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2MA Series with Sleeve Nut Mount

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Mounting Kit Assembly

Perform the following steps when installing mounting kits on 2MA Series cylinders with sleeve nut mounts.

- 1) Clean mating parts to remove oil, grease and dirt.
- 2) Fasteners should be clean, dry and burr free.
- 3) Brush mounting fastener threads thoroughly with anti-seize lubricant.
- 4) Follow the appropriate procedure below for the desired mounting.

Rear Pivot Mounting Kits - Style MP1, MP2 and MP4 (Fig. 1)

Place pivot mount over end cap, lining up the four fastener holes in the end cap with the pivot mounting plate. Note that the pivot mount can be rotated allowing for different cylinder port locations. Secure mounting to cylinder cap (finger tight) using the four fasteners. Torque the fasteners to the specifications in the table below.

End Angle Mounting Kit - Style MS1 (Fig. 2)

The end angles bolt to the front and rear of the cylinder end caps. The spacer plate* provided is to be assembled at the rod end under the angle plate. Line up the two holes of the spacer plate and angle plate with the two fastener holes in the cylinder head. If 2 different length fasteners are in the kit, use the longer fasteners for the cylinder head end (rod end) mount. Secure (finger tight) using two fasteners. Repeat this assembly at the opposite end (less spacer). Place the assembly with the end angles down on a flat surface and torque the four fasteners to the specifications shown in the table below.

Flange Mounting Kits - Style MF1 and MF2 Single and Double Rod Cylinders (Fig. 3)

Place rectangular flange plate over appropriate end cap. Line up the four holes in the mounting plate with the four fastener holes in the cylinder end cap. Note that the rectangular mounting plate can be rotated to allow for different port locations. Secure the rectangular mounting plate to the end cap (finger tight) using the four fasteners. Then torque the four fasteners to the specifications shown in the table below.

Side End Lug Mounting Kits - Style MS7 (Fig. 4)

Attach the two longer lugs with the fasteners provided in the kit to the cylinder head as shown. Attach the two shorter lugs to the cylinder cap in a similar fashion. Place the assembly with the lugs down on a flat surface and torque the four fasteners to the specifications shown in the table below.

Re-Assembly and Torquing of Cylinder

The following procedure is recommended to ensure the correct re-assembly of the cylinder.

- A) Tighten the mounting fasteners in the opposite corner sequence to approximately 3/4 of final tightening torque.
- B) Using a calibrated torque wrench, tighten the mounting fasteners to the final torque listed repeating the opposite corner sequence procedure.

Fig. 1 - Pivot Mounting Kit

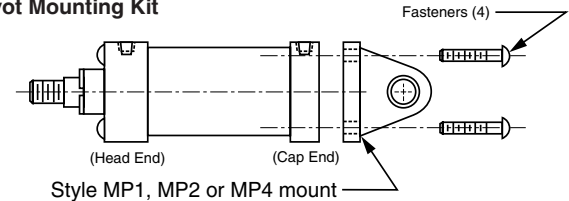


Fig. 2 - End Angle Mounting Kit

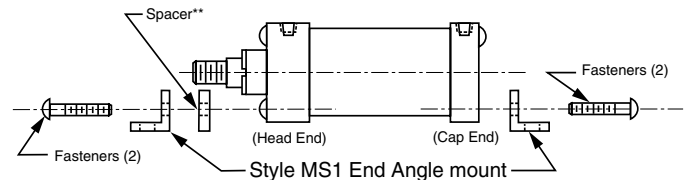


Fig. 3 - Flange Mounting Kit

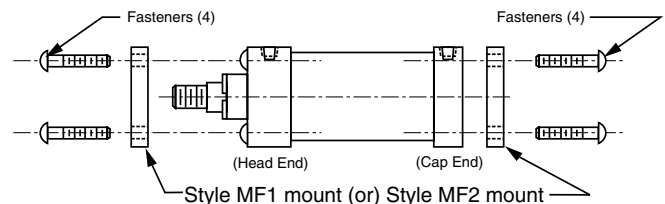
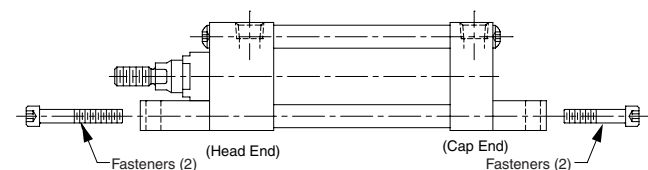


Fig. 4 - Side End Lug Mounting Kit - Style MS7



2MA Series with Sleeve Nut Mounts – Mounting Kits								Minimum Stroke*	Fastener Torque	
Bore Size	MF1	MF2	MP1	MP4	MS1	MP2	MS7	For customer assembled mounting kits only!	in. lbs.	N - m
	Head Rectangular Flange	Cap Rectangular Flange	Cap Clevis	Cap Pivot	Side End Angles	Cap Detachable Clevis	Side End Lug			
	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.	Part No.			
1 1/2"	L07496015T	L07496015T	L07497015T	L07498015T	L07499015T	L07500015T	L07502015T	1"	32 + 4	3.6 + 0.5
2"	L07496020T	L07496020T	L07497020T	L07498020T	L07499020T	L07500020T	L07502020T	1"	72 + 10	8 + 1
2 1/2"	L07496025T	L07496025T	L07497025T	L07498025T	L07499025T	L07500025T	L07502025T	7/8"	72 + 10	8 + 1
3 1/4"	L07496032T	L07496032T	L07497032T	L07498032T	L07499032T	L07500032T	L07502032T	1 3/8"	216 + 12	24 + 1.3
4"	L07496040T	L07496040T	L07497040T	L07498040T	L07499040T	L07500040T	L07502040T	1 3/8"	216 + 12	24 + 1.3

* Mounting kits on cylinders with stroke lengths shorter than those listed in the table above must be assembled by the factory to ensure proper fastener thread engagement.

** Spacer plate not used for 4" bore or double rod cylinders.