

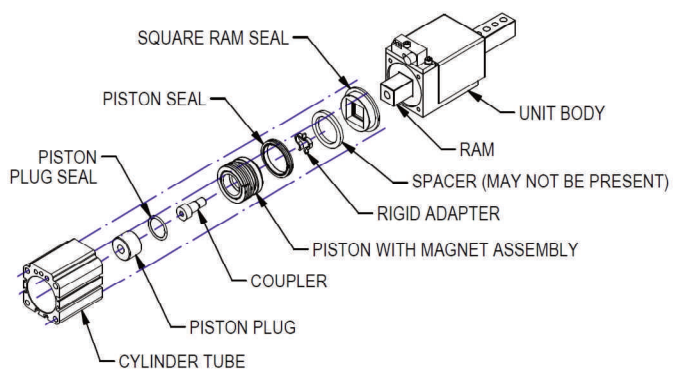
UB2 SERIES SHOT PIN ~ CSK MAINTENANCE

FOR UNITS WITH DOUBLE ROD CYLINDER (ACTUATOR 03/04) COUPLERLESS UNIT SHOWN

1. When replacing seals: Note seal orientation when removing. Clean seal grooves thoroughly. Lightly coat new seals and tube I.D. with Magnalube G or equivalent.
2. Disengage plant air from unit. Disconnect and remove cylinder switch if present, noting positions on tie rods.
3. Remove fixed/adjustable stop.
4. Remove screws & lock washers from stop plate. Remove stop plate.
5. Remove cylinder stop rod. Replace rod wiper
6. Remove end cap, noting port orientation. Replace end cap seal.
7. Remove cylinder tube.
8. FOR UNITS WITH 2-PIECE COUPLER & RAM: Piston plug is installed with removable adhesive. Use belt or strap wrench to loosen piston plug being careful not to scratch or damage piston. Remove piston plug. Remove coupler and piston.
9. FOR UNITS WITH 1-PIECE COUPLER/RAM: Remove piston from coupler by sliding out of coupler pocket.
10. Remove rigid adapter located between piston and ram.
11. Remove piston seal using plastic or brass tool. Clean seal groove. Replace piston seal.
12. Remove second end cap. Replace tube seals on end caps.
13. Replace square ram seal.
14. FOR UNITS WITH 2-PIECE COUPLER & RAM: Install piston to ram with coupler, using removable adhesive on threads. Install piston plug to piston using removable adhesive on threads.
15. FOR UNITS WITH 1-PIECE COUPLER/RAM: Install piston to ram at coupler pocket.
16. Install the rigid adapter to same location.
17. Install cylinder tube, end cap, and adapter. Secure with cylinder stop rod.
18. Install rod stop plate. Secure with tie rods/lock washers. Tighten in an "X" pattern to torque specifications. Install fixed/adjustable stop.
19. Engage plant air, making sure lines are free of contaminants. Reconnect switch. Test



UNIT WITH SEPARATE RAM & COUPLER:



UB2 END CAP SCREW TORQUE SPECS				
RAM	THREAD	FT-LBF	IN-IBF	N-M
24	1/4-28"	6.5	78	8.8