



FLAT-II AIR CYLINDER GENERAL REPAIR INSTRUCTIONS

DISASSEMBLY

Remove screws and separate end block from rods. Remove screws and separate end caps, tube, and piston/rod assembly.

REPAIR AND REASSEMBLY

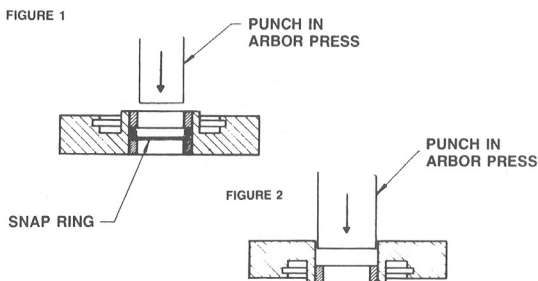
To remove front bushings, insert the snap ring and press out the bushings as shown in Figure 1 by using a punch slightly larger than the piston rod. NOTE: 3/4" bore cylinders will have no snap ring. To remove front bushings, use a punch of a slightly smaller diameter than the rod held on an angle to press out the bushing.

Turn the end cap over and press out the other bushings as shown in Figure 2 by using a punch slightly larger than the piston rod diameter. This is done so the bushings are not pressed across the area where the "O" ring seals.

Press in four new bushings; two from each side until flush. CAUTION: An "O" ring should be inserted in the bore before pressing in the second bushing for both rods.

Replace other seals, applying a thin film of a good hydraulic oil to the piston rod and tube. I.D.

Reassemble and torque screws to final specifications shown below. CAUTION: The rods should be retracted into the cylinder before the end block is attached.



ASSEMBLY SCREW TORQUE VALUES

BORE	SCREW SIZE	TORQUE (IN-LB)
3/4", 1-1/16"	#4-40	7
1-1/2", 2"	#10-24	35

END BLOCK SCREW TORQUE VALUES

BORE	SCREW SIZE	TORQUE (IN-LB)
3/4"	#6-32	13
1-1/16"	#8-32	25
1-1/2"	1/4-20	90
2"	5/16-18	150

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