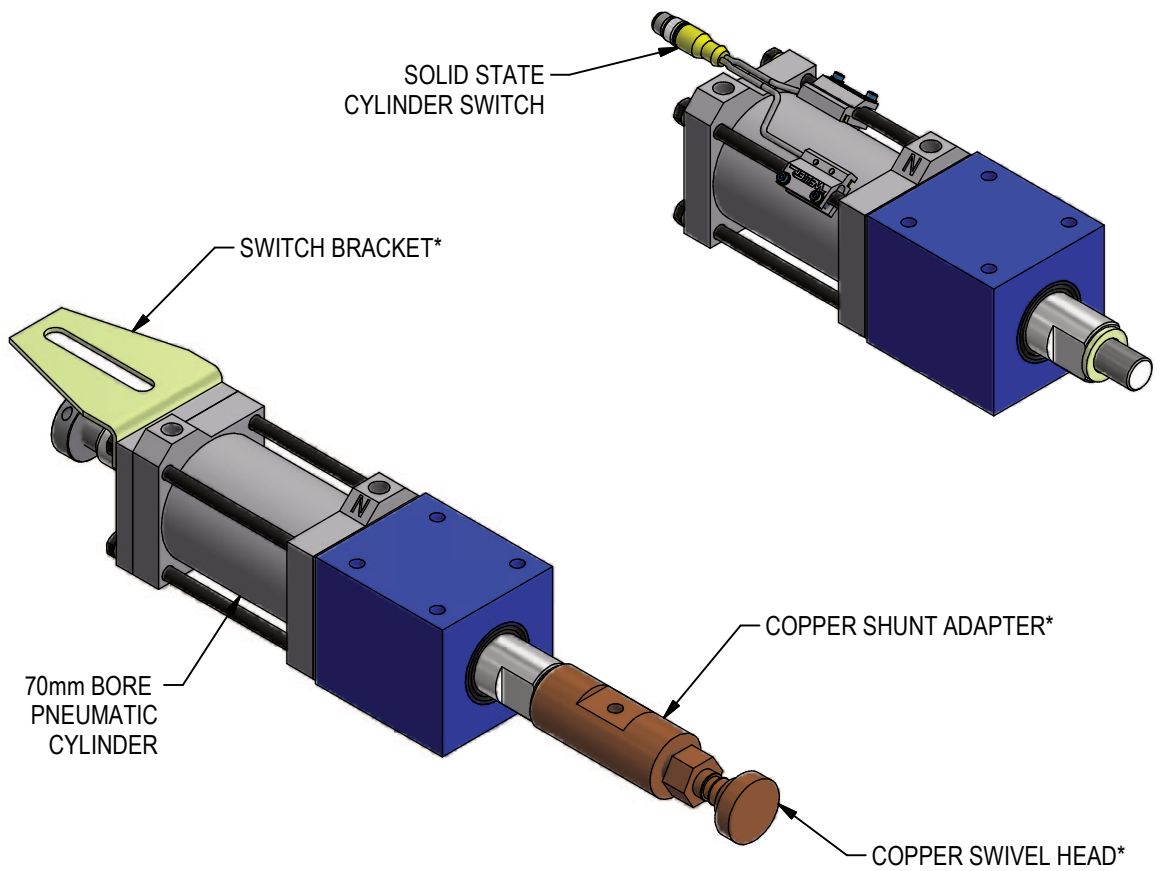


MAINTENANCE MANUAL GB3 GROUND BLOCK CYLINDER



*OPTIONAL

MAINTENANCE

SAFETY FIRST!

MAINTENANCE SHOULD ONLY BE PERFORMED BY QUALIFIED PERSONNEL. PROPER SAFETY GEAR AND PROCEDURES MUST BE USED AT ALL TIMES.

BEFORE PERFORMING MAINTENANCE, CUT OFF AIR SUPPLY TO THE UNIT, ENSURE THAT ALL AIR IS REMOVED AND THAT THERE ARE NO "TRAPPED AIR" CONDITIONS.

PREVENTATIVE MAINTENANCE: Regularly inspect unit to verify proper operation. Check for debris build up and clean as needed. Inspect all pneumatic, electrical, and mounting connections, making sure all connections are tight and secure. Routine replacement of cylinder seals is recommended.

CYLINDER: Welker pneumatic cylinders are lube free and require very little maintenance. Check for abnormal wear or damage. Plant air supply to the cylinder should be free of contaminants, filtered to a minimum of 50micron and have a water separator. Be sure fittings are in good condition. Seals are subject to wear under normal operating conditions. It is recommended to keep a spare cylinder seal kit or repair kit on hand.

SWITCH: Switches may fail and need replacement; it is recommended to keep a spare switch on hand.

TROUBLESHOOTING

FAILURE	POSSIBLE CAUSE	SOLUTION
Unit does not extend/retract.	Cylinder failure Switch failure	Inspect unit for dirt/debris. Check plant air supply for proper pressure; too little will result in lack of cylinder movement. Seals may be worn, damaged or deteriorating. Replace as needed. If cylinder has been serviced, be sure tie rod nuts have been tightened to torque specifications. Check switch for proper operation. Replace as needed.

REPLACEMENT PARTS

QTY	STOCK*	DESCRIPTION	TYPE	PART NUMBER
1	1	CYLINDER SEAL KIT		GB3-CSK
1	1	CYLINDER SWITCH		SEE CHART BELOW
1	1	REPLACEMENT NOSE OPTION A		GB3-A
1	1	REPLACEMENT NOSE OPTION B		GB3-B
1	1	REPLACEMENT NOSE OPTION C		GB3-C
1		COPPER SHUNT ADAPTER (ONLY)		GB3E01
1		COPPER TIP ADAPTER (ONLY)		AP-H25B-10
1		COPPER SWIVEL HEAD (ONLY)		SN-1512
1		KNURLED COPPER SWIVEL HEAD (ONLY)		GB3E25
2	2	WIPER		MC1375X1875-312U
1		SWITCH BRACKET	25-50mm STROKE	BP4NE03
1		SWITCH BRACKET	75-100mm STROKE	GB3E03

* RECOMMENDED SPARE PARTS TO KEEP IN STOCK

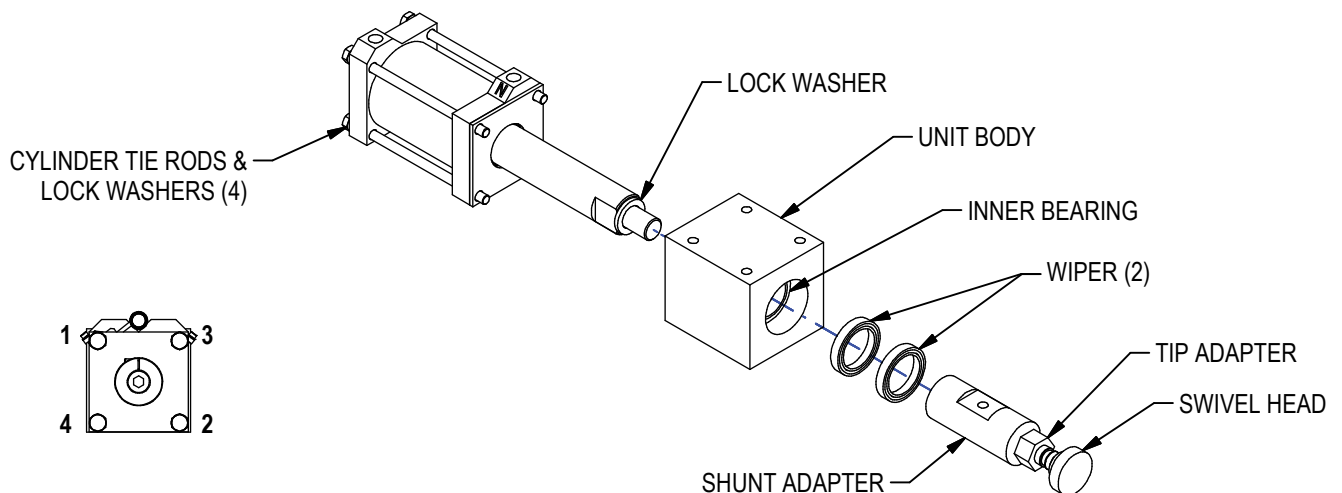
	Reorder #	Mfr. Part Number	Manufacturer	Description
Cylinder Switches	SWITCH L3	SWITCH L3 L3 switch is weld field immune, comparable to World Switches	Welker	4-Wire, 4-Pin, DC M12 X 1 (PNP) Quick Disconnect
	SWITCH L5	MK5113	ifm Efector	3-Wire, 4-Pin, DC M12 X 1 (NPN) Quick Disconnect

Standard Switch Option - All other options may affect price and delivery

TO REPLACE WIPER

1. Remove air lines from the cylinder. Remove unit from mount. Remove cylinder switch if applicable.
2. Loosen (4) cylinder tie rods enough to free unit body. Remove unit body.
3. Remove existing wipers, being careful to note orientation of groove.
4. Install new wipers in unit body**, groove placement same as old wipers. Use a flat surface/plate to install wiper; a hand press is recommended. Press first wiper into unit until it makes contact with inner bearing. Press second wiper into unit until flush with surface, leaving desired gap between wipers.
5. Reassemble unit body and cylinder. Using torque wrench tighten tie rods to pattern shown. Tighten to 15 ft.lb.
6. Install cylinder switch if applicable. Install unit to mount. Install air lines, making sure they are free of contaminants.

**** Grease all seals with dielectric grease: super lube silicone lubricating grease #92016 or 92150 (available from Applied Material)**

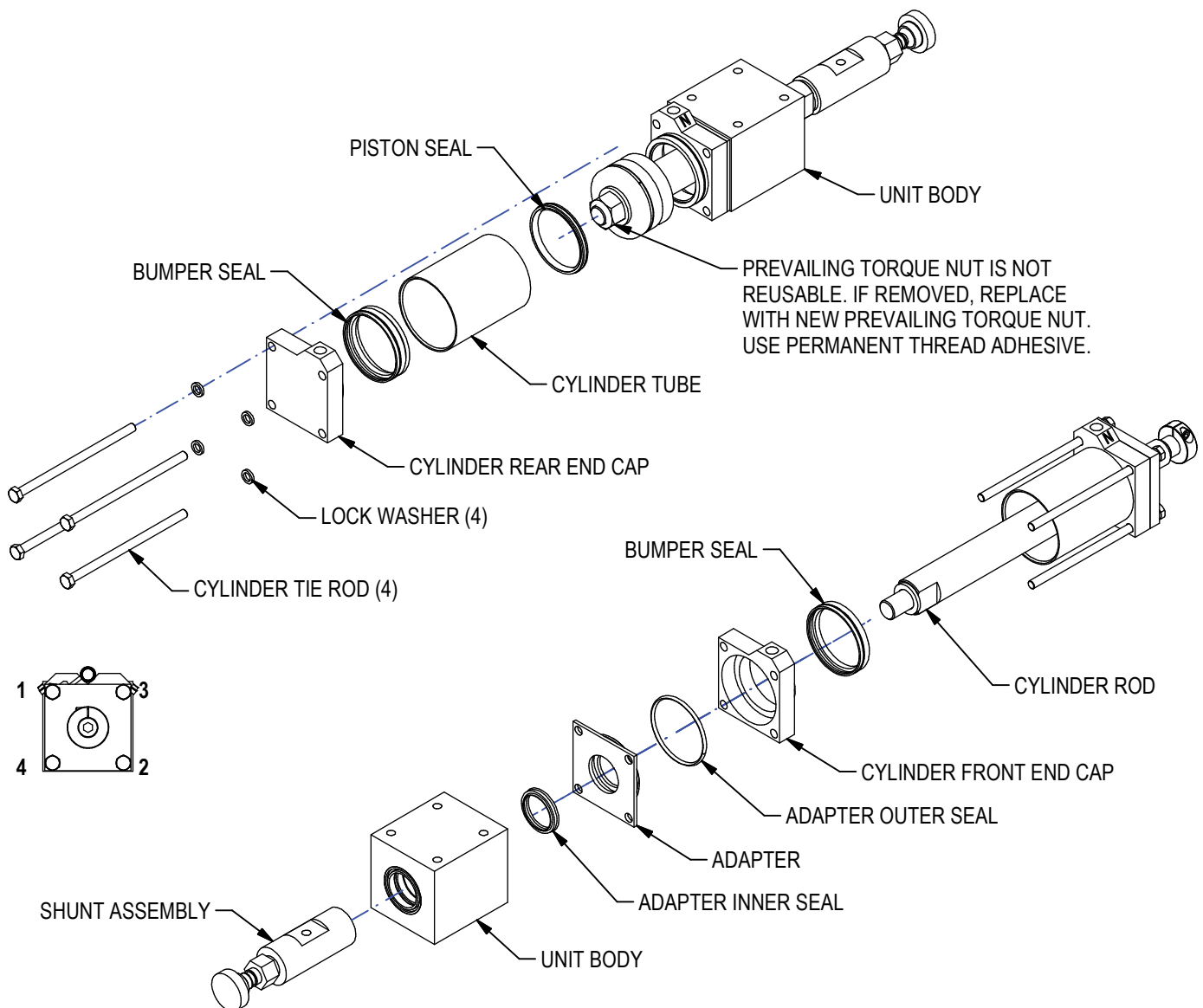


CYLINDER SEAL MAINTENANCE

Seals should be replaced routinely to avoid cylinder failure. Please have cylinder model information and/or Welker job number ready when ordering seal kits or repair kits. This information is located on the unit's tag and on the cylinder.

1. Remove air lines from the cylinder. Remove unit from mount. Remove cylinder switch if applicable.
2. Remove the cylinder tie rods & lock washers. Remove end cap & tube noting port position.
3. Clean seal groove thoroughly. Replace bumper seal.**
4. Remove piston seal using plastic or brass tool. NOTE ORIENTATION OF SEALS. Inspect parts for wear. Clean piston and install new seal.**
5. To access front bumper seal and adapter seals, remove shunt assembly. Slide unit body off cylinder rod. Remove adapter. Remove inner and outer seal. Clean seal grooves thoroughly. Replace seals.**
6. Remove front end cap & bumper seal noting port position. Clean seal groove thoroughly. Replace bumper seal.**
7. Reassemble unit with cylinder tie rods & lock washers. Be sure cylinder ports are in proper position. Using torque wrench tighten bolts to pattern shown. Tighten bolts to 15 ft.lb.
8. Install cylinder switch if applicable. Install unit to mount. Install air lines, making sure they are free of contaminants.

**** Grease all seals, piston, and interior of cylinder tube with dielectric grease: super lube silicone lubricating grease #92016 or 92150 (available from Applied Material)**

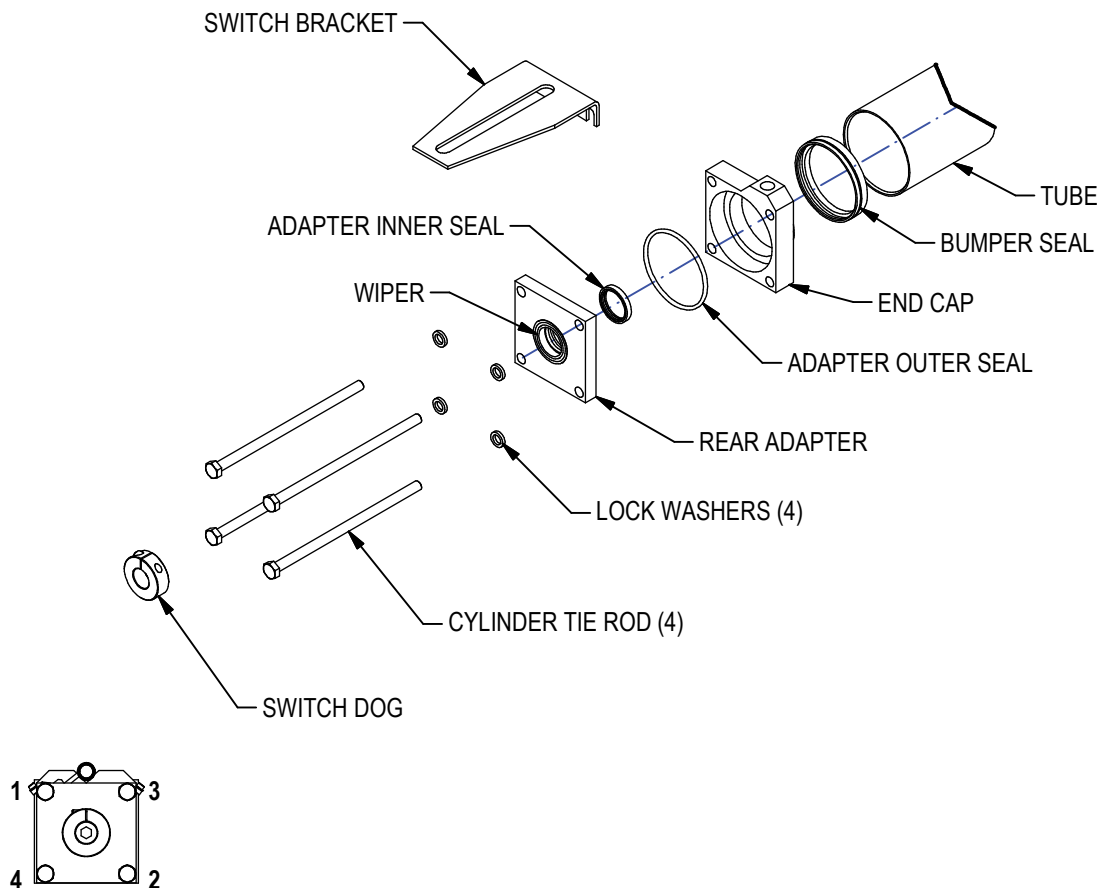


ADDITIONAL SEAL MAINTENANCE ~ DOUBLE ROD CYLINDERS

Two additional seals are included for double rod cylinders:

1. Remove switch dog noting position on rod.
2. Remove the cylinder tie rods & washers. Remove switch bracket. Remove rear adapter.
3. Replace adapter inner and outer seals.**
4. Align adapters, end caps, tube, bumper seals on cylinder rod and install to unit body with cylinder tie rods & lock washers. Be sure cylinder ports are in proper position. Install switch bracket. Using torque wrench tighten bolts to pattern shown. Tighten bolts to 15 ft.lb.
6. Install switch dog to position. Install unit to mount. Install air lines, making sure they are free of contaminants.

**** Grease all seals, piston, and interior of cylinder tube with dielectric grease: super lube silicone lubricating grease #92016 or 92150 (available from Applied Material)**



REPLACING TIE ROD CYLINDER SWITCH

1. BEFORE REMOVING OLD SWITCH: NOTE SENSOR PLACEMENT! FOR SWITCHES WITH TWO SENSORS, EACH WILL BE TAGGED WITH A BAND AROUND THE WIRE INDICATING S1 AND S2 (OR S01 AND S02).
2. TO REMOVE SWITCH, REMOVE BOLTS AND WASHERS FROM BRACKET. SLIDE BRACKET OUT FROM TIE ROD.
3. SENSOR IS SNAPPED INTO BRACKET. REMOVE.
4. INSTALL NEW SWITCH SENSOR FLUSH INTO BRACKET, BEING CAREFUL TO MATCH SENSOR CORRECTLY TO LOCATION ON CYLINDER.
5. LOCATE BRACKET TO CYLINDER, SLIDE ON TO TIE ROD. SECURE WITH BOLTS & WASHERS.

