

TRAC-TROL CABLE ASSEMBLY AND SEAL REPLACEMENT INSTRUCTIONS.

1. Remove the unit from machinery, and place on clean work table.
2. Loosen the set screws (#24) in the trolley (#25), and then disconnect the old cable subassemblies (#8) from the trolley.
3. Remove the retaining rings (#21), and then remove the two guide rods (#23) and the trolley (#25).
4. Remove the four headbolts (#2) at each end, and separate the heads (#3) from the ends of the tube (#14).
5. Grasp the cable and pull to bring the piston (#13) out of the tube at one end.
6. Cut both cables off the piston, and discard the old cables.
7. Before proceeding to remove the piston screws (#35) from the piston (#13), it may be necessary to slightly heat the piston to break down the threadlocker that secures the cables to the piston. Start by wrapping the piston with cloth (exposing only the piston nose which requires heating) and place in a round jaw vice; be careful not to damage the piston.
8. Gradually heat up the piston (#13) with a propane torch as you unscrew each of the cut cable ends from the piston.
9. Allow piston (#13) to cool before removing from vice.
10. Lubricate all seals with pneumatic grease (Magnalube-G® with Teflon®, or similar) for pneumatic service, or oil treatment (STP® Oil Treatment, or similar) for hydraulic or low-friction service.
11. Replace the piston u-cups (#10) with new (observe the orientation of the old u-cups)
12. Replace all of the seals in the heads: The head o-rings (#6), the cushion seals (#7), and the needle o-rings (#5).
13. Clean the tube (#14).
14. Determine which end of the new cable assembly (#8) should connect to the piston (#13): The piston end should have the shorter piston-screw (#35), and the trolley end should have the longer trolley-screw (#31). Take care not to scratch the nylon on the cable.
15. Replace the cable seal (#34) into the head (#3) by tucking in the lips, and replace the pilot washer (#33) between the head and the rod flange (#22).
16. Apply threadlocker (Loctite® 242 or similar) to the piston screw (#35), and tighten it all the way into the piston (#13).
17. Lubricate a few inches inside the tube (#14) in front of the piston (#13), and then push the piston back into the tube by gently tucking in the lips of the piston u-cup (#10).
18. Attach the head (#3), rod flange (#22), and sheave bracket (#17) to the tube (#14) with the four screws (#2).
19. Move the piston (#13) to the opposite end of the tube (#14) by applying a controlled air supply to the port. Make sure the air flow rate is set very low to prevent high speeds.
20. Repeat steps 14 - 19 for the other cable at the other end of the tube.
21. Replace trolley (#25), guide rods (#23), and retaining rings (#21).
22. Connect the trolley screws (#31) to the trolley (#25).
23. Proof-load and pretension the cable according to the Proof-loading instructions.
24. After the cables are properly tensioned, retighten the two set screws (#24) that are in the trolley (#25).

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