



SQUARE FLAT-II AIR CYLINDER GENERAL REPAIR INSTRUCTIONS

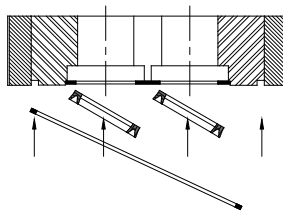
DISASSEMBLY

Remove tie rods and rod end block screws. Remove end block, then separate endcaps, tube, and piston/rod assembly.

REPAIR AND REASSEMBLY

Remove fiber gasket tube seal from outer groove of each endcap; insert new tube seals. From the internal-face side of the rod guide, remove rod seals using needle nose pliers or tweezers. Insert new rod seals, ensuring the open "V" of the seal faces the internal face of the rod guide (Figure 1). Replace piston seal(s). Reassemble and torque fasteners to specifications shown below.

FIGURE 1



TIE ROD TORQUE VALUES

| BORE | TIE ROD SIZE | TORQUE (IN-LB) |
|---------------|--------------|----------------|
| 3/4", 1-1/16" | #5-44 | 10 |
| 1-1/2", 2" | .185-24 | 30 |

END BLOCK SCREW TORQUE VALUES

| BORE | SOCKET CAP SCREW | | SET SCREW | |
|---------|------------------|----------------|-----------|----------------|
| | SIZE | TORQUE (IN-LB) | SIZE | TORQUE (IN-LB) |
| 3/4" | #6-32 | 13 | #6-32 | 10 |
| 1-1/16" | #8-32 | 25 | #6-32 | 10 |
| 1-1/2" | 1/4-20 | 90 | #8-32 | 20 |
| 2" | 5/16-18 | 150 | #10-24 | 36 |

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