

1. APPLICABLE STANDARDS/SPECIFICATIONS:

- A. ASME Y14.100-2000
B. ASME Y14.5M-1994

2. IEEE/ASTM SI 10 SHALL BE USED IN CONVERTING AND ROUNDING OFF. 1 INCH = 25.4mm APPLIES.

3. FINISH: FINAL PROTECTIVE FINISH IAW 12420325
METHOD 4.

4. DIMENSIONS WITHOUT TOLERANCES SPECIFIED ARE FOR REFERENCE ONLY AND SHALL NOT BE USED FOR INSPECTION PURPOSES.

5. DIMENSIONAL LIMITS APPLY BEFORE PAINTING.

6. PLUG/CAP ALL PORT PRIOR TO SHIPMENT.

7. THE O-RING PORTS CONSTRUCTION SHALL BE IAW SAE J1926.

- ## 8. CYLINDER CONSTRUCTION:

- A. BORE DIA: $\varnothing 50.8\text{mm}$ ($\varnothing 2.00$ IN.)
 B. ROD DIA: $\varnothing 25.4\text{mm}$ ($\varnothing 1.00$ IN.)
 C. PUSH AREA: 20.3 SQ. CM. (3.14 SQ. IN.)
 D. PULL AREA: 15.2 SQ. CM. (2.36 SQ. IN.)
 E. RECOMMENDED FLUID MIL-H-5606

- ## 9. ENVIRONMENTAL REQUIREMENTS:

- A. OPERATING TEMPERATURE RANGE SHALL BE -50°F TO 120°F

- B. THE CYLINDER SHALL MEET THE REQUIREMENTS FOR A 96 HOUR SALT SPRAY IAW ASTM B117. AFTER COMPLETION. CORROSION PRODUCTS ARE ACCEPTABLE ON SHARP EDGES AND CORNERS.

- ## 10. PERFORMANCE REQUIREMENTS:

- A. APPROX. OPERATING PRESSURE 4,000 PSI
- B. MAXIMUM PUSH FORCE: 5700 KG (12566 LB.)
- C. MAXIMUM PULL FORCE: 4275 KG (9425 LB.)
- D. SEALS SHALL BE COMPATIBLE WITH MIL-H-5606 WHEN QUALIFIED WITH METHOD 1 OR METHOD 2.
 - METHOD 1: PRE-AUTHORIZED MATERIALS:
PARKER COMPOUND NUMBERS N0304-75,
N0756-75,N0507-90.
 - METHOD 2: OTHER ELASTOMER MATERIALS:
PERFORM TEST FOR PROPERTIES AFTER OIL AGING
AND COMPRESSION SET IN OIL IAW SAE AMS-P-5510.
- E. MINIMUM BURST PRESSURE: 55.16 MPa (8000 PSI).
TESTED IAW ANSI B30.1
- F. FLOW VELOCITY LIMITATIONS:
CYLINDER SHALL BE EQUIPPED WITH A VELOCITY
FUSE LOCKING DEVICE IN THE PUSH MODE. THE LOCKED
FUSE SHALL PREVENT CYLINDER FROM RETRACTING
UNDER LOAD. THE VELOCITY FUSE SHALL ACTUATE
AT 7.6 ± 1.1 Lpm (2.0 ± 0.3 gpm) WHEN CYLINDER
IS TESTED WITH MIL-H-5606 OIL AT $24 \pm 5.6^{\circ}\text{C}$
($75 \pm 10^{\circ}\text{F}$). USING ANY OIL THERE THAN
MIL-H-5606 WILL CHANGE THE VELOCITY FUSE
ACTUATION POINT AND MAY RESULT IN IMPROPER
OPERATION OF THE CYLINDER.
- G. ORIFICE: CYLINDER SHALL BE EQUIPPED WITH A
.017 \pm .002 INCH DIAMETER ORIFICE TO RESTRICT
FLOW OUT OF PULL PORT.
- H. SCREENS: CYLINDER PORTS SHALL BE EQUIPPED
WITH SCREENS OR FILTERS AS SHOWN TO PREVENT
PARTICLES FROM BLOCKING VELOCITY FUSE AND ORIFICE.
- J. THE CYLINDER ASSEMBLY SHALL BE CAPABLE OF
BEING CYCLED 2500 TIMES AT 3000 PSI. THE
CYLINDER PRESSURE SHALL NOT DECAY FASTER
THAN 750 PSI IN 30 SECONDS AT 70°F.

- ## 11. FIRST ARTICLE TESTING REQUIREMENTS:

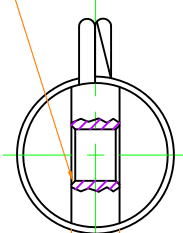
- A. COMPLETE PERFORMANCE VERIFICATION OF NOTED TEST REQUIREMENTS. SEE NOTE NO'S 9 AND 10.

- B. TEST SAMPLE FAILURE:
FAILURE OF ANY TEST SAMPLE SHALL BE CAUSE
FOR REJECTION OF THE ENTIRE REPRESENTATIVE
PRODUCTION LOT. ITEMS SHALL NOT BE PRESENTED
FOR ACCEPTANCE AFTER A FAILURE UNTIL
CORRECTIVE ACTION HAS ELIMINATED THE DEFECT
AND THE ROOT CAUSE OF THE FAILURE.

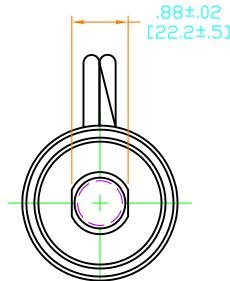
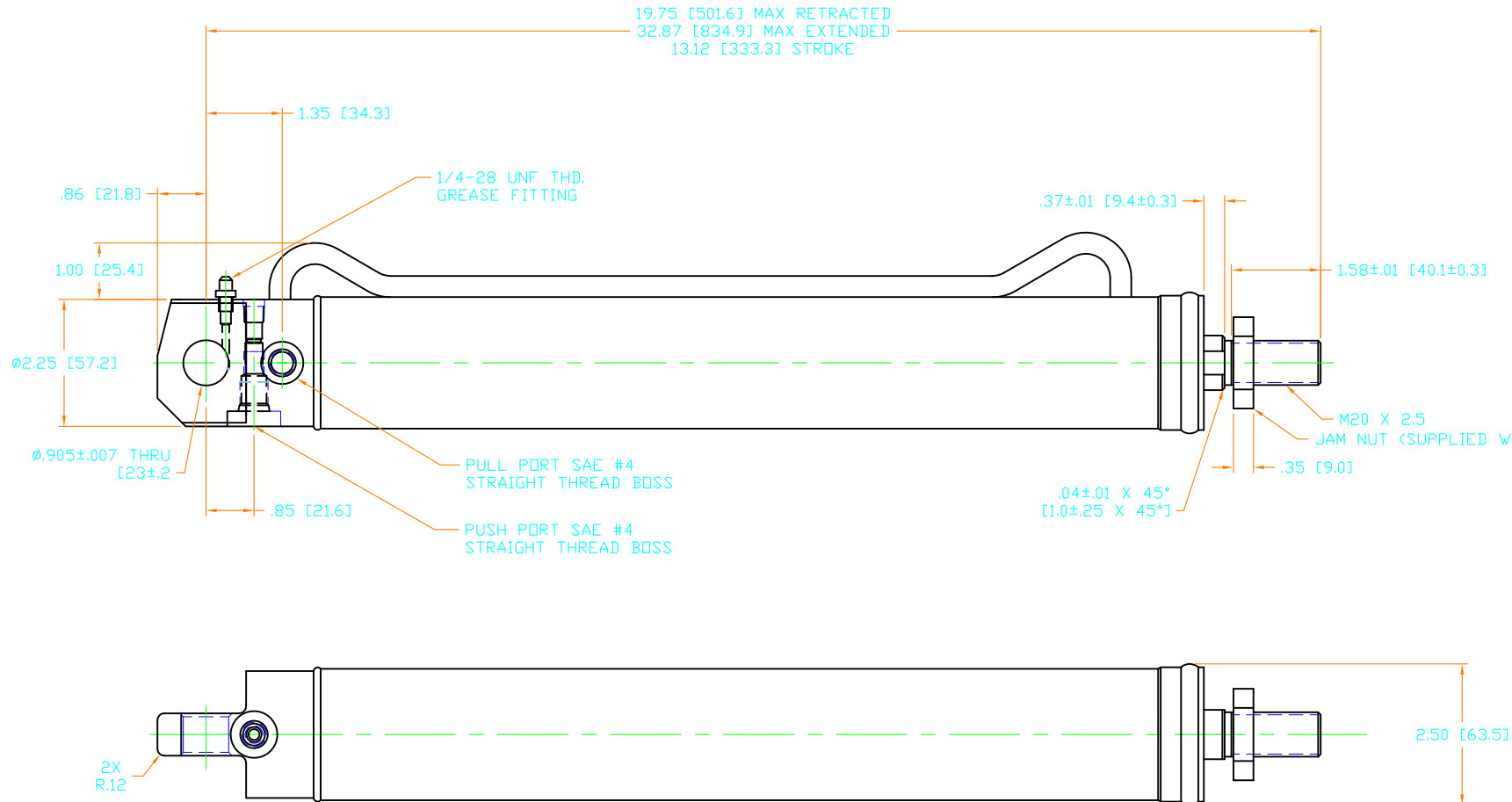
12. ITEM IDENTIFICATION: RUBBER STAMPS OR
STENCIL THE THE FOLLOWING MARKING IAW
MIL-STD-130.
19207-12422486
MFR-  — MANUFACTURER'S CAGE CODE

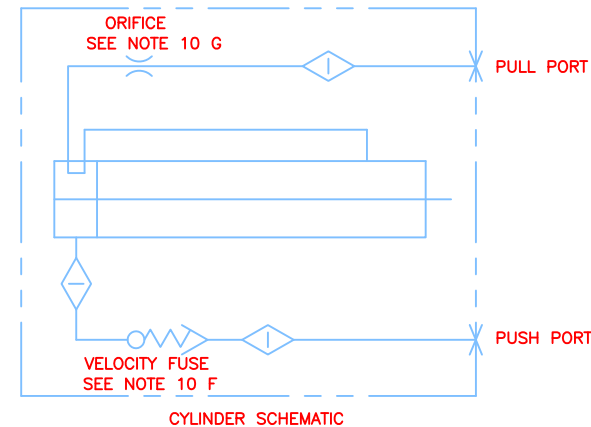
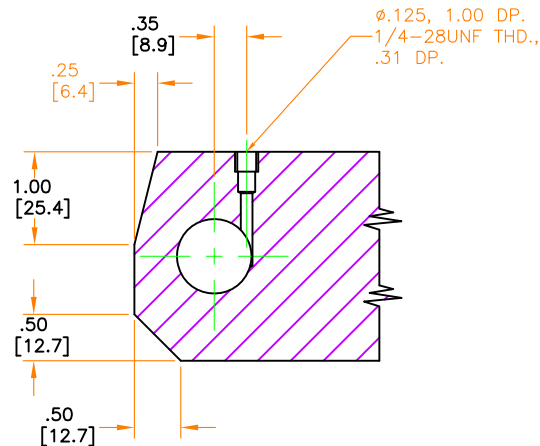
13. IDENTIFICATION OF SUGGESTED SOURCE (S) OF SUPPLY HEREON IS NOT TO BE CONSTRUED AS A GUARANTEE OF PRESENT OR CONTINUED AVAILABILITY AS A SOURCE OF SUPPLY FOR THE ITEM(S)

CAMFER .06±.01 X 2X 45°
[1.5±.3 X 45°



.75±.01 [19.1±0.3]


$$.88 \pm .02$$

$$[22.2 \pm .5]$$


CYLINDER SCHEMATIC

NOTE: ALL DIMENSIONS ARE NOMINAL AND MAY VARY WITH MANUFACTURING TOLERANCES.

DO NOT SCALE	DESCRIPTION CYLINDER ASSEMBLY		DRAWING: DK		Actuant - POWER PACKER LAST REVISED: 04/17/07 ECN: 07-0074 PART NUMBER CA20157305
	MATERIAL SEE BOM		DATE: 06/07/05		
			TOLERANCES		
			CHECKED: DATE:		
SIZE	PROJECTION	THIS DOCUMENT AND THE INFORMATION CONTAINED HEREIN IS THE SOLE PROPERTY OF ACTUANT AND ITS SUBSIDIARIES. IT CONTAINS PROPERTY INFORMATION, WHICH IS CONFIDENTIAL. ANY USE OR REPRODUCTION OF THIS DRAWING WITHOUT AUTHORIZATION FROM ACTUANT OR ITS SUBSIDIARIE MAY WARRANT LEGAL ACTION AGAINST THE USER.		DECIMALS ANGLES $X \pm .015 \quad \pm 1'$ $X \pm .010 \quad \pm .005$ BREAK ALL SHARP EDGES .005/000 UNLESS OTHERWISE SPECIFIED	UNITS: INCHES (mm) SCALE: 1:1.5 SHEET REF 1 OF 1
				PART NUMBER CA20157305	REV. 0C