

Perform the following steps when dis-assembling, installing mounting kits and re-assembling 2MA Series cylinders

Dis-assembly of cylinder to add Mounting Kit*

- 1) Un-Torque cylinder mounting fasteners using corner to corner sequence until fasteners are finger tight.
- 2) Remove all fasteners.
- 3) Clean mating parts to remove oil, grease and dirt.
- 4) Fasteners should be clean, dry and burr free.
- 5) Brush mounting fastener threads thoroughly with anti-seize lubricant.
- 6) Follow the appropriate procedure below for the desired mounting.

Rear Pivot Mounting Kits - Style BB, BC and BE (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 CB (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. 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 J and H 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 G (Fig. 4)

Remove the bottom two fasteners holding the head to the cylinder body. 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 After Maintenance

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

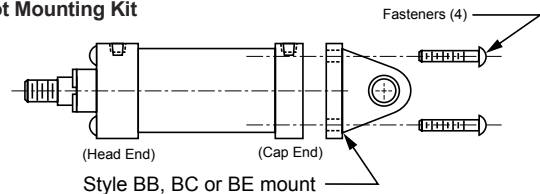


Fig. 2 - End Angle Mounting Kit

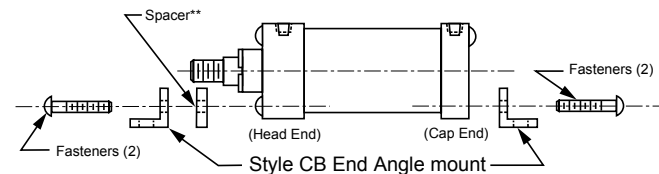


Fig. 3 - Flange Mounting Kit

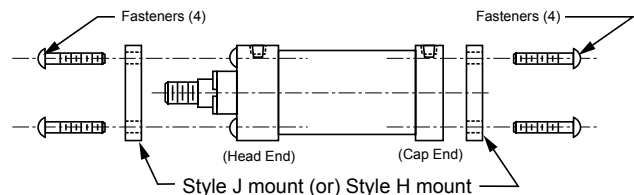
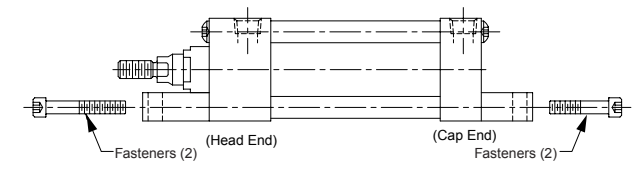


Fig. 4 - Side End Lug Mounting Kit - Style G



2MA Series Mounting Kits								Minimum Stroke	Fastener Torque	
Bore Size	J(MF1) Head Rectangular Flange Part No.	H(MF2) Cap Rectangular Flange Part No.	BB(MP1) Cap Clevis Part No.	BE(MP4) Cap Pivot Part No.	CB(MS1) Side End Angles Part No.	BC(MP2) Cap Detachable Clevis Part No.	G(MS7) Side End Lug Part No.		in. lbs.	N - m
1 1/4"	L074960125	L074960125	—	L074980125	L074990125	L075000125	L075020125	5/8"	32 + 4	3.6 + 0.5
1 1/2"	L074960150	L074960150	L074970150	L074980150	L074990150	L075000150	L075020150	1"	32 + 4	3.6 + 0.5
2"	L074960200	L074960200	L074970200	L074980200	L074990200	L075000200	L075020200	1"	72 + 10	8 + 1
2 1/2"	L074960250	L074960250	L074970250	L074980250	L074990250	L075000250	L075020250	7/8"	72 + 10	8 + 1
3 1/4"	L074960325	L074960325	L074970325	L074980325	L074990325	L075000325	L075020325	1 3/8"	216 + 12	24 + 1.3
4"	L074960400	L074960400	L074970400	L074980400	L074990400	L075000400	L075020400	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.