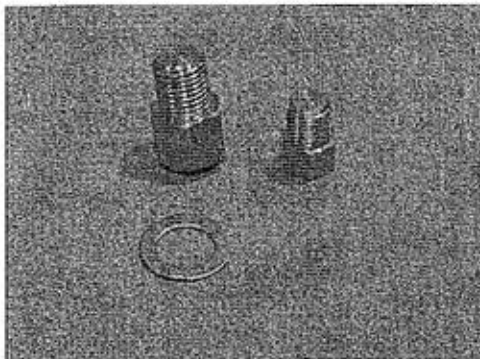
Previously, the Model 6, Model 60 and Aero 6000 **Drum brake actuators** used a 1209800 orifice connector. The Model 10 and Model 20 actuators used a 1209900 orifice connector and #0774500 copper gasket. We have now changed the bore in the 2374400 to use the 1209800 orifice connector. This will simplify ordering replacement parts and cut down on the number of replacement parts needed.

The older 2374400 master cylinders have a ½" UNF female thread for the connector and should be equipped as follows:

- 1 – 0774500 gasket
- 1- 1209900 orifice connector with male ½" UNF threads going into the master cylinder, a female 3/8" 24 UNF threads with an inverted seat for the brake line.

The new 2374400 master cylinders have a 1/8" NPT female thread for the orifice connector and should be equipped as follows:

- 1 – 1209800 orifice connector with male 1/8"NPT going into the master cylinder, a female 3/8" 24 UNF thread with an inverted seat for the brake line.



Photos showing new and old style orifice connectors.