

Dismantling and Assembling the Cylinder

1. Dismantle the Rear end cover (7) using appropriate tools.
2. Remove the Cylinder barrel (1) and check for damages in the bore.
3. Remove the Piston assembly along with the piston rod and check for dirt and damage.
4. Check the 'O' ring and Nutring cum wiper for any damages and scratches.
5. Clean all the elements thoroughly.
6. Replace the required necessary spares.
7. Apply general purpose grease on all the rubber seals, cylinder bore, bearing bush and piston rod.
8. Reassemble the complete cylinder.
9. Check the performance of the cylinder using a suitable valve.

How to order for spare parts

Mention the spare parts numbers as given in the tables

Example :- Nutring cum wiper for ø32 cylinder: Ordering number: 641516

For further information contact our regional Marketing office or Registered office

JANATICS INDIA PRIVATE LIMITED

Regd. Office & Works : E - 25, SIDCO Industrial Estate, Kurichi, Coimbatore - 641 021, INDIA

Tel : + 91 422 2672800 Email : janatics@md2.vsnl.net.in

Fax : + 91 422 2672304 Web : www.janatics.com

Marketing Offices : Ahmedabad Bangalore Chennai Hyderabad Indore Kolkata Mumbai New Delhi Pune

Installation / Operating / Maintenance Instructions

Air Cylinder Series A60, A61, A63, A64

Specification

Cylinder bore dia (mm)	25 *	32	40	50	63	80	100
Standard stroke (mm)	5, 10, 15, 20, 25, 30, 40, 50, 60	10, 15, 20, 25, 30, 40, 50, 60, 70, 80					
Medium	Compressed air - filtered - lubricated						
Medium temperature	5° - 60° C						
Working pressure range	0.5 - 10 bar						
Materials of construction	Aluminium, Nitrile, Steel						

* Ø25mm Double end cylinder (Series A60, A61) 5mm stroke not available .

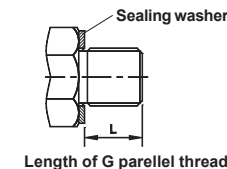
Important

Since this equipment is used in compressed air, proper precautions are to be taken for safety.

Installation Instruction

1. Install in clean / acid free atmosphere.
2. Before installation of the cylinder check whether the unit is as per the specifications.
3. Check for proper fittings to be used on to the cylinder. Use only (R) taper thread nipples with teflon tape.
4. When using (G) parallel thread nipples, use sealing washer and check the length of the thread as below.

Thread Size	Tightening torque Nm	Length (L) of thread
M5	1 - 1.5	4 mm Max.
G1/8	7 - 9	6 mm Max.



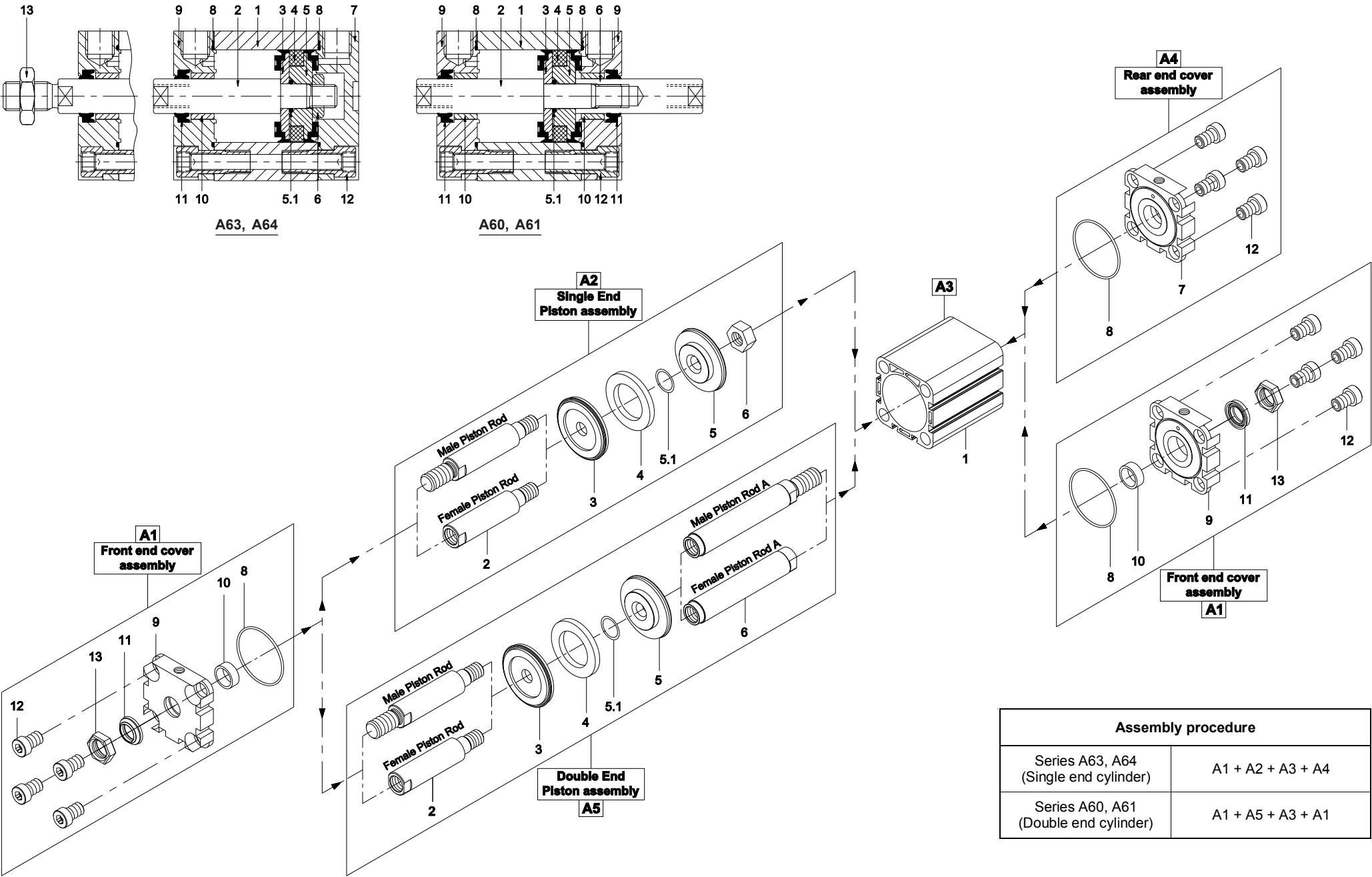
5. Tighten the pipings / nipples to the cylinder using proper tools. Do not give excess torque for tightening (See the above table for tightening torque)
6. Align the cylinder for your requirement such that no radial load is applied on the piston rod.
7. Ensure correct pressure and flow for proper functioning of the cylinder. Use correct size of tubings as required.

Maintenance Instructions

- a. Before dismantling the unit, exhaust the air in the cylinder completely.
- b. Remove the cylinder assembly from the machine and clean the assembly thoroughly.
- c. Test the cylinder for operation using a suitable valve.
- d. Note the problems / troubles and ascertain the probable causes and its remedies from the table on page 5

Assembly / Spare parts list

IS - A60, A61, A63, A64 - 01 - 02 - B



Spare parts list

Air Cylinder Series A60, A61, A63, A64

IS - A60, A61, A63, A64 - 01 - 02 - B

Ref. No.	No. off		Part name	Ordering no. for						
	A63 A64	A60 A61		Ø 25	Ø 32	Ø 40	Ø 50	Ø 63	Ø 80	Ø 100
1	1		Cylinder barrel	-	-	-	-	-	-	-
2	1		Piston rod	-	-	-	-	-	-	-
3	1		Piston B complete	610031	SA0077	SA0078	SA0079	SA0080	SA0081	SA0082
4	1		Magnet (Series A60, A63 only)	-	-	-	-	-	-	-
	1		Spacer (Series A61, A64 only)	-	-	-	-	-	-	-
5	1		Piston A complete	610030	SA0071	SA0072	SA0073	SA0074	SA0075	SA0076
5.1	1		'O' ring	651023	650005	650005	650008	650008	650010	650010
6	1		Nut (Series A63, A64 only)	-	-	-	-	-	-	-
	1		Piston rod A (Series A60, A61 only)	-	-	-	-	-	-	-
7	1		Rear end cover	-	-	-	-	-	-	-
8	2		'O' ring	651033	651030	651029	651028	651031	651114	651115
9	1	2	Front end cover	-	-	-	-	-	-	-
10	1	2	Bearing bush	-	-	-	-	-	-	-
11	1	2	Nutring cum wiper	641511	641516	641516	641517	641517	641518	641518
12	8		End cover bolt	-	-	-	-	-	-	-
13	1	2	Lock nut (Male piston rod only)	-	-	-	-	-	-	-

Spare parts list

Air Cylinder Series A60, A61, A63, A64

IS - A60, A61, A63, A64 - 01 - 02 - B

Though the ordering numbers have been given for individual seals, it is recommended to order as a **Seal kit** during major maintenance.

Cylinder bore dia		25	32	40	50	63	80	100
Seal kit Ordering no.	A63, A64	SK0138	SK0139	SK0140	SK0141	SK0142	SK0143	SK0144
	A60, A61	SK0145	SK0146	SK0147	SK0148	SK0149	SK0150	SK0151

Seal kit :

Series A63, A64

consists of the following :

- (3) Piston B complete - 1 no
- (5) Piston A complete - 1 no
- (5.1) 'O' ring - 1 no
- (8) 'O' ring - 2 no's
- (11) Nutring cum wiper - 1 no

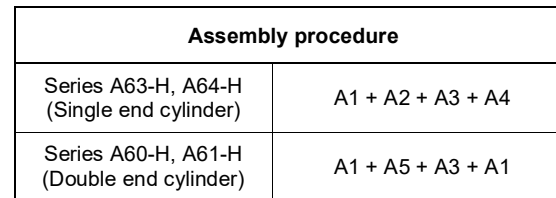
Series A60, A61

consists of the following :

- (3) Piston B complete - 1 no
- (5) Piston A complete - 1 no
- (5.1) 'O' ring - 1 no
- (8) 'O' ring - 2 no's
- (11) Nutring cum wiper - 2 no's

Trouble shooting

Trouble	Cause	Remedy
1. Cylinder does not function	a. Low inlet pressure b. Leak through the Piston seal c. Leak through the Piston seal d. Leak through the End covers and the Cylinder barrel	a. Increase the inlet pressure b. Replace the 'O' ring (5.1) c. Replace the Piston A complete (5) or Piston B complete (3) d. Replace the 'O' ring (8)
2. Piston Jerks during forward stroke	a. Leak through the Piston seal	a. Replace Piston A complete (5)
3. Piston Jerks during Reverse stroke	a. Leak through the Piston seal	a. Replace the 'O' ring (5.1) b. Replace the Piston B complete (3)
4. Leak at piston rod end	a. Defective Nutring cum wiper (11)	a. Replace the Nutring cum wiper (11)
5. Dust inside the front end cover	a. Defective Nutring cum wiper (11)	a. Replace the Nutring cum wiper (11)

Page 4