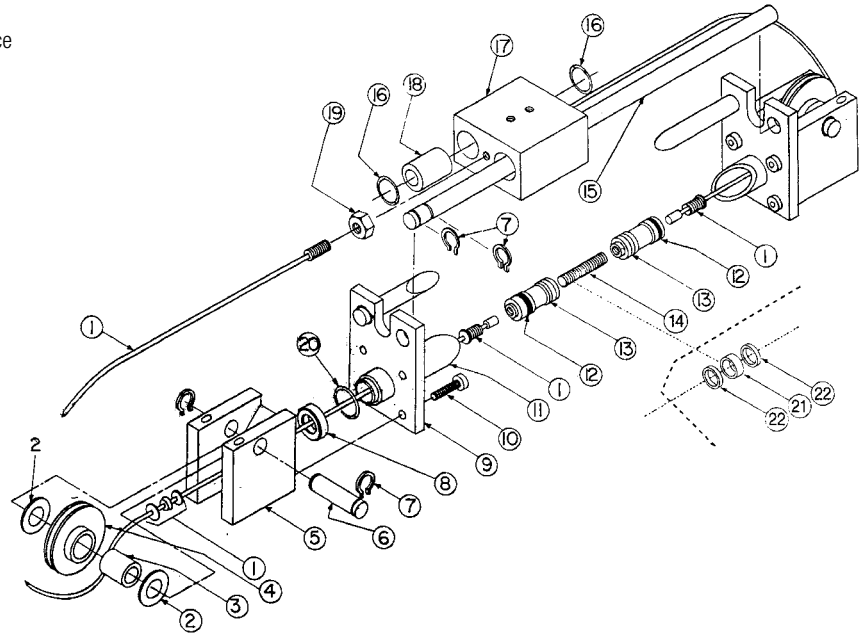
Drawing repeated for reference



Installation

When unpacking a track cable cylinder, BE EXTRA CAREFUL NOT TO SCRATCH OR MAR THE NYLON COVERING ON THE CABLE. The cylinder may be mounted by use of the bolt holes in head. When attaching the bearing block to a driven mechanism, be sure it is in perfect alignment and that the load does not exceed the specifications listed in the catalog.

Pretensioning and proof-loading instructions: All track cable cylinders are shipped without being pretensioned. They must be tensioned after mounting to insure the maximum service life of the unit. There are two types of stretch in cable— constructional and elastic. The constructional stretch is removed by proof-loading of the cable. The elastic stretch is removed by proper pretensioning of the cable.

Proof-loading of cables (for cylinders without Auto Tensioners)

1. Tighten the bracket terminal lock nuts equally with a torque wrench to torque requirements listed in Table A.
2. Let set for 30 seconds.
3. Loosen lock nuts to remove tension. (But leave them tight enough to eliminate any slack.)
4. Follow Pretensioning Instructions.

TABLE A: TORQUE TO PROOF-LOAD THE CABLE	
MODEL	**REQUIRED TORQUE**
TC05	15 INCH-POUNDS *(1.69 NEWTON-METERS)*

Pretensioning of cables

1. Remove one of the guide shafts to gain access to the terminals to adjust the cable tension.
2. Block the load some distance from the end of travel to keep the cylinder from bottoming.
3. Apply pressure 15 to 20 percent higher than the actual pressure required to move the load.

   NOTE: Load pressure is defined as the actual pressure required to move the load. When the load is stopped externally before the piston bottoms, the relief valve or regulator setting becomes the load pressure.

When pressurized, one cable will become tight while the other becomes slack. Manually take up the slack in the cable. Release the pressure and block the load from the other side. Repeat the manual adjustment on the other cable. Release pressure and remove the blocks. Reinstall the guide shaft which had been removed. Return the regulator to its original setting.

The cylinder is now pretensioned. Additional manual adjustment should not be required. It is suggested however, that the cable tension be checked periodically.

Alternate Method: If the load cannot be blocked for cable pretensioning as stated above, tighten the bracket terminal lock nuts with a torque wrench to total pretensioning torque as stated in Table B.

TABLE B: TORQUE FOR UNBLOCKABLE LOADS					
MODEL	**PRETENSIONING TORQUE**	**+**	**STARTING TORQUE OF TERMINAL NUTS**	**=**	**TOTAL PRETENSIONING TORQUE**
TC05	2.5 IN-LBS.	+	10.0 IN.-LBS.	=	12.5 IN.-LBS.
	0.282 N-M	+	*1.130 N-M*	=	*1.412 N-M*

TO REBUILD THE CYLINDER

1. Remove the track cable cylinder from machinery.
2. Remove the Guide Shafts (15) then disconnect Cables (1) from Bearing Block (17) and remove Pulleys (4) on both ends of track cable cylinder.
3. Remove one Head (5) from track cable cylinder by removing the four Cap Screws (10).
4. Pull Piston (13) towards the removed Cylinder Head (5) and remove from the Tube (11).
5. Disconnect Cables (1) from Piston (13). (See Cable Assembly/ Disassembly Instructions). Then remove the other Cylinder Head (5) from Tube (11) and disengage Cable (1) from it.
6. Install new U-cups (12) Pistons (13).
7. See Cable Assembly/Reassembly Instructions below. Always lubricate seals with oil when installing.