



# Square Flat-II Air Cylinder General Repair Instructions

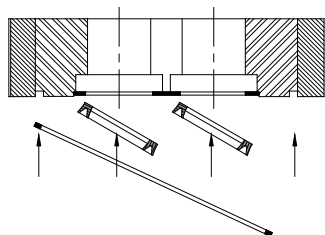
## DISASSEMBLY

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 SIZE	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 SIZE	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	#10-324	36

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