



LINEAR THRUSTER

SERVICE AND MAINTENANCE INSTRUCTIONS

Linear Thrusters are precise linear actuators that use air pressure up to 250 psi. Air cylinders are pre-lubricated at the factory and should be used with a filter-lubricator combination for best results. Otherwise, introduce a few drops of 10 weight oil into the cylinder every 500 hours of operation.

Two spring loaded oiler ports are located on the face of the Linear Thruster housings. Introduce several drops of 10 weight oil into each port for every 100 hours of normal operation, more often if rapid cycling is necessary.

CAUTION: When removing or replacing the air cylinder, be sure that the cylinder mounting nut is not over-tightened. This nut should be tightened down and then backed off approximately 1/8 turn so that the air cylinder floats. This is to prevent binding of the cylinder rod and undue wear on the cylinder rod bearing or seal.

REPLACEMENT OF BEARINGS AND SEALS

For T Series Thrusters, worn or damaged linear bearings can be pressed out of the housing after first removing the seals from both ends of the bores. The seals are pressed into the bores and can easily be pried out with a screwdriver or similar tool. Use a mandrel slightly smaller than the bore to press out the bearing and proceed carefully to prevent damage to the I.D. Any traces of Loctite remaining within the bore should be carefully removed by scraping.

Replacement bearings should easily slide into the bore with moderate finger pressure. Spread two to four drops of Loctite RC/680 around the bearing case, insert into the bore and rotate while pressing flush with the top of the housing. Set the seal atop the bearing and immediately force it into the bore using a mechanical or hydraulic press. Repeat this procedure for the other bearings and allow about 30 to 40 minutes setup time before returning the housing to service.

For the maintenance of the TE units, the bearings can be replaced in the field. The bearings can be pressed out and then replaced with a new bearing plus a small amount of RC 680 Loctite (1 drop wiped around leading edge of bearing).

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