

NOTES:

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:

- BORE DIA: $\phi 50.8\text{mm}$ ($\phi 2.00\text{ IN.}$)
- ROD DIA: $\phi 25.4\text{mm}$ ($\phi 1.00\text{ IN.}$)
- PUSH AREA: 20.3 SQ. CM. (3.14 SQ. IN.)
- PULL AREA: 15.2 SQ. CM. (2.36 SQ. IN.)
- 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:

- APPROX. OPERATING PRESSURE 4,000 PSI
- MAXIMUM PUSH FORCE: 5700 KG (12566 LB.)
- MAXIMUM PULL FORCE: 4275 KG (9425 LB.)
- SEALS SHALL BE COMPATIBLE WITH MIL-H-5606 WHEN QUALIFIED WITH METHOD 1 OR METHOD 2.

METHOD 1: PRE-AUTHORIZED MATERIALS:
PARKER COMPOUND NUMBERS NO304-75,
NO756-75, NO507-90.

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 $24^\circ \pm 5.6^\circ\text{C}$ ($75^\circ \pm 10^\circ\text{F}$). 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.

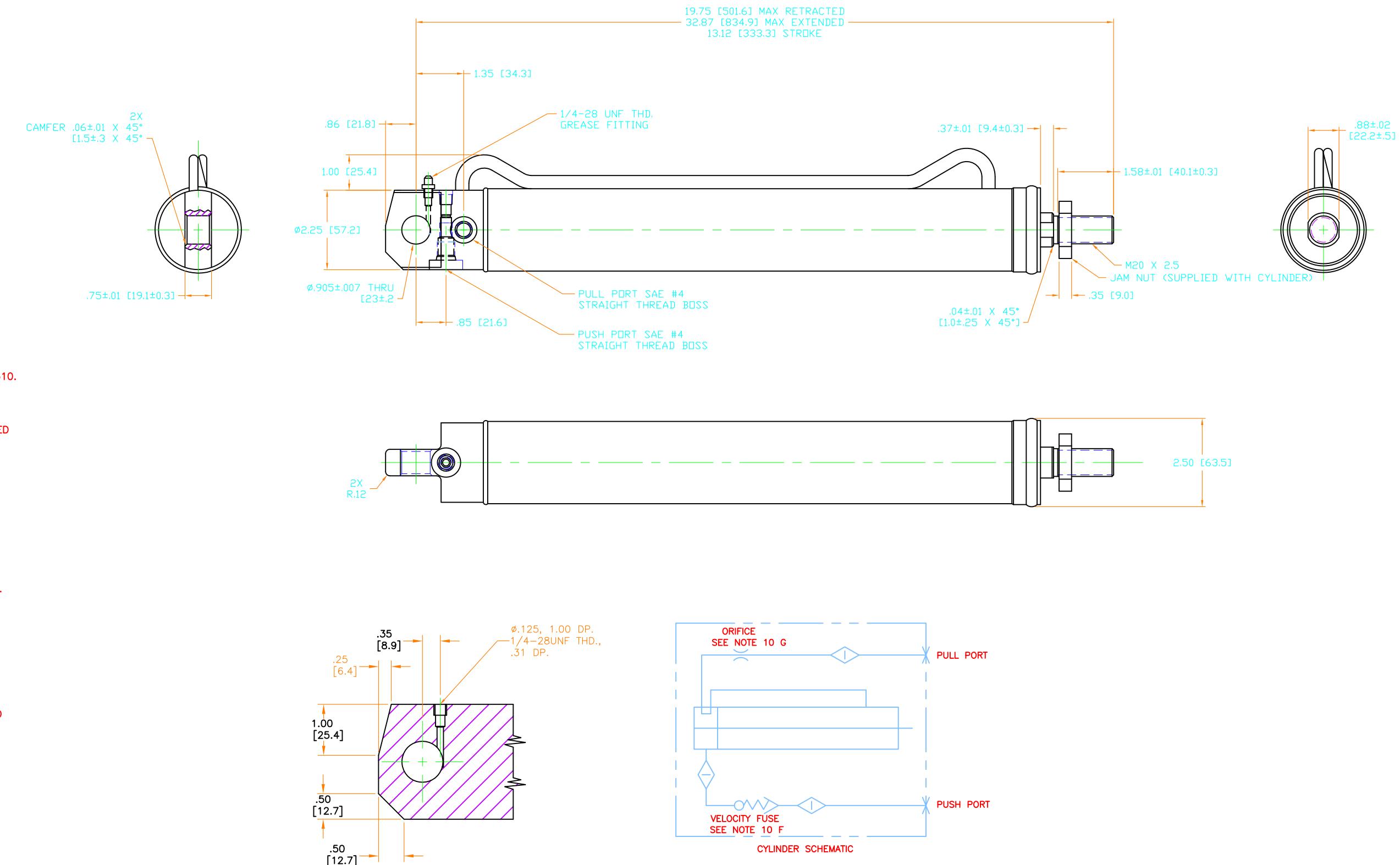
12. ITEM IDENTIFICATION: RUBBER STAMPS OR STENCIL THE THE FOLLOWING MARKING IAW MIL-STD-130.

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 ITEMS(S)

VENDOR CAGE CODE	VENDOR PART NUMBER	ITEM IDENTIFICATION	STEWART & STEVENSON P/N
IK076	CA20157305	IK076-CA20157305	12422486
IK076	CA20157305S	IK076-CA20157305S	12422486VE



DESCRIPTION: CYLINDER ASSEMBLY	DRAWN: DK DATE: 06/07/05
MATERIAL: SEE BOM	CHECKED: DATE: <input type="text"/>
SIZE: <input type="text"/>	TOLERANCES: DEGREES: ANGLES: <input type="text"/>
PROJECTION: <input type="text"/>	UNITS: INCHES (mm) <input type="text"/>
DO NOT SCALE: <input type="checkbox"/>	SCALES: 1:15
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UNLESS OTHERWISE SPECIFIED	

Actuant - POWER
Packer

LAST REVISED: 04/17/07 ECN: 07-0074-1
PART NUMBER: CA20157305 REV: 0C
SHEET 1 OF 1

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