
SERIES 98 PNEUMATIC & 98H HYDRAULIC
SCOTCH YOKE ACTUATOR

Installation, Operation and Maintenance Manual

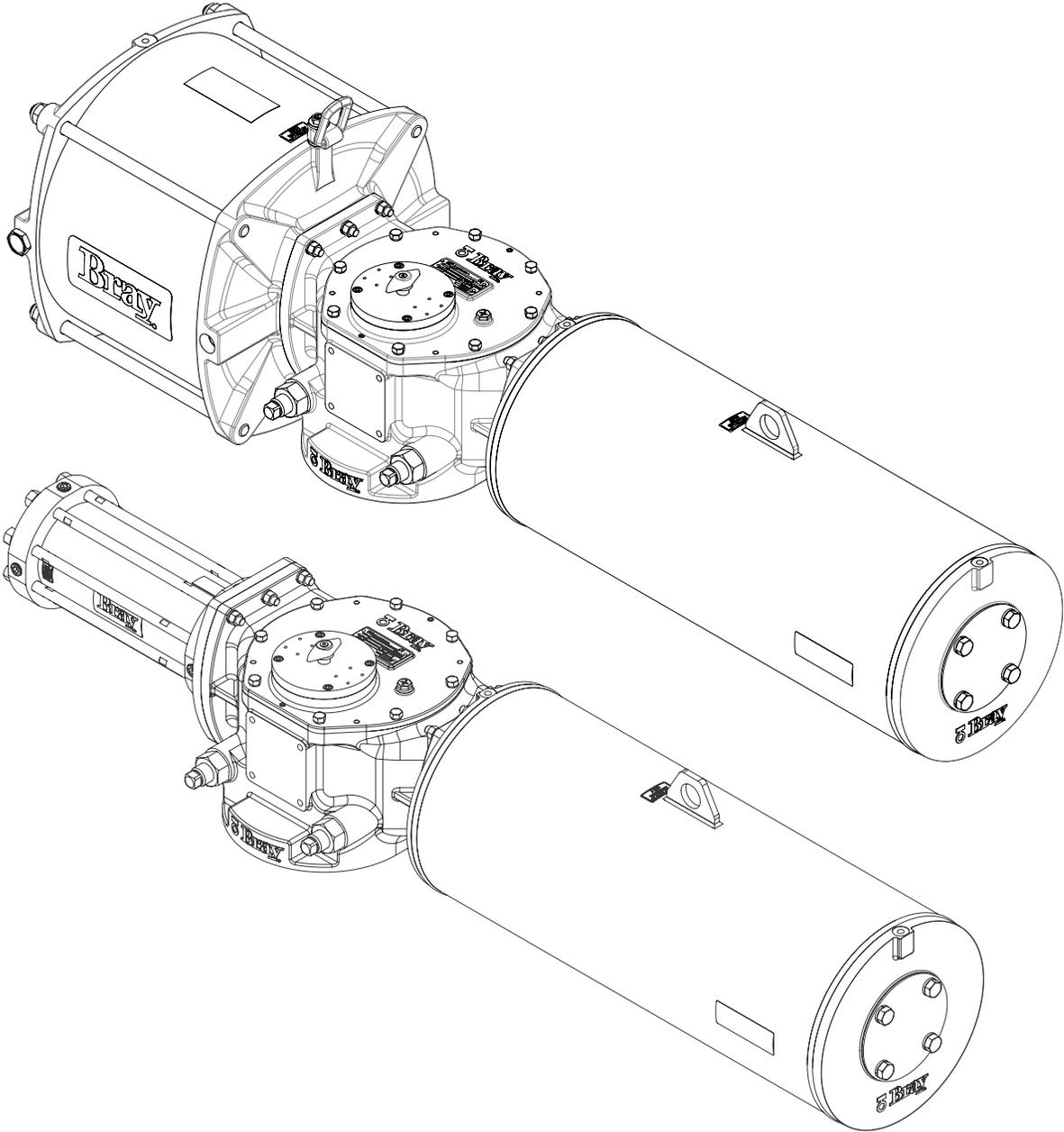


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**READ AND FOLLOW THESE INSTRUCTIONS CAREFULLY.
SAVE THIS MANUAL FOR LATER USE.**

1.0 DEFINITION OF TERMS

WARNING

Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION

Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

NOTICE

Used without the safety alert symbol, indicates a potential situation which, if not avoided, may result in an undesirable result or state, including property damage.

2.0 INTRODUCTION

The instructions and guidelines in this manual enable competent technicians to install, operate, adjust and carry out routine maintenance activities on Series 98 pneumatic and hydraulic actuators. Responsibility lies with the user to follow the instructions in this and in any additional documentation related to the product and accessories supplied with it.

User shall ensure the equipment is installed and operated in the environment that it is intended for and effective protections are provided against exposure to pressure and temperature in excess of maximum rating. Failing to do so may affect the product warranty. Only trained personnel, aware of precautions in hazardous environments and health and safety in the workplace should service the equipment.

Series 98 Scotch Yoke Actuators are designed for quarter turn rotary valves, in configurations as:

- DA- Double Acting with a single cylinder
- DD- Double Acting with dual cylinders
- SC- Spring Return Fail Close (CW) - Symmetrical and Canted Yoke
- SO- Spring Return Fail Open (CCW) - Symmetrical Yoke only.

The pneumatic pressure module of the S98 is replaced with a hydraulic pressure module in the S98H, while the Torque and Spring modules remain the same.

Two output torque characteristic profiles are available in the form of Symmetrical Yoke and Canted Yoke.

Standard actuators have a mounting base to ISO 5211. MSS mounting base is available as an option.

Mounting of the shaft driven accessories is per VDE 3845/ NAMUR standard.

The operating pressure range of the Series 98 Pneumatic Actuators is 40 to 150 psig, and 500 to 3000 psig for Series 98H, depending upon the size and configuration. Refer to the MOP (maximum operating pressure) charts or the name plate on the actuator for the maximum operating pressure.

Operating media for S98 pneumatic shall be clean and dry compressed air, in accordance to ISO 8573-1 Class 2.3.4 filtered to 5 microns or better, with pressure dew point of -20°C (-4°F) or at least 10°C (18°F) below ambient temperature.

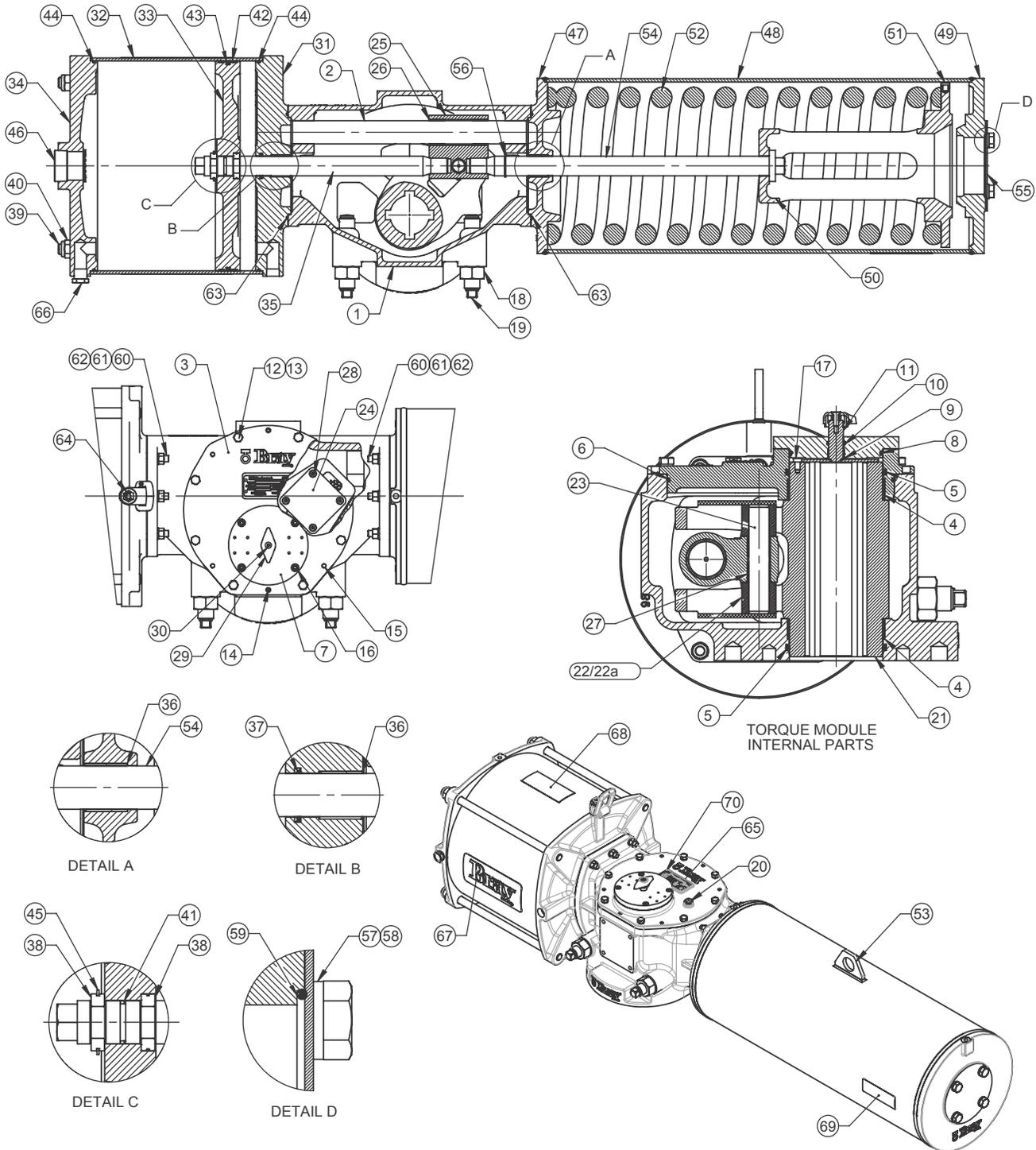
For S98H hydraulic actuators, operating media shall be the recommended grade of hydraulic fluid, specified to ISO 4406 class 18/16/13 maximum contamination level and flash point > 157°C, for the standard temperature trim.

The user shall plan and implement a periodic maintenance program to ensure the service conditions continue as intended and the actuator is monitored and maintained per manufacturer's recommendations.

Information on certification documentation is available on the Bray website or by contacting your local Bray Sales Representative.

3.0 ASSEMBLY DRAWINGS AND MATERIALS OF CONSTRUCTION

3.1 Spring Return Pneumatic Actuator Assembly Drawing



For reference only. Please refer to current revision of ES-00019 drawing for more information.

3.2 Spring Return Pneumatic Actuator Materials of Construction

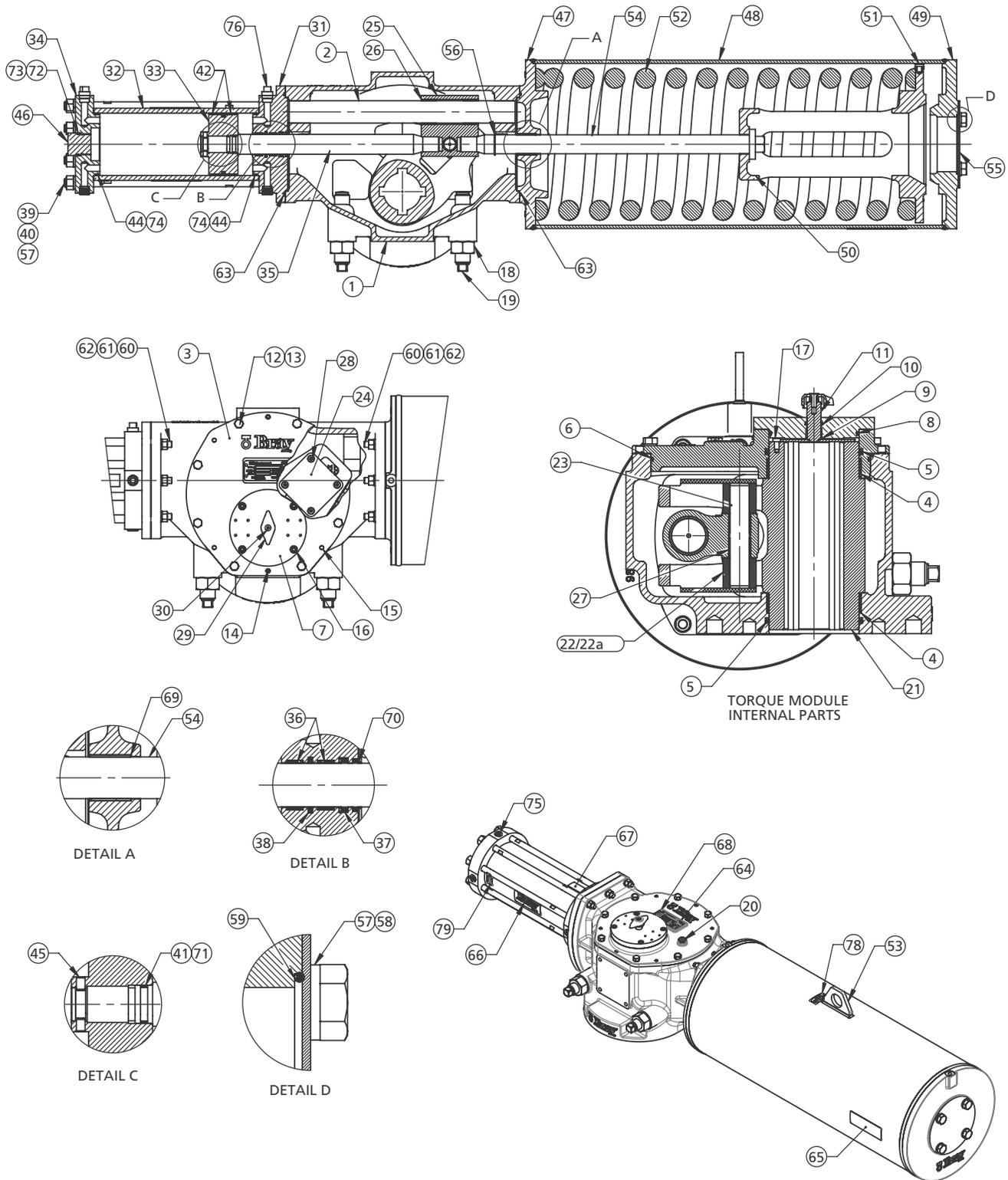
Item	Description	Material	Qty.
1	Yoke Housing	Ductile Iron	1
2	Guide Rod	Alloy Steel	1
3	Housing Cover	Ductile Iron	1
4**	Bushing (Yoke)	PTFE Bronze	2
5*	O-Ring (Yoke)	Buna-N	2
6*	O-Ring (Cover)	Buna-N	1
7	Top Cover	Ductile Iron	1
8*	O-Ring (Top Cover)	Buna-N	1
9**	Flanged Bushing	PTFE Bronze	1
10*	O-Ring (Accessory Drive)	Buna-N	1
11	Accessory Drive	Stainless Steel	1
12	Hex Bolt	Steel	8
13	Spring Washer	Spring Steel	8
14	Set Screw, Socket Head	Steel	2
15	Dowel Pin	Hardened Steel	4
16	Socket Head Caps Screw	Steel	4
17	Socket Head Caps Screw, Low Head	Steel	1
18	Seal Nut	Steel	2
19	Stop Bolt	Steel	2
20	Breather Vents	Carbon Steel	1
21	Yoke	Ductile Iron	1
22**	Slider Block	Bronze	2
22a**	Roller	Steel	2
23	Yoke Pin	Alloy Steel	1
24	Retainer Plate	Plastic	2
25	Guide Block	Carbon Steel	1
26**	Bushing (Guide Rod)	PTFE Bronze	2
27**	Bushing (Yoke Pin)	PTFE Bronze	2
28	Cap Screw, Flat Head, Hex Socket	Steel	8
29	Position Indicator	Plastic	1
30	Cap Screw, Flat Head, Hex Socket	Steel	1
31	Adaptor, Pressure Module	Ductile Iron	1
32	Barrel	Carbon Steel	1
33	Piston	Ductile Iron	1
34	End Cap, Pressure Module	Ductile Iron	1
35	Piston Rod	Alloy Steel	1
36**	Bushing (Adaptor)	PTFE Bronze	2
37*	Seal, U-Cup	Buna-N	1

Item	Description	Material	Qty.
38	Split Collar	Alloy Steel	4
39	Tie Rod	Steel	4
40	Locknut, Nylok	Steel	4
41*	O-Ring (Piston Rod)	Buna-N	1
42*	Wear Ring	PTFE	2
43*	Quad Seal	Buna-N	1
44*	O-Ring (Barrel)	Buna-N	2
45	Retainer Ring	Stainless Steel	1
46	Pipe Plug	Carbon Steel	1
47	Adaptor, Spring Module	Carbon Steel	1
48	Pipe	Carbon Steel	1
49	End Cap, Spring Module	Carbon Steel	1
50	Spring Guide	Carbon Steel	1
51	Button	Plastic	9
52	Spring, Compression	Alloy Steel	1
53	Lifting Lug	Carbon Steel	1
54	Spring Rod	Alloy Steel	1
55	End Cover	Carbon Steel	1
56	Retainer Ring	Stainless Steel	1
57	Spring Washer	Spring Steel	4
58	Hex Bolt	Steel	4
59*	O-Ring (End Cover)	Buna-N	1
60	Stud	Steel	12
61	Nut	Steel	12
62	Spring Washer	Spring Steel	12
63*	O-Ring (Module)	Buna-N	2
64	Lifting Eye Bolt	Carbon Steel	1
65	Name Plate	Stainless Steel	1
66	Breather Vent	Stainless Steel	1
67	Label, Logo	Metallized Polyester	2
68	Label, Configuration	Metallized Polyester	1
69	Label, Caution	Metallized Polyester	1
70	Rivets	Stainless Steel	4

*	Parts in Seal Kits
* & **	Parts in Repair Kits

For reference only. Please refer to current revision of ES-00019 drawing for more information.

3.3 Spring Return Hydraulic Actuator Assembly Drawing



For reference only. Please refer to current revision of ES-00690 drawing for more information.

3.4 Spring Return Hydraulic Actuator Materials of Construction

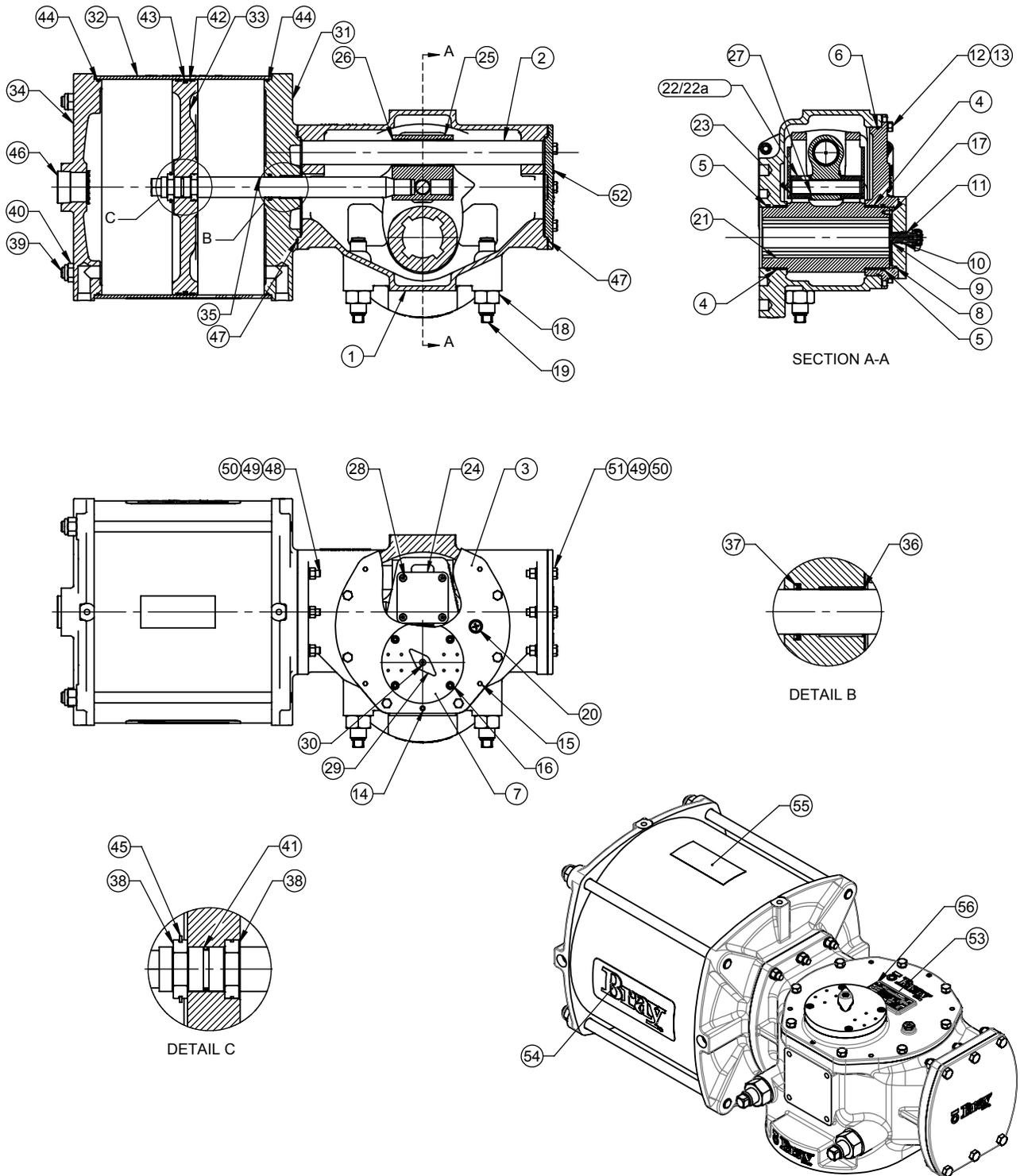
Item	Description	Material	Qty
1	Yoke Housing	Ductile Iron	1
2	Guide Rod Alloy	Steel	1
3	Housing Cover	Ductile Iron	1
4**	Bushing (Yoke)	PTFE Bronze	2
5*	O-Ring (Yoke)	Buna-N	2
6*	O-Ring (Cover)	Buna-N	1
7	Top Cover	Ductile Iron	1
8*	O-Ring (Top Cover)	Buna-N	1
9**	Flanged Bushing	PTFE Bronze	1
10*	O-Ring (Accessory Drive)	Buna-N	1
11	Accessory Drive	Stainless Steel	1
12	Hex Bolt	Steel	8
13	Spring Washer	Spring Steel	8
14	Set Screw, Socket Head	Steel	2
15	Dowel Pin	Hardened Steel	4
16	Socket Head Caps Screw	Steel	4
17	Socket Head Caps Screw, Low Head	Steel	1
18	Seal Nut	Steel	2
19	Stop Bolt	Steel	2
20	Breather Vents Carbon	Steel	1
21	Yoke	Ductile Iron	1
22**	Slider Block	Bronze	2
22a**	Roller	Steel	2
23	Yoke Pin	Alloy Steel	1
24	Retainer Plate	Plastic	2
25	Guide Block	Carbon Steel	1
26**	Bushing (Guide Rod)	PTFE Bronze	2
27**	Bushing (Yoke Pin)	PTFE Bronze	2
28	Cap Screw, Flat Head, Hex Socket	Steel	8
29	Position Indicator	Plastic	1
30	Cap Screw, Flat Head, Hex Socket	Steel	1
31	Adaptor, Pressure Module	Carbon Steel	1
32	Barrel	Carbon Steel	1
33	Piston	Alloy Steel	1
34	End Cap, Pressure Module	Carbon Steel	1
35	Piston Rod	Alloy Steel	1
36*	Guide Ring, Piston Rod	Phenolic Resin	2
37*	Lip Seal	Polyurethane	1
38*	Sealing Set, Piston Rod	PTFE & Buna-N	1
39	Tie Rod	Alloy Steel	8
40	Nut, Tie Rod	Steel	8
41*	O-Ring (Piston Rod)	Buna-N	1

Item	Description	Material	Qty
42*	Guide Ring, Piston	Phenolic Resin	2
43*	Sealing Set, Piston	PTFE & Buna-N	1
44*	O-Ring (Barrel)	Buna-N	2
45	Set Screw, Piston Lock	Steel	2
46	End Plug	Steel	1
47	Adaptor, Spring Module	Carbon Steel	1
48	Pipe Carbon	Steel	1
49	End Cap, Spring Module	Carbon Steel	1
50	Spring Guide	Carbon Steel	1
51	Button	Plastic	9
52	Spring, Compression	Alloy Steel	1
53	Lifting Lug	Carbon Steel	1
54	Spring Rod	Alloy Steel	1
55	End Cover	Carbon Steel	1
56	Retainer Ring	Stainless Steel	1
57	Spring Washer	Spring Steel	12
58	Hex Bolt	Steel	4
59*	O-Ring (End Cover)	Buna-N	1
60	Stud / Hex Bolt (Module)	Steel	12
61	Nut (Module)	Steel	12
62	Spring Washer (Module)	Spring Steel	12
63*	O-Ring (Module)	Buna-N	2
64	Name Plate	Stainless Steel	1
65	Label, Caution	Metallized Polyester	1
66	Label, Logo	Metallized Polyester	2
67	Label, Configuration	Metallized Polyester	1
68	Rivets	Stainless Steel	4
69**	Bushing (Adaptor)	PTFE Bronze	1
70*	Wiper	Polyurethane	1
71*	Backup Ring (Piston Rod)	PTFE	2
72*	O-Ring (End Plug)	Buna-N	1
73*	Backup Ring (End Plug)	PTFE	1
74*	Backup Ring (Barrel)	PTFE	2
75	Pipe Plug	Carbon Steel	4
76	Protective Plug	Plastic	2
78	Label, Lifting	Metallized Polyester	1
79	Label, Venting	Metallized Polyester	1

*	Parts in Seal Kits
* & **	Parts in Repair Kits

For reference only. Please refer to current revision of ES-00690 drawing for more information.

3.5 Pneumatic Actuator - Double Acting, Single Cylinder Assembly Drawing



For reference only. Please refer to current revision of ES-00020 drawing for more information.

3.6 Pneumatic Actuator - Double Acting, Single Cylinder Materials of Construction

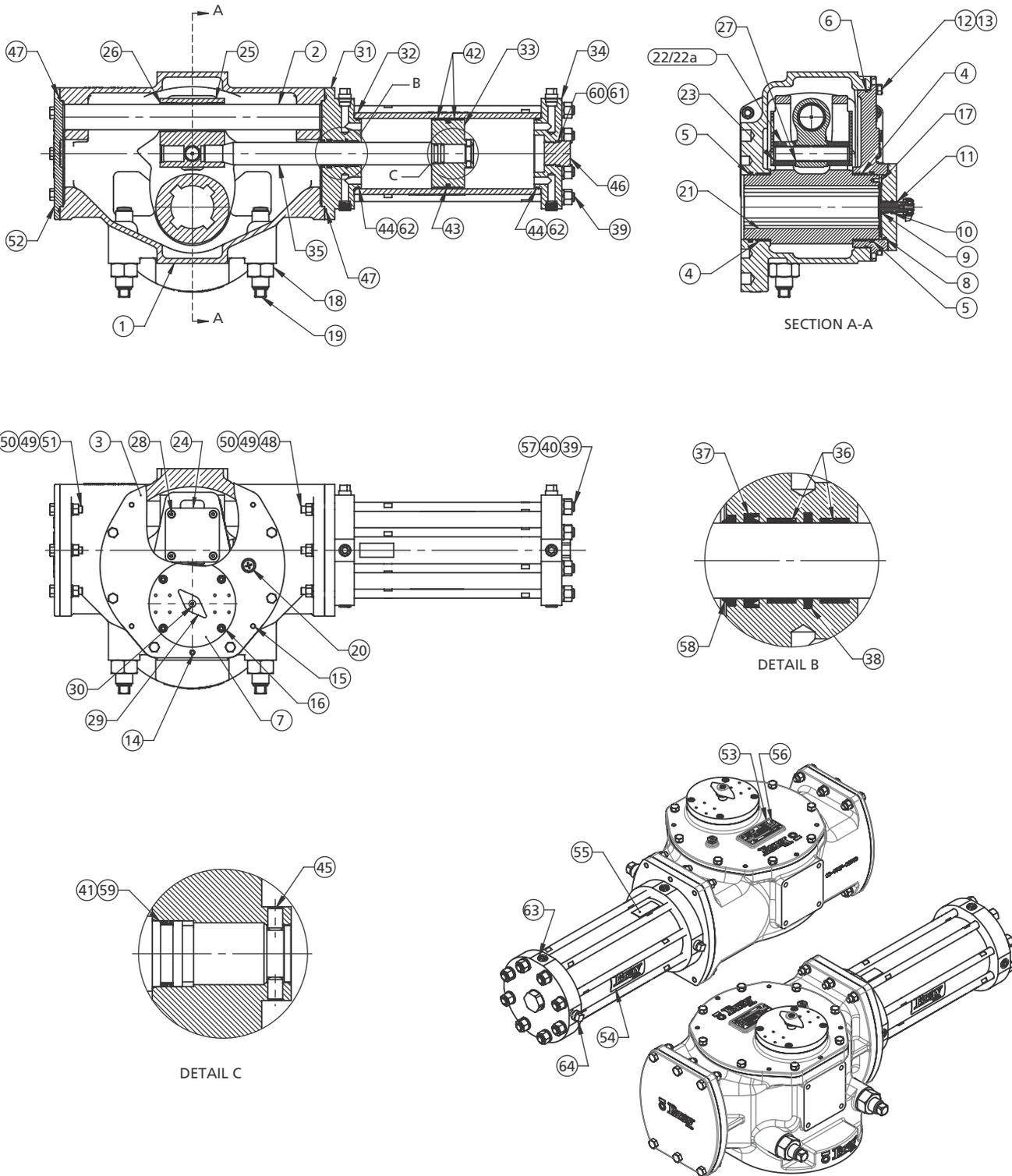
Item	Description	Material	Qty.
1	Yoke Housing	Ductile Iron	1
2	Guide Rod	Alloy Steel	1
3	Housing Cover	Ductile Iron	1
4**	Bushing (Yoke)	PTFE Bronze	2
5*	O-ring (Yoke)	Buna-N	2
6*	O-ring (Cover)	Buna-N	1
7	Top Cover	Ductile Iron	1
8*	O-ring (Top Cover)	Buna-N	1
9**	Flanged Bushing	PTFE Bronze	1
10*	O-ring (Accessory Drive)	Buna-N	1
11	Accessory Drive	Stainless Steel	1
12	Hex Bolt	Steel	8
13	Spring Washer	Spring Steel	8
14	Set Screw, Socket Head	Steel	2
15	Dowel Pin	Hardened Steel	4
16	Socket Head Caps Screw	Steel	4
17	Socket Head Caps Screw, Low Head	Steel	1
18	Seal Nut	Steel	2
19	Stop Bolt	Steel	2
20	Breather Vents	Carbon Steel	1
21	Yoke	Ductile Iron	1
22**	Slider Block	Bronze	2
22a**	Roller	Steel	2
23	Yoke Pin	Alloy Steel	1
24	Retainer Plate	Plastic	2
25	Guide Block	Carbon Steel	1
26**	Bushing (Guide Rod)	PTFE Bronze	2
27**	Bushing (Yoke Pin)	PTFE Bronze	2
28	Cap Screw, Flat Head, Hex Socket	Steel	8

Item	Description	Material	Qty.
29	Position Indicator	Plastic	1
30	Cap Screw, Flat Head, Hex Socket	Steel	1
31	Adaptor, Pressure Module	Ductile Iron	1
32	Barrel	Carbon Steel	1
33	Piston	Ductile Iron	1
34	End Cap, Pressure Module	Ductile Iron	1
35	Piston Rod	Alloy Steel	1
36**	Bushing (Adaptor)	PTFE Bronze	1
37*	Seal, U-cup	Buna-N	1
38	Split Collar	Alloy Steel	4
39	Tie Rod	Steel	4
40	Locknut, Nylok	Steel	4
41*	O-ring (Piston Rod)	Buna-N	1
42*	Wear Ring	PTFE	2
43*	Quad Seal	Buna-N	1
44*	O-ring (Barrel)	Buna-N	2
45	Retainer Ring	Stainless Steel	1
46	Pipe Plug	Carbon Steel	1
47*	O-ring (Module)	Buna-N	2
48	Stud	Steel	6
49	Spring Washer	Spring Steel	12
50	Nut	Steel	12
51	Hex Bolt	Steel	6
52	End Cover, DA	Ductile Iron	1
53	Name Plate	Stainless Steel	1
54	Label, Logo	Metallized Polyester	2
55	Label, Configuration	Metallized Polyester	1
56	Rivets	Stainless Steel	4

*	Parts in Seal Kits
* & **	Parts in Repair Kits

For reference only. Please refer to current revision of ES-00020 drawing for more information.

3.7 Hydraulic Actuator - Double Acting, Single Cylinder Assembly Drawing



For reference only. Please refer to current revision of ES-00688 drawing for more information.

3.8 Hydraulic Actuator - Double Acting, Single Cylinder Materials of Construction

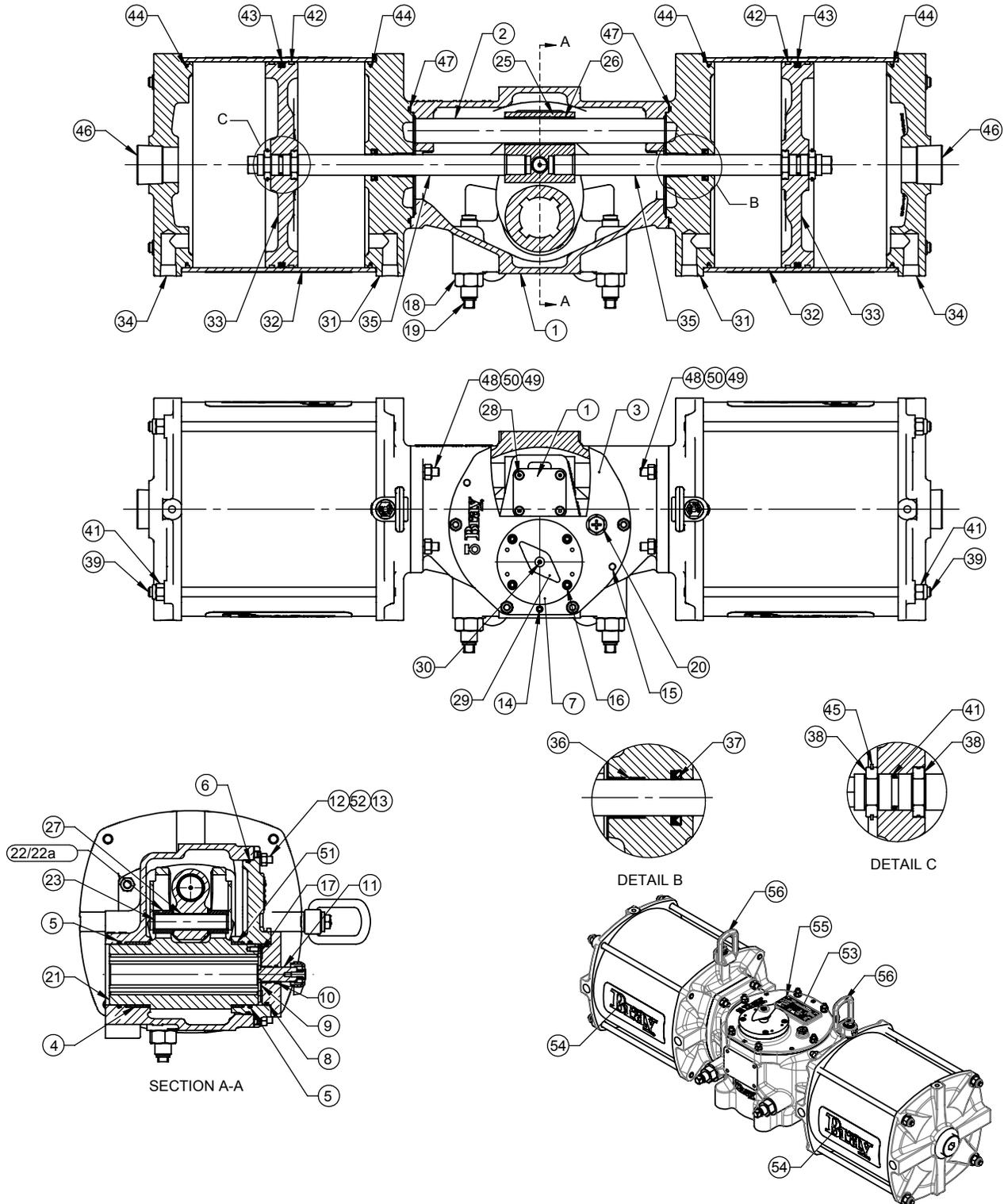
Item	Description	Material	Qty.
1	Yoke Housing	Ductile Iron	1
2	Guide Rod	Alloy Steel	1
3	Housing Cover	Ductile Iron	1
4 **	Bushing (Yoke)	PTFE Bronze	2
5 *	O-Ring (Yoke)	Buna-N	2
6 *	O-Ring (Cover)	Buna-N	1
7	Top Cover	Ductile Iron	1
8 *	O-Ring (Top Cover)	Buna-N	1
9 **	Flanged Bushing	PTFE Bronze	1
10 *	O-Ring (Accessory Drive)	Buna-N	1
11	Accessory Drive	Stainless Steel	1
12	Hex Bolt	Steel	8
13	Spring Washer	Spring Steel	8
14	Set Screw, Socket Head	Steel	2
15	Dowel Pin	Hardened Steel	4
16	Socket Head Caps Screw	Steel	4
17	Socket Head Caps Screw Low Head	Steel	1
18	Seal Nut	Steel	2
19	Stop Bolt	Steel	2
20	Breather Vents Carbon	Steel	1
21	Yoke	Ductile Iron	1
22 **	Slider Block	Bronze	2
22a **	Roller	Steel	2
23	Yoke Pin	Alloy Steel	1
24	Retainer Plate	Plastic	2
25	Guide Block	Carbon Steel	1
26 **	Bushing (Guide Rod)	PTFE Bronze	2
27 **	Bushing (Yoke Pin)	Ptfe Bronze	2
28	Cap Screw, Flat Head, Hex Socket	Steel	8
29	Position Indicator	Plastic	1
30	Cap Screw, Flat Head, Hex Socket	Steel	1
31	Adaptor, Pressure Module	Carbon Steel	1
32	Barrel	Carbon Steel	1
33	Piston	Alloy Steel	1
34	End Cap, Pressure Module	Carbon Steel	1

Item	Description	Material	Qty.
35	Piston Rod	Alloy Steel	1
36 *	Guide Ring, Piston Rod	Phenolic Resin	2
37 *	Lip Seal	Polyurethane	1
38 *	Sealing Set, Piston Rod	PTFE & Buna-N	1
39	Tie Rod	Alloy Steel	8
40	Nut, Tie Rod	Steel	8
41 *	O-Ring (Piston Rod)	Buna-N	1
42 *	Guide Ring, Piston	Phenolic Resin	2
43 *	Sealing Set, Piston	PTFE & Buna-N	1
44 *	O-Ring (Barrel)	Buna-N	2
45	Set Screw, Piston Lock	Steel	2
46	End Plug	Steel	1
47 *	O-Ring (Module)	Buna-N	2
48	Stud / Bolt (Module)	Steel	6
49	Spring Washer (Module)	Spring Steel	12
50	Nut (Module)	Steel	2
51	Hex Bolt	Steel	6
52	End Cover, DA	Ductile Iron	1
53	Name Plate	Stainless Steel	1
54	Label, Logo	Metallized Polyester	2
55	Label, Configuration	Metallized Polyester	1
56	Rivets	Stainless Steel	4
57	Spring Washer, Tie Rod	Spring Steel	8
58 *	Wiper	Polyurethane	1
59 *	Backup Ring (Piston Rod)	PTFE	2
60 *	O-Ring (End Plug)	Buna-N	1
61 *	Backup Ring (End Plug)	PTFE	1
62 *	Backup Ring (Barrel)	PTFE	2
63	Pipe Plug	Carbon Steel	4
64	Protective Plug	Plastic	2

*	Parts in Seal Kits
* & **	Parts in Repair Kits

For reference only. Please refer to current revision of ES-00688 drawing for more information.

3.9 Pneumatic Actuator - Double Acting, Dual Cylinder Assembly Drawing



For reference only. Please refer to current revision of ES-00021 drawing for more information.

3.10 Pneumatic Actuator - Double Acting, Dual Cylinder Materials of Construction

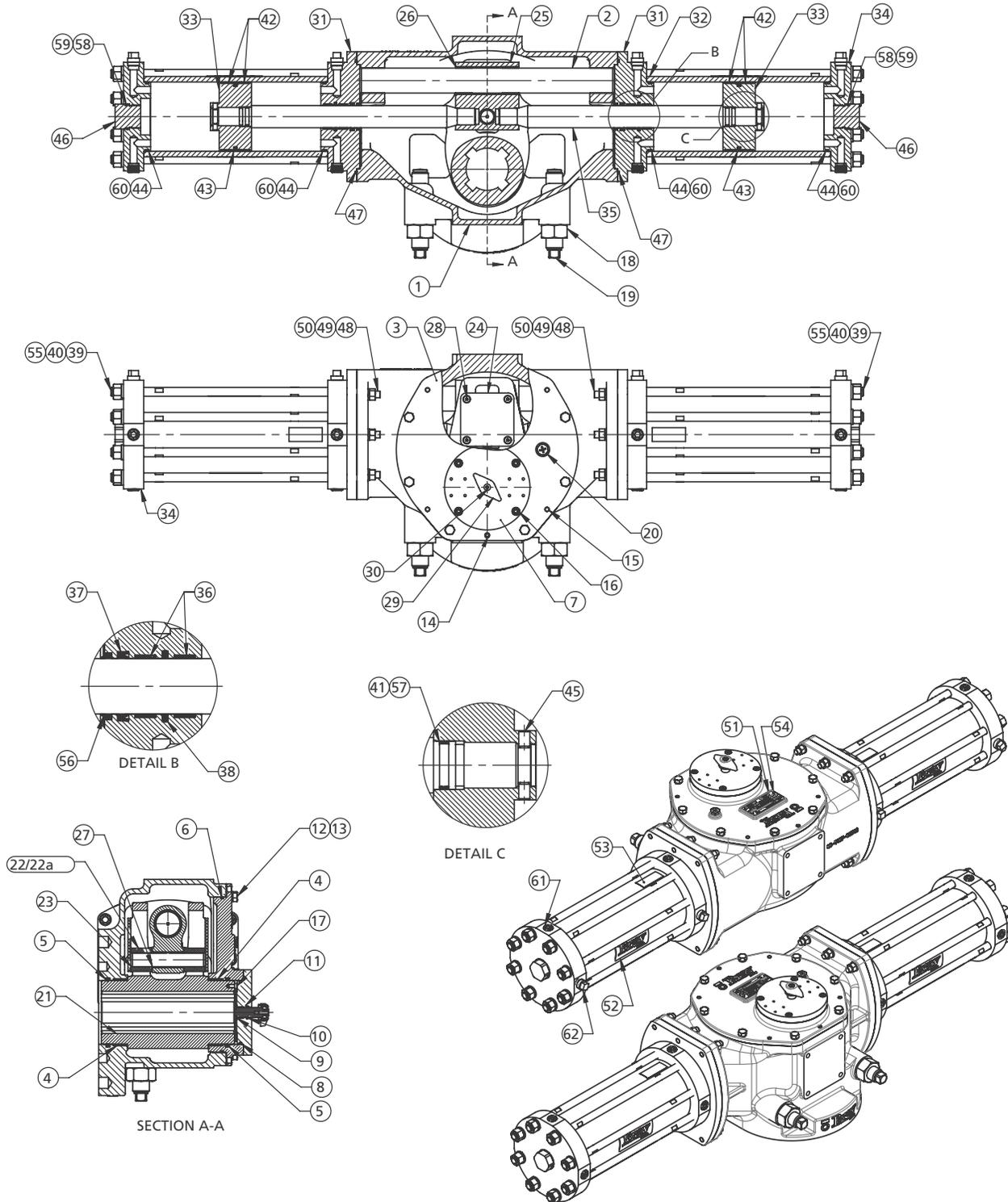
Item	Description	Material	Qty.
1	Yoke Housing	Ductile Iron	1
2	Guide Rod	Alloy Steel	1
3	Housing Cover	Ductile Iron	1
4 **	Bushing (Yoke)	PTFE Bronze	2
5 *	O-Ring (Yoke)	Buna-N	2
6 *	O-Ring (Cover)	Buna-N	1
7	Top Cover	Ductile Iron	1
8 *	O-Ring (Top Cover)	Buna-N	1
9 **	Flanged Bushing	PTFE Bronze	1
10 *	O-Ring (Accessory Drive)	Buna-N	1
11	Accessory Drive	Stainless Steel	1
12	Hex Bolt	Steel	8
13	Spring Washer	Spring Steel	8
14	Set Screw, Socket Head	Steel	2
15	Dowel Pin	Hardened Steel	4
16	Socket Head Caps Screw	Steel	4
17	Socket Head Caps Screw, Low Head	Steel	1
18	Seal Nut	Steel	2
19	Stop Bolt	Steel	2
20	Breather Vents	Carbon Steel	1
21	Yoke	Ductile Iron	1
22 **	Slider Block	Bronze	2
22a **	Roller	Steel	2
23	Yoke Pin	Alloy Steel	1
24	Retainer Plate	Plastic	2
25	Guide Block	Carbon Steel	1
26 **	Bushing (Guide Rod)	PTFE Bronze	2
27 **	Bushing (Yoke Pin)	PTFE Bronze	2
28	Cap Screw, Flat Head, Hex Socket	Steel	8
29	Position Indicator	Plastic	1
30	Cap Screw, Flat Head, Hex Socket	Steel	1
31	Adaptor, Pressure Module	Ductile Iron	1
32	Barrel	Carbon Steel	1
33	Piston	Ductile Iron	1
34	End Cap, Pressure Module	Ductile Iron	1
35	Piston Rod	Alloy Steel	1
36 **	Bushing (Adaptor)	PTFE Bronze	2

Item	Description	Material	Qty.
37 *	Seal, U-Cup	Buna-N	1
38	Split Collar	Alloy Steel	4
39	Tie Rod	Steel	4
40	Locknut, Nylok	Steel	4
41 *	O-Ring (Piston Rod)	Buna-N	1
42 *	Wear Ring	PTFE	2
43 *	Quad Seal	Buna-N	1
44 *	O-Ring (Barrel)	Buna-N	2
45	Retainer Ring	Stainless Steel	1
46	Pipe Plug	Carbon Steel	1
47	Adaptor, Spring Module	Carbon Steel	1
48	Pipe	Carbon Steel	1
49	End Cap, Spring Module	Carbon Steel	1
50	Spring Guide	Carbon Steel	1
51	Button	Plastic	9
52	Spring, Compression	Alloy Steel	1
53	Lifting Lug	Carbon Steel	1
54	Spring Rod	Alloy Steel	1
55	End Cover	Carbon Steel	1
56	Retainer Ring	Stainless Steel	1
57	Spring Washer	Spring Steel	4
58	Hex Bolt	Steel	4
59 *	O-Ring (End Cover)	Buna-N	1
60	Stud	Steel	12
61	Nut	Steel	12
62	Spring Washer	Spring Steel	12
63 *	O-Ring (Module)	Buna-N	2
64	Lifting Eye Bolt	Carbon Steel	1
65	Name Plate	Stainless Steel	1
66	Breather Vent	Stainless Steel	1
67	Label, Logo	Metallized Polyester	2
68	Label, Configuration	Metallized Polyester	1
69	Label, Caution	Metallized Polyester	1
70	Rivets	Stainless Steel	4

*	Parts in Seal Kits
* & **	Parts in Repair Kits

For reference only. Please refer to current revision of ES-00021 drawing for more information.

3.11 Hydraulic Actuator - Double Acting, Dual Cylinder Assembly Drawing



For reference only. Please refer to current revision of ES-00689 drawing for more information.

3.12 Hydraulic Actuator - Double Acting, Dual Cylinder Materials of Construction

Item	Description	Material	Qty.
1	Yoke Housing	Ductile Iron	1
2	Guide Rod	Alloy Steel	1
3	Housing Cover	Ductile Iron	1
4 **	Bushing (Yoke)	PTFE Bronze	2
5 *	O-Ring (Yoke)	Buna-N	2
6 *	O-Ring (Cover)	Buna-N	1
7	Top Cover	Ductile Iron	1
8 *	O-Ring (Top Cover)	Buna-N	1
9 **	Flanged Bushing	PTFE Bronze	1
10 *	O-Ring (Accessory Drive)	Buna-N	1
11	Accessory Drive	Stainless Steel	1
12	Hex Bolt	Steel	8
13	Spring Washer	Spring Steel	8
14	Set Screw, Socket Head	Steel	2
15	Dowel Pin	Hardened Steel	4
16	Socket Head Caps Screw,	Steel	4
17	Socket Head Caps Screw, Low Head	Steel	1
18	Seal Nut	Steel	2
19	Stop Bolt	Steel	2
20	Breather Vents	Carbon Steel	1
21	Yoke	Ductile Iron	1
22 **	Slider Block	Bronze	2
22a **	Roller	Steel	2
23	Yoke Pin	Alloy Steel	1
24	Retainer Plate	Plastic	2
25	Guide Block	Carbon Steel	1
26 **	Bushing (Guide Rod)	PTFE Bronze	2
27 **	Bushing (Yoke Pin)	PTFE Bronze	2
28	Cap Screw, Flat Head, Hex Socket	Steel	8
29	Position Indicator	Plastic	1
30	Cap Screw, Flat Head, Hex Socket	Steel	1
31	Adaptor, Pressure Module	Carbon Steel	2
32	Barrel	Carbon Steel	2
33	Piston	Alloy Steel	2

Item	Description	Material	Qty.
34	End Cap, Pressure Module	Carbon Steel	2
35	Piston Rod	Alloy Steel	2
36 *	Guide Ring, Piston Rod	Phenolic Resin	4
37 *	Lip Seal	Polyurethane	2
38 *	Sealing Set, Piston Rod	PTFE & Buna-N	2
39	Tie Rod	Steel	16
40	Nut, Tie Rod	Steel	16
41 *	O-Ring (Piston Rod)	Buna-N	2
42 *	Guide Ring, Piston	Phenolic Resin	4
43 *	Sealing Set, Piston	PTFE & Buna-N	2
44 *	O-Ring (Barrel)	Buna-N	4
45	Set Screw, Piston Lock	Steel	4
46	End Plug	Steel	2
47 *	O-Ring (Module)	Buna-N	2
48	Stud / Hex Bolt (Module)	Steel	12
49	Spring Washer (Module)	Spring Steel	12
50	Nut (Module)	Steel	12
51	Name Plate	Stainless Steel	1
52	Label, Logo	Metallized Polyester	4
53	Label, Configuration	Metallized Polyester	2
54	Rivets	Stainless Steel	4
55	Spring Washer, Tie Rod	Spring Steel	16
56 *	Wiper	Polyurethane	2
57 *	Backup Ring (Piston Rod)	PTFE	4
58 *	O-Ring (End Plug)	Buna-N	2
59 *	Backup Ring (End Plug)	PTFE	2
60 *	Backup Ring (Barrel)	PTFE	4
61	Pipe Plug	Carbon Steel	8
62	Protective Plug	Plastic	4

*	Parts in Seal Kits
* & **	Parts in Repair Kits

For reference only. Please refer to current revision of ES-00689 drawing for more information.

4.0 SAFETY INFORMATION

Actuator assemblies with the accessories and controls in shipped condition, are safe for the intended use. Before installing the supplied assemblies, ensure the operating environment conditions are within the equipment's service limits.

Instructions contained within this manual shall be adhered to and executed by skilled and competent personnel trained in such equipment operation and maintenance tasks.

For the safety of personnel working on these actuators, the procedures for maintenance and safe disassembly/ reassembly shall be reviewed and adhered to. WARNINGS, CAUTIONS and NOTICES stated in this manual shall be specifically noted and close attention paid to them. Suitable PPE (personal protection Equipment) shall always be worn by the operators and technicians, per the plant regulations.

No modifications and alterations shall be carried out on the supplied equipment as it would violate product certifications and render the warranty invalid.

Maintenance and operation shall be in accordance with the local statutory codes/provisions related to safe use of such equipment. The service instructions here do not supersede or override any site safety or work procedures of the customer. In event of conflicting instructions, differences need be resolved first, between authorized representatives of parties involved.

End user shall devise and implement mitigation measures for residual risks arising from the installation site environment or from normal operation of the equipment. Risks types such as thermal, noise, health, mechanical, magnetic, radiation, etc. that may be present at the equipment installation site shall be addressed with use of proper PPEs and use of plant safety procedures, including lockout/tag out and other safety work instructions for remotely operable equipment.

5.0 HAZARD-FREE USE

This device left the factory in proper condition to be safely installed and operated in a hazard-free manner. The notes and warnings in this document must be observed by the user if this safe condition is to be maintained and hazard-free operation of the device assured.

- > Take all necessary precautions to prevent damage due to rough handling, impact, or improper storage. Do not use abrasive compounds to clean, or scrape its surfaces with any objects.
- > Configuration and calibration procedures are described in this document. Proper configuration and calibration is required for the safe operation of this product.
- > The control system in which the unit is installed must have proper safeguards to prevent injury to personnel, or damage to equipment, should failure of system components occur.
- > This document does not cover every detail about every version of the product described. It cannot take into account every potential occurrence in installation, operation, maintenance and use.
- > If situations transpire that are not documented in sufficient detail, please request the required information from the Bray Distributor or Representative responsible for your area.

6.0 QUALIFIED PERSONNEL

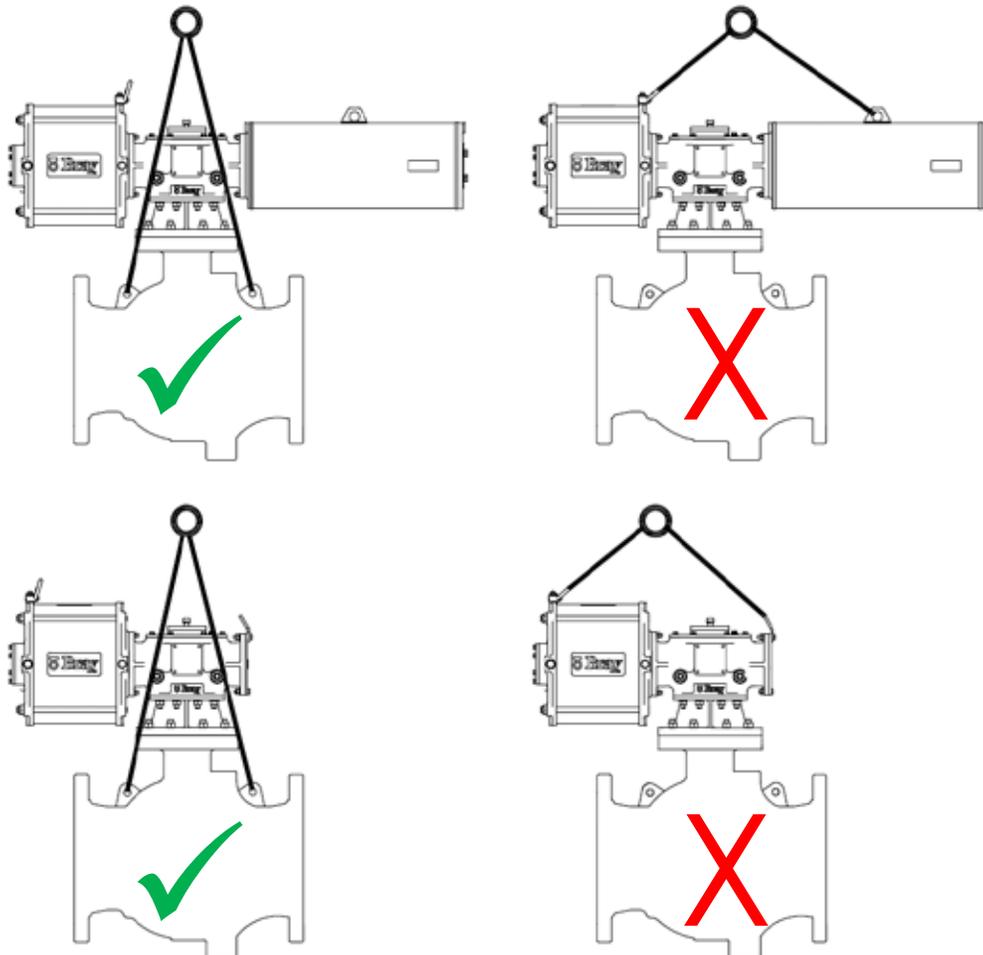
A qualified person in terms of this document is one who is familiar with the installation, commissioning and operation of the product and who has appropriate qualifications, such as:

- > Is trained in the operation and maintenance of pneumatic and hydraulic pressure equipment and systems in accordance with established safety practices.
- > Is trained or authorized to energize, de-energize, ground, tag and lock electrical circuits and equipment in accordance with established safety practices.
- > Is trained in the proper use and care of personal protective equipment (PPE) in accordance with established safety practices.
- > Is trained in first aid.
- > In cases where the device is installed in a potentially explosive (hazardous) location - is trained in the operation, commissioning, and maintenance of equipment in hazardous locations

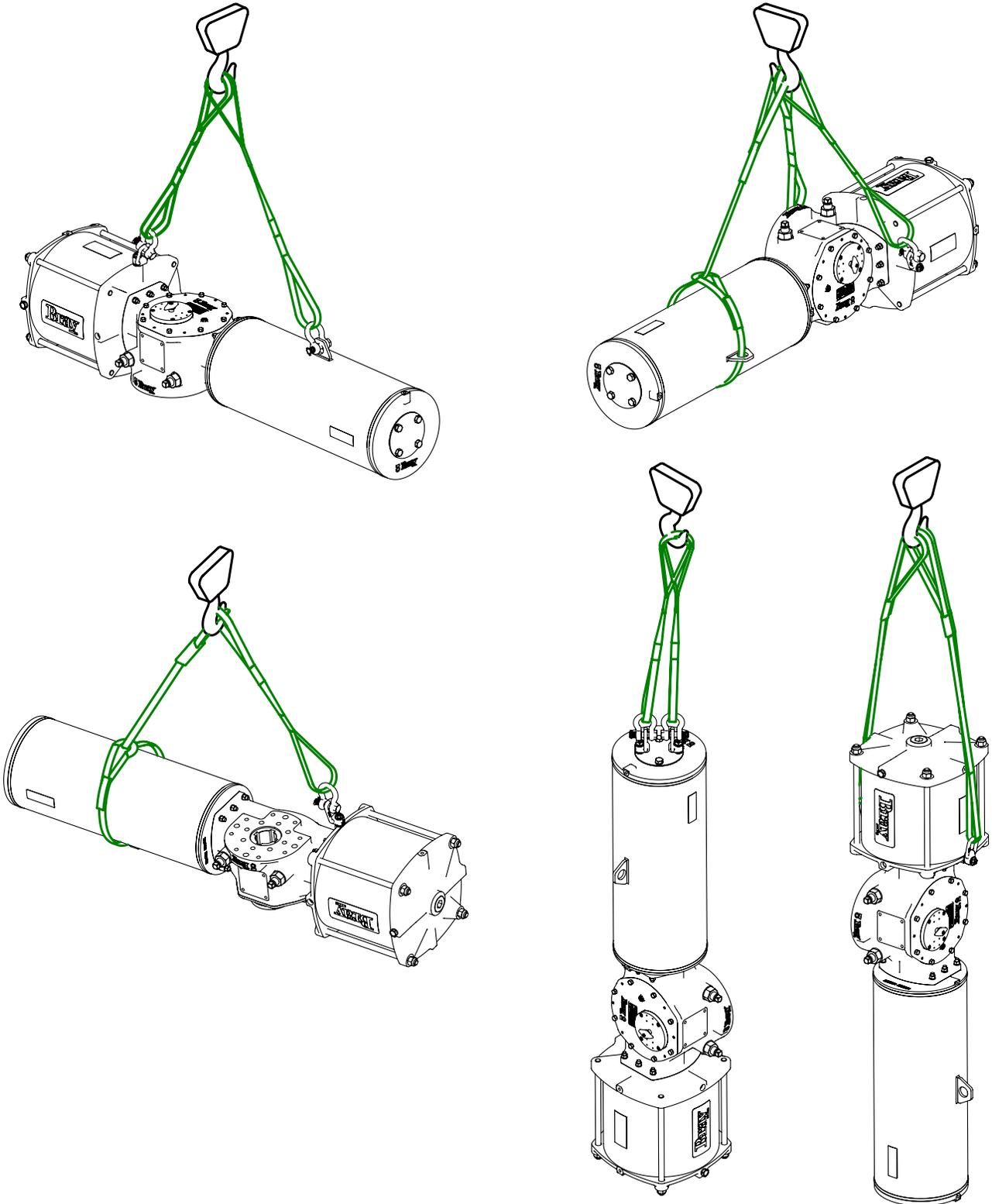
7.0 HANDLING REQUIREMENTS

7.1 Lifting Recommendations/ Instructions

- > Use appropriate tackles and slings to lift the actuator. Refer to Technical Data table for the approximate actuator weight.
- > The lifting lugs provided are for lifting the actuator only and not for lifting the complete valve-actuator-accessory assembly.
- > Do not use damaged slings.
- > For lifting purposes, use only suitable lifting tools.
- > Do not make any ad hoc arrangements such as, welding lifting lugs or drilling holes on the actuator for lifting.
- > Avoid abrupt or sudden movements during lifting.
- > Isolate all the energy sources, prior to lifting the actuator.
- > For different actuator mounting orientations, use the below recommended lifting methods. Contact Bray for any assistance.



7.2 Lifting Illustrations



8.0 STORAGE

Bray Series 98 & 98H are not weatherproof until the unit is properly installed, or all conduits and applicable port connections are sealed off and prepared for storage. The units may be shipped with temporary covers to prevent foreign matter from entering through the conduit openings; however, the user is responsible for replacing with the proper sealing plugs to support its NEMA/IP ratings.

To prevent condensation from forming inside the unit, maintain a near constant external temperature and store indoors in a well ventilated, clean, dry room. The temperature shall be between 40°F (4°C) and 85°F (29°C), with a relative humidity less than 70%. Store units away from vibration and direct sunlight exposure, and place units on a shelf or wooden pallet in order to protect against dampness. Keep units covered to protect against dust and dirt; if storing for long term, placing the unit inside a plastic sealed bag may be preferred.

Bray cannot accept responsibility for deterioration caused on-site once the cover is removed or due to improper storage.

9.0 INSTALLATION

The S98 actuators are assembled, tested and delivered per the configuration ordered. The mounting of the actuator may be direct onto the valve or may require a mounting kit that would include a bracket, coupler shaft with keys and hardware.

WARNING

Use appropriate tackles and slings to lift the actuator. Refer to Technical Data table for the approximate actuator weight. The lifting lugs provided are for lifting the actuator only and not for lifting the complete valve-actuator-accessory assembly.

NOTICE

- > Actuators do not have any built-in pressure limiting devices. Such devices must be incorporated in the pressure supply lines or in the hydraulic power unit as part of the controls system.
- > The user shall ensure installation in intended service conditions and that the actuator is not covered with dirt/dust or other substances that may affect any heat dissipation capability, resulting in exceeding the maximum temperature rating of the actuator.
- > To prolong actuator seal life use only permitted media of recommended quality.
- > The actuator shall not be installed in hazardous areas incompatible with the defined gas groups and temperature class.
- > When using manual override sandwich gearbox, ensure the gearbox has over travel at least equal to that of the actuator.
- > The actuators can be mounted on valves in different positions, but care shall be taken to reorient suitably, some accessories like filter regulation units, hydraulic override power pack reservoirs, etc. that are gravity dependent for functioning.
- > For extended temperature range service, please refer to the Special Requirements under Appendix to prepare the actuator, before proceeding with the below steps on installation.

Before proceeding with installation, check compatibility of the valve stem to the actuator bore. The length, size and configurations (keyways / double D / square) must match. Additionally, check compatibility of valve and actuator bolting pattern. If using a mounting kit, physically check the coupler to ensure it fits the actuator bore and the valve stem.

- > Ensure the pressure module is depressurized completely by venting the ports of S98 pneumatic actuator to atmosphere and any power sources to accessories are disconnected. The S98H hydraulic actuator's cylinder ports shall be vented into the oil reservoir, through the direction control valve, in its de-energized state.
- > Ensure the valve and actuator are aligned to the same position (i.e., valve closed - actuator closed or both in open). For spring return actuators, align the valve to the fail safe position of the actuator. If a sandwich gearbox manual override is used, then make sure it is also aligned with the valve and actuator position.
- > Secure the valve, bolt the mounting bracket to the valve and fit the coupler shaft on the valve stem (when using mounting kit). Ensure the actuator's bore and seating face are clean and coat the valve stem/adaptor with a suitable oil/grease. Position the actuator to align the valve stem (or coupler shaft) with the yoke bore and slide the actuator on until the actuator seats on the bracket mounting surface (or on the valve top flange, in case of direct mounting).
- > When using a manual override sandwich gearbox between the actuator and valve, first couple and fix the gearbox on the valve following the gearbox installation procedure. Back off the gearbox travel stop bolts. Mount the actuator on the gearbox with the coupler shaft and bolt up the actuator on the gearbox flange.
- > In order to align the bolt holes, it may be necessary to loosen the valve-bracket bolting slightly. The actuator mounting bolts should easily thread into the actuator base without side loading on the bracket (or the valve top flange). If needed, turn the actuator a bit and/or adjust the actuator travel stops. Bolt up the actuator to the bracket / gearbox flange / valve as the case may be. Refer to the Bolting Torque table for recommended torque values.
- > Before operating the actuator, disengage the manual override, if present. The travel stops of the actuator shall limit the stroke and not those on the gearbox/valve, if present.
- > Adjust the travel stop bolts of the actuator for the proper open and closed valve positions, per valve manufacturer's recommendations. Refer to the Series 98 specifications for the travel adjustment range for different models.
- > Tighten the travel stop bolts lock nuts after adjusting the stop bolts. Ensure the travel stops on gearbox or valve, if provided, are now adjusted and locked to fractionally lag the actuator's stop position.

NOTE: When used for actuating torque seated valves or swing disc type of valves, ensure that the stop bolt is sufficiently backed off to permit the valve disc to seat.

- > Ensure the manual overrides are set for the normal pneumatic operation before putting the actuator to test in power operation mode. Refer to Sec. 19 through 21.
- > Stroke the actuator a few times at not more than MOP to check for proper and smooth operation. If the actuator is equipped with a switchbox or other accessories, adjust them at this time.

NOTICE

It is recommended to ground the actuator assembly against any buildup of static electricity.

10.0 OPERATION GUIDELINES

Series 98 actuators operate well in both on-off and modulating applications. The accessories, control elements, tubing and fittings shall be chosen for adequate flow rates so as not to constrict flow or cause high pressure drop affecting the performance of the actuator.

Maximum Operating Pressure (MOP) of the actuator is mentioned on the nameplate and shall not be exceeded. Suitable pressure regulator and safety valve shall be incorporated in the supply line, if the line pressure is higher than this.



Do not pressurize from the cap end port of the spring return actuator. On the pneumatic actuator, this port is normally fitted with a breather filter. If there is a possibility of the actuator being submerged temporarily in water due to flooding, then this port must be provided with an extension pipe with the breather filter on the pipe end, at a safe height above the water level. On the hydraulic SR actuators, tube this port directly to the oil reservoir to vent it above oil level. To avoid any back pressure, do not connect it to other return lines.

Spring Return actuators work on pressure stroke or spring stroke by pressurizing or venting respectively, the adaptor side port (rod end side). A 3/2 way valve is typically used.

DA models require alternate ports to be pressurized and vented for stroking. A 5/2 or 5/3 way direction control valve or two 3/2 way valves may be used.

DD models have adaptor ports of the cylinders tubed in parallel with the end cap ports of the other side cylinder. The two cylinders work simultaneously with cap end of one and rod end of the other pressurized, at a time.

Actuator & Mounting Kit Bolting Torques		
Bolt Size	Torque	
	Nm	Lb-in
M8	30	265
M12	110	975
M16	260	2300
M20	510	4515
M30	1550	13720
M36	2500	22125

11.0 MAINTENANCE

Series 98 actuators are designed for long service periods between maintenance, in demanding conditions. However, a preventative maintenance program is essential for ensuring good performance, safe operation, extended life of equipment and to avoid expensive down time.

The service conditions, load and cycling frequency may vary largely, which would require the maintenance program to be suitably designed, with sound judgment of the working conditions. Contact manufacturer for assistance.

In general, the scheduled service shall include replacement of all seals and wear parts.

Seals are recommended to be replaced if the actuator is in storage or inactive for long periods of time to avoid leakage due to the seal set. Actuators inactive or in storage for >6 months may be checked for leaks first.

11.1 Lubricants and Maintenance Consumables

The standard actuators use the following lubricants, refer to Section 25.0 Appendix B - Lubricants or contact factory for information on high/low temperature actuator lubricants.

- > Shell Alvania EP2 (LF) grease for the Torque & Spring Modules
- > Molykote 55 for the Pneumatic Pressure Module.
- > ISO Grade 32 hydraulic fluid for hydraulic override
- > Thread lock compound: Loctite 243 (or equivalent)
- > Thread Sealant: Loctite 577(or equivalent)
- > Hydraulic fittings thread sealant: Loctite 542 (or equivalent)
- > Commercial leak check fluid: Snoop (or equivalent)
- > Anti seize compound: Loctite 77164 (or equivalent)
- > Section 25.0 Appendix B - Lubricants

11.2 Disassembly, Service & Reassembly of Modules



Prior to disassembly of the actuator, disconnect all air/hydraulic and electrical power from actuator, remove the relevant accessories from actuator and dismount actuator from valve (or override gearbox, if present).

NOTICE

Replacement of the press fitted bushings may require workshop infrastructure to remove the worn bearings from their housing and to press fit new ones, without damaging the housings. We recommend sending the actuator (or module) to our factory for overhauls/major repairs.

References:

- > Drawing # ES-00019 - Spring Return Actuator Assembly
 - > Drawing # ES-00020 - DA Assembly
 - > Drawing # ES-00021 - DD Assembly
 - > Drawing # ES-00690 - Spring Return Hydraulic Actuator Assembly
 - > Drawing # ES-00689 - DD Hydraulic Actuator Assembly
 - > Drawing # ES-00688 - DA Hydraulic Actuator Assembly
- (Refer to the Bray website for current revisions of the drawings)

11.3 Spring Module



WARNING

Follow the sequence of steps as described below. Injury or damages may occur if critical steps are bypassed or shortcuts taken.

Never attempt to cut open the Spring Module welded assembly as the spring inside is energized and can cause fatal/severe injury or extensive damages.

Note: If the actuator is provided with a jackscrew or hydraulic override cylinder on the Spring Module, first ensure to back off the override fully, to unload it from any spring force. Remove the override assembly before disassembling Spring Module.

11.3.1 Removing the Spring Module

(Refer to the relevant Spring Return Actuator Assembly drawing)

1. Slacken the Spring Module side Travel Stop Bolt Lock Nuts (18) on the torque module (and extended stopper, if provided). Apply pressure to pressure module adaptor port (rod end port), raising pressure slowly, enough to release spring force on the Travel Stop Bolt (19).
2. Mark the set position of the Stop Bolts and back off fully both the Stop Bolts (and Extended Stopper/Jackscrew, if present) and release pressure. This will relieve the spring preload.



CAUTION

Never try to loosen the Spring Rod without completely relieving the spring load on it.

3. Remove the Extended Stopper/ override assembly, if present, from the Spring Module by unfastening the bolts holding the assembly on the End Cap (49).



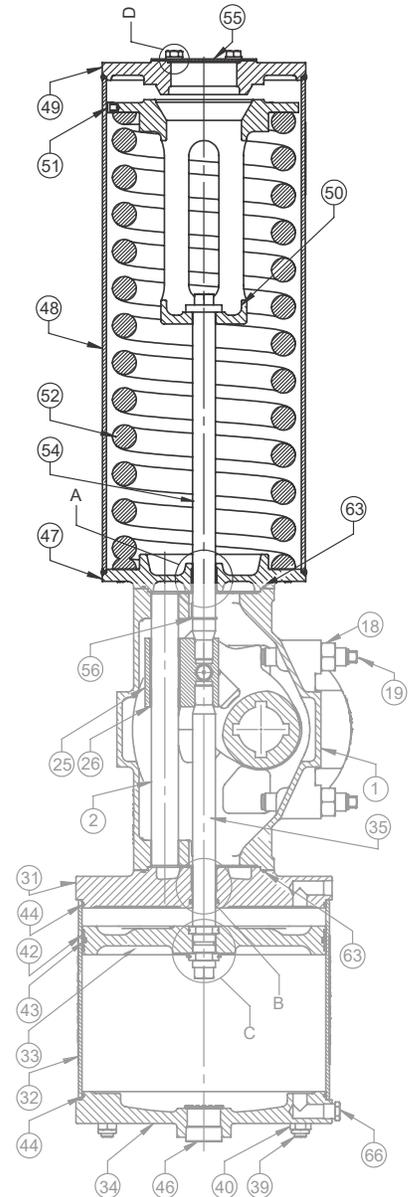
WARNING

The Spring Module is welded into an integral component and cannot be disassembled.

Spring within is under compression. Never attempt to modify or cut open this module.

Do not dispose of the spring module in metal scrap unless it is appropriately disarmed.

Spring Module



4. To take the Spring Module off the actuator, unscrew the End Cover Bolts (58), remove the End Cover (55) and the O-ring (59). Using an extended socket spanner /tube spanner, unscrew and disconnect the Spring Rod (54) from the Guide Block (25) in Torque Module. A retainer ring on the threaded side of the Spring Rod stops it from being taken out of the Spring Module.
5. Sling and support the Spring Module and remove the Module's mounting flange Stud Nuts (61) and Lock washers (62). Spring Module can now be pulled off the Torque Module. Pull off the module carefully so as not to damage the threads on the Spring Rod and studs on the Adaptor.

11.3.2 Service & Reassembly of the Spring Module

Ensure that a correct Repair Kit is on hand, prior to assembly.

1. Take the Retainer Ring (56) off and pull the Spring Rod out from the cover end.
2. Replace the Bushing (Adaptor) (36), clean and lubricate the Spring Rod and slide it back in.
3. Install the Retainer Ring back in the Spring Rod groove.
4. Fit the Module back on Torque Module with new O-ring (63).
5. Thread in the Spring Rod back into the Torque Module's Guide Block (25) and torque it to value as in Table 10.3.
6. Fit End Cover back with new O-ring (59).

11.4 Pressure Module

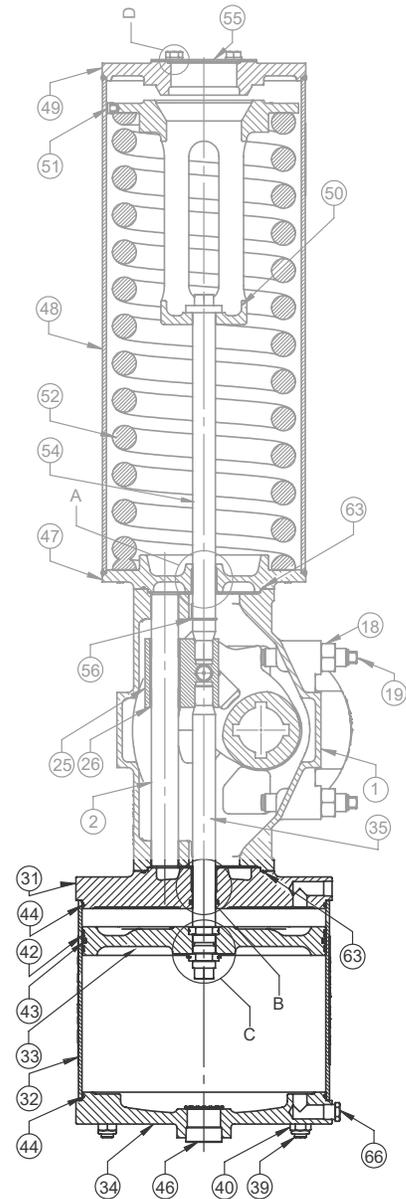


Ensure the ports are depressurized before disassembly of Pressure Module. Failure to do so could cause severe injury. To take the Pressure Module off the Spring Return Actuator, first the Spring Module must be removed or at least the Spring Rod must be disconnected from the Guide Block (steps 1-4), as described in section 11.3.1.

11.4.1 Removing the Pressure Module from Actuator

1. For Spring return actuators the spring rod shall be first disconnected following the steps 1-4 of 11.3.1. For double acting actuators skip this step.
2. Apply low pressure 5-7 psi on pneumatic or 30-50 psi on hydraulic actuators to the adaptor port (rod end side port) to move the piston to end cap side.
3. Depressurize and remove the Plug (46) (or cover plate) on the End Cap (34). On the S98H, drain out oil from the ports first, to avoid oil spill.
4. Use an extended socket or tube spanner and unscrew the Piston Rod (35) from the Guide Block (25) in Torque Module. Use a square drive or extended hex wrench (Allen Key) on the hydraulic pressure modules.

Pneumatic Pressure Module



5. Sling and support the Pressure Module. Remove the Adaptor Stud Nuts (61) and Lock washers (62). Pressure Module can now be pulled off the Torque Module. Pull off the module carefully so as not to damage the threads on the Piston Rod and studs on the Adaptor.
6. Ensure the Module sealing O-ring (63) is retained in the groove.

11.4.2 Disassembling the Pneumatic Pressure Module

1. Secure the Module and unscrew the Tie Rod Nuts (40).
2. Gently tap the End Cap (34) off the cylinder Barrel (32) with a plastic mallet and remove the End Cap
3. Slide the Barrel over and off the Adaptor (31) and Piston (33), being careful not to scratch or dent the honed and chrome plated surface of the barrel.
4. Take the Piston Assembly off the Adaptor, taking care not to damage the threads.
5. Tie Rods (39) may be unscrewed from the Adaptor Plate.
6. Remove the Retainer Ring (45) and take the Split Collars (38) off the Piston Rod (35) upper groove. Pull the Piston Rod off the Piston and remove the Split Collars from the lower groove.

11.4.3 Service & Reassembly of the Pneumatic Pressure Module

NOTICE

The wear parts (all seals, piston wear bands and rod guide bushings in the Repair Kit) shall be replaced during the maintenance cycle. Ensure the replacement seals are suitable for the service temperature. Remove old seals and clean all the parts thoroughly.

The assembly of the Pressure Module is done in vertical orientation.

Use Dow Corning Molykote 55 lubricant in the Pneumatic Pressure Module.

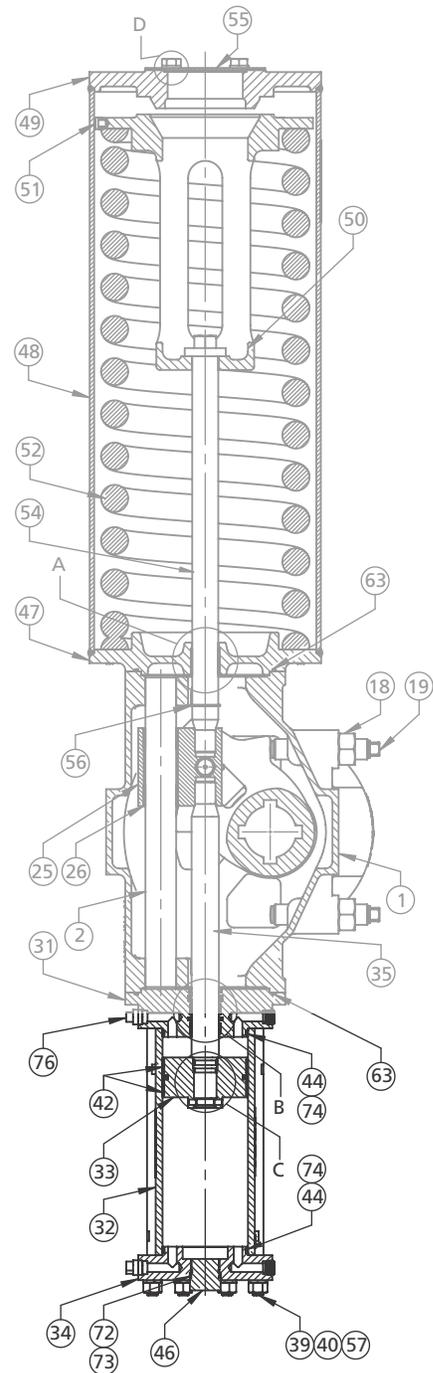
1. To reassemble, secure the Adaptor Plate horizontally, after replacing the Bushing (36), with sufficient space below, to accommodate the Piston Rod. The rod seal groove side of the Adaptor faces upwards.
2. Lubricate the piston rod U-cup Seal (37) and insert it in the groove in Adaptor Plate with the seal lip towards piston side.
3. Lubricate and install the Adaptor O-ring (44).
4. Lubricate the piston rod O-ring (41) and install in the groove on the piston rod.
5. Grease and slip in the Split Collars on the Piston Rod lower groove and slide in the Piston Rod (hex side) through the Piston till the split collars locate in the counter bore in the piston.
6. Install the Split Collars on the upper groove similarly and secure it by the Spiral Retainer Ring.

7. Lubricate the Piston Rod and carefully slide in the Piston Assembly through the Rod Seal and Bushing in the Adaptor. Beware of the pinch points between the Piston and the Adaptor while lowering the Piston Assembly on the Adaptor inner face.
8. Lubricate and install the Wear Bands (42) and the Piston Quad Seal (43) on the Piston.
9. Carefully lift and slide in the Barrel over the Piston Wear Bands, Quad Seal and Adaptor O-ring and push it down on to the Adaptor.
10. Thread the Tie Rods into the Adaptor, use thread lock compound on the threads.
11. Lubricate the inside of the Barrel and slide in the End Cap, aligning the ports on the Adaptor and the End Cap.
12. Fasten the assembly with Tie Rod Nuts tightened to the recommended torque. (Refer to Section 13 Bolting Torque Tables)
13. Lift the Module using lifting eye bolts threaded into the End Cap and place it horizontally. Put back the Plug/End Cover on the End Cap to test the module.
14. Apply 10-15 psi air pressure to ports alternately to check for smooth stroking for 5-10 cycles and then raise to 80 psi and hold the pressure to check for any leaks past the Piston, through the Rod Seal and the Barrel O-rings.
15. Leak test the piston seal by bubble test at 80 psi pressure and for other seals check visually using commercial leak check fluids (Snoop or equivalent).
16. Leakage rate after hold down time shall not be much higher than 1-2 bubbles per minute with a 1/4" ID tube.
17. Stroke the piston a few times to set the seals if leakage is higher, and repeat the bubble test. If still not within the limits, dismantle the module to examine the cause.
18. If no abnormalities are seen, the Module is ready for assembly on the Torque Module. 11.4.5 Service & Reassembly of the Hydraulic Pressure Module

11.4.4 Disassembling the Hydraulic Pressure Module

1. Secure the Module and unscrew the Tie Rod Nuts (40).
2. Gently tap the End Cap (34) off the cylinder Barrel (32) with a mallet and remove the End Cap.
3. Slide the Barrel over and off the Adaptor (31) and Piston (33), being careful not to scratch or dent the honed and chrome plated surface of the barrel.
4. Take the Piston Assembly off the Adaptor, taking care not to damage the threads.
5. Tie Rods (39) may be unscrewed from the Adaptor Plate.
6. Remove the Lock Screw (45) and unscrew the Piston (33) off the Piston Rod (35).

Hydraulic Pressure Module



7. Pull out all seals, backup rings and wear rings from the grooves on piston, piston rod, adaptor, end cap and the end cap plug.

11.4.5 Service & Reassembly of the Hydraulic Pressure Module

NOTICE

The wear parts (all seals, wiper, piston & rod wear rings and backup rings in the Seal Kit) shall be replaced during the maintenance cycle. Ensure the replacement seals are suitable for the service temperature. Remove old seals and clean all the parts thoroughly.

The assembly of the Pressure Module is done preferably in vertical orientation.

Use ISO grade 32 or 46 as lubricant in the Pressure Module.

1. To reassemble, secure the Adaptor (1) after thorough cleaning, with sufficient space below to accommodate the Piston Rod. The wiper seal groove side of the Adaptor faces upwards.
2. Lubricate Wear Rings (21), U-cup Rod Seal (17) and the wiper seal (12) lightly with oil and install them in the respective grooves with the wear rings inserted first.
3. Flip the Adaptor (1) and install the PTFE Energized Rod Seal (16) by first lubricating and installing the energizer O-ring (15) in the seal groove followed by installing the PTFE seal ring over the O-ring using an appropriate installation tool. Ensure the PTFE seal is inserted in the correct direction with the sealing step facing the hydraulic pressure.
4. Lubricate and install the second Wear Ring (21) in the bearing groove.
5. Install the scarf cut (split type) PTFE Backup Ring (18) in the groove on the Header for the cylinder barrel sealing.
6. Lubricate and install the static O-Ring (10) in the groove with this O-ring on the outside.
7. Similarly, install the scarf cut (split type) PTFE Backup Ring (24) in the seal groove on the Piston Rod (3).
8. Lubricate and install the O-ring (23) in the groove. Use a thin walled protective sleeve over threads, to protect O-ring while assembling.
9. Install the second Backup Ring (24) in the groove, such that the O-ring (23) is between the two Backup Rings.
10. Thread in the Piston (2) onto the Piston Rod (3) threads and tighten till the leading piston face loads on the step or on the circlip.
11. Apply a drop of thread lock compound and thread in the Set Screw (25) into the tapped hole in Piston's flat end and tighten it firmly.

12. Lubricate with oil the energizer O-ring (13) and install in the piston seal groove. Ensure the O-ring is not twisted.
13. Install the PTFE Seal (14), using appropriate installation tools.
14. Install the two Wear Rings (20) on the Piston grooves.
15. Carefully guide the Piston Rod's threaded end through the Header (1) assembly, ensuring the rod thread do not damage the seals in the Header.
16. Slide the Piston Rod all the way through, to rest the Piston face on the Header end.
17. Coat the wear rings and piston seal thinly with oil and carefully guide the Barrel (4) over the Piston, pushing it down until it slides over the Header static seal (10 & 18) and touches the header body.
18. Thread in the Tie Rods (6) all the way into the tapped holes on the Header body.
19. Install the PTFE Backup Ring (18) in the End Cap (5) groove, followed by the O-ring (10) such that the O-ring is on the outside.
20. Lightly coat the O-ring (10) in the End Cap (5) with oil and install the end cap through the tie rods onto the Barrel (4), ensuring the alignment of the ports on end cap with those on the header.
21. Install the Lock Washers (9) and thread in the Tie Rod Nuts (8) on the ends of the tie rods and torque them in cross pattern, refer to Table A1 for tightening torque values.
22. Install the PTFE Backup Ring (19) on the Plug (7) groove, followed by O-ring (11) such that the O-ring is on the threaded side.
23. Thread in the Plug (7) into the End Cap (5) and tighten it firmly and the module can be then pressure tested.
24. Apply about 1000 psi hydraulic pressure to stroke the piston forward and back a few times. Then raise the pressure to MOP of the actuator (if higher than 1000psi) to check for any external leaks. With pressure held on one port of the cylinder, wait for about 5 minutes to check for any leak through the other port.
25. If no abnormalities are seen, the Module is ready for assembly on the Torque Module.

11.5 Torque Module

11.5.1 Disassembling the Torque Module

NOTICE

For SR actuators, the Spring Module or the Pressure Module must be removed from the Torque Module to allow for removal of the Guide Bar and Yoke Assembly from the Torque Module. For DA actuators, remove the end cover on the Torque Module.

1. Disconnect the Piston Rod (35) and the Spring Rod (54) from the Guide Block prior to disassembly.
2. Remove the position Indicator (29), if provided.
3. Remove Top Cover Bolts (16) and the Top Cover (7).
4. Take off the Accessory Drive Shaft Assembly (11) from top of the Yoke.
5. Remove the Housing Cover Bolts (12) and Lock Washers (13).
6. Tighten the two Set Screws (14) on the Housing Cover (3), half turn at a time alternately till the Housing Cover is separated enough to pry off the Housing with a blunt tool.
7. Gently tap with plastic hammer or pull off the Guide Bar (2) from the Guide Block (25) and the Housing (1).
8. Rotate and center the Yoke Assembly, move the Guide Block towards the Yoke center and lift the Yoke Assembly out of Housing.

NOTICE

For smaller models (up to 14E3) this can be done by hand. Larger models may require use of a hoist to support the weight of the Yoke sub-assembly. For this, remove the Screw (17) off the Yoke and fit an eye bolt in place.

9. Secure the Yoke Assembly and remove the Retainer Plate Screws (28) and the Retainer Plate (24).

Note: For some applications, the Slider Blocks in the Yoke sub-assembly are replaced by Steel rollers

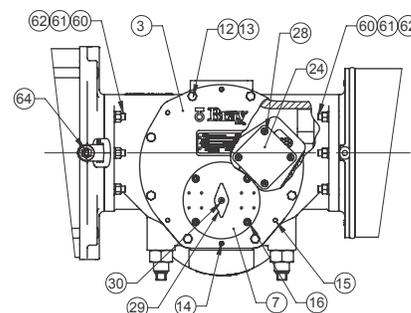
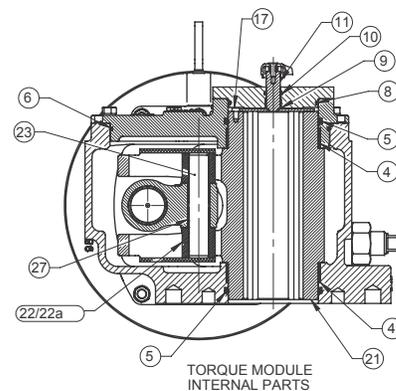
10. Pull out the Yoke Pin (23), and the upper Slider Block (22) / Roller (22a), as the case may be.
11. Slide the Guide Block out of the Yoke (21) and remove the bottom Slider Block/Roller.
12. Remove the Yoke sealing O-rings (5) from the Housing and Housing Cover, if replacement is required.
13. The Yoke Bushing (4) in the Housing and the Housing Cover, the Guide Bar Bushing (26) and Yoke Pin Bushing (27) in the Guide Block are press fitted and may need suitable workshop tools for removal without damaging the housing.

11.5.2 Service & Reassembly of the Torque Module

Note: Thoroughly clean/degrease all components prior to assembly.

1. Replace the bushings in the Housing, the Housing Cover and the Guide Block with suitable pressing tools. Contact factory for more information.
2. Secure the Yoke and fit the bottom Retainer Plate (24) with Screws (28), applying a drop of thread lock compound on the screw threads.

Torque Module



3. Flip the Yoke over, grease the bottom slot and the Slider Block (22) /Roller (22a) generously and slide the Slider Block/Roller into the slot
4. Grease the Guide Block bushings and slide the Guide Block between the arms of the Yoke aligning the Yoke Pin bushings with the lower Slider Block/Roller pin hole.
5. Grease the Yoke Pin (23) and slide it through the upper slot in the Yoke and the Guide Block pin bearings, locating it in the lower Slider Block/Roller hole. Push the Yoke Pin down to touch the bottom Retainer Plate.
6. Grease the upper slot and the Slider Block/Roller and slide it down on the Yoke Pin through the upper slot till it rests on the Guide Block.
7. Fit the upper Retainer Plate to complete the Yoke Assembly.
8. Lubricate and Install the Yoke O-ring (5) in the Housing and grease the bushing and the Yoke seating raised face.
9. Carefully slide in the Yoke Assembly into the Housing bushing and push it down to seat it on the raised seating face in the Housing.
10. Grease and slide in the Guide Bar (2) through the Housing and Guide Block.
11. If removed previously, screw back the accessory drive shaft assembly Screw (17) on top of the Yoke, applying a drop of thread lock compound. Grease the upper journal of the Yoke.
12. Lubricate and install the Yoke O-ring and Cover O-ring (6) in the Housing Cover. Ensure the two set screws on the Housing Cover are fully backed off. Locate the Housing Cover on the Yoke's upper journal and fit it on the Housing with the Cover Bolts (12).
13. Locate the Accessory Drive Shaft Assembly on the top of the Yoke, locating the plate slot into the screw head.
14. Replace the flanged bushing and the O-rings in the Top cover and fit it back on the Housing Cover with the Top Cover Bolts. Fit the indicator on the drive shaft.
15. Apply anti-seize compound on the stopper bolt threads and thread them with the Lock Nuts into the Torque Module Housing.

11.6 Reassembly of Actuator

1. Secure the Torque Module on its base.
2. Mark the position and then back off the Travel Stop Bolts (19) fully and manually turn the Yoke to the side on which the Pressure Module is to be fixed.
3. Lift the Pressure Module, lubricate and place the module flange O-ring in the groove. Degrease the Piston Rod threads, apply a drop of thread lock compound on the threads and locate the module on the Torque Module's mounting flange.
4. Carefully guide the Studs into the flange and center the module on the spigot (centering ring).

5. Fasten the modules with Spring Washers and Stud Nuts, refer to the tables for torque values.
6. Take the Plug/End Cover off the End Cap of the Pressure Module and couple the Piston Rod threads to the Guide block, using an extended socket or tube spanner for pneumatic pressure module. Refer to the tables in Section 10 for torque values. For hydraulic pressure module, use a hex wrench or a square drive.
7. Install the Plug (or End Cover) with thread sealant and apply low pressure on the End Cap port till the Yoke reaches end of stroke. Restrain the Guide Bar from sliding out of the Housing while stroking.
8. For DA models (refer to Drawing #ES-00020-DA Assembly), fit the DA End Cover (52) with O-ring (47) in the groove, using Bolts (51), Nuts (50) and Spring Washers (49). Skip to step 12.
9. For DD models, pressurize the cap end port of the mounted cylinder to turn the yoke fully to the other end to mount the second Pressure Module on the other side of Torque Module, following relevant actions from steps 3 through 7. Skip to step 12.
10. For Spring Return Models, mount the Spring Module on the other side of the Torque Module in same manner as the Pressure Module and couple the Spring Rod to Guide Block just as was done with the Piston Rod. Always ensure to tighten the Piston and the Spring Rod to the recommended torque.
11. Fix the End Cover with O-ring on the Spring Module (or the Extended Travel Stop/Jackscrew Assembly/Hydraulic override cylinder, if provided).
12. Set the Travel Stops to previously marked positions. For spring return actuator, connect air pressure line to the adaptor port (rod end side port) and slowly raise pressure enough to start the yoke rotation, to be able to adjust the spring module side travel stop bolt.
13. Test the actuator for smooth operation at the Maximum Operating Pressure, as noted on the nameplate.

12.0 FIELD CONVERSIONS

12.1 Fail Safe Condition (for Spring Return Actuators)

Prior to configuration change, refer to the torque charts and ensure the actuator’s torques would be suitable for the new application.

The fail safe direction on Series 98 spring return actuator can be reversed from fail CW to fail CCW and vice versa. This requires interchanging the position of Pressure and Spring Modules.

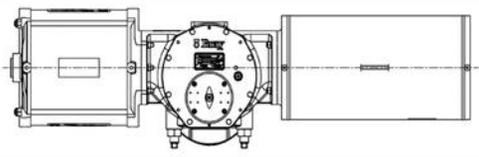
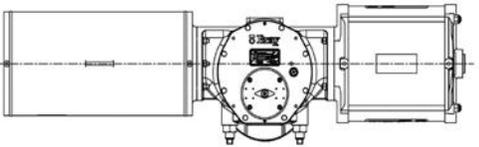
NOTICE

Fail Safe direction change is limited to Symmetric Yoke actuators. Canted Yoke is meant specifically for FCW application. It is strongly recommended to take the actuator off the valve to do the fail safe reversal.

CAUTION

Never try to unscrew and remove the Spring Rod without completely relieving the spring load on it.

1. Follow the steps for removing the Spring and Pressure Modules from the actuator, as described in Sections 6.3 and 6.4 respectively.
2. Switch the positions of the two modules, mount the Pressure Module first. Take care to seat the module sealing O-ring properly in the groove. Pneumatic Pressure Module will need to be flipped about its’ axis before mounting if the supply ports are required to be on the front side of the actuator. On the hydraulic pressure modules, shift the pipe plugs on ports, as required.
3. Follow instructions in Section 11.6 Reassembly of the Actuator.
4. Follow Sec. 3.0 to mount the Actuator back on the valve/ gearbox and adjust the travel stop bolts, as required for proper valve operation. Tighten the Lock Nuts on the travel Stop Bolts.
5. Check actuator for proper operation, at the rated working pressure.

Actuator Configuration	Fail Direction	
	CW	
	CCW	

NOTICE

Actuator part number and fail direction needs to be suitably changed on the name plate, after completing any configuration change. Refer to Technical Manual or contact factory for information.

12.2 Double Acting to Spring Return

1. To convert the DA actuator to Spring Return (FCW or FCCW), a Spring Module will need to be mounted opposite the Pressure Module with a Module Mounting Kit.
2. If the Pressure Module needs to be shifted, for the required configuration of the Spring Return actuator, then first remove the Pressure Module from the actuator. Follow the procedure in Section 11.4 to remove the Pressure Module and Section 11.6 for Reassembly of Actuator. Skip this step if shifting the Pressure Module is not required.
3. Remove the DA End Cover (52), (refer to Drawing #ES-00020 - DA Assembly).
4. Tighten the Studs from Module Mounting Kit into the Spring Module Adaptor, applying thread lock compound on the threads. Install the module O-ring in adaptor groove.
5. Follow steps in Section 11.6 for Reassembly of the Actuator.
6. Set the travel Stop Bolts on the Torque Module as required for proper valve seating.
7. Remove the air connection from the End Cap port of the Pneumatic Pressure Module and replace the connector with a breather-filter. On the hydraulic pressure modules, connect the cap end port to the hydraulic fluid reservoir.
8. The Spring Return Actuator requires pressure connection only on the Adaptor port (rod end port).

12.3 Spring Return to Double Acting

1. Remove Spring Module from actuator (refer to Section 11.3).
2. Fit DA End Cover with O-ring and fasteners from the DA Cover Kit.
3. Adjust travel Stop Bolts, as required.
4. Remove the breather-filter from the End Cap of the pneumatic Pressure Module and connect suitable connector for connecting the air line from the direction control valve.

13.0 BOLTING TORQUES AND TOOLS

13.1.a S98 Pneumatic Pressure Module																
	5	6	7	8	9	10	12	14	16	18	20	22	24	28	32	36
Tie Rod Thread	M8	M8	M10	M10	M12	M12	M16	M16	M20	M20	M24	M24	M30	M24	M30	M30
Spanner Size, mm	13	13	16	16	18	18	24	24	30	30	36	36	46	36	46	46
Torque, Nm	15	15	25	25	35	45	100	110	180	230	335	410	610	330	540	685
End Plug, NPT	1.25	1.25	1.25	1.25	1.5	1.5	2	2	2							
Allen Key, inch	.75	.75	.75	.75	1	1	1	1	1							
End Cover Bolts										M10						
Spanner Size, mm										16	16	16	16	16	16	16
Torque, Nm										35	35	35	35	35	35	35
Consumables																
Thread Sealant	Loctite 577 / Equivalent															
Thread Lock	Loctite 243 / Equivalent															
Lubricant	Dow Corning Molykote 55 (for Standard Actuators). Refer to Section 25 Appendix B - Lubricants															

13.1.b S98 Pneumatic Pressure Module								
Model	12 E2	18 E2	45 E2	73 E2	14 E3	24 E3	45 E3	10 E4
Piston Rod Diameter, inch	0.875	1	1	1.25	1.5	1.75	2.25	2.75
Rod Thread	M20x2	M24x2	M24x2	M27x2	M30x2	M36x3	M48x3	M60x4
Piston Rod Hex A/F, mm	18	21	21	26	32	36	46	55
Torque, Nm	150	200	200	200	250	250	350	450
Piston Rod Minimum No of Turns	10	12	10	14	15	12	16	15

13.1.c S98H Hydraulic Pressure Module							
Model	12 E2	45 E2	73 E2	14 E3	24 E3	45 E3	10 E4
Rod Thread	M20x2	M24x2	M27x2	M30x2	M36x3	M48x3	M60x4
Hydraulic Piston Socket	10 mm Hex Socket	10 mm Hex Socket	10 mm Hex Socket	1/2" Square Socket	1/2" Square Socket	3/4" Square Socket	1" Square Socket
Torque, Nm	165	220	220	275	275	385	500
Piston Rod Min. No of Turns	10	10	14	15	12	16	15

13.2 Torque Module								
Model	12 E2	18 E2	45 E2	73 E2	14 E3	24 E3	45 E3	10 E4
Housing Cover Bolts/ Studs	M8	M8	M8	M8	M10	M12	M12	M16
Spanner Size , mm	13	13	13	13	16	18	18	24
Torque, Nm	30	30	30	30	55	95	95	165
Retainer plate Screws	M5	M5	M5	M6	M6	M6	M6	M8
Allen Key,mm	3	3	3	4	4	4	4	5
Acc Drive Screw			M6	M6	M6	M8	M8	M10
Allen Key,mm			4	4	4	5	5	7
Top Cover Bolts	M6	M6	M6	M8	M8	M8	M8	M10
Allen Key,mm	5	5	5	6	6			
Spanner Size , Metric						13	13	16
Consumables								
Thread Sealant	Loctite 577 / Equivalent							
Thread Lock	Loctite 243 / Equivalent							
Anti seize	Loctite Ni Anti Seize							
Lubricant	Shell Alvania Lead free EP2 Grease (for Standard Actuator). Refer to Section 25 Appendix B - Lubricants							

13.3 Spring Module								
Model	12 E2	18 E2	45 E2	73 E2	14 E3	24 E3	45 E3	10 E4
Spring Rod Diameter, inch	0.875	1	1	1.25	1.5	1.75	2.25	2.75
Rod Thread	M20x2	M24x2	M24x2	M27x2	M30x2	M36x3	M48x3	M60x4
Spring Rod Hex A/F, mm	18	21	21	26	32	36	46	55
Torque, Nm	150	200	200	200	250	250	350	450
Spring Rod Minimum No. of Turns	10	12	10	14	15	12	16	15
End Cover Bolt	M10	M10	M12	M12	M16	M16	M16	M20
Spanner Size, mm	16	16	18	18	24	24	24	30

13.4 Actuator Assembly								
Model	12 E2	18 E2	45 E2	73 E2	14 E3	24 E3	45 E3	10 E4
ISO Base	F12/ F07	F12	F16/ F12	F16/ F12	F25/ F16	F30/ F25	F35/F30	F40/F35
Base Bolting Size	M12/M8	M12	M20/M12	M20/M12	M16/M20	M20/M16	M30/M20	M36/M30
Module Mounting Stud- Nut Size	M8	M10	M10	M12	M12	M16	M16	M24
Spanner Size , Metric	13	16	16	18	18	24	24	36
Torque, Nm	30	55	55	95	95	165	165	545
Consumables								
Thread Sealant	Loctite 577 / Equivalent							
Thread Lock	Loctite 243 / Equivalent							
Lubricant	Shell Alvania Lead free EP2 Grease (for Standard Actuator). Refer to Section 25 Appendix B - Lubricants							

14.0 TECHNICAL DATA

14.1 S98 Double Acting Pneumatic Actuators

Model	Maximum Operating Pressure				Volume				Actuator Weight		Assembly Weight (approx)				
	Symmetrical		Canted		Cu. in.		Lts		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override		
	psi	bar	psi	bar	Rod End	Cap End	Rod End	Cap End			Lbs	Kg	Lbs	Kg	Lbs
DA	12E2-05	150	10.3	150	10.3	84	94	1.4	1.5	60	27	86	40		
	12E2-06	140	9.7	116	8.0	124	137	2.0	2.2	62	28	88	41		
	12E2-07	103	7.1	85	5.9	170	187	2.8	3.1	68	31	95	44		
	12E2-08	79	5.4	65	4.5	223	244	3.7	4.0	82	37	108	50		
	12E2-09	62	4.3	51	3.5	285	309	4.7	5.1	90	41	117	54		
DD	12E2-05	103	7.1	85	5.8	178	178	2.9	2.9	86	39				
	12E2-06	71	4.9	58	4.0	261	261	4.3	4.3	90	41				
	12E2-07	52	3.6	43	2.9	358	358	5.9	5.9	104	47				
	12E2-08	40	2.7			468	468	7.7	7.7	130	59				
DA	18E2-06	150	10.3	139	9.6	146	163	2.4	2.7	90	41	134	61		
	18E2-07	124	8.5	102	7.0	200	223	3.3	3.6	95	43	139	63		
	18E2-08	95	6.5	78	5.4	266	289	4.4	4.7	112	51	157	71		
	18E2-09	75	5.2	62	4.2	344	366	5.6	6.0	121	55	165	75		
	18E2-10	61	4.2	50	3.4	429	467	7.0	7.7	141	64	185	84		
DD	18E2-06	85	5.9	70	4.8	310	310	5.1	5.1	126	57				
	18E2-07	62	4.3	51	3.5	423	423	6.9	6.9	134	61				
	18E2-08	48	3.3			555	555	9.1	9.1	170	77				
DA	45E2-08	150	10.3	150	10.3	322	346	5.3	5.7	143	65	207	94		
	45E2-09	144	9.9	119	8.2	417	442	6.8	7.2	152	69	216	98		
	45E2-10	117	8.0	96	6.6	519	560	8.5	9.2	172	78	236	107		
	45E2-12	81	5.6	67	4.6	750	831	12.3	13.6	209	95	273	124		
	45E2-14	59	4.1	49	3.4	1020	1135	16.7	18.6	267	121	331	150		
DD	45E2-08	92	6.3	76	5.2	669	669	11.0	11.0	203	92				
	45E2-09	72	5.0	60	4.1	858	858	14.1	14.1	220	100				
	45E2-10	59	4.0	48	3.3	1079	1079	17.7	17.7	260	118				
	45E2-12	41	2.8			1581	1581	25.9	25.9	335	152				
DA	73E2-10	150	10.3	127	8.7	621	668	10.2	11.0	245	111	331	150	359	163
	73E2-12	107	7.4	88	6.1	902	985	14.8	16.2	280	127	366	166	395	179
	73E2-14	78	5.4	65	4.4	1227	1347	20.1	22.1	331	150	417	189	445	202
	73E2-16	60	4.1	49	3.4	1588	1766	26.0	29.0	399	181	485	220	514	233
	DD	73E2-10	77	5.3	64	4.4	1289	1289	21.1	21.1	344	156			
73E2-12		54	3.7	44	3.0	1887	1887	30.9	30.9	414	188				
DA	14E3-12	150	10.3	142	9.8	1071	1152	17.6	18.9	386	175	534	242	558	253
	14E3-14	127	8.7	104	7.2	1458	1574	23.9	25.8	437	198	584	265	608	276
	14E3-16	97	6.7	80	5.5	1890	2061	31.0	33.8	507	230	655	297	679	308
	14E3-18	77	5.3	63	4.3	2421	2626	39.7	43.1	591	268	739	335	763	346
	14E3-20	62	4.3	51	3.5	2978	3300	48.8	54.1	721	327	869	394	893	405
DD	14E3-12	87	6.0	72	4.9	2223	2223	36.5	36.5	536	243				
	14E3-14	64	4.4	52	3.6	3032	3032	49.7	49.7	637	289				
	14E3-16	49	3.4	40	2.8	3951	3951	64.8	64.8	778	353				
DA	24E3-14	150	10.3	134	9.2	1831	1954	30.0	32.0	657	298	873	396	910	413
	24E3-16	124	8.6	102	7.1	2387	2560	39.2	42.0	721	327	937	425	974	442
	24E3-18	98	6.8	81	5.6	3059	3255	50.2	53.4	800	363	1016	461	1054	478
	24E3-20	80	5.5	66	4.5	3750	4084	61.5	67.0	941	427	1157	525	1195	542
	24E3-22	66	4.5	54	3.7	4561	5012	74.8	82.2	1041	472	1257	570	1294	587
	24E3-24	55	3.8	46	3.1	5452	5917	89.4	97.0	1208	548	1424	646	1462	663
DD	24E3-14	82	5.6	67	4.6	3785	3785	62.1	62.1	886	402				
	24E3-16	63	4.3	52	3.5	4948	4948	81.1	81.1	1014	460				
	24E3-18	49	3.4			6314	6314	103.5	103.5	1173	532				
	24E3-20	40	2.8			7834	7834	128.5	128.5	1455	660				

14.1 S98 Double Acting Pneumatic Actuators - Continued

Model	Maximum Operating Pressure				Volume				Actuator Weight		Assembly Weight (approx)				
	Symmetrical		Canted		Cu. in.		Lts		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override		
	psi	bar	psi	bar	Rod End	Cap End	Rod End	Cap End			Lbs	Kg	Lbs	kg	Lbs
DA	45E3-18	150	10.3	123	8.5	3722	3895	61.0	63.9	1105	501			1457	661
	45E3-20	121	8.4	100	6.9	4584	4878	75.2	80.0	1241	563			1594	723
	45E3-22	100	6.9	83	5.7	5591	5973	91.7	98.0	1345	610			1698	770
	45E3-24	84	5.8	69	4.8	6676	7068	109.5	115.9	1515	687			1867	847
	45E3-28	62	4.3	51	3.5	9074	9699	148.8	159.1	1942	881			2295	1041
DD	45E3-18	75	5.2	62	4.3	7617	7617	124.9	124.9	1543	700				
	45E3-20	61	4.2	50	3.5	9462	9462	155.2	155.2	1817	824				
	45E3-22	50	3.5	41	2.9	11564	11564	189.7	189.7	2024	918				
	45E3-24	42	2.9			13745	13745	225.4	225.4	2363	1072				
DA	10E4-22	150	10.3	150	10.3	6875	7205	112.8	118.2	2092	949			2698	1224
	10E4-24	150	10.3	126	8.7	8173	8504	134.0	139.5	2269	1029			2875	1304
	10E4-28	113	7.8	93	6.4	11049	11713	181.2	192.1	2754	1249			3360	1524
	10E4-32	86	5.9	71	4.9	14589	15908	239.3	260.9	3309	1501			3915	1776
	10E4-36	68	4.7	56	3.9	18327	19859	300.6	325.7	4017	1822			4623	2097
DD	10E4-22	92	6.3	76	5.2	14080	14080	230.9	230.9	2873	1303				
	10E4-24	77	5.3	64	4.4	16676	16676	273.5	273.5	3225	1463				
	10E4-28	57	3.9	47	3.2	22763	22763	373.3	373.3	4195	1903				
	10E4-32	43	3.0			30497	30497	500.2	500.2	5306	2407				

14.2 S98H Double Acting Hydraulic Actuators

	Model	Maximum Operating Pressure				Volume				Actuator Weight		Assembly Weight (approx)				
		Symmetrical		Canted		Cu. In		Lts		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override		
		psi	bar	psi	bar	Rod End	Cap End	Rod End	Cap End			Lbs	Kg	Lbs	Kg	Lbs
DA	12E2-32	3000	206.7	2620	180.5											
	12E2-40	2036	140.3	1677	115.5	5.5	8.5	0.10	0.15	50	23	78	35.5			
	12E2-50	1303	89.8	1073	74.0	10.5	13.5	0.20	0.25	53	24	82	37			
	12E2-63	841	57.9	692	47.7	19.0	21.5	0.35	0.35	61	28	89	41			
DD	12E2-32	2083	143.5	1716	118.2											
	12E2-40	1199	82.6	1012	69.7	14.0	14.0	0.25	0.25	62	28					
	12E2-50	739	50.9	608	41.9	24.0	24.0	0.39	0.39	68	31					
DA	18E2-40	2443	168.3	2012	138.7											
	18E2-50	1564	107.7	1288	88.7	12.0	16.0	0.20	0.30	82	37	126	57			
	18E2-63	1009	69.5	831	57.2	22.0	25.5	0.40	0.45	90	41	134	61			
	18E2-80	626	43.1	515	35.5	33.0	41.5	0.55	0.70	106	48	150	68			
DD	18E2-40	1518	104.6	1250	86.2											
	18E2-50	915	63.0	754	51.9	28.0	28.0	0.46	0.46	99	45					
	18E2-63	547	37.7			47.5	47.5	0.80	0.80	117	53					
DA	45E2-50	3000	206.7	2477	170.7	14.5	20.5	0.25	0.35	111	51	175	79.5			
	45E2-63	1894	130.5	1560	107.5	27.0	31.5	0.45	0.50	120	55	184	83.5			
	45E2-80	1175	80.9	991	68.3	41.5	52.0	0.70	0.85	137	62	201	91			
	45E2-100	770	53.1	634	43.7	67.0	82.5	1.10	1.35	157	71	220	100			
DD	45E2-50	1718	118.4	1415	97.5	35.0	35.0	0.60	0.60	130	59					
	45E2-63	1028	70.8	867	59.7	58.5	58.5	1.00	1.00	148	67					
	45E2-80	632	43.6	521	35.9	93.5	93.5	1.55	1.55	181	82					
DA	73E2-50	3000	206.7	3000	206.7	13.5	26.5	0.25	0.45	186	85	272	123.5	301	136.5	
	73E2-63	2497	172.0	2056	141.7	28.0	38.0	0.50	0.65	196	89	282	128	311	141	
	73E2-80	1548	106.7	1275	87.9	51.0	61.5	0.85	1.05	215	98	301	136.5	330	149.5	
	73E2-100	1015	69.9	836	57.6	79.0	99.0	1.35	1.65	235	107	321	145.5	349	158.5	
	73E2-125	649	44.7	535	36.9	127.5	142.0	2.10	2.35	266	121	352	160	380	172.5	
DD	73E2-50	2492	171.7	2053	141.4	40.0	40.0	0.70	0.70	209	95					
	73E2-63	1433	98.7	1180	81.3	66.0	66.0	1.15	1.15	229	104					
	73E2-80	862	59.4	710	48.9	112.5	112.5	1.90	1.90	267	121					
DA	14E3-63	3000	206.7	3000	206.7	26.5	46.0	0.45	0.75	304	138	452	205	476	216	
	14E3-80	2500	172.3	2060	141.9	52.0	71.5	0.85	1.20	325	148	473	214.5	497	225.5	
	14E3-100	1600	110.3	1318	90.8	89.0	114.0	1.50	1.90	342	155	489	222	514	233	
	14E3-125	1024	70.6	864	59.5	148.0	167.5	2.45	2.75	374	170	521	236.5	546	247.5	
	14E3-140	836	57.6	689	47.5	190.0	217.0	3.15	3.60	400	182	548	248.5	572	259.5	
DD	14E3-63	2525	174.0	2080	143.3	72.5	72.5	1.20	1.20	342	155					
	14E3-80	1429	98.4	1177	81.1	123.5	123.5	2.05	2.05	384	174					
	14E3-100	891	61.4	734	50.5	203.0	203.0	3.40	3.40	417	189					
	14E3-125	553	38.1			315.5	315.5	5.20	5.20	481	218					
DA	24E3-80	3000	206.7	2642	182.0	62.0	91.5	1.05	1.50	554	252	771	350	808	366.5	
	24E3-100	2053	141.5	1691	116.5	116.5	145.0	1.95	2.40	558	253	774	351	811	368	
	24E3-125	1314	90.5	1082	74.6	186.0	216.5	3.05	3.55	611	277	827	375	864	392	
	24E3-140	1047	72.2	884	60.9	240.0	278.0	3.95	4.60	643	292	859	390	896	406.5	
	24E3-160	822	56.6	677	46.6	322.5	365.5	5.30	6.00	675	306	891	404	928	421	
DD	24E3-80	1905	131.3	1569	108.1	153.5	153.5	2.55	2.55	628	285					
	24E3-100	1142	78.7	964	66.4	261.5	261.5	4.35	4.35	635	288					
	24E3-125	720	49.6	592.9	40.9	402.5	402.5	6.60	6.60	741	336					
	24E3-140	566	39.0			518.0	518.0	8.55	8.55	805	365					

14.2 S98H Double Acting Hydraulic Actuators - Continued

	Model	Maximum Operating Pressure				Volume				Actuator Weight		Assembly Weight (approx)				
		Symmetrical		Canted		Cu. In		Lts		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override		
		psi	bar	psi	bar	Rod End	Cap End	Rod End	Cap End			Lbs	Kg	Lbs	Kg	
DA	45E3-100	3000	206.7	2576	177.5											
	45E3-125	2002	138.0	1649	113.6											
	45E3-140	1596	110.0	1314	90.6	276.5	336.5	4.55	5.55	942	428			1295	588	
	45E3-160	1222	84.2	1031	71.0											
	45E3-180	989	68.1	815	56.2											
DD	45E3-100	1855	127.8	1528	105.3											
	45E3-125	1112	76.7	939	64.7											
	45E3-140	889	61.2	732	50.4	613.0	613.0	10.10	10.10	666	302					
	45E3-160	667	45.9	549.2	37.8											
DA	10E4-125	3000	206.7	3000	206.7											
	10E4-140	2910	200.5	2397	165.1											
	10E4-160	2228	153.5	1835	126.4	431.50	548.00	7.10	9.00	1756	797			2362	1071.5	
	10E4-180	1760	121.3	1450	99.9	575.50	697.50	9.40	11.45	1824	828			2431	1102.5	
	10E4-200	1426	98.2	1174	80.9	731.00	862.00	12.00	14.15	1912	868			2519	1142.5	
	10E4-220	1178	81.2	994	68.5											
	10E4-250	935	64.4	770	53.1											
DD	10E4-125	2164	149.1	1783	122.8											
	10E4-140	1663	114.6	1369	94.4											
	10E4-160	1232	84.9	1015	69.9	979.5	979.5	16.1	16.1	2041	926					
	10E4-180	976	67.2	804	55.4	1273.0	1273.0	20.9	20.9	2178	988					
	10E4-200	778	53.6	641.0	44.2	1593.0	1593.0	26.2	26.2	2355	1068					

14.3 S98 Spring Return Pneumatic Actuators

Model	Spring #	Maximum Operating Pressure				Volume		Actuator Weight		Assembly Weight (approx)			
		Symmetrical		Canted		Rod End		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override	
		psi	bar	psi	bar	Cu. In	Lts			Lbs	Kg	Lbs	Kg
12E2-05	1	150	10.3	150	10.3	84	1.4	112	51	123	57		
12E2-06		150	10.3	150	10.3	124	2.0	115	52	126	58		
12E2-07		132	9.1	113	7.8	170	2.8	121	55	132	61		
12E2-08		101	6.9	86	6.0	223	3.7	134	61	146	67		
12E2-09		79	5.5	68	4.7	285	4.7	143	65	154	71		
12E2-05	2	150	10.3	150	10.3	84	1.4	112	51	123	57		
12E2-06		150	10.3	150	10.3	124	2.0	115	52	126	58		
12E2-07		139	9.5	120	8.3	170	2.8	121	55	132	61		
12E2-08		106	7.3	92	6.3	223	3.7	134	61	146	67		
12E2-09		83	5.7	72	5.0	285	4.7	143	65	154	71		
12E2-06	3	150	10.3	150	10.3	124	2.0	121	55	132	61		
12E2-07		150	10.3	134	9.2	170	2.8	128	58	139	64		
12E2-08		116	8.0	102	7.0	223	3.7	141	64	152	70		
12E2-09		91	6.3	80	5.5	285	4.7	150	68	161	74		
18E2-06	1	150	10.3	150	10.3	146	2.4	172	78	185	84		
18E2-07		150	10.3	141	9.7	200	3.3	176	80	190	86		
18E2-08		125	8.6	108	7.4	266	4.4	194	88	207	94		
18E2-09		98	6.8	85	5.8	344	5.6	203	92	216	98		
18E2-10		79	5.5	69	4.7	429	7.0	223	101	236	107		
18E2-06	2	150	10.3	150	10.3	146	2.4	176	80	190	86		
18E2-07		150	10.3	147	10.1	200	3.3	181	82	194	88		
18E2-08		129	8.9	112	7.7	266	4.4	198	90	212	96		
18E2-09		102	7.0	88	6.1	344	5.6	207	94	220	100		
18E2-10		82	5.7	71	4.9	429	7.0	227	103	240	109		
18E2-06	3	150	10.3			146	2.4	181	82	194	88		
18E2-07		150	10.3	150	10.3	200	3.3	185	84	198	90		
18E2-08		142	9.8	125	8.6	266	4.4	203	92	216	98		
18E2-09		112	7.7	98	6.8	344	5.6	212	96	225	102		
18E2-10		90	6.2	79	5.5	429	7.0	231	105	245	111		
45E2-08	1	150	10.3	150	10.3	322	5.3	278	126	304	138		
45E2-09		150	10.3	150	10.3	417	6.8	287	130	313	142		
45E2-10		146	10.0	125	8.6	519	8.5	306	139	333	151		
45E2-12		101	7.0	87	6.0	750	12.3	344	156	370	168		
45E2-14		74	5.1	63	4.4	1020	16.7	401	182	428	194		
45E2-08	2	150	10.3	150	10.3	322	5.3	289	131	315	143		
45E2-09		150	10.3	150	10.3	417	6.8	298	135	324	147		
45E2-10		150	10.3	135	9.3	519	8.5	317	144	344	156		
45E2-12		108	7.4	93	6.4	750	12.3	355	161	381	173		
45E2-14		79	5.4	69	4.7	1020	16.7	412	187	439	199		
45E2-08	3	150	10.3	150	10.3	322	5.3	295	134	353	160		
45E2-09		150	10.3	150	10.3	417	6.8	304	138	362	164		
45E2-10		150	10.3	148	10.2	519	8.5	324	147	381	173		
45E2-12		117	8.1	103	7.1	750	12.3	362	164	419	190		
45E2-14		86	5.9	75	5.2	1020	16.7	419	190	476	216		
45E2-09	4	150	10.3	150	10.3	417	6.8	324	147	384	174		
45E2-10		150	10.3	150	10.3	519	8.5	344	156	403	183		
45E2-12		121	8.4	107	7.4	750	12.3	381	173	441	200		
45E2-14		89	6.1	79	5.4	1020	16.7	439	199	498	226		

14.3 S98 Spring Return Pneumatic Actuators - Continued

Model	Spring #	Maximum Operating Pressure				Volume		Actuator Weight		Assembly Weight (approx)			
		Symmetrical		Canted		Rod End		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override	
		psi	bar	psi	bar	Cu. In	Lts			Lbs	Kg	Lbs	Kg
73E2-10	1	150	10.3	150	10.3	621	10.2	459	208	520	236	536	243
73E2-12		139	9.6	120	8.3	902	14.8	494	224	556	252	571	259
73E2-14		102	7.0	88	6.1	1227	20.1	545	247	606	275	622	282
73E2-16		78	5.4	67	4.6	1588	26.0	613	278	675	306	690	313
73E2-10	2	150	10.3	150	10.3	621	10.2	461	209	525	238	538	244
73E2-12		144	9.9	125	8.6	902	14.8	496	225	560	254	573	260
73E2-14		105	7.3	91	6.3	1227	20.1	547	248	611	277	624	283
73E2-16		80	5.5	70	4.8	1588	26.0	615	279	679	308	692	314
73E2-10	3	150	10.3	150	10.3	621	10.2	483	219	549	249	560	254
73E2-12		150	10.3	133	9.2	902	14.8	518	235	584	265	595	270
73E2-14		111	7.7	98	6.7	1227	20.1	569	258	635	288	646	293
73E2-16		85	5.9	75	5.1	1588	26.0	637	289	703	319	714	324
73E2-10	4	150	10.3	150	10.3	621	10.2	538	244	604	274	615	279
73E2-12		150	10.3	141	9.7	902	14.8	573	260	639	290	650	295
73E2-14		117	8.1	103	7.1	1227	20.1	624	283	690	313	701	318
73E2-16		90	6.2	79	5.4	1588	26.0	692	314	758	344	769	349
14E3-12	1	150	10.3	150	10.3	1071	17.6	747	339	842	382	855	388
14E3-14		150	10.3	137	9.5	1458	23.9	798	362	893	405	906	411
14E3-16		122	8.4	105	7.2	1890	31.0	869	394	963	437	977	443
14E3-18		96	6.6	83	5.7	2421	39.7	952	432	1047	475	1060	481
14E3-20		78	5.4	67	4.6	2978	48.8	1082	491	1177	534	1190	540
14E3-12	2	150	10.3	150	10.3	1071	17.6	769	349	869	394	877	398
14E3-14		150	10.3	142	9.8	1458	23.9	820	372	919	417	928	421
14E3-16		126	8.7	108	7.5	1890	31.0	891	404	990	449	999	453
14E3-18		99	6.8	86	5.9	2421	39.7	974	442	1074	487	1082	491
14E3-20		80	5.5	69	4.8	2978	48.8	1105	501	1204	546	1213	550
14E3-12	3	150	10.3	150	10.3	1071	17.6	789	358	888	403	897	407
14E3-14		150	10.3	148	10.2	1458	23.9	840	381	939	426	948	430
14E3-16		130	9.0	113	7.8	1890	31.0	910	413	1010	458	1019	462
14E3-18		103	7.1	89	6.1	2421	39.7	994	451	1093	496	1102	500
14E3-20		83	5.7	72	5.0	2978	48.8	1124	510	1224	555	1232	559
14E3-12	4	150	10.3	150	10.3	1071	17.6	816	370	930	422	924	419
14E3-14		150	10.3	150	10.3	1458	23.9	866	393	981	445	974	442
14E3-16		138	9.5	121	8.3	1890	31.0	937	425	1052	477	1045	474
14E3-18		109	7.5	95	6.6	2421	39.7	1021	463	1135	515	1129	512
14E3-20		88	6.1	77	5.3	2978	48.8	1151	522	1265	574	1259	571
14E3-12	5	150	10.3	150	10.3	1071	17.6	838	380	952	432	946	429
14E3-14		150	10.3	150	10.3	1458	23.9	888	403	1003	455	996	452
14E3-16		143	9.8	126	8.7	1890	31.0	959	435	1074	487	1067	484
14E3-18		113	7.8	99	6.8	2421	39.7	1043	473	1157	525	1151	522
14E3-20		91	6.3	80	5.5	2978	48.8	1173	532	1287	584	1281	581

14.3 S98 Spring Return Pneumatic Actuators - Continued

Model	Spring #	Maximum Operating Pressure				Volume		Actuator Weight		Assembly Weight (approx)			
		Symmetrical		Canted		Rod End		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override	
		psi	bar	psi	bar	Cu. In	Lts			Lbs	Kg	Lbs	Kg
24E3-14	1	150	10.3	150	10.3	1831	30.0	1232	559	1387	629	1389	630
24E3-16		150	10.3	138	9.5	2387	39.2	1296	588	1451	658	1453	659
24E3-18		126	8.7	109	7.5	3059	50.2	1376	624	1530	694	1532	695
24E3-20		102	7.0	88	6.1	3750	61.5	1517	688	1671	758	1673	759
24E3-22		84	5.8	73	5.0	4561	74.8	1616	733	1770	803	1772	804
24E3-24		71	4.9	61	4.2	5452	89.4	1784	809	1938	879	1940	880
24E3-14		2	150	10.3	150	10.3	1831	30.0	1250	567	1407	638	1407
24E3-16	150		10.3	145	10.0	2387	39.2	1314	596	1470	667	1470	667
24E3-18	132		9.1	114	7.9	3059	50.2	1393	632	1550	703	1550	703
24E3-20	106		7.3	92	6.4	3750	61.5	1534	696	1691	767	1691	767
24E3-22	88		6.1	76	5.2	4561	74.8	1634	741	1790	812	1790	812
24E3-24	74		5.1	64	4.4	5452	89.4	1801	817	1958	888	1958	888
24E3-14	3		150	10.3	150	10.3	1831	30.0	1276	579	1468	666	1433
24E3-16		150	10.3	150	10.3	2387	39.2	1340	608	1532	695	1497	679
24E3-18		139	9.6	122	8.4	3059	50.2	1420	644	1612	731	1576	715
24E3-20		113	7.8	99	6.8	3750	61.5	1561	708	1753	795	1717	779
24E3-22		93	6.4	81	5.6	4561	74.8	1660	753	1852	840	1817	824
24E3-24		78	5.4	68	4.7	5452	89.4	1828	829	2019	916	1984	900
24E3-14		4	150	10.3	150	10.3	1831	30.0	1334	605	1528	693	1490
24E3-16	150		10.3	150	10.3	2387	39.2	1398	634	1592	722	1554	705
24E3-18	145		10.0	127	8.8	3059	50.2	1477	670	1671	758	1634	741
24E3-20	117		8.1	103	7.1	3750	61.5	1618	734	1812	822	1775	805
24E3-22	97		6.7	85	5.8	4561	74.8	1717	779	1911	867	1874	850
24E3-24	81		5.6	71	4.9	5452	89.4	1885	855	2079	943	2041	926
24E3-16	5		150	10.3	150	10.3	2387	39.2	1400	635	1596	724	1556
24E3-18		150	10.3	133	9.2	3059	50.2	1479	671	1675	760	1636	742
24E3-20		122	8.4	108	7.4	3750	61.5	1620	735	1817	824	1777	806
24E3-22		101	6.9	89	6.1	4561	74.8	1720	780	1916	869	1876	851
24E3-24		84	5.8	75	5.1	5452	89.4	1887	856	2083	945	2044	927

14.3 S98 Spring Return Pneumatic Actuators - Continued

Model	Spring #	Maximum Operating Pressure				Volume		Actuator Weight		Assembly Weight (approx)			
		Symmetrical		Canted		Rod End		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override	
		psi	bar	psi	bar	Cu. In	Lts			Lbs	Kg	Lbs	Kg
45E3-18	1	150	10.3	150	10.3	3722	61.0	2169	984			2418	1097
45E3-20		150	10.3	134	9.2	4584	75.2	2306	1046			2555	1159
45E3-22		128	8.8	110	7.6	5591	91.7	2410	1093			2659	1206
45E3-24		107	7.4	93	6.4	6676	109.5	2579	1170			2829	1283
45E3-28		79	5.4	68	4.7	9074	148.8	3007	1364			3256	1477
45E3-18	2	150	10.3	150	10.3	3722	61.0	2220	1007			2469	1120
45E3-20		150	10.3	138	9.5	4584	75.2	2357	1069			2606	1182
45E3-22		132	9.1	114	7.9	5591	91.7	2460	1116			2709	1229
45E3-24		111	7.6	96	6.6	6676	109.5	2630	1193			2879	1306
45E3-28		81	5.6	70	4.8	9074	148.8	3058	1387			3307	1500
45E3-18	3	150	10.3	150	10.3	3722	61.0	2363	1072			2612	1185
45E3-20		150	10.3	147	10.2	4584	75.2	2500	1134			2749	1247
45E3-22		139	9.6	122	8.4	5591	91.7	2604	1181			2853	1294
45E3-24		117	8.1	102	7.0	6676	109.5	2773	1258			3023	1371
45E3-28		86	5.9	75	5.2	9074	148.8	3201	1452			3450	1565
45E3-18	4	150	10.3	150	10.3	3722	61.0	2474	1122			2723	1235
45E3-20		150	10.3	150	10.3	4584	75.2	2610	1184			2859	1297
45E3-22		144	9.9	126	8.7	5591	91.7	2714	1231			2963	1344
45E3-24		120	8.3	105	7.3	6676	109.5	2884	1308			3133	1421
45E3-28		88	6.1	77	5.3	9074	148.8	3311	1502			3560	1615
45E3-18	5	150	10.3	150	10.3	3722	61.0	2535	1150			2784	1263
45E3-20		150	10.3	150	10.3	4584	75.2	2672	1212			2921	1325
45E3-22		149	10.2	131	9.0	5591	91.7	2776	1259			3025	1372
45E3-24		125	8.6	110	7.6	6676	109.5	2945	1336			3194	1449
45E3-28		91	6.3	80	5.5	9074	148.8	3373	1530			3622	1643
10E4-22	1	150	10.3	150	10.3	6875	112.8	4153	1884			4429	2009
10E4-24		150	10.3	150	10.3	8173	134.0	4330	1964			4605	2089
10E4-28		143	9.8	123	8.4	11049	181.2	4815	2184			5090	2309
10E4-32		109	7.5	94	6.4	14589	239.3	5370	2436			5646	2561
10E4-36		86	5.9	74	5.1	18327	300.6	6078	2757			6354	2882
10E4-22	2	150	10.3	150	10.3	6875	112.8	4297	1949			4572	2074
10E4-24		150	10.3	150	10.3	8173	134.0	4473	2029			4749	2154
10E4-28		147	10.1	126	8.7	11049	181.2	4958	2249			5234	2374
10E4-32		112	7.7	97	6.7	14589	239.3	5514	2501			5789	2626
10E4-36		88	6.1	76	5.3	18327	300.6	6221	2822			6497	2947
10E4-22	3	150	10.3	150	10.3	6875	112.8	4594	2084			4870	2209
10E4-24		150	10.3	150	10.3	8173	134.0	4771	2164			5046	2289
10E4-28		150	10.3	135	9.3	11049	181.2	5256	2384			5531	2509
10E4-32		119	8.2	103	7.1	14589	239.3	5811	2636			6087	2761
10E4-36		94	6.5	82	5.6	18327	300.6	6519	2957			6795	3082
10E4-22	4	150	10.3	150	10.3	6875	112.8	4793	2174			5068	2299
10E4-24		150	10.3	150	10.3	8173	134.0	4969	2254			5245	2379
10E4-28		150	10.3	141	9.7	11049	181.2	5454	2474			5730	2599
10E4-32		123	8.5	108	7.4	14589	239.3	6010	2726			6285	2851
10E4-36		97	6.7	85	5.9	18327	300.6	6717	3047			6993	3172

14.4 S98H Spring Return Hydraulic Actuators

Model	Spring #	Maximum Operating Pressure				Volume		Actuator Weight		Assembly Weight (approx)			
		Symmetrical		Canted		Rod end		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override	
		psi	bar	psi	bar	Cu. In	Lts			Lbs	Kg	Lbs	Kg
12E2-40	1	3000	206.7	3000	206.7	5.5	0.10	100	45.5	114	51.5		
12E2-50		2134	147.0	1831	126.2	10.5	0.20	104	47	117	53		
12E2-63		1234	85.1	1059	73.0	19.0	0.35	111	51	125	57		
12E2-80		727	50.1	624	43.0	28.0	0.50	125	57	138	63		
12E2-40	2	3000	206.7	3000	206.7	5.5	0.10	100	45.5	114	51.5		
12E2-50		2238	154.2	1936	133.4	10.5	0.20	104	47	117	53		
12E2-63		1295	89.2	1120	77.1	19.0	0.35	111	51	125	56.5		
12E2-80		763	52.6	660	45.4	28.0	0.50	125	57	138	62.5		
12E2-40	3	3000	206.7	3000	206.7	5.5	0.10	107	48.5	120	54.5		
12E2-50		2449	168.7	2146	147.9	10.5	0.20	110	50	123	56		
12E2-63		1417	97.6	1241	85.5	19.0	0.35	118	54	131	59.5		
12E2-80		834	57.5	731	50.4	28.0	0.50	131	60	144	65.5		
18E2-50	1	2702	186.1	2334	160.8	12.0	0.20	159	72	172	78		
18E2-63		1515	104.4	1309	90.2	22.0	0.40	168	76	181	82		
18E2-80		893	61.6	771	53.1	33.0	0.55	183	83	196	89		
18E2-50	2	2800	192.9	2432	167.6	12.0	0.20	163	74	176	80		
18E2-63		1570	108.2	1364	94.0	22.0	0.40	172	78	185	84		
18E2-80		925	63.8	803	55.3	33.0	0.55	187	85	201	91		
18E2-50	3	3000	206.7	2706	186.5	12.0	0.20	168	76	181	82		
18E2-63		1723	118.7	1517	104.5	22.0	0.40	176	80	190	86		
18E2-80		1014	69.9	892	61.5	33.0	0.55	192	87	205	93		
45E2-63	1	2784	191.8	2388	164.5	27.0	0.45	250	114	277	125.5		
45E2-80		1612	111.1	1382	95.3	41.5	0.70	267	121	293	133		
45E2-100		1012	69.7	868	59.8	67.0	1.10	287	130	313	142		
45E2-63	2	2973	204.9	2577	177.6	27.0	0.45	261	119	288	130.5		
45E2-80		1722	118.6	1492	102.8	41.5	0.70	278	126	304	138		
45E2-100		1061	73.1	935	64.4	67.0	1.10	298	135	324	147		
45E2-63	3	3000	206.7	2835	195.3	27.0	0.45	268	122	325	147.5		
45E2-80		1871	128.9	1642	113.1	41.5	0.70	284	129	342	155		
45E2-100		1153	79.4	1027	70.8	67.0	1.10	304	138	362	164		
45E2-63	4	3000	206.7	2952	203.4	27.0	0.45	288	131	347	157.5		
45E2-80		1939	133.6	1710	117.8	41.5	0.70	304	138	364	165		
45E2-100		1194	82.3	1069	73.7	67.0	1.10	324	147	384	174		

14.4 S98H Spring Return Hydraulic Actuators - Continued

Model	Spring #	Maximum Operating Pressure				Volume		Actuator Weight		Assembly Weight (approx)			
		Symmetrical		Canted		Rod end		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override	
		psi	bar	psi	bar	Cu. In	Lts			Lbs	Kg	Lbs	Kg
73E2-63	1	3000	206.7	3000	206.7	28.0	0.50	401	182	463	210	478	217
73E2-80		2381	164.0	2056	141.6	51.0	0.85	420	191	482	218.5	497	225.5
73E2-100		1426	98.2	1231	84.8	79.0	1.35	440	200	502	227.5	517	234.5
73E2-125		893	61.5	770	53.1	127.5	2.10	471	214	532	241.5	548	248.5
73E2-63	2	3000	206.7	3000	206.7	28.0	0.50	403	183	467	212	481	218
73E2-80		2455	169.2	2130	146.8	51.0	0.85	422	192	486	220.5	499	226.5
73E2-100		1471	101.3	1276	87.9	79.0	1.35	442	201	506	229.5	519	235.5
73E2-125		920	63.4	798	55.0	127.5	2.10	473	215	537	243.5	550	249.5
73E2-63	3	3000	206.7	3000	206.7	28.0	0.50	425	193	492	223	503	228
73E2-80		2600	179.1	2275	156.7	51.0	0.85	444	202	510	231.5	521	236.5
73E2-100		1557	107.3	1362	93.9	79.0	1.35	464	211	530	240.5	541	245.5
73E2-125		974	67.1	851	58.6	127.5	2.10	495	225	561	254.5	572	259.5
73E2-63	4	3000	206.7	3000	206.7	28.0	0.50	481	218	547	248	558	253
73E2-80		2733	188.3	2408	165.9	51.0	0.85	499	227	565	256.5	577	261.5
73E2-100		1637	112.8	1442	99.4	79.0	1.35	519	236	585	265.5	596	270.5
73E2-125		1023	70.5	900	62.0	127.5	2.10	550	250	616	279.5	627	284.5
14E3-80	1	3000	206.7	3000	206.7	52.0	0.85	671	305	766	347.5	779	353.5
14E3-100		2379	163.9	2043	140.8	89.0	1.50	688	312	783	355	796	361
14E3-125		1425	98.2	1224	84.3	148.0	2.45	720	327	815	370	828	375.5
14E3-140		1110	76.5	971	66.9	190.0	3.15	746	339	841	382	854	387.5
14E3-160		849	58.5	728	50.2	253.5	4.15	786	357	881	400	894	405.5
14E3-80	2	3000	206.7	3000	206.7	52.0	0.85	693	315	793	359.5	801	363.5
14E3-100		2448	168.7	2112	145.5	89.0	1.50	710	322	809	367	818	371
14E3-125		1466	101.0	1265	87.2	148.0	2.45	742	337	841	382	850	385.5
14E3-140		1143	78.7	1003	69.1	190.0	3.15	768	349	868	394	876	397.5
14E3-160		873	60.1	753	51.9	253.5	4.15	808	367	907	412	916	415.5
14E3-80	3	3000	206.7	3000	206.7	52.0	0.85	713	324	812	368.5	821	372.5
14E3-100		2538	174.9	2202	151.7	89.0	1.50	730	331	829	376	838	380
14E3-125		1520	104.7	1319	90.9	148.0	2.45	762	346	861	391	870	394.5
14E3-140		1184	81.6	1028	70.8	190.0	3.15	788	358	887	403	896	406.5
14E3-160		904	62.3	784	54.0	253.5	4.15	828	376	927	421	936	424.5
14E3-80	4	3000	206.7	3000	206.7	52.0	0.85	740	336	854	387.5	848	384.5
14E3-100		2685	185.0	2349	161.8	89.0	1.50	756	343	871	395	864	392
14E3-125		1608	110.8	1407	96.9	148.0	2.45	788	358	903	410	896	406.5
14E3-140		1253	86.3	1096	75.5	190.0	3.15	815	370	929	422	923	418.5
14E3-160		956	65.8	835	57.5	253.5	4.15	854	388	969	440	962	436.5
14E3-80	5	3000	206.7	3000	206.7	52.0	0.85	762	346	876	397.5	870	394.5
14E3-100		2784	191.8	2449	168.7	89.0	1.50	778	353	893	405	886	402
14E3-125		1668	114.9	1467	101.0	148.0	2.45	810	368	925	420	918	416.5
14E3-140		1299	89.5	1143	78.7	190.0	3.15	837	380	951	432	945	428.5
14E3-160		991	68.3	870	60.0	253.5	4.15	876	398	991	450	984	446.5

14.4 S98H Spring Return Hydraulic Actuators - Continued

Model	Spring #	Maximum Operating Pressure				Volume		Actuator Weight		Assembly Weight (approx)			
		Symmetrical		Canted		Rod end		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override	
		psi	bar	psi	bar	Cu. In	Lts			Lbs	Kg	Lbs	Kg
24E3-100	1	3000	206.7	2824	194.5	116.5	1.95	1107	502	1261	572	1263	573
24E3-125		1922	132.4	1656	114.1	186.0	3.05	1160	526	1314	596	1316	597
24E3-140		1487	102.5	1281	88.3	240.0	3.95	1192	541	1346	611	1348	612
24E3-160		1109	76.4	973	67.0	322.5	5.30	1224	555	1378	625	1380	626
24E3-180		877	60.4	755	52.0								
24E3-100	2	3000	206.7	2963	204.2	116.5	1.95	1124	510	1281	581	1281	581
24E3-125		2004	138.1	1738	119.7	186.0	3.05	1177	534	1334	605	1334	605
24E3-140		1551	106.8	1345	92.6	240.0	3.95	1209	549	1366	620	1366	620
24E3-160		1156	79.6	1020	70.3	322.5	5.30	1241	563	1398	634	1398	634
24E3-180		914	63.0	792	54.5								
24E3-100	3	3000	206.7	3000	206.7	116.5	1.95	1151	522	1343	609	1307	593
24E3-125		2120	146.1	1854	127.7	186.0	3.05	1204	546	1396	633	1360	617
24E3-140		1641	113.0	1435	98.9	240.0	3.95	1236	561	1427	648	1392	632
24E3-160		1223	84.3	1070	73.7	322.5	5.30	1268	575	1459	662	1424	646
24E3-180		966	66.6	844	58.1								
24E3-100	4	3000	206.7	3000	206.7	116.5	1.95	1208	548	1402	636	1365	619
24E3-125		2202	151.7	1935	133.3	186.0	3.05	1261	572	1455	660	1418	643
24E3-140		1704	117.4	1498	103.2	240.0	3.95	1293	587	1487	675	1450	658
24E3-160		1270	87.5	1116	76.9	322.5	5.30	1325	601	1519	689	1481	672
24E3-180		1002	69.1	880	60.7								
24E3-100	5	3000	206.7	3000	206.7	116.5	1.95	1210	549	1407	638	1367	620
24E3-125		2294	158.1	2028	139.7	186.0	3.05	1263	573	1459	662	1420	644
24E3-140		1775	122.3	1570	108.1	240.0	3.95	1295	588	1491	677	1452	659
24E3-160		1324		1170		322.5	5.30	1327	602	1523	691	1484	673
24E3-180		1044	71.9	922	63.5								

14.4 S98H Spring Return Hydraulic Actuators - Continued

Model	Spring #	Maximum Operating Pressure				Volume		Actuator Weight		Assembly Weight (approx)			
		Symmetrical		Canted		Rod end		Lbs	Kg	w/Jackscrew Override		w/Hydraulic Override	
		psi	bar	psi	bar	Cu. In	Lts			Lbs	Kg	Lbs	Kg
45E3-125	1	3000	206.7	2728	187.9								
45E3-140		2404	165.6	2069	142.6	276.5	4.55	1970	894			2219	1006.5
45E3-160		1762	121.4	1517	104.5								
45E3-180		1353	93.2	1164	80.2								
45E3-200		1074	74.0	941	64.9	618.5	10.15	2136	969			2385	1082
45E3-125	2	3000	206.7	2823	194.5								
45E3-140		2477	170.6	2142	147.6	276.5	4.55	2021	917			2270	1029.5
45E3-160		1815	125.1	1570	108.2								
45E3-180		1393	96.0	1205	83.0								
45E3-200		1106	76.2	974	67.1	618.5	10.15	2187	992			2436	1105
45E3-125	3	3000	206.7	3000	206.7								
45E3-140		2616	180.2	2281	157.2	276.5	4.55	2164	982			2413	1094.5
45E3-160		1917	132.1	1672	115.2								
45E3-180		1472	101.4	1283	88.4								
45E3-200		1168	80.5	1019	70.2	618.5	10.15	2330	1057			2579	1170
45E3-125	4	3000	206.7	3000	206.7								
45E3-140		2693	185.5	2358	162.5	276.5	4.55	2274	1032			2523	1144.5
45E3-160		1974	136.0	1728	119.1								
45E3-180		1515	104.4	1327	91.4								
45E3-200		1203	82.9	1053	72.6	618.5	10.15	2440	1107			2690	1220
45E3-125	5	3000	206.7	3000	206.7								
45E3-140		2790	192.2	2455	169.1	276.5	4.55	2336	1060			2585	1172.5
45E3-160		2045	140.9	1799	124.0								
45E3-180		1569	108.1	1381	95.2								
45E3-200		1246	85.8	1096	75.5	618.5	10.15	2502	1135			2751	1248
10E4-160	1	3000	206.7	2964	204.2	431.5	7.10	3738	1696			4013	1820.5
10E4-180		2597	178.9	2231	153.7	575.5	9.40	3806	1727			4082	1851.5
10E4-200		2035	140.2	1748	120.4	731.0	12.00	3894	1767			4170	1891.5
10E4-220		1642	113.1	1411	97.2								
10E4-250		1240	85.4	1065	73.4								
10E4-160	2	3000	206.7	3000	206.7	431.5	7.10	3881	1761			4157	1885.5
10E4-180		2669	183.9	2303	158.7	575.5	9.40	3950	1792			4225	1916.5
10E4-200		2091	144.1	1804	124.3	731.0	12.00	4038	1832			4313	1956.5
10E4-220		1687	116.2	1456	100.3								
10E4-250		1274	87.8	1100	75.8								
10E4-160	3	3000	206.7	3000	206.7	431.5	7.10	4179	1896			4454	2020.5
10E4-180		2832	195.1	2466	169.9	575.5	9.40	4247	1927			4523	2051.5
10E4-200		2219	152.9	1932	133.1	731.0	12.00	4335	1967			4611	2091.5
10E4-220		1790	123.4	1559	107.4								
10E4-250		1352	93.2	1178	81.1								
10E4-160	4	3000	206.7	3000	206.7	431.5	7.10	4377	1986			4653	2110.5
10E4-180		2933	202.1	2567	176.9	575.5	9.40	4446	2017			4721	2141.5
10E4-200		2298	158.3	2011	138.6	731.0	12.00	4534	2057			4809	2181.5
10E4-220		1854	127.8	1623	111.8								
10E4-250		1400	96.5	1226	84.5								

15.0 MODULE WEIGHTS

MODULE WEIGHTS (APPROX), Lbs																							
Model	Rated Torq. Nm	Torque Module	Pneumatic Pressure Modules Size, Inch														Spring Modules						
			5	6	7	8	9	10	12	14	16	18	20	22	24	28	32	36	1	2	3	4	5
12 E2	1,200	33	26	29	35	49	57												53	53	60		
18 E2	1,800	55		35	40	57	66	86											82	86	90		
45 E2	4,500	84				60	68	88	126	183									134	146	152	172	
73 E2	7,300	146						99	134	185	254								214	216	238	293	
14 E3	14,000	236							150	201	271	355	485						362	384	403	430	452
24 E3	24,000	428								229	293	373	514	613	780				575	593	619	677	679
45 E3	45,000	666											439	575	679	849	1276		1065	1116	1259	1369	1431
10 E4	100,000	1312													780	957	1442	1997	2705	2061	2205	2502	2701

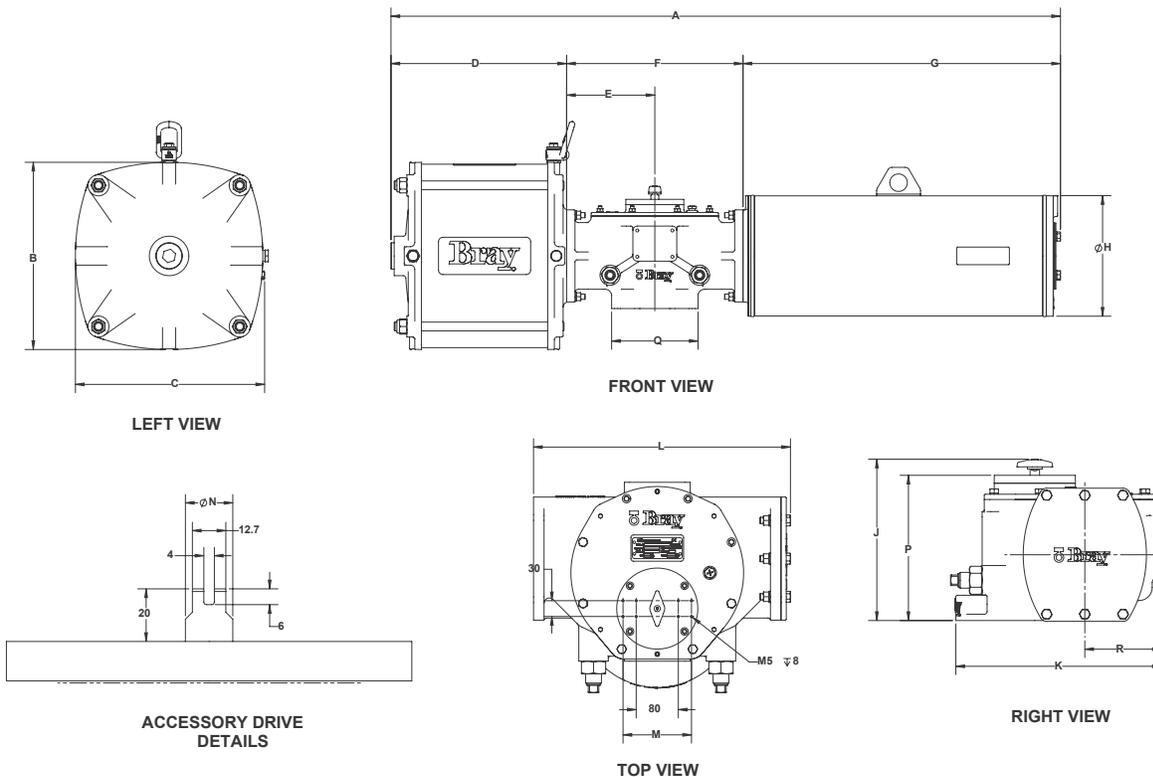
MODULE WEIGHTS (APPROX), Kg																							
Model	Rated Torq. Nm	Torque Module	Pneumatic Pressure Modules Size, Inch														Spring Modules						
			5	6	7	8	9	10	12	14	16	18	20	22	24	28	32	36	1	2	3	4	5
12 E2	1,200	15	12	13	16	22	26												24	24	27		
18 E2	1,800	25		16	18	26	30	39											37	39	41		
45 E2	4,500	38				27	31	40	57	83									61	66	69	78	
73 E2	7,300	66						45	61	84	115								97	98	108	133	
14 E3	14,000	107							68	91	123	161	220						164	174	183	195	205
24 E3	24,000	194								104	133	169	233	278	354				261	269	281	307	308
45 E3	45,000	302											199	261	308	385	579		483	506	571	621	649
10 E4	100,000	595													354	434	654	906	1227	935	1000	1135	1225

MODULE WEIGHTS (APPROX), Lbs																							
Model	Rated Torq. Nm	Torque Module	Hydraulic Pressure Modules, mm												Spring Modules								
			32	40	50	63	80	100	125	140	160	180	200	220	250	1	2	3	4	5			
12 E2	1,200	33	13	14	18	25	39												53	53	60		
18 E2	1,800	55		19	22	31	46												82	86	90		
45 E2	4,500	84			23	32	49	68											134	146	152	172	
73 E2	7,300	146			32	42	61	80	111										214	216	238	293	
14 E3	14,000	236				53	74	90	122	149	188								362	384	403	430	452
24 E3	24,000	428					100	104	157	188	220	282							575	593	619	677	679
45 E3	45,000	666						174	177	239	276	335	406						1065	1116	1259	1369	1431
10 E4	100,000	1312							249	278	365	433	521	648	802.5				2061	2205	2502	2701	

MODULE WEIGHTS (APPROX), Kg																							
Model	Rated Torq. Nm	Torque Module	Hydraulic Pressure Modules Size, mm												Spring Modules								
			32	40	50	63	80	100	125	140	160	180	200	220	250	1	2	3	4	5			
12 E2	1,200	15	6	6.5	8.0	11.5	17.5												24	24	27		
18 E2	1,800	25		8.5	10.0	14.0	21.0												37	39	41		
45 E2	4,500	38			10.5	14.5	22.0	31.0											61	66	69	78	
73 E2	7,300	66			14.5	19.0	27.5	36.5	50.5										97	98	108	133	
14 E3	14,000	107				24.0	33.5	41.0	55.5	67.5	85.5								164	174	183	195	205
24 E3	24,000	194					45.5	47.0	71.0	85.5	100.0	128							261	269	281	307	308
45 E3	45,000	302						79	80.5	108.5	125	152	184.0						483	506	571	621	649
10 E4	100,000	595							113	126	165.5	196.5	236.5	294	364				935	1000	1135	1225	

16.0 DIMENSIONS

16.1 Series 98 Pneumatic Dimensions



Series 98 Max Dimensions, inch																	
Model	ISO Base	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R
12E2	F12/F07	35.2	9.8	9.8	10.1	4.6	9.3	15.7	7.1	7.3	6.8	9.8	--	0.6	6.1	4.4	3.0
18E2	F12	42.4	10.8	10.8	12.2	5.5	11.1	19.1	8.1	8.7	8.7	11.7	--	0.6	7.4	4.4	4.0
45E2	F16/F12	52.8	14.8	14.8	14.2	6.3	12.5	26.2	9.4	9.7	9.4	13.1	--	0.7	8.5	7.7	3.8
73E2	F16/F12	60.1	16.8	16.8	15.8	7.9	15.8	28.5	12.8	11.8	11.3	16.5	--	0.7	9.8	7.8	5.1
14E3	F25/16	72.6	21.3	21.3	18.8	9.3	18.5	35.3	13.5	12.1	15.4	19.6	5.1	0.7	10.9	11.8	5.7
24E3	F30/25	90.0	25.1	25.1	21.9	11.5	22.9	45.2	15.6	14.3	19.3	23.8	5.1	1.0	13.1	13.8	7.3
45E3	F35/30	113.3	33.3	33.3	25.8	14.3	28.6	58.9	18.7	15.3	22.8	29.5	5.1	1.0	14.1	16.3	8.3
10E4	F40/F35	138.1	41.7	38.0	32.8	17.8	35.5	69.8	21.9	18.9	28.3	37.6	5.1	1.0	17.8	18.7	11.3

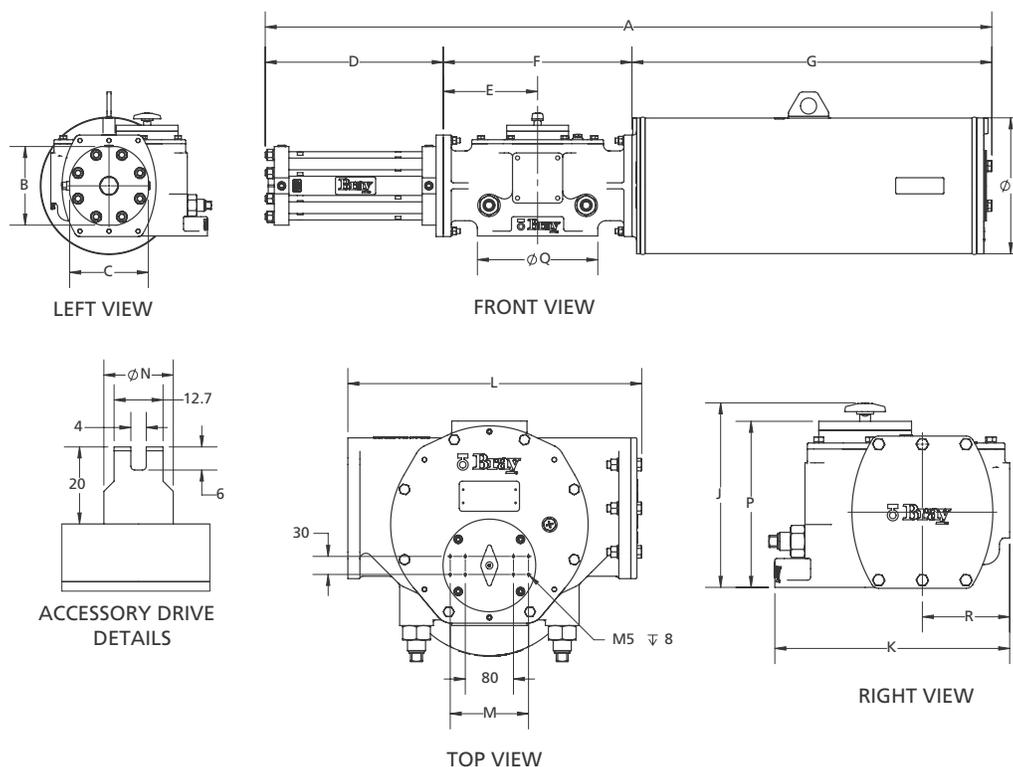
Series 98 Max Dimensions, mm																	
Model	ISO Base	A	B	C	D	E	F	G	H	J	K	L	M	N	P	T	U
12E2	F12/F07	893	248	248	257	118	236	400	180	185	173	248	--	15	155	113	76
18E2	F12	1077	274	274	309	141	281	486	205	222	220	296	--	15	189	113	102
45E2	F16/F12	1342	376	376	360	159	318	664	240	246	240	333	--	18	216	195	96
73E2	F16/F12	1526	427	427	400	201	402	723	326	300	288	420	--	18	249	197	129
14E3	F25/16	1843	542	542	477	235	470	896	342	307	390	498	130	18	276	300	145
24E3	F30/25	2287	638	638	556	291	582	1148	397	364	491	605	130	25	334	350	186
45E3	F35/30	2877	845	845	656	363	726	1495	476	388	580	750	130	25	357	415	212
10E4	F40/F35	3507	1060	964	832	451	902	1773	556	481	720	955	130	25	451	475	286

Note: Refer ES drawings for dimensions of specific models

Pneumatic Cylinder Port Size

Cylinder Size	5" - 9"	10"	12" - 16"	18" - 24"	28" - 36"
Ports, NPT	3/8"	1/2"	3/4"	1"	1.5"

16.2 Series 98 Hydraulic Dimensions



Series 98H Max Dimensions, inch																	
Model	ISO Base	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R
12E2	F12/F07	36.9	4.5	4.5	11.9	4.6	9.3	15.7	7.1	7.3	6.8	9.8	--	0.6	6.1	4.4	3.0
18E2	F12	43.7	4.5	4.5	13.5	5.5	11.1	19.1	8.1	8.7	8.7	11.7	--	0.6	7.4	4.4	4.0
45E2	F16/F12	52.7	5.5	5.5	14.1	6.3	12.5	26.2	9.4	9.7	9.4	13.1	--	0.7	8.5	7.7	3.8
73E2	F16/F12	60.6	7.7	7.7	16.3	7.9	15.8	28.5	12.8	11.8	11.3	16.5	--	0.7	9.8	7.8	5.1
14E3	F25/16	72.1	9.4	9.4	18.4	9.3	18.5	35.3	13.5	12.1	15.4	19.6	5.1	0.7	10.9	11.8	5.7
24E3	F30/25	90.4	10.8	10.8	22.3	11.5	22.9	45.2	15.6	14.3	19.3	23.8	5.1	1.0	13.1	13.8	7.3
45E3	F35/30	112.1	12.2	12.2	24.6	14.3	28.6	58.9	18.7	15.3	22.8	29.5	5.1	1.0	14.1	16.3	8.3
10E4	F40/F35	134.5	14.2	14.2	29.2	17.8	35.5	69.8	21.9	18.9	28.3	37.6	5.1	1.0	17.8	18.7	11.3

Series 98H Max Dimensions, mm																	
Model	ISO Base	A	B	C	D	E	F	G	H	J	K	L	M	N	P	Q	R
12E2	F12/F07	937	115	115	301	118	236	400	180	185	173	248	--	15	155	113	76
18E2	F12	1110	115	115	342.5	140.5	281	486	205	222	220	296	--	15	189	113	102
45E2	F16/F12	1339	140	140	357	159	318	664	240	246	240	333	--	18	216	195	96
73E2	F16/F12	1540	196	196	415	201	402	723.45	326	300	288	420	--	18	249	197	129
14E3	F25/16	1832	240	240	467	235	470	896	342	307	390	498	130	18	276	300	145
24E3	F30/25	2296	275	275	566	291	582	1148	397	364	491	605	130	25	334	350	186
45E3	F35/30	2847	310	310	625.5	363	726	1495	476	388	580	750	130	25	357	415	212
10E4	F40/F35	3418	360	360	742.5	451	902	1773	556	481	720	955	130	25	451	475	286

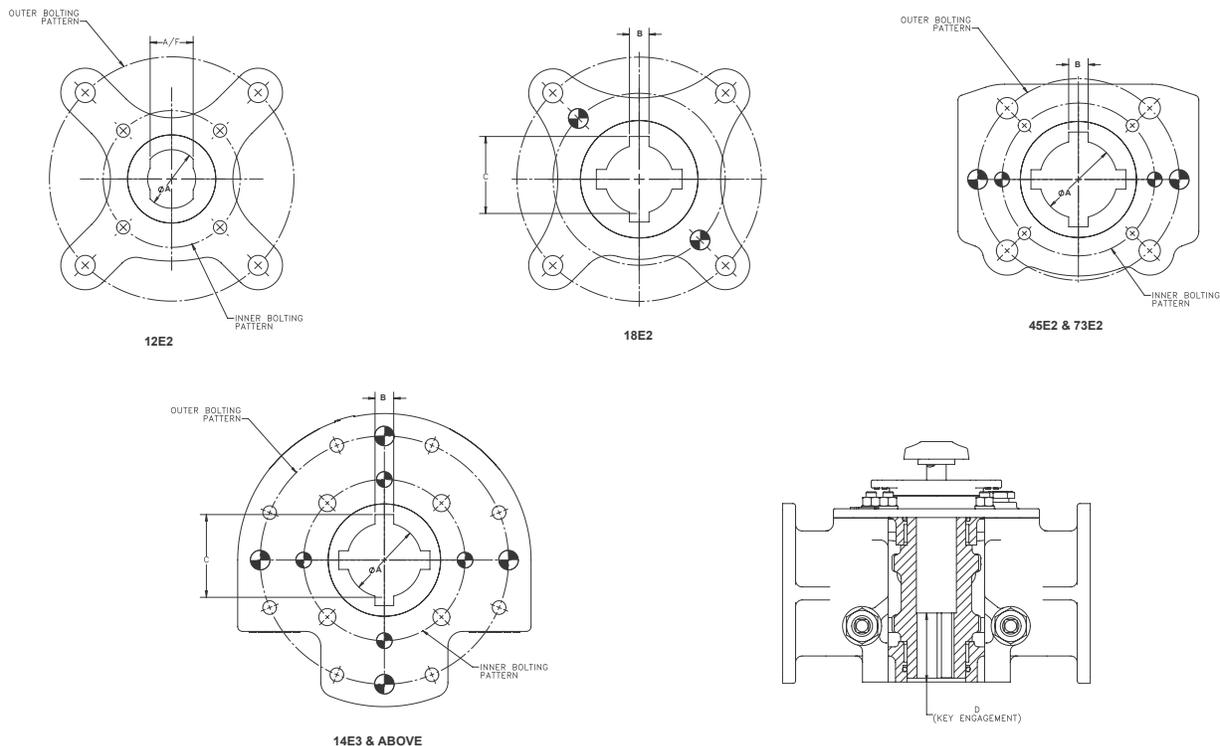
Note: Refer ES drawings for dimensions of specific models

Hydraulic Cylinder Port Size

Cylinder Size	32-50mm	63-140mm	160-250mm
Ports, NPT	1/4"	1/2"	3/4"

Note: 3 NPT ports, 90 degrees apart provided on the end cap and adaptor.

16.3 Series 98/98H Dimensions - Bolting Pattern



Model	Max Stem Height	Outer Bolting Pattern						Inner Bolting Pattern					
		ISO Base	Thread Size	Bolt Circle	No. of Bolt Holes	Dowel Hole Size	No. of Dowel Holes	ISO Base	Tapped Hole	Bolt Circle	No. of Tapped Holes	Dowel	No. of Dowel Holes
12E2	130	F12	M12 x 15mm	125	4	-	-	F07	M8 x 12mm	70	4	-	-
18E2	163	F12	M12 x 18mm	125	4	-	-	-	-	88	-	10.1 +0.05/0, x 10mm	2
45E2	183	F16	M20 x 30mm	165	4	16.1 +0.05/0 x 15mm	2	F12	M12 x 18mm	125	4	12.1 +0.05/0 x 13mm	2
73E2	216	F16	M20 x 30mm	165	4	16.1 +0.05/0 x 15mm	2	F12	M12 x 18mm	125	4	12.1 +0.05/0 x 13mm	2
14E3	240	F25	M16 x 24mm	254	8	20.1 +0.05/0 x 17.5mm	4	F16	M20 x 30mm	165	4	16.1 +0.05/0 x 15mm	4
24E3	295	F30	M20 x 30mm	298	8	20.1 +0.05/0 x 17.5mm	4	F25	M16 x 24mm	254	8	20.1 +0.05/0 x 17.5mm	4
45E3	318	F35	M30 x 45mm	356	8	30.1 +0.05/0 x 27mm	4	F30	M20 x 30mm	298	8	20.1 +0.05/0 x 17.5mm	4
10E4	402	F40	M36 x 54mm	406	8	36.1 +0.05/0 x 36mm	4	F35 Option	M30 x 45mm	356	8	30.1 +0.05/0 x 27mm	4

16.4 Valve Stem Interface Dimensions

Model	Bore 1 (Standard)						Bore 2						Bore 3						Bore 4						
	Drive	A	A/F	B	C	D	Drive	A	A/F	B	C	D	Drive	A	A/F	B	C	D	Drive	A	A/F	B	C	D	
12E2	Double D	30 +0.18/+0.10	22 +0.08/+0.03	-	-	50																			
18E2	Key	35 +0.18/+0.10	-	10.05 +0.05/0	39.4 +0.3/0	163	Double D	30 +0.18/+0.10	22 +0.08/+0.03	-	-	53													
45E2	Key	50 +0.18/+0.10	-	12.05 +0.05/0	54.5 +0.3/0	183	Key	35 +0.18/+0.10	-	10.05 +0.05/0	39.4 +0.3/0	65	Key	44.45 +0.18/+0.10	-	9.53 +0.05/0	48.82 +0.3/0	183							
73E2	Key	63.5 +0.18/+0.10	-	15.93 +0.08/0	70.6 +0.3/0	216	Key	50 +0.18/+0.10	-	12.05 +0.05/0	54.5 +0.3/0	68	Key	60 +0.18/+0.10	-	+0.12/+0.05	64.4 +0.2/0	216							
14E3	Key	76.2 +0.18/+0.10	-	19.1 +0.08/0	84.7 +0.3/0	240	Key	63.5 +0.18/+0.10	-	15.93 +0.08/0	70.6 +0.3/0	119	Key	60 +0.18/+0.10	-	+0.12/+0.05	64.4 +0.2/0	117							
24E3	Key	114.3 +0.18/+0.10	-	25.45 +0.08/0	122.6 +0.3/0	295	Key	101.6 +0.18/+0.10	-	25.45 +0.08/0	109.7 +0.3/0	162	Key	88.9 +0.18/+0.10	-	22.28 +0.08/0	95.7 +0.3/0	154	Key	80 +0.18/+0.10	-	22 +0.12/+0.07	85.4 +0.3/0	154	
45E3	Key	152.4 +0.18/+0.10	-	38.18 +0.1/0	162.9 +0.3/0	318	Key	127 +0.18/+0.10	-	31.85 +0.1/0	136.3 +0.3/0	175	Key	120 +0.18/+0.10	-	32 +0.18/+0.08	127.4 +0.2/0	170							
10E4	Key	177.8 +0.18/+0.10	-	44.5 +0.15/0.05	194.3 +0.3/0	402	Key	152.4 +0.18/+0.10	-	38.18 +0.1/0	162.9 +0.3/0	172													

17.0 SERIES 98/98H GENERAL SPECIFICATIONS AND FEATURES

GENERAL SPECIFICATIONS											
RANGE											
Model	ISO Mounting Base	Rated Torque		Spring End Torque Nm		Spring End Torque Lb-in		Maximum Stem Acceptance Diameter		Maximum Stem Height	Over Travel (on either side)
		Nm	Lb-in	Min	Max	Min	Max	mm	inch	mm	± degrees
12 E2	F07/F12	1,200	10,621	310	660	2,744	5,842	22 A/F	0.87 A/F	130	5
18 E2	F12	1,800	15,932	530	1,035	4,691	9,161	35.0	1.38	163	5
45 E2	F12/F16	4,500	39,830	1,070	2,675	9,471	23,676	50.0	1.97	183	5
73 E2	F12/F16	7,300	64,612	2,130	4,280	18,853	37,882	63.5	2.50	216	5
14 E3	F16/F25	14,000	123,914	3,485	7,845	30,846	69,436	76.2	3.00	240	5
24 E3	F25/F30	24,000	212,424	6,555	15,150	58,018	134,093	114.3	4.50	295	3
45 E3	F30/F35	45,000	398,295	11,950	25,595	105,769	226,541	152.4	6.00	318	3
10 E4	F35/F40	100,000	885,100	25,226	50,306	223,275	445,261	177.8	7.00	402	3
CONFIGURATIONS											
DA	Double Acting- Single Cylinder										
DD	Double Acting- Dual Cylinders										
SR-CW	Spring Return- Fail CW										
SR-CCW	Spring Return- Fail CCW										
Operating Conditions											
	S98 PNEUMATIC					S98H HYDRAULIC					
Pressure Range	S98 Pneumatic - 40 to 150 psig					S98H Hydraulic - 500 to 3000 psig					
Media	Dry Compressed Air/Inert/Natural Gas					Hydraulic Fluid - ISO VG 32/46, flash point>157°C					
Temperature Range - Standard Options	Standard : -20°F to 200°F (-29°C to 93°C)				PED and Non-PED	Standard	-20°F to 212°F (-29°C to 100 °C)			Non-PED	
	High Temp : Up to 300°F (149°C)						-20°F to 176°F (-29°C to 80 °C)			PED	
	Low Temp : Down to -50°F (-46°C)				Non-PED		Low Temp : Down to -50°F (-46°C)				
	Contact factory for extended range					Contact factory for extended range					
Compliances											
Torque Base	Mounting dimensions options per ISO 5211										
Accessories	Shaft Driven Accessories Mounting as per NAMUR-VDE										
Testing	In accordance with EN 15714-3:2009					In accordance with EN 15714-4 : 2009					
Ingress Protection	IP67M per IEC 60529					IP67M & IP68					
Safety	ATEX, SIL 3, PED										

18.0 SERIES 98 SEAL KITS AND REPAIR KITS

18.1 Series 98 Pneumatic Seal Kits

SEAL KIT & REPAIR KIT (Standard)									
MODEL	KIT	TORQUE MODULE	PRESSURE MODULE					SPRING MODULE	
12E2			5	6	7	8	9		
	Seal Kit	98-T10B-21900-560	98-P05B-21900-560	98-P06B-21900-560	98-P07B-21900-560	98-P08B-21900-560	98-P09B-21900-560		98-S00B-21900-560
	Repair Kit	98-T10B-21901-560	98-P05B-21901-560	98-P06B-21901-560	98-P07B-21901-560	98-P08B-21901-560	98-P09B-21901-560		98-S00B-21901-560
18E2			6	7	8	9	10		
	Seal Kit	98-T12C-21900-560	98-P06C-21900-560	98-P07C-21900-560	98-P08D-21900-560	98-P09D-21900-560	98-P10D-21900-560		98-S00B-21900-560
	Repair Kit	98-T12C-21901-560	98-P06C-21901-560	98-P07C-21901-560	98-P08D-21901-560	98-P09D-21901-560	98-P10D-21901-560		98-S00C-21901-560
45E2			8	9	10	12	14		
	Seal Kit	98-T15D-21900-560	98-P08D-21900-560	98-P09D-21900-560	98-P10D-21900-560	98-P12D-21900-560	98-P14D-21900-560		98-S00D-21900-560
	Repair Kit	98-T15D-21901-560	98-P08D-21901-560	98-P09D-21901-560	98-P10D-21901-560	98-P12D-21901-560	98-P14D-21901-560		98-S00D-21901-560
73E2			10	12	14	16			
	Seal Kit	98-T17E-21900-560	98-P10E-21900-560	98-P12E-21900-560	98-P14E-21900-560	98-P16E-21900-560			98-S00E-21900-560
	Repair Kit	98-T17E-21901-560	98-P10E-21901-560	98-P12E-21901-560	98-P14E-21901-560	98-P16E-21901-560			98-S00E-21901-560
14E3			12	14	16	18	20		
	Seal Kit	98-T18F-21900-560	98-P12F-21900-560	98-P14F-21900-560	98-P16F-21900-560	98-P18F-21900-560	98-P20F-21900-560		98-S00F-21900-560
	Repair Kit	98-T18F-21901-560	98-P12F-21901-560	98-P14F-21901-560	98-P16F-21901-560	98-P18F-21901-560	98-P20F-21901-560		98-S00F-21901-560
24E3			14	16	18	20	22	24	
	Seal Kit	98-T21G-21900-560	98-P14G-21900-560	98-P16G-21900-560	98-P18G-21900-560	98-P20G-21900-560	98-P22G-21900-560	98-P24G-21900-560	98-S00G-21900-560
	Repair Kit	98-T21G-21901-560	98-P14G-21901-560	98-P16G-21901-560	98-P18G-21901-560	98-P20G-21901-560	98-P22G-21901-560	98-P24G-21901-560	98-S00G-21901-560
45E3			18	20	22	24	28		
	Seal Kit	98-T23H-21900-560	98-P18H-21900-560	98-P20H-21900-560	98-P22H-21900-560	98-P24H-21900-560	98-P28H-21900-560		98-S00H-21900-560
	Repair Kit	98-T23H-21901-560	98-P18H-21901-560	98-P20H-21901-560	98-P22H-21901-560	98-P24H-21901-560	98-P28H-21901-560		98-S00H-21901-560
10E4			22	24	28	32	36		
	Seal Kit	98-T24J-21900-560	98-P22J-21900-560	98-P24J-21900-560	98-P28J-21900-560	98-P32J-21900-560	98-P36J-21900-560		98-S00J-21900-560
	Repair Kit	98-T24J-21901-560	98-P22J-21901-560	98-P24J-21901-560	98-P28J-21901-560	98-P32J-21901-560	98-P36J-21901-560		98-S00J-21901-560
SEAL KIT & REPAIR KIT (Low Temperature)									
MODEL	KIT	TORQUE MODULE	PRESSURE MODULE					SPRING MODULE	
12E2			5	6	7	8	9		
	Seal Kit	98-T10B-21900-5XA	98-P05B-21900-5XA	98-P06B-21900-5XA	98-P07B-21900-5XA	98-P08B-21900-5XA	98-P09B-21900-5XA		98-S00B-21900-5XA
	Repair Kit	98-T10B-21901-5XA	98-P05B-21901-5XA	98-P06B-21901-5XA	98-P07B-21901-5XA	98-P08B-21901-5XA	98-P09B-21901-5XA		98-S00B-21901-5XA
18E2			6	7	8	9	10		
	Seal Kit	98-T12C-21900-5XA	98-P06C-21900-5XA	98-P07C-21900-5XA	98-P08D-21900-5XA	98-P09D-21900-5XA	98-P10D-21900-5XA		98-S00B-21900-5XA
	Repair Kit	98-T12C-21901-5XA	98-P06C-21901-5XA	98-P07C-21901-5XA	98-P08D-21901-5XA	98-P09D-21901-5XA	98-P10D-21901-5XA		98-S00C-21901-5XA
45E2			8	9	10	12	14		
	Seal Kit	98-T15D-21900-5XA	98-P08D-21900-5XA	98-P09D-21900-5XA	98-P10D-21900-5XA	98-P12D-21900-5XA	98-P14D-21900-5XA		98-S00D-21900-5XA
	Repair Kit	98-T15D-21901-5XA	98-P08D-21901-5XA	98-P09D-21901-5XA	98-P10D-21901-5XA	98-P12D-21901-5XA	98-P14D-21901-5XA		98-S00D-21901-5XA
73E2			10	12	14	16			
	Seal Kit	98-T17E-21900-5XA	98-P10E-21900-5XA	98-P12E-21900-5XA	98-P14E-21900-5XA	98-P16E-21900-5XA			98-S00E-21900-5XA
	Repair Kit	98-T17E-21901-5XA	98-P10E-21901-5XA	98-P12E-21901-5XA	98-P14E-21901-5XA	98-P16E-21901-5XA			98-S00E-21901-5XA
14E3			12	14	16	18	20		
	Seal Kit	98-T18F-21900-5XA	98-P12F-21900-5XA	98-P14F-21900-5XA	98-P16F-21900-5XA	98-P18F-21900-5XA	98-P20F-21900-5XA		98-S00F-21900-5XA
	Repair Kit	98-T18F-21901-5XA	98-P12F-21901-5XA	98-P14F-21901-5XA	98-P16F-21901-5XA	98-P18F-21901-5XA	98-P20F-21901-5XA		98-S00F-21901-5XA
24E3			14	16	18	20	22	24	
	Seal Kit	98-T21G-21900-5XA	98-P14G-21900-5XA	98-P16G-21900-5XA	98-P18G-21900-5XA	98-P20G-21900-5XA	98-P22G-21900-5XA	98-P24G-21900-5XA	98-S00G-21900-5XA
	Repair Kit	98-T21G-21901-5XA	98-P14G-21901-5XA	98-P16G-21901-5XA	98-P18G-21901-5XA	98-P20G-21901-5XA	98-P22G-21901-5XA	98-P24G-21901-5XA	98-S00G-21901-5XA
45E3			18	20	22	24	28		
	Seal Kit	98-T23H-21900-5XA	98-P18H-21900-5XA	98-P20H-21900-5XA	98-P22H-21900-5XA	98-P24H-21900-5XA	98-P28H-21900-5XA		98-S00H-21900-5XA
	Repair Kit	98-T23H-21901-5XA	98-P18H-21901-5XA	98-P20H-21901-5XA	98-P22H-21901-5XA	98-P24H-21901-5XA	98-P28H-21901-5XA		98-S00H-21901-5XA
10E4			22	24	28	32	36		
	Seal Kit	98-T24J-21900-5XA	98-P22J-21900-5XA	98-P24J-21900-5XA	98-P28J-21900-5XA	98-P32J-21900-5XA	98-P36J-21900-5XA		98-S00J-21900-5XA
	Repair Kit	98-T24J-21901-5XA	98-P22J-21901-5XA	98-P24J-21901-5XA	98-P28J-21901-5XA	98-P32J-21901-5XA	98-P36J-21901-5XA		98-S00J-21901-5XA

SEAL KIT & REPAIR KIT (HIGH TEMPERATURE)									
MODEL	KIT	TORQUE MODULE	PRESSURE MODULE					SPRING MODULE	
12E2			5	6	7	8	9		
	Seal Kit	98-T10B-21900-5XB	98-P05B-21900-5XB	98-P06B-21900-5XB	98-P07B-21900-5XB	98-P08B-21900-5XB	98-P09B-21900-5XB		98-S00B-21900-5XB
	Repair Kit	98-T10B-21901-5XB	98-P05B-21901-5XB	98-P06B-21901-5XB	98-P07B-21901-5XB	98-P08B-21901-5XB	98-P09B-21901-5XB		98-S00B-21901-5XB
18E2			6	7	8	9	10		
	Seal Kit	98-T12C-21900-5XB	98-P06C-21900-5XB	98-P07C-21900-5XB	98-P08D-21900-5XB	98-P09D-21900-5XB	98-P10D-21900-5XB		98-S00B-21900-5XB
	Repair Kit	98-T12C-21901-5XB	98-P06C-21901-5XB	98-P07C-21901-5XB	98-P08D-21901-5XB	98-P09D-21901-5XB	98-P10D-21901-5XB		98-S00C-21901-5XB
45E2			8	9	10	12	14		
	Seal Kit	98-T15D-21900-5XB	98-P08D-21900-5XB	98-P09D-21900-5XB	98-P10D-21900-5XB	98-P12D-21900-5XB	98-P14D-21900-5XB		98-S00D-21900-5XB
	Repair Kit	98-T15D-21901-5XB	98-P08D-21901-5XB	98-P09D-21901-5XB	98-P10D-21901-5XB	98-P12D-21901-5XB	98-P14D-21901-5XB		98-S00D-21901-5XB
73E2			10	12	14	16			
	Seal Kit	98-T17E-21900-5XB	98-P10E-21900-5XB	98-P12E-21900-5XB	98-P14E-21900-5XB	98-P16E-21900-5XB			98-S00E-21900-5XB
	Repair Kit	98-T17E-21901-5XB	98-P10E-21901-5XB	98-P12E-21901-5XB	98-P14E-21901-5XB	98-P16E-21901-5XB			98-S00E-21901-5XB
14E3			12	14	16	18	20		
	Seal Kit	98-T18F-21900-5XB	98-P12F-21900-5XB	98-P14F-21900-5XB	98-P16F-21900-5XB	98-P18F-21900-5XB	98-P20F-21900-5XB		98-S00F-21900-5XB
	Repair Kit	98-T18F-21901-5XB	98-P12F-21901-5XB	98-P14F-21901-5XB	98-P16F-21901-5XB	98-P18F-21901-5XB	98-P20F-21901-5XB		98-S00F-21901-5XB
24E3			14	16	18	20	22	24	
	Seal Kit	98-T21G-21900-5XB	98-P14G-21900-5XB	98-P16G-21900-5XB	98-P18G-21900-5XB	98-P20G-21900-5XB	98-P22G-21900-5XB	98-P24G-21900-5XB	98-S00G-21900-5XB
	Repair Kit	98-T21G-21901-5XB	98-P14G-21901-5XB	98-P16G-21901-5XB	98-P18G-21901-5XB	98-P20G-21901-5XB	98-P22G-21901-5XB	98-P24G-21901-5XB	98-S00G-21901-5XB
45E3			18	20	22	24	28		
	Seal Kit	98-T23H-21900-5XB	98-P18H-21900-5XB	98-P20H-21900-5XB	98-P22H-21900-5XB	98-P24H-21900-5XB	98-P28H-21900-5XB		98-S00H-21900-5XB
	Repair Kit	98-T23H-21901-5XB	98-P18H-21901-5XB	98-P20H-21901-5XB	98-P22H-21901-5XB	98-P24H-21901-5XB	98-P28H-21901-5XB		98-S00H-21901-5XB
10E4			22	24	28	32	36		
	Seal Kit	98-T24J-21900-5XB	98-P22J-21900-5XB	98-P24J-21900-5XB	98-P28J-21900-5XB	98-P32J-21900-5XB	98-P36J-21900-5XB		98-S00J-21900-5XB
	Repair Kit	98-T24J-21901-5XB	98-P22J-21901-5XB	98-P24J-21901-5XB	98-P28J-21901-5XB	98-P32J-21901-5XB	98-P36J-21901-5XB		98-S00J-21901-5XB

NOTE: The Repair Kit includes the Seal Kit

18.2 Series 98 Hydraulic Seal Kits And Repair Kits

SEAL KIT & REPAIR KIT (STANDARD)									
MODEL	KIT	TORQUE MODULE	HYDRAULIC PRESSURE MODULE, mm					SPRING MODULE	
			32	40	50	63	80		
12E2	Seal Kit	98-T10B-21900-560							98-S00B-21900-560
	Repair Kit	98-T10B-21901-560		98H-040B-21900-0S0	98H-050B-21900-0S0	98H-063B-21900-0S0	98H-080B-21900-0S0		98-S00B-21901-560
18E2	Seal Kit	98-T12C-21900-560	40	50	63	80			98-S00B-21900-560
	Repair Kit	98-T12C-21901-560		98H-050C-21900-0S0	98H-063C-21900-0S0	98H-080C-21900-0S0			98-S00C-21901-560
45E2	Seal Kit	98-T15D-21900-560	50	63	80	100			98-S00D-21900-560
	Repair Kit	98-T15D-21901-560	98H-050C-21900-0S0	98H-063C-21900-0S0	98H-080C-21900-0S0	98H-100D-21900-0S0			98-S00D-21901-560
73E2	Seal Kit	98-T17E-21900-560	50	63	80	100	125		98-S00E-21900-560
	Repair Kit	98-T17E-21901-560	98H-050E-21900-0S0	98H-063E-21900-0S0	98H-080E-21900-0S0	98H-100E-21900-0S0	98H-125E-21900-0S0		98-S00E-21901-560
14E3	Seal Kit	98-T18F-21900-560	63	80	100	125	140	160	98-S00F-21900-560
	Repair Kit	98-T18F-21901-560	98H-063F-21900-0S0	98H-080F-21900-0S0	98H-100F-21900-0S0	98H-125F-21900-0S0	98H-140F-21900-0S0	98H-160F-21900-0S0	98-S00F-21901-560
24E3	Seal Kit	98-T21G-21900-560	80	100	125	140	160	180	98-S00G-21900-560
	Repair Kit	98-T21G-21901-560	98H-080G-21900-0S0	98H-100G-21900-0S0	98H-125G-21900-0S0	98H-140G-21900-0S0	98H-160G-21900-0S0		98-S00G-21901-560
45E3	Seal Kit	98-T23H-21900-560	100	125	140	160	180	200	98-S00H-21900-560
	Repair Kit	98-T23H-21901-560			98H-140H-21900-0S0			98H-200H-21900-0S0	98-S00H-21901-560
10E4	Seal Kit	98-T24J-21900-560	125	140	160	180	200	220	98-S00J-21900-560
	Repair Kit	98-T24J-21901-560			98H-160J-21900-0S0	98H-180J-21900-0S0	98H-200J-21900-0S0		98-S00J-21901-560

SEAL KIT & REPAIR KIT (LOW TEMPERATURE)									
MODEL	KIT	TORQUE MODULE	HYDRAULIC PRESSURE MODULE, mm					SPRING MODULE	
12E2	Seal Kit	98-T10B-21900-5XA	32	40	50	63	80	98-S00B-21900-5XA	
	Repair Kit	98-T10B-21901-5XA		98H-040B-21900-0LO	98H-050B-21900-0LO	98H-063B-21900-0LO	98H-080B-21900-0LO		
18E2	Seal Kit	98-T12C-21900-5XA	40	50	63	80	98-S00C-21901-5XA		
	Repair Kit	98-T12C-21901-5XA		98H-050C-21900-0LO	98H-063C-21900-0LO	98H-080C-21900-0LO			
45E2	Seal Kit	98-T15D-21900-5XA	50	63	80	100	98-S00D-21900-5XA		
	Repair Kit	98-T15D-21901-5XA	98H-050C-21900-0LO	98H-063C-21900-0LO	98H-080C-21900-0LO	98H-100D-21900-0LO			
73E2	Seal Kit	98-T17E-21900-5XA	50	63	80	100	125	98-S00E-21900-5XA	
	Repair Kit	98-T17E-21901-5XA	98H-050E-21900-0LO	98H-063E-21900-0LO	98H-080E-21900-0LO	98H-100E-21900-0LO	98H-125E-21900-0LO		
14E3	Seal Kit	98-T18F-21900-5XA	63	80	100	125	140	160	98-S00F-21900-5XA
	Repair Kit	98-T18F-21901-5XA	98H-063F-21900-0LO	98H-080F-21900-0LO	98H-100F-21900-0LO	98H-125F-21900-0LO	98H-140F-21900-0LO	98H-160F-21900-0LO	
24E3	Seal Kit	98-T21G-21900-5XA	80	100	125	140	160	180	98-S00G-21900-5XA
	Repair Kit	98-T21G-21901-5XA	98H-080G-21900-0LO	98H-100G-21900-0LO	98H-125G-21900-0LO	98H-140G-21900-0LO	98H-160G-21900-0LO		
45E3	Seal Kit	98-T23H-21900-5XA	100	125	140	160	180	200	98-S00H-21900-5XA
	Repair Kit	98-T23H-21901-5XA			98H-140H-21900-0LO		98H-200H-21900-0LO		
10E4	Seal Kit	98-T24J-21900-5XA	125	140	160	180	200	220	98-S00J-21900-5XA
	Repair Kit	98-T24J-21901-5XA			98H-160J-21900-0LO	98H-180J-21900-0LO	98H-200J-21900-0LO		

NOTE:

1. For Hydraulic Pressure Module Seal and Repair Kits are same.
2. The Repair Kit includes the Seal Kit

19.0 HYDRAULIC OVERRIDE ON S98 PNEUMATIC ACTUATORS

Hydraulic overrides on S98 actuators provide low effort, high thrust in a compact size for manually operating the actuator. The hydraulic override cylinders are single acting on the SR models and double acting on the DA models of the Actuators. These are available on Models 73E2 through 10E4.

The hydraulic override consists of a power pack with a hand operated high pressure pump and oil reservoir connected by steel tubing to the hydraulic override cylinder. The hydraulic cylinder is mounted on the Spring Module end thrust base on SR models and on the Torque Module flange on the DA models.

The hydraulic override cylinders provide adequate thrust to output the required valve torque. The operating pressure required is set on the hand pump assembly through a built-in relief valve.

19.1 Installation

Series 98 standard actuators with hydraulic overrides are shipped pre-assembled with the cylinder, hand pump, bypass valves and tubing complete. The hand pump unit is selected, factory installed and the hydraulic pressure valve set per the application. No additional customer installation/adjustment is usually required.

Actuators in service, without this override option, can be retrofitted with the override kit as described below.

19.1.1 Installing Hydraulic Override on Spring Return Actuators

1. Disconnect air pressure and electrical power from actuator.
2. In fail safe position of the actuator, remove the end cover plate retaining the O-ring on the End Cap.
3. Firmly thread the studs (10) supplied with the override mounting kit, into the thrust base. With the piston rod fully retracted, insert the Hydraulic Cylinder into the Spring Module positioning the air venting plug at the top.
4. Secure the cylinder flange on the thrust base of the Spring Module with the spring washers and nuts from the override mounting kit.
5. Thread in the hydraulic connector into the cylinder port (if not already fitted into the cylinder). Use a commercial hydraulic fitting thread sealant (Loctite 542 or equivalent).
6. Fit a 3-way valve, rated for 150 psi (10.3 bar) working pressure, to the pneumatic module's port (Refer to Fig. 3). Turn the valve to venting position so that the pneumatic cylinder's port is connected to atmosphere.
7. Fit the hydraulic hand pump assembly bracket on the rear accessories mounting pad of the Torque Module with the 4 bolts supplied in the kit. Tube the cylinder port to the pump outlet port, as in Fig. 3. The standard mounting, as shown, is for the actuator in horizontal orientation. Special brackets for other orientations of the actuator can be supplied upon request.

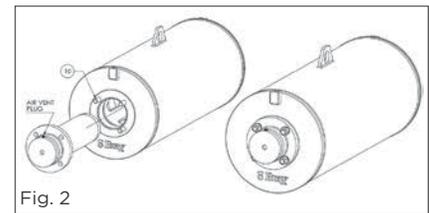


Fig. 2

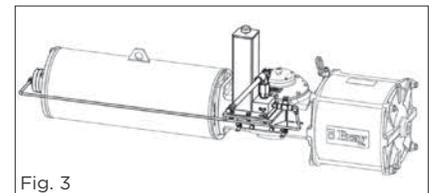


Fig. 3

8. On the Tee fitting at the pump outlet, remove the plug and install a suitable pressure gage (0-4000psi).
9. Remove the filler-breather cap and fill the reservoir till about 1-2" from the top with hydraulic fluid (refer to Section 25 Appendix B - Lubricants). Install the breather cap on the reservoir (do not substitute the breather cap with a plug). Stroke the pump a few times with the pressure release valve on the pump open, to bleed air out of pump.
10. Lightly loosen the air vent screw on the cylinder flange to bleed off air from the hydraulic lines. Close the pressure release valve on the pump and stroke the hydraulic pump till the pressure builds up. Tighten the vent plug when no more air bubbles bleed out. The piston rod advances to press against the Spring Rod's end face and the thrust from the hydraulic pressure effects the override function.
11. Note the maximum hydraulic pressure setting for the actuator model (refer to the SR Hydraulic MOP table). Check the hydraulic pressure on the gage at the end of the actuator's stroke. Refer to the hand pump service manual and adjust the overload valve setting on the pump to the MOP.

MOP for SR Hydraulic Overrides						
Model	MOP	Spring Number				
		1	2	3	4	5
73 E2	psi	1585	1880	2425	2740	
	bar	109	130	167	189	
14 E3	psi	1325	1520	1770	2260	2705
	bar	91	105	122	156	187
24 E3	psi	1290	1530	1950	2260	2595
	bar	89	105	134	156	179
45 E3	psi	1185	1415	1615	1855	2155
	bar	82	98	111	128	149
10 E4	psi	2465	3005	3630	4400	
	bar	170	207	250	303	

19.1.2 Operation - Spring Return Hydraulic Override

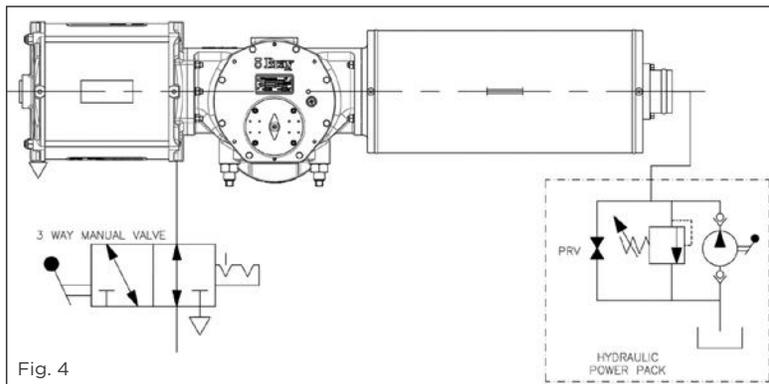


Fig. 4

1. To operate the override, turn the 3/2 way valve on the pressure module to vent the cylinder port to atmosphere and Close the pressure release valve (PRV) on the hand pump manifold. Operating the Hand Pump on the power pack extends the Hydraulic cylinder's piston rod and pushes the Spring Rod while compressing the spring and operates the actuator manually.
2. Opening the pressure release valve relieves the hydraulic pressure to reservoir. The spring returns the piston rod of override cylinder to retracted position and the actuator to fail safe position.
3. To restore normal pneumatic operation, turn the pressure release valve to full Open and switch the 3/2 way valve on pneumatic cylinder, to connect the cylinder port to the air supply pressure.

19.2 Installing Hydraulic Override on DA Actuator

1. Apply pressure to cap end port to turn the actuator's yoke so that the guide block is at the cover end side of the Torque Module and ensure it stays in this position after disconnecting air pressure and electrical power from actuator.
2. Remove the DA cover from the torque module and mount the DA hydraulic override cylinder assembly with the hardware supplied in mounting kit. Make sure to install the O-ring on the mounting flange.
3. If the hydraulic cylinder has no plug on the end cap's outer face, then remove the hydraulic cylinder's tie rod nuts and the end cap without disturbing the cylinder barrel. With a suitable socket/tube spanner located on the hex head at the piston end, thread and tighten the piston rod into the threading on Guide Block (inside the Torque Module). Refer to the table below for tightening torque. On designs with a plug on end, remove plug and use Allen Key or a square drive.

Hydraulic Piston Rod Tightening Torque		
Model	Torque	
	Lb-ft	Nm
73 E2	163	220
14 E3	203	275
24 E3	203	275
45 E3	284	385
10 E4	369	500

4. Replace the end cap, taking care not to damage the cap seal, and tighten the tie rod nuts of the hydraulic cylinder.

Hydraulic Cylinder Tie Rod Nut Tightening Torque		
Nut Size	Torque	
	Lb-ft	Nm
M16	66	90
M20	155	210
M24	302	410
M30	627	850
M36	749	1015

5. Install the 3-way valves, rated for 150 psi (10.3 bar) working pressure, on the pneumatic cylinder ports (Refer to Fig. 5) and turn them to venting position.
6. Mount the hydraulic pump assembly on the Torque Module's rear accessories pad, as described in previous section.
7. Tube the ports of the hydraulic cylinder to the direction control valve's ports, on the hydraulic hand pump unit. (Refer to Fig. 5) Fill the reservoir with clean hydraulic fluid, till about 1-2" from the top. Fit back the filler-breather cap.

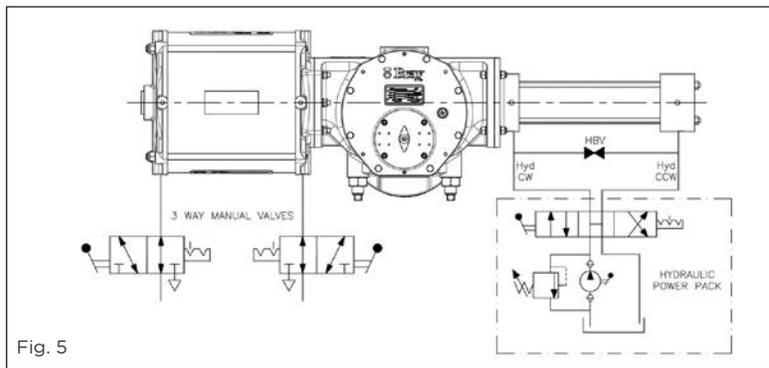


Fig. 5

8. Turn the direction control valve on the hand pump unit to direct oil flow to one of the cylinder ports. Loosen the corresponding vent plug on the cylinder and stroke the hand pump to vent out air in the lines. Tighten the vent plug when no more air bubbles are seen. Repeat the same for the other side of the cylinder.
9. Check and ensure the Hydraulic pressure setting of the pump does not exceed the MOP setting, refer to the table on DA Hydraulic MOP. Use the plugged port on the pressure line Tee to connect a suitable pressure gage. Set the pump relief valve to the MOP, at the stroke end.

MOP for DA Hydraulic Overrides		
Model	MOP	
73 E2	psi	1935
	bar	133
14 E3	psi	2000
	bar	138
24 E3	psi	2090
	bar	144
45 E3	psi	2005
	bar	138
10 E4	psi	2130
	bar	147

19.2.1 Operation - DA Hydraulic Override

1. For Manual Override operation, turn the 3-way valves on the pressure module to vent the cylinder ports to atmosphere and close the hydraulic bypass valve, (HBV). Turn the lever on the direction control valve on the hand pump unit to select the direction of the actuator rotation and stroke the hand pump to reach the required valve position.
2. To restore pneumatic operation, turn the direction control valve to center position, the HBV to Open position and switch the vent valves to connect the cylinder ports to the air supply lines.



Over thrust by the hydraulic override may cause actuator damage. Prevent unsafe conditions and damage by adjusting the overload valve on the pump to limit the hydraulic pressure as per the MOP tables.

19.3 Maintenance of Hydraulic Override

The hydraulic system may require servicing only when testing the system indicates no build up of pressure or the cylinder seals leak.

19.3.1 Spring Return Hydraulic Override Cylinder

Leakage of hydraulic fluid past the piston seal can be a cause for failure to hold the position when operating the override. Leakage can be confirmed if oil can be seen dripping out of the weep hole on the cylinder.

19.3.2 Disassembly of Hydraulic Cylinder

Ensure the hydraulic cylinder seal kit is on hand before disassembling the cylinder.

1. Disconnect the air pressure and the electrical power from the actuator and ensure the actuator turns to the fail safe position.
2. Disconnect the hydraulic tubing from the override cylinder port.

3. Remove the nuts and spring washers from the studs (10) holding the cylinder flange on the Spring Module end.
4. Pull the cylinder out of the Spring Module and inspect for leakage from the weep hole at the rod end. Proceed to replace seals if leakage is confirmed.
5. Secure the cylinder, loosen and remove the rod end guide nut.
6. Pull the piston assembly out of the cylinder.

19.3.3 Servicing Hydraulic Cylinder

1. Remove the old seal and wear rings from the piston and thoroughly clean the cylinder and piston assembly.
2. Replace the u-cup seal and wear ring on the piston with new ones. Lubricate the seal and the wear ring with clean hydraulic fluid and carefully slide the piston into the cylinder.
3. Replace the seals and guide bushing on the rod side nut and install the nut.
4. Flush clean the oil tank and tubing, fill fresh hydraulic fluid and re-mount the cylinder on the Spring module, connect the tubing and vent out the air from the line, as described in the Installation Section.
5. Operate the hydraulic override to test for correct operation.

19.4 DA Override Cylinder

19.4.1 Disassembly of Hydraulic Cylinder

1. Operate the actuator so that the hydraulic cylinder piston is at the cap end side.
2. Shift the direction control valve on the hand pump unit to mid position, disconnect the air pressure and the electrical power from actuator and ensure it stays in this position.
3. Disconnect the hydraulic tubing from the cylinder ports
4. Remove the tie rod nuts off the hydraulic cylinder and pull the end cap off the barrel.
5. With a socket spanner located on the hex head of the hydraulic cylinder's piston, loosen and disengage the piston rod from the Guide Block in the Torque Module.
6. Remove the fasteners holding the hydraulic cylinder's flange on the Torque Module end.
7. Take the cylinder assembly off the Torque Module.

19.4.2 Servicing Hydraulic Cylinder

1. Drain the oil from the rod side of the cylinder and pull the barrel with the piston and the piston rod out of the cylinder head.
2. Pull the barrel off the piston, remove the old seals and wear band. Thoroughly wash/clean all parts.
3. Inspect the barrel and the piston for any damage or scoring. Repair/replace any damaged parts.

4. Replace the seals, wear rings, guide bushings, o-rings on the cylinder head and end caps. Reassemble the cylinder and install it on the Torque Module as described in the Installation Section.
5. Flush clean the hydraulic fluid reservoir and tubing. Fill fresh fluid to required level before testing the operation of the override as described in installation section.

19.5 Servicing Hand Pump Unit

Refer to the hand pump unit manufacturer's service manual for maintenance instructions.

20.0 JACKSCREW OVERRIDE

Jackscrews provide an economical manual override option on the actuator for use in case of air failure. These jackscrews come in two types, direct hand wheel operated and bevel gearbox driven.

The direct hand wheel jackscrew has a rotating screw threading into a bronze nut when installed on the Torque module of DA actuators and on the Spring module of Spring Return actuators. The hand wheel directly turns the screw or nut to move the jackscrew forward or back.

The bevel gearbox driven jackscrews are required to reduce the manual effort on larger actuator models and stiffer springs that require higher thrust to compress. Here the screw translates with an anti-rotation arrangement.

20.1 Installation

Jackscrew overrides are usually factory installed on the actuator. Override units are shipped with the jackscrew assembly installed on the actuator so that the actuator is ready for installation in the auto operation mode. No additional customer installation is required.

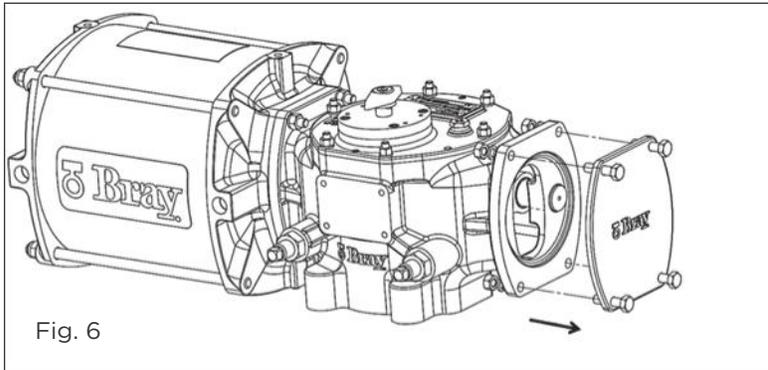
If a field retrofit is required on actuators without a manual override, the installation instructions provide a guide for a qualified technician to install and operate the Jackscrew overrides.

NOTICE

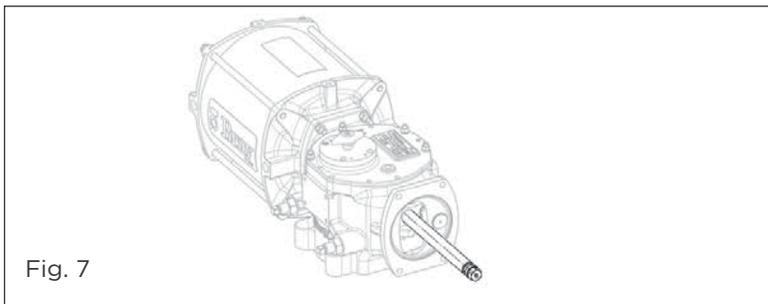
The jackscrew override and the procedure to install is the same on the S98H Hydraulic actuator.

20.1.1 Installing DA Jackscrew Override

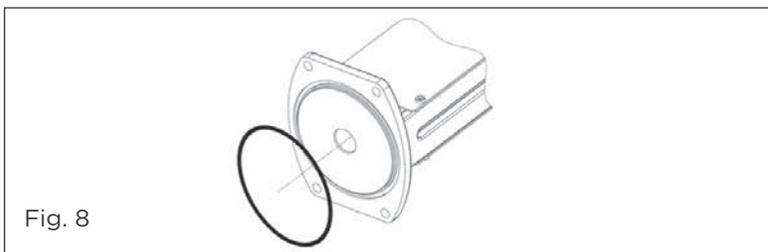
1. Disconnect the air pressure and the electrical power from actuator.
2. Remove the DA end cover from the actuator.



3. Free the Extension Rod from the Jackscrew assembly, apply a drop of medium strength thread lock compound on the extension rod threads and firmly tighten it into the threading in the Guide Block inside the Torque Module. Refer to the piston rod tightening torque table under Section 19.2.



4. Coat the extension rod with NLGI2 grease.
5. Lubricate and place the flange O-ring into the groove on the jackscrew assembly flange.



6. Back off the jackscrew fully in the assembly and carefully slide the mounting flange of the jackscrew assembly on the extension rod. Take care in locating the bushing and the flange seal on the extension rod.

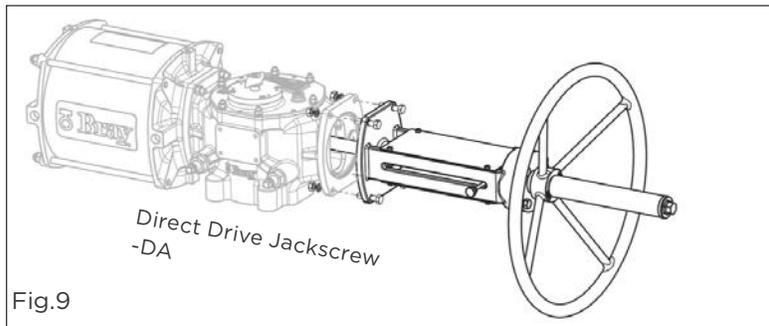


Fig. 9

7. Slide the assembly to locate and mate the flanges. Use the hardware supplied in the kit to fasten the assembly to the Torque Module flange.

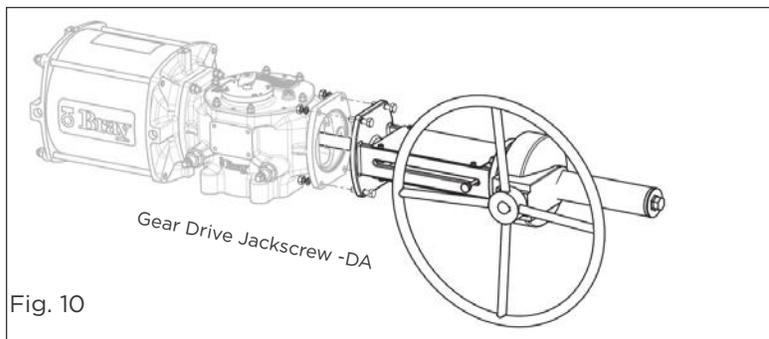
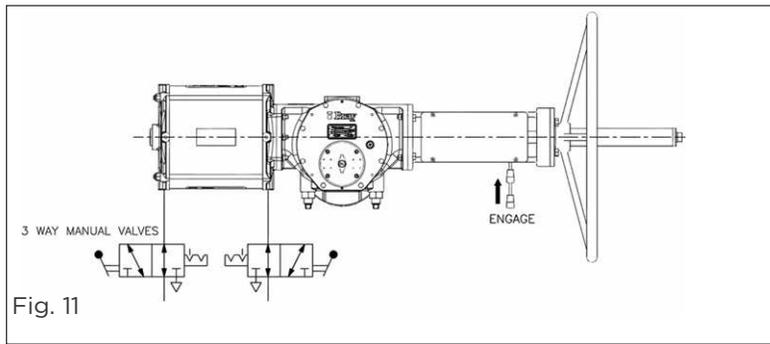


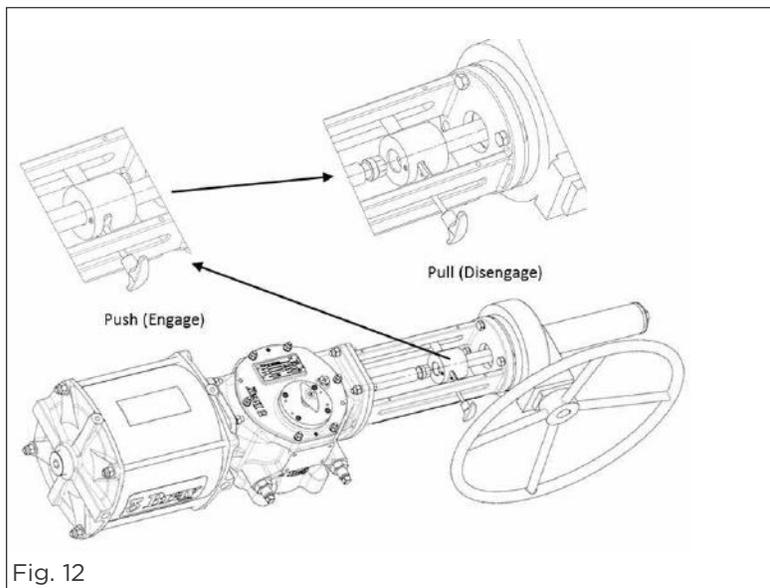
Fig. 10

8. Above depicted is default Gear Drive assembly. To re-orient gear box and handwheel to suit the site condition, unfasten the mounting nuts and lock washers of gear box, pull the gear box assembly outwards, to have mounting studs clear the flange. If studs don't clear off the mounting flange, turn the handwheel to advance the jack screw outwards to provide sufficient gap. Rotate the gear box assembly as required and reassemble in the new orientation.
9. Install suitable size 3/2 manual valves on the pneumatic cylinder's ports, which will either connect the ports to the air supply or vent them to atmosphere. The ports must be vented when operating the manual override (Refer to Fig. 11). On the S98H, the direction control valve's de-energized state shall be such that both cylinder ports connect to hydraulic oil tank (A&B to T spool configuration)



20.1.2 Operating DA Jackscrew Override

1. To test / operate the override, shut off the main air supply and turn the 3 position valves on the pneumatic cylinder ports to vent the ports to atmosphere. On the S98H hydraulic actuators, ensure the direction control valve is de-energized to let both ports connect to the tank line.



2. Turn the hand wheel on the jackscrew assembly to move the screw forward, until it touches the extension rod's end.
3. Push the T-handle into the jackscrew head to couple it with the extension rod.
4. Turn the hand wheel to turn the actuator in required direction (see direction markers on the hand wheel).
5. After completing the manual override stroke, disengage the coupler by pulling out the T-handle. Back off the jackscrew completely before restoring pneumatic operation.

NOTICE

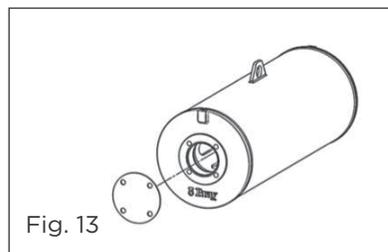
The jackscrew is not designed as an extended travel stop. It must be taken to fully backed-off position for the actuator to work normally in automatic mode. Turn the 3 position valves to connect the air supply to restore automatic operation.

CAUTION

The extension rod moves back and forth in normal operation. Do not remove any protective covers on the DA jackscrew assembly without ensuring the air supply is cut off and that the automatic operation of actuator is disabled.

20.2 Installing SR Jackscrew Override

1. Disconnect the air pressure and the electrical power from actuator and ensure the actuator is at its fail safe position.
2. Remove the end cover on the Spring module. Retain/replace the cover O-ring.



3. Apply a drop of thread lock compound on the mounting stud threads and firmly tighten them into the spring module end cap.



4. Back off the jackscrew fully in the assembly and mount the jackscrew assembly on the spring module end cap thrust base.

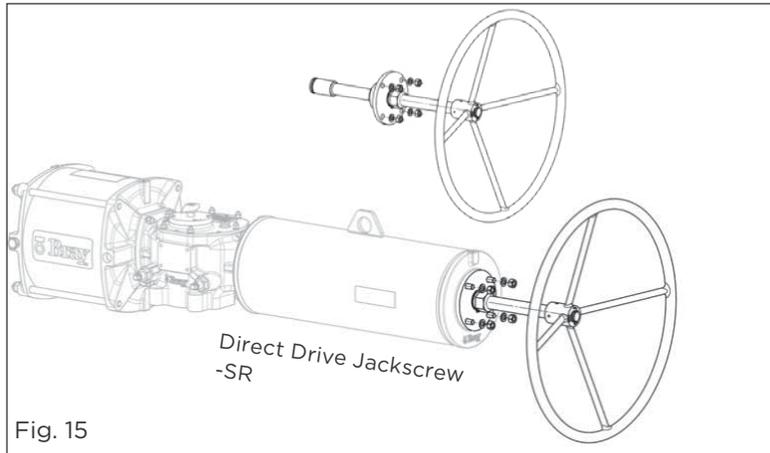


Fig. 15

5. Locate the Jackscrew assembly flange into the studs and fasten with the supplied nuts and lock washers.
6. To re-orient the Gear box and handwheel to suit the site condition, unfasten the mounting nuts and lock washers of Gear drive Module assembly, pull Module off the studs, rotate the Gear drive Module assembly as required and reassemble in the new orientation.

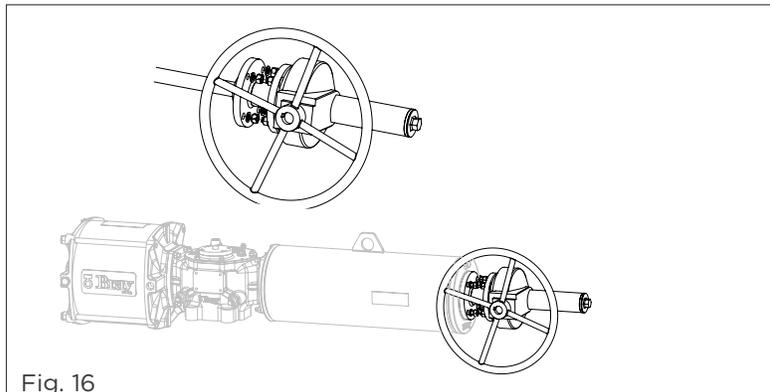
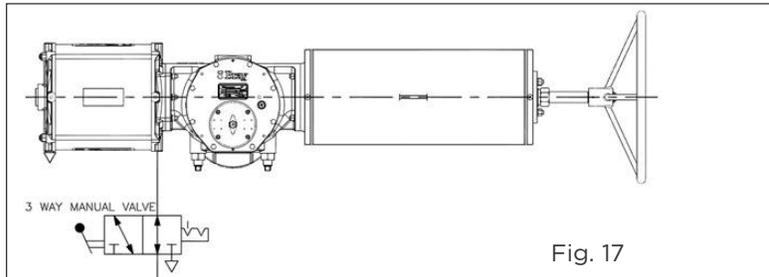


Fig. 16

7. Install a suitable 3 position manual valve to the pneumatic cylinder's rod end port (Refer to Fig. 17).



20.2.1 Operating SR Jackscrew Override

1. To test / operate the override, shut off the main air supply and turn the 3 position valve on the cylinder port to vent the cylinder port to atmosphere. The actuator should move to its fail safe position.
2. Turn the hand wheel on the jackscrew to advance the screw into the spring module (see direction markers on the hand wheel).
3. Resistance will be felt when the thrust head of the jackscrew touches the end of the spring rod.
4. Turning the hand wheel further will compress the spring and simultaneously turn the actuator.

NOTICE

The spring constantly loads on the jackscrew and returns the actuator to fail safe state when the jackscrew is retracted. Bring the actuator to fail safe position and turn the 3 position valve on cylinder port to connect to air supply to restore auto operation mode.

CAUTION

Never disassemble the Jackscrew assembly with the spring load on the screw. Severe injuries/damage can result due to non-compliance.

Retract the jackscrew completely to free the load, before attempting any maintenance on the assembly.

21.0 EXTENDED STOPPERS

Extended Stoppers allow restriction of the actuator rotation angle higher than the travel stops provided on the Torque Module. These Extended Stoppers modules fit on the Torque Module for single cylinder double acting actuators and on the Spring Module for the spring return actuators.

The standard extended stops restrict the linear stroke of the Guide Block to provide the rotation adjustment up to 45 degrees from the end. A 90 degree extended stop is an option.

21.1 Installation

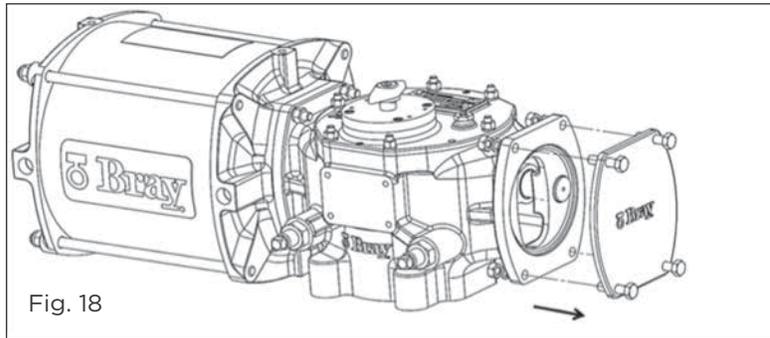
Extended Stoppers are usually factory installed on the actuator and adjusted to the angle per customer's requirement if supplied as a valve-actuator package. If supplied as fitted on stand-alone actuator then the stoppers are backed off fully, to permit installation at site on the valve and they must be adjusted after installation.

If a field retrofit is required on actuators without the extended stopper, the installation instructions provide a guide for a qualified technician to install and adjust them.

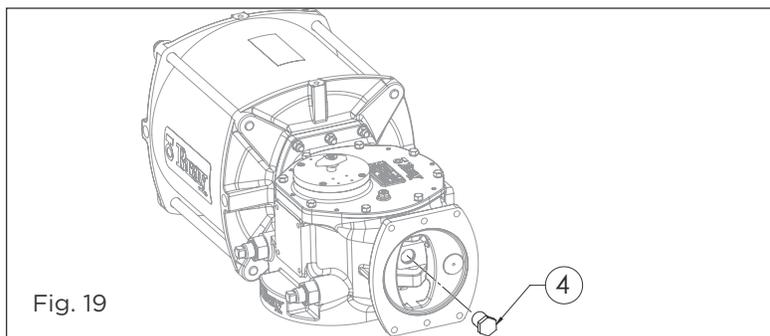
21.1.1 Installing Extended Stopper for Torque Module

This Extended Stopper module is installed only on Single Cylinder DA actuators. The installation is essentially the same on the S98H Hydraulic actuator.

1. Disconnect the air pressure and the electrical power from actuator.
2. Remove the DA end cover from the actuator.

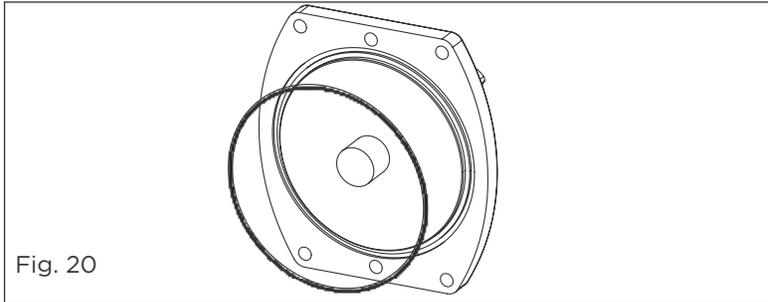


3. Clean threads on the Guide Block.
4. Apply medium strength thread lock compound to the threads of the Bolt (4) and thread it into the Guide Block and tighten to lock the Bolt on the Guide Block face.

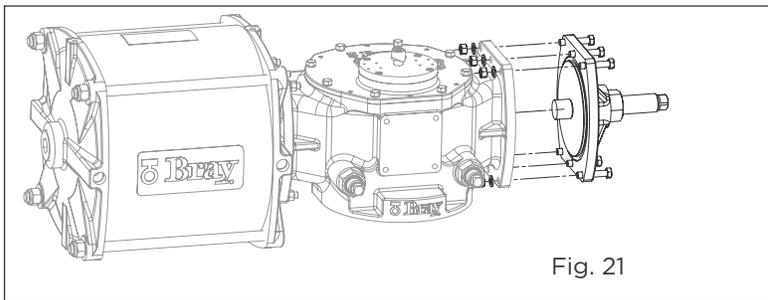


5. Loosen the Lock Nut and back off the Extended Stopper in the assembly.

6. Lubricate and locate the flange O-ring in the groove on the assembly's flange and mount the assembly on the torque module.

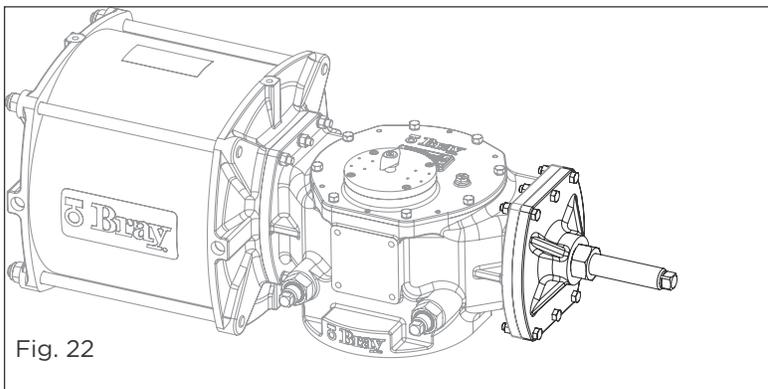


7. Secure the assembly with the mounting bolts, nuts and lock washers from the mounting kit.



21.1.2 Adjusting Extended Stopper

Connect air supply to the rod end side port of the pneumatic cylinder, adjust the extended stopper screw to required position, and reverse the actuator direction to stop movement by the extended stopper. Confirm position and tighten the seal-nut to lock the position.



NOTICE

The Extended Stopper is not designed as a jackscrew. Do not use this to manually override the actuator. Always adjust the stopper with no load on it.

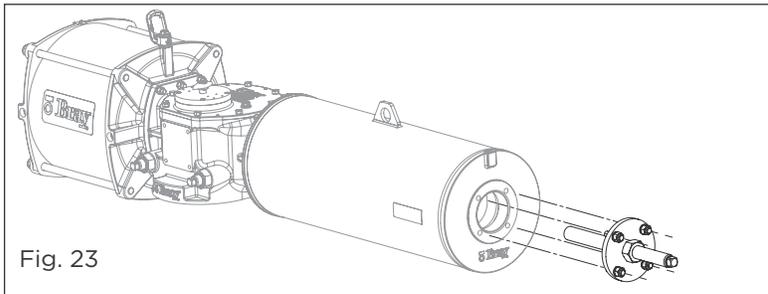
 **WARNING**

Never remove the assembly fasteners without first backing off the Extended Stopper fully to release any load on it.

21.2 Installing Extended Stopper for Spring Module

This Extended Stopper module is installed on Spring Module's thrust base.

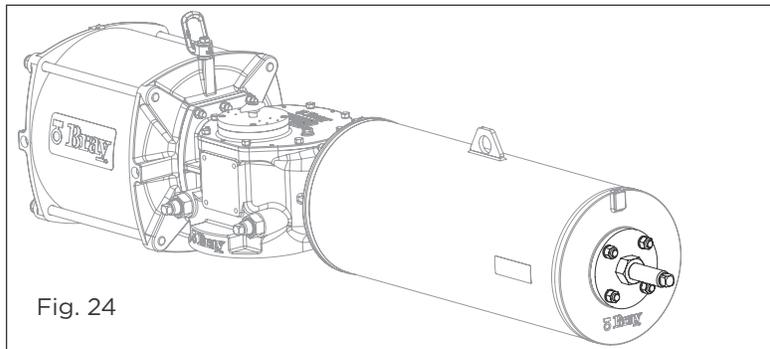
1. Disconnect air pressure and any electrical power from actuator.
2. Remove the end cover on the Spring Module.
3. Thread in and tighten the studs from the mounting kit, into the Spring Module thrust base. Use thread lock (Loctite 242 or equivalent). Locate the end cover O-ring in the groove.
4. Back off the stopper bolt and mount the Extended Stopper assembly on the Spring Module end cap.



5. Tighten the nuts with spring washers; refer to Table 10.4 for tightening torque for the nut size.

21.2.1 Adjusting Extended Stopper

1. Connect air supply to the rod end side (Adaptor) port of the pneumatic cylinder; tighten the extended stopper screw to approximately required position. Release air so that the actuator will reverse direction by the spring action and stop against the extended stopper. Repeat to get to final position.
2. Confirm position and tighten the seal-nut to lock the position.



NOTICE

The Extended Stopper is not designed as a jackscrew. Do not use this to manually override the actuator. Always adjust the stopper with no load on it.

WARNING

Never remove the assembly fasteners without first backing off the Extended Stopper fully to release the spring load on it.

22.0 HYDRAULIC DAMPER

In fast stroking applications, S98 Pneumatic actuators use a hydraulic damper to slow down the stroke, to avoid the valve disc slamming against the seat and the impact damages to the actuator that may otherwise result. The hydraulic damper on S98 is also modular in construction and can be added on to the standard actuator, without any modifications to the basic actuator. Installation is set for approximately the last 15 to 20 degrees of the rotation, reducing the linear speed of the actuator's members when the damper comes into action. The position, and on most models, the dampening rate too is adjustable to fine tune it to the requirement.

The hydraulic damper module mounts on the free end flange of Torque Module in DA actuators and on the end cap of the Spring Module in SR actuator.

Note: A damper can be mounted only if no other accessory / manual override, such as an extended stopper, jack screw or hydraulic manual override is already mounted.

The Hydraulic Damper assembly consists of the damper unit, the damper housing, lock nut, O-ring seal, End cover and the mounting fasteners.

22.1 Installing the Hydraulic Damper on a DA actuator

NOTICE

The damper module installation and adjustment shall be carried out only after the valve-actuator assembly has been first set for proper seating of valve closure element (disc/ball/plug) by the actuator's travel stops.

In case of a stand- alone actuator having been supplied with a hydraulic damper module pre-installed, the damper module may need to be taken off for proper adjusted per below procedure, after the actuator is installed on the valve.

1. With the actuator at clockwise travel end position, depressurize the actuator and remove the DA cover (52) by unfastening the bolts (51).

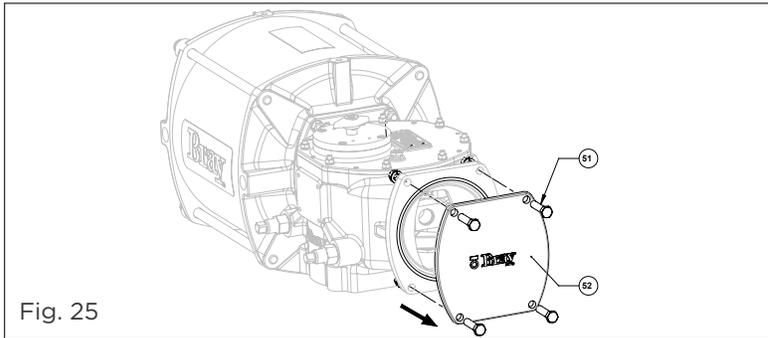


Fig. 25

2. Thread in the extension rod (6) into the guide block threads and torque it to values as for piston rod, on table 13.1.b. Measure distance 'Y' from the flange face to the extension rod end.

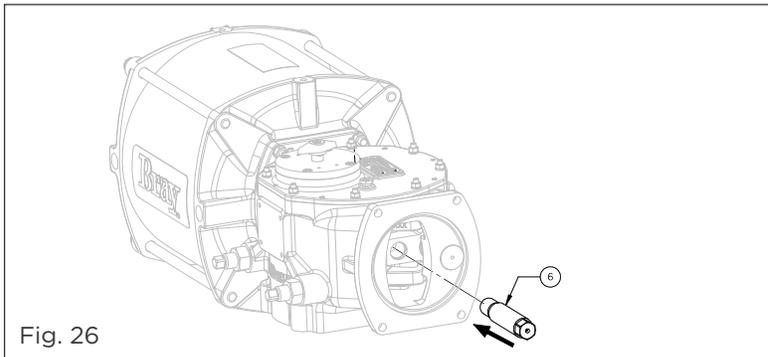


Fig. 26

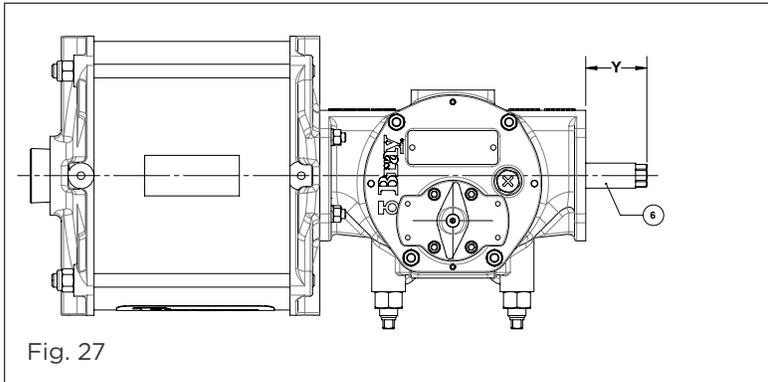


Fig. 27

3. For the body threaded type of dampers, unscrew and remove the tubular cover (5). Slacken the ring lock nut (3) and turn the damper unit (2) in the housing (1) to set the length 'L'.

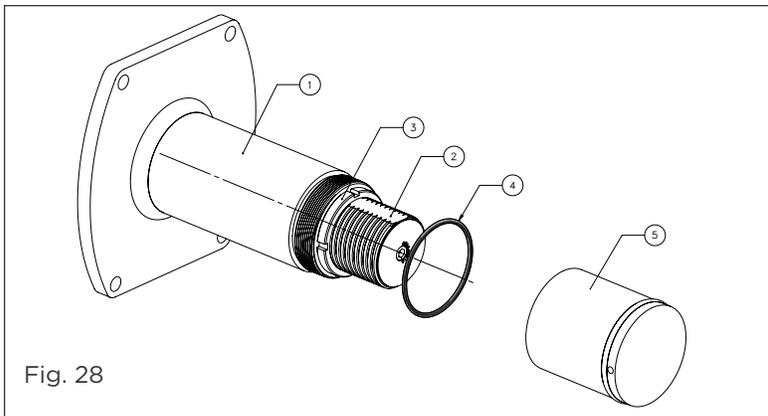


Fig. 28

For the end threaded type of dampers, slacken the lock screws (14) and loosen the lock nut (3) to turn the damper (2) in the housing (1).

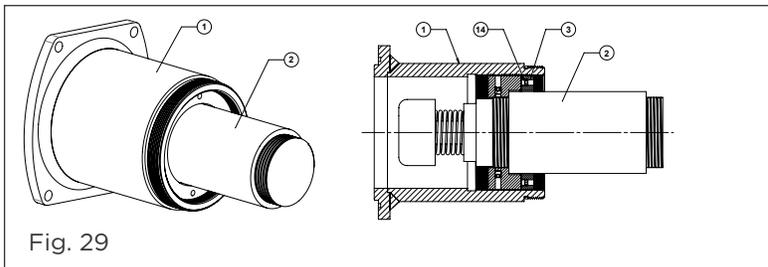
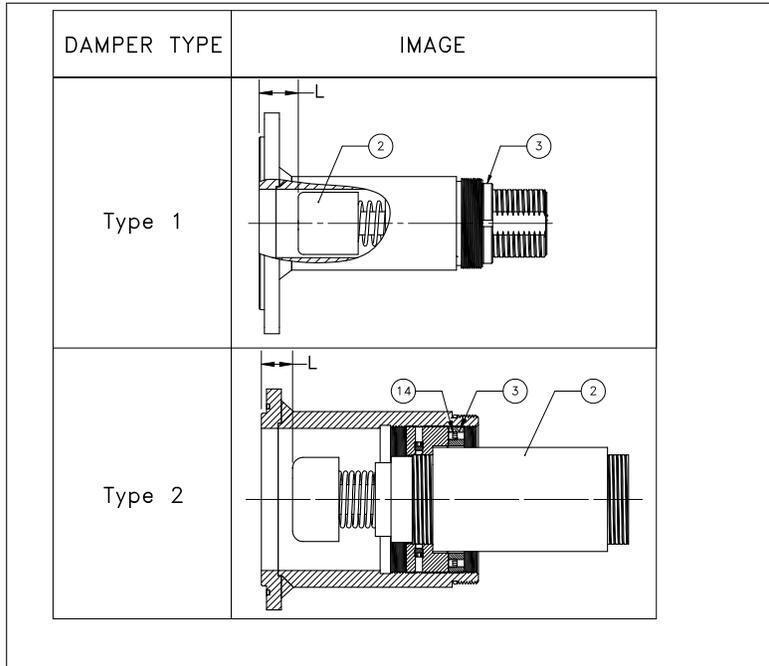


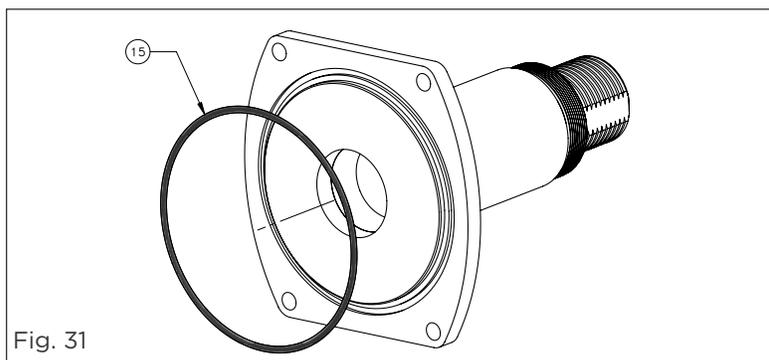
Fig. 29

4. Set the length 'L' per the below table and lock the setting with the lock nut (3) or lock screws (14).



Actuator Size	Setting Length L, mm
12E2	L = Y-37
18E2	L = Y-37
45E2	L = Y-37
73E2	L = Y-35
14E3	L = Y-35
24E3	L = Y-35
45E3	L = Y-35

- Lubricate and locate the O-ring (15) in the groove on the module flange face.



- Operate the actuator counterclockwise, if necessary, with low pressure air to mount the damper module on the torque module end flange with the supplied fasteners and torque them to valves on the fasteners tightening torque table.

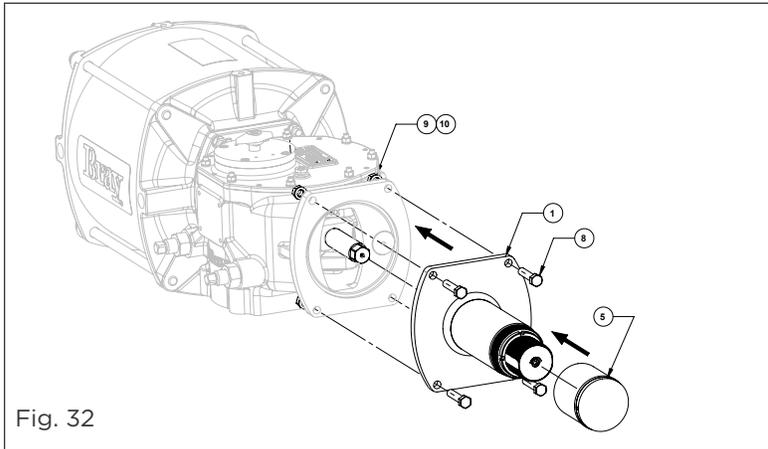


Fig. 32

Fasteners Tightening Torque		
Nut Size	Torque	
	Lb-ft	Nm
M8	22	30
M10	41	55
M12	70	95
M16	122	165
M20	232	315
M24	402	545

- Operate the actuator at working pressure and adjust the dampening adjustment screw with a hex wrench to the required level of dampening. Screw back the tubular cover.

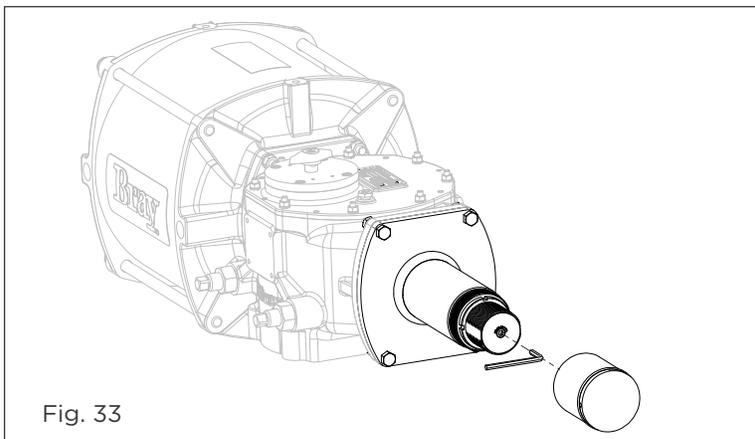


Fig. 33

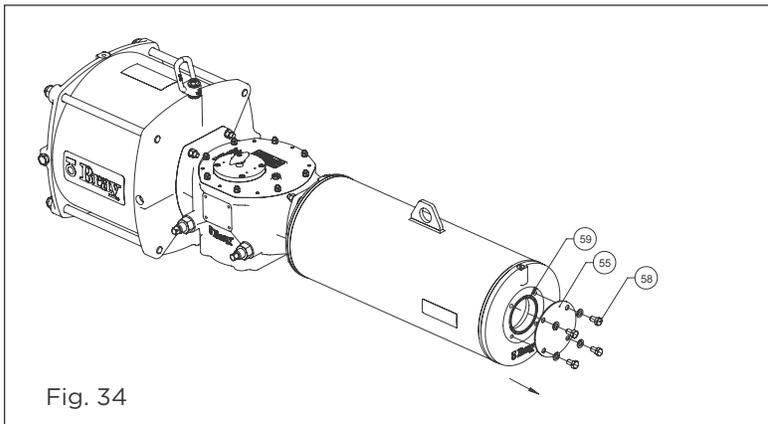
22.2 Installing the Hydraulic Damper on SR actuator

NOTICE

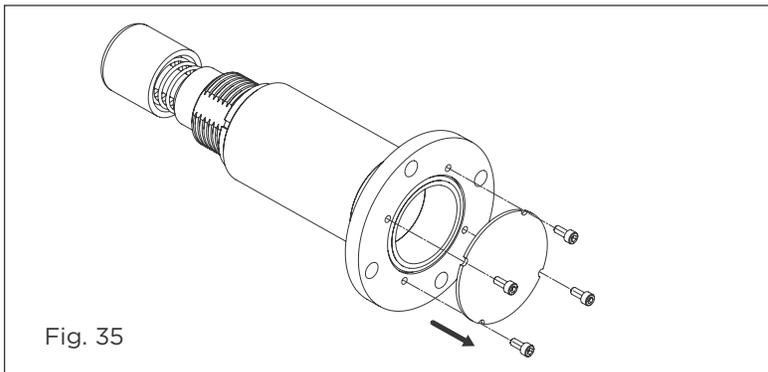
The damper module installation and adjustment shall be carried out only after the valve-actuator assembly has been first set for proper seating of valve closure element (disc/ball/plug) by the actuator's travel stops.

In case of a stand- alone actuator having been supplied with a hydraulic damper module pre-installed, the damper module may need to be taken off for proper adjusted per below procedure, after the actuator is installed on the valve.

1. Depressurize the actuator and remove the end cover (55) by unfastening the bolts (58). Retain the O-ring (59) in the end cap groove.

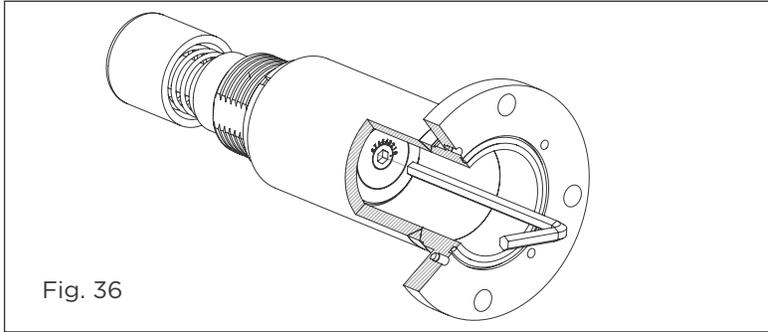


2. Remove Damper end cover from its housing.

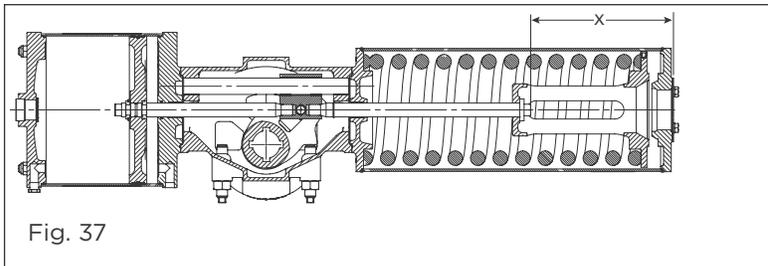


NOTE: For all actuator sizes up to 45E3-SR2, the hydraulic dampers have the dampening rate adjustment screw and is located at the rear of the damper unit.

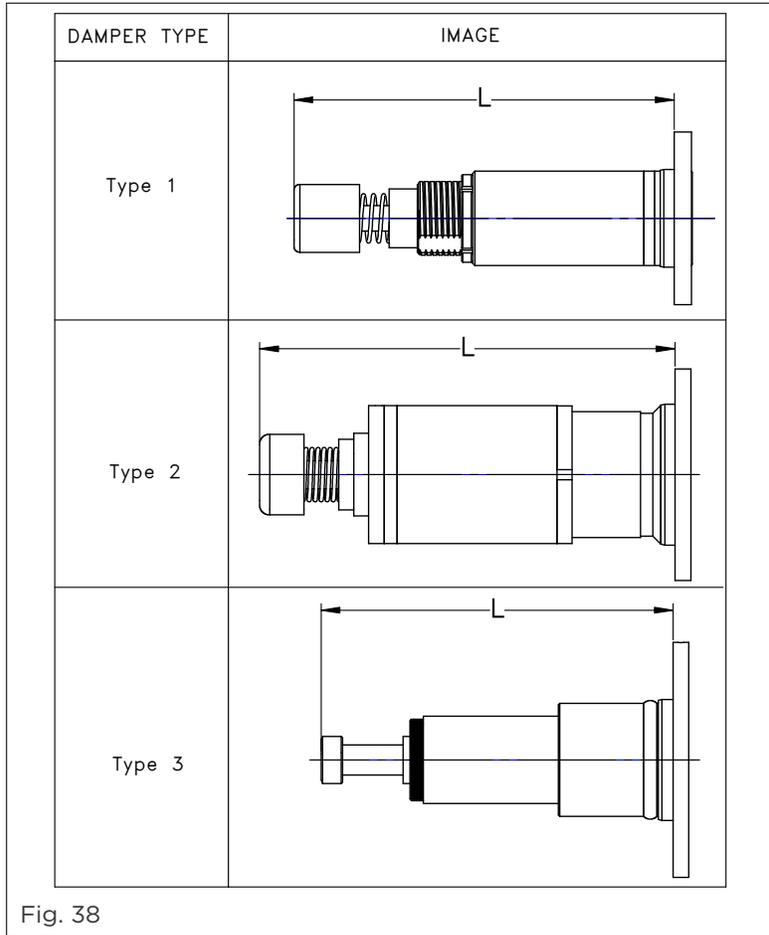
3. On the adjustable damper modules use an extended hex wrench (Allen key), to turn the damper rate adjustment screw at the base of the damper unit to the minimum setting. At this setting it would be possible to press the damper piston by hand, against the return spring.



4. Ensure the actuator's travel stops have been set & locked for proper valve seating position.
5. Measure the distance "X" from the spring module's end cap machined face to the spring rod's face.



6. This length shall not be less than the solid length of the damper assembly. Use the below guide to check and reset the assembly length "L" of the damper module.



Type	Actuator Size	Setting Length, L in mm
1	12E2 thru 14E3 all spring sizes 24E3 SR1 & SR2	$L = X + 40$
2	24E3 SR3 thru SR5 45E3 SR1 & SR2	$L = X + 40$
3	45E3 SR3 thru SR5	$L = X + 40$
	10E4 SR1 & SR2	$L = X + 90$

- Slacken the ring lock nut (3) on type 1 & type 2 dampers to turn the damper unit in housing for setting the length 'L'. For type 3 dampers, loosen the two lock screws (14) on lock nut (3), to back off the lock nut. Set the length L by turning the damper unit in the housing. Upon setting the length L, turn the lock nut clockwise to just bear on the sleeve nut (11) and back it up by two turns. Tighten the lock screws (14), to secure it.

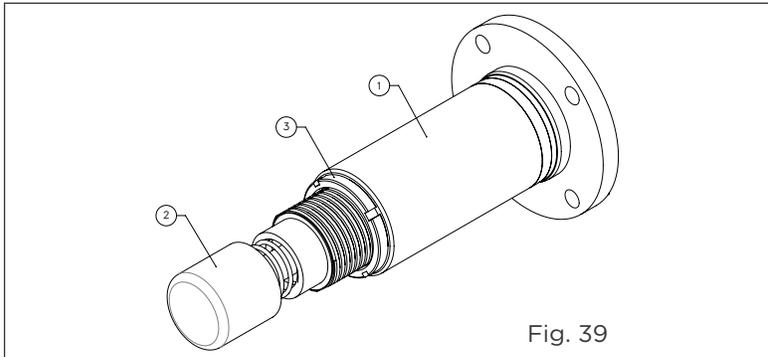


Fig. 39

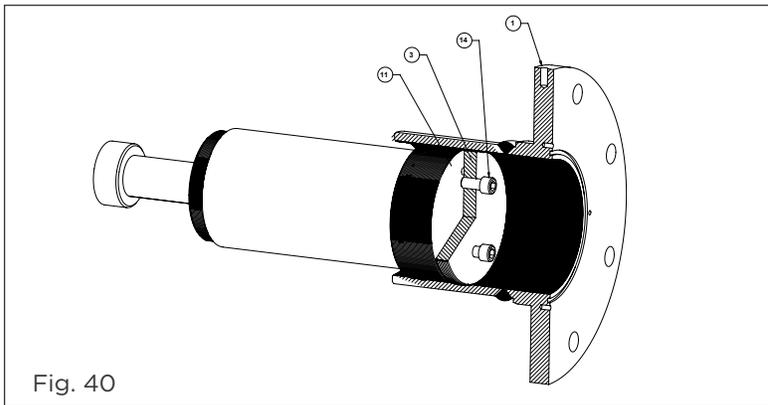


Fig. 40

8. Apply a drop of thread lock compound and thread in the studs (8) from the kit into the end cap.

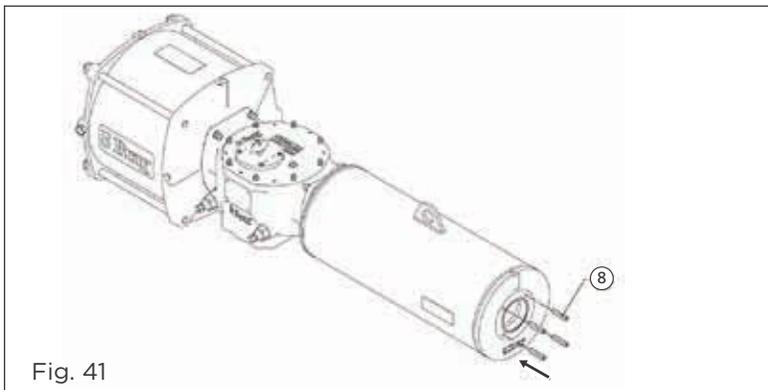


Fig. 41

9. Insert the damper assembly into the spring module, locating the flange through the studs. Press the flange to mate the inside face on the flange to the spring module's end cap and secure the assembly with the spring washers and nuts. Tighten the nuts, refer to below table for torque values.

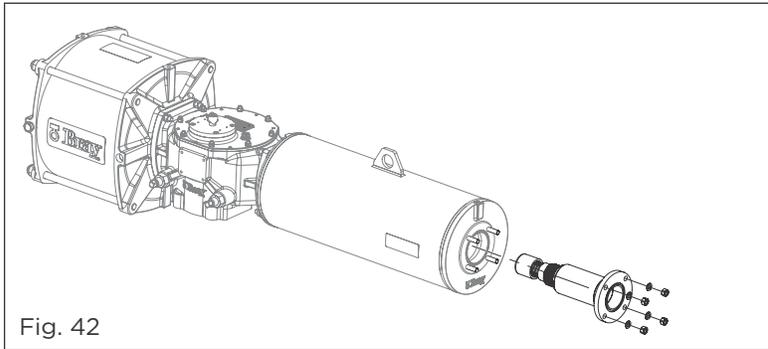


Fig. 42

Fasteners Tightening Torque		
Nut Size	Torque	
	Lb-ft	Nm
M8	22	30
M10	41	55
M12	70	95
M16	122	165
M20	232	315
M24	402	545

10. With an extended hex wrench adjust the damper setting screw to about two settings below the maximum.

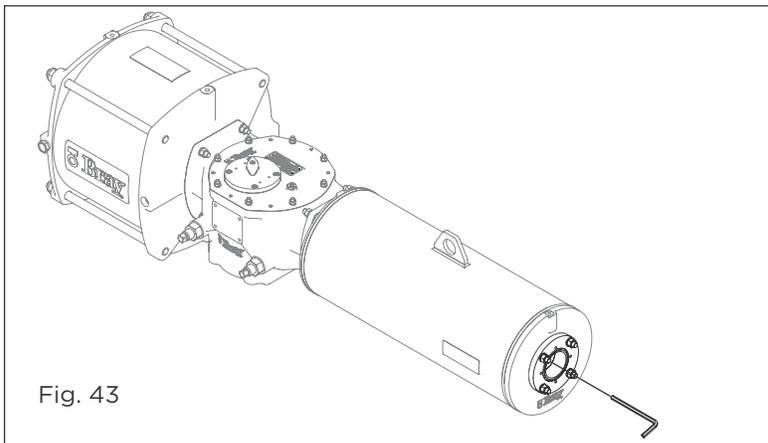


Fig. 43

11. Operate the actuator by pneumatic pressure to full stroke and release the air pressure. Observe the valve disc for the dampening rate and adjust the damper screw to higher or lower setting, as required.
12. For the non-adjustable damper module assemblies, connect the actuator's adaptor port to air supply through a 2/2 valve (ball or plug valve) and an air pressure regulator. Open the valve and pressurize the adaptor port of the pressure module to compress the spring fully, not exceeding the MOP of the actuator mentioned on the name plate. Close the valve to positively hold the actuator in this position.

13. With the spring in the compressed position, insert the damper assembly into the spring module, locating the flange through the studs. Press the flange to seat the inside face on the flange on the spring module's end cap and secure the assembly with the spring washers and nuts. Tighten the bolts, refer to table for bolt torque values.
14. Lubricate and insert the supplied O-ring in the groove on the outside of the damper housing flange.

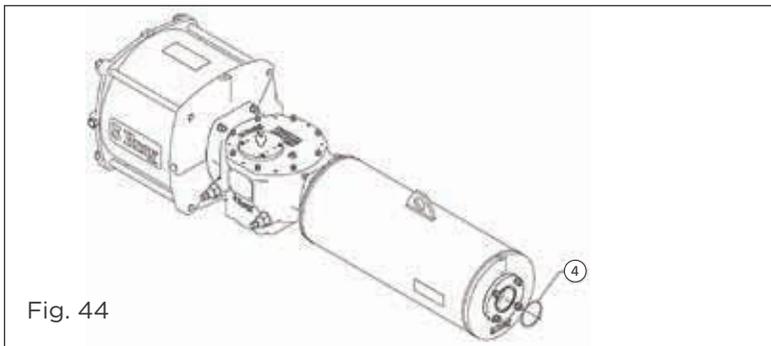


Fig. 44

15. Fix back the damper end cover with screws.

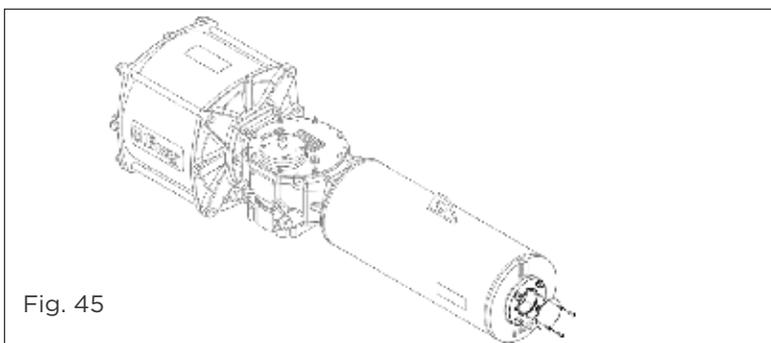


Fig. 45

! CAUTION

Ensure there is no loss of air from pressure module while assembling the damper and spring is in the compressed position. For safety, do not stand directly in line of the spring module while assembling.

23.0 PARTIAL STROKE TEST & LOCKING DEVICE

A Partial Stroke Test (PST) device is used on an actuator, typically in an emergency shut down (ESD) service, to enable the periodic testing of the control system, including the actuator as the final element. The device when engaged, permits only a small preset partial stroke of the actuator (and the line valve) so that the process parameters are not adversely affected.

The device designed for use on S98 actuators is a combination device that can be set for either partial stroke test or as a locking device at any one end of the stroke. It is modular in construction and can be added on to the S98 standard actuator, without any modifications to the basic actuator.

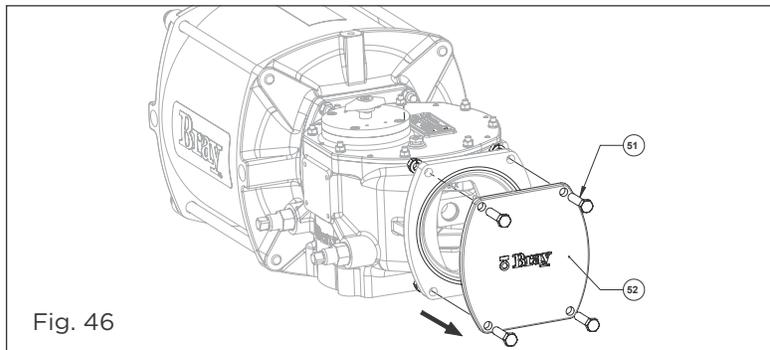
23.1 Installing PST &LD on a standard DA actuator

NOTICE

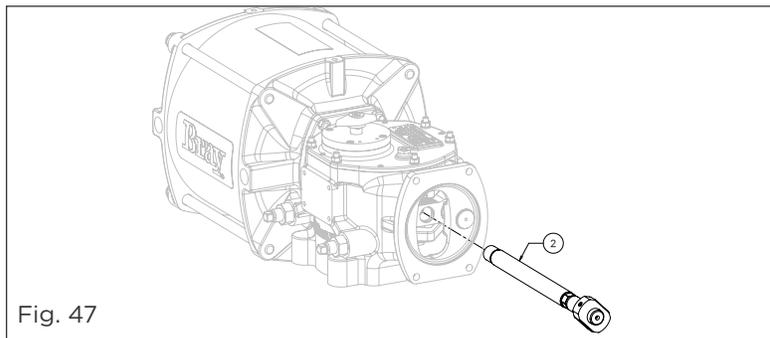
The PST&LD module installation and adjustment shall be carried out only after the valve-actuator assembly has been first set for proper seating of valve closure element (disc/ball/plug) by the actuator's travel stops.

In case of a stand- alone actuator having been supplied with a PST&LD module pre-installed, ensure the device is adjusted per below procedure, after the actuator is installed on the valve and it's travel stops are set and locked in position.

1. With the actuator at its clockwise travel end position, depressurize the actuator and remove the DA cover (52) by unfastening the bolts (51).



2. Thread in the extension rod (2) into the guide block threads and torque it to values as for piston rod, on table 10.1.b



3. Slacken the set screws (11) and unscrew the lock nut (3) off the extension rod (2). Take care not to drop the plastic buttons (14).

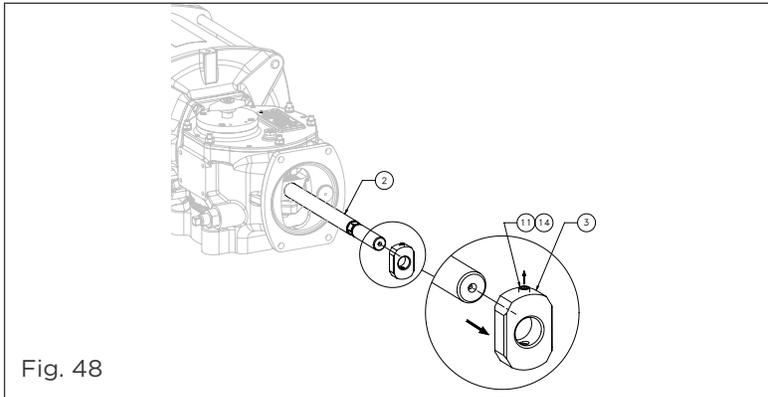


Fig. 48

4. Unscrew the tubular cover (6) off the PST&LD module.

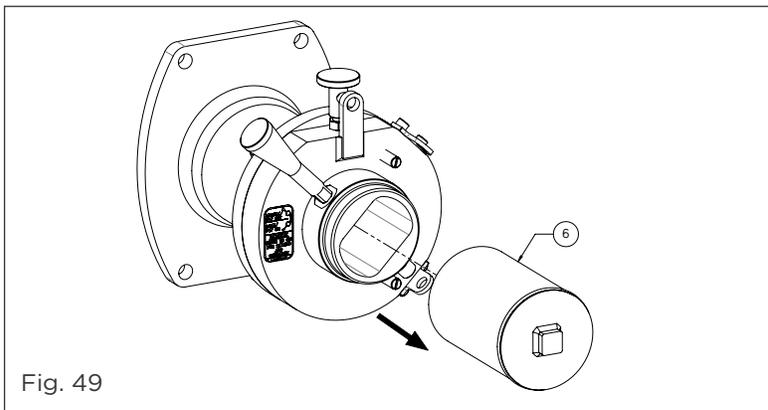


Fig. 49

5. Lubricate and install the O-ring (19) into the groove on the flange face.

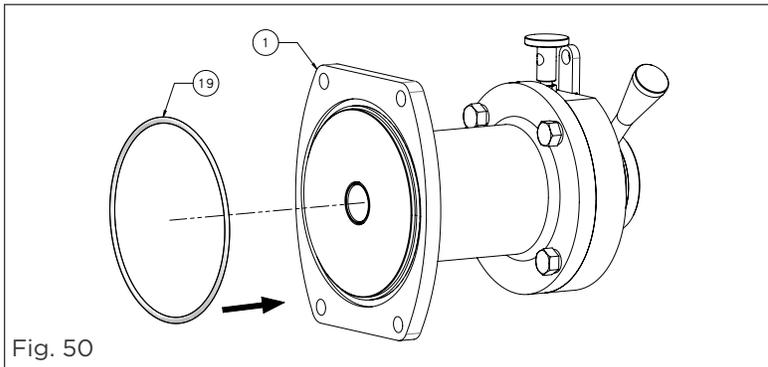


Fig. 50

6. Lubricate the extension rod (2) and the profiled bore in the index sleeve (4) with grease and carefully guide the PST&LD module's bushing (15) in the housing (1) over the extension rod, to mate the device's flange with the torque module's flange. Orient the device with the indexing plunger Knob (23) at the top.

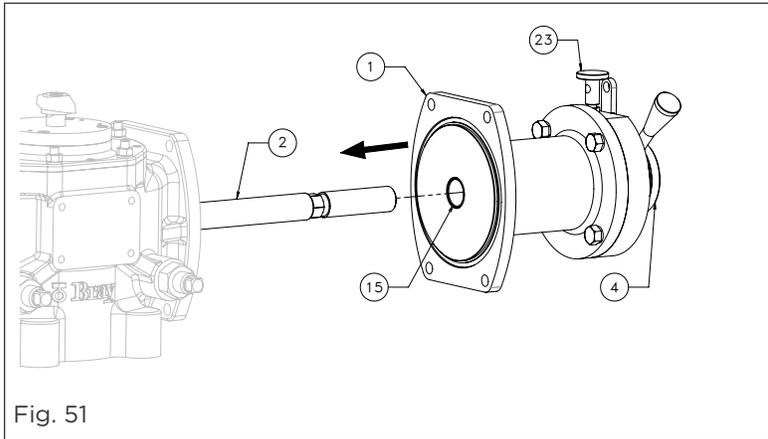


Fig. 51

7. Fasten the assembly with the bolts (16), washers (18) and nuts (17) provided in the kit.

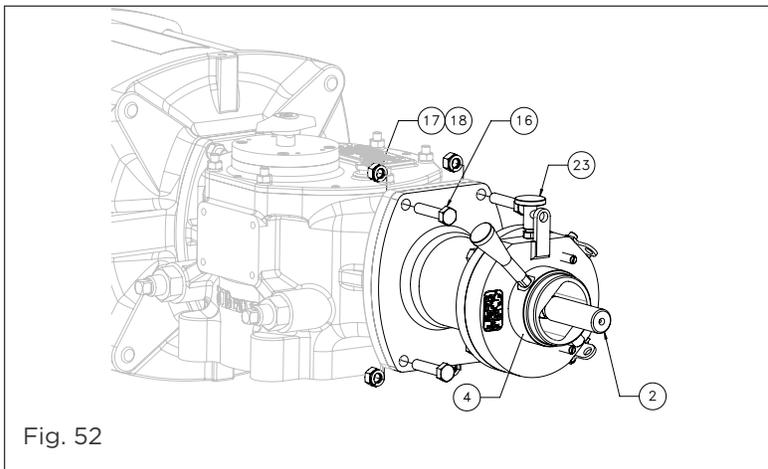


Fig. 52

23.2 Configuring as a Locking Device to lock at CW end

The valve is sometimes required to be locked in the clockwise end position, which is usually the valve's closed position, during maintenance or for safety reasons. The PST&LD on S98 is easily configured to do this.

1. On the standard assembly, ensure the actuator is at clockwise end, stopped by its travel stop and that both travel stops have been set and locked to the valve's requirement. Turn the handle (7) on the device to the UNLOCKED position, if not already in this position, by pulling up the index plunger knob (23) and then turning the handle upwards until the index plunger locks in this position.

CAUTION

Be wary of the extension rod moving in /out of the device and keep hands away while actuating the assembly on power.

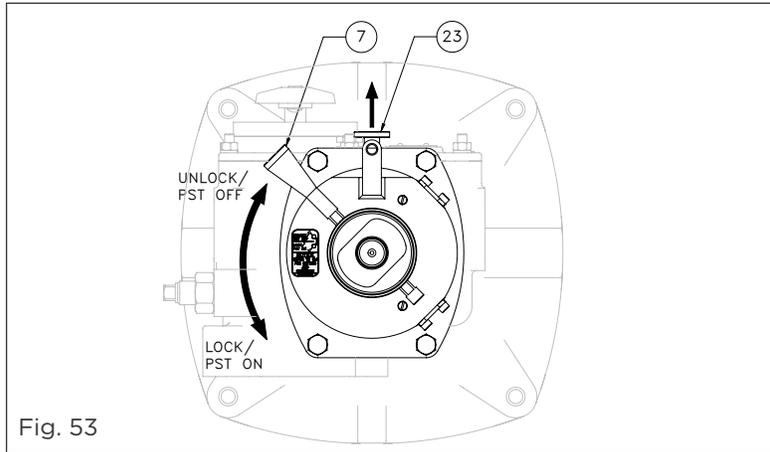


Fig. 53

2. Thread in the lock nut (3) on the extension rod threads with the inside face of locknut right up to the face of the index sleeve (4). Turn the nut a bit counterclockwise, to align the flat sides on the lock nut with the flats in the sleeve, so that the nut will enter the sleeve without any interference when the extension rod (2) moves inwards.

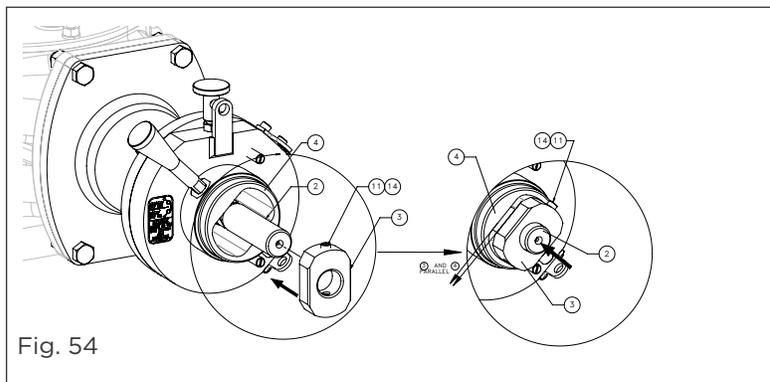
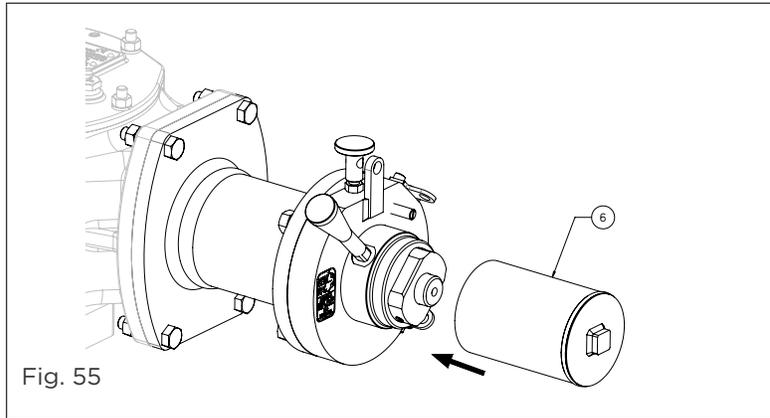


Fig. 54

Note: Do not turn the nut clockwise to align it with the sleeve, as this could compromise the working clearance required between the locknut's inner face and the sleeve face.

3. Tighten the set screws (11) to jam the plastic buttons (14) on the extension rod threads to secure this position of the lock nut.
4. Pull the index plunger up and turn the handle up and down, to check for smooth movement without the locknut rubbing on the sleeve face. If necessary, reset the locknut (3) by loosening it half turn and realign it with the index sleeve's profiled bore. Restore the device to UNLOCKED position and thread in the tubular cover (6) on the index sleeve threads.

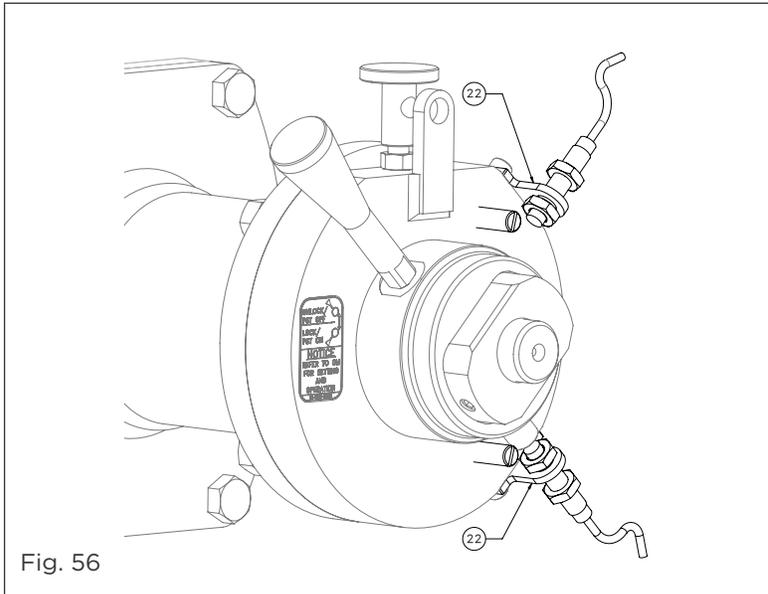


5. Actuate the assembly with compressed air at working pressure a couple of times in the UNLOCKED position of device, to ensure there is no restriction or any rubbing noise from the device side and that the actuator works full stroke, as normally would.
6. With the actuator at the CW end position, engage the locking by pulling up the indexing plunger and turning the handle downwards to the LOCKED position, ensuring the indexing plunger seats into the position and that the handle cannot be turned in this indexed position.
7. Rotation of the actuator by pressurizing in this condition will be prevented by the locknut bearing on the sleeve face, thus mechanically locking the actuator in its end position.

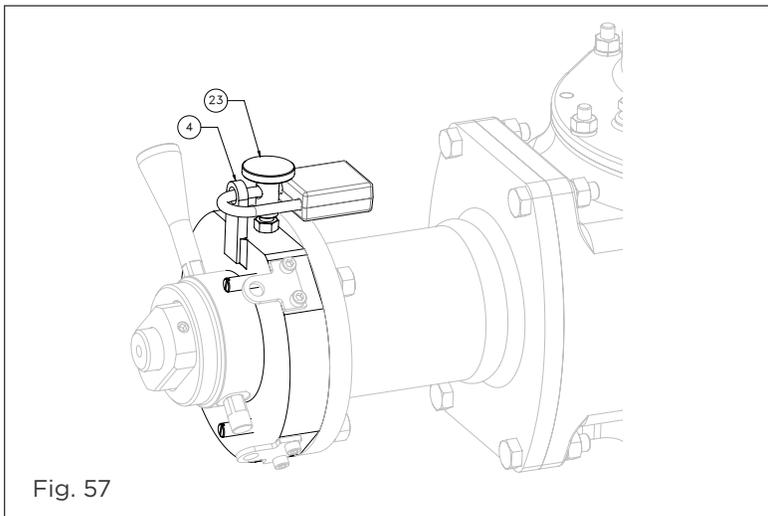
 **CAUTION**

Do not try to unlock the device in this state of locknut loaded on the sleeve by the pressurized actuator.

8. To unlock the actuator, switch the direction of the actuator rotation to unload the locknut off the index sleeve and then pull up the indexing plunger to turn the handle to the UNLOCKED position, ensuring the indexing plunger sits in and secures this position. Now pressurizing the actuator should restore the normal operation.
9. Proximity switches can be fitted on the plates (22) to provide feedback on the position of the device.



10. The two indexed positions of the device can be physically locked with a padlock through the indexing plunger knob (23), to prevent inadvertent or unauthorized operation of the device.



23.3 Configuring as Locking Device at CCW end

At times, the valve is required to be locked in the counterclockwise end position, which is usually the valve's open position. The locking device on S98 is capable of being configured to do this as well.

1. First, ensure the travel stops on the actuator have been set and locked to the valve's requirement. Turn the actuator to its CW end position and turn the handle (7) on the device upwards to the UNLOCKED position, if not already in this position. Ensure the position is secured by the indexing plunger sitting in and the handle will not turn in this indexed position.

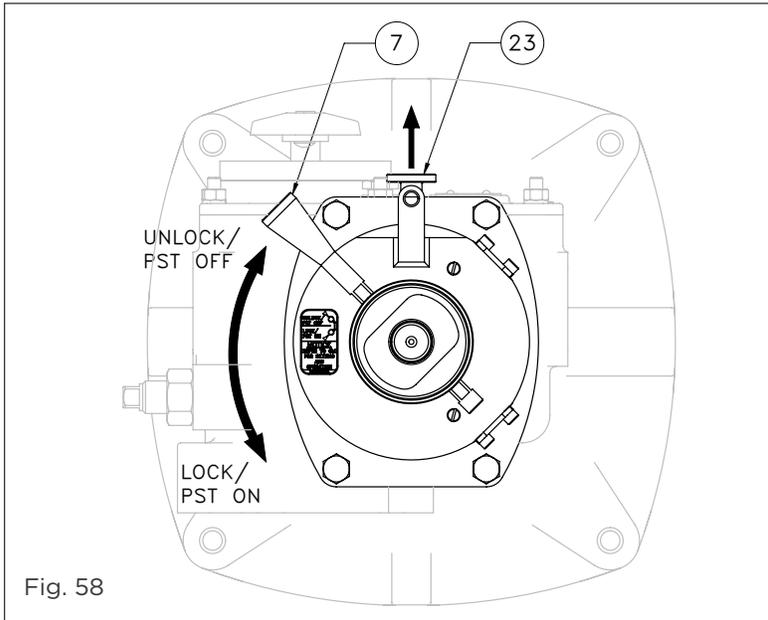


Fig. 58

2. Measure the total stroke (S) of the Extension rod (2). Turn the actuator to its CW end position and measure the projected length of the Extension rod end from the sleeve face. Next, operate the actuator to CCW position and measure the depth of the Extension rod face from the sleeve face. Add the two to get the total stroke length.
 $S=L1+L2$.

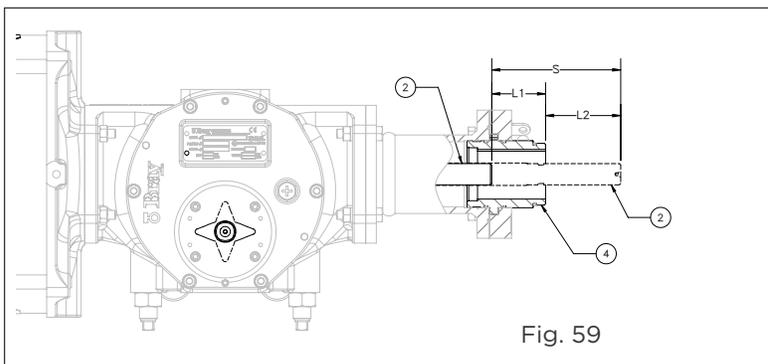


Fig. 59

3. Loosen the locknut (3) by first slackening the set screws (11). Set the distance "L" between the index sleeve's outer face and the inner face of the locknut per the below table.
 $L=S-A$, mm
 S, Stroke Measured, mm

SI No	Model	A, mm
1	12E2	60
2	18E2	74
3	45E2	97
4	73E2	118
5	14E3	140
6	24E3	191
7	45E3	234

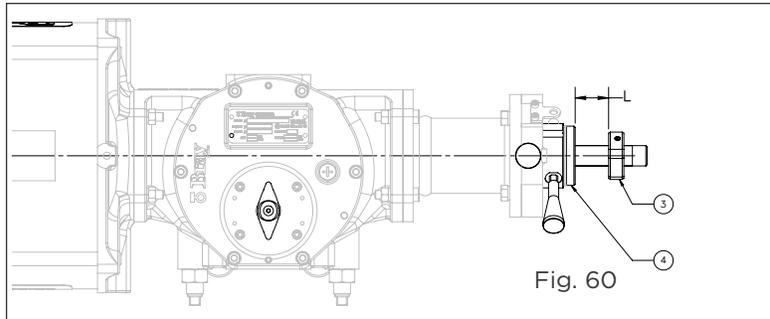


Fig. 60

- Return the actuator to the CW end. Turn the locknut a bit clockwise to align the locknut's flat faces to the sleeve's flat sides, so that the sleeve's profile will not interfere with the locknut when the extension rod moves inwards. Lock the set screws to secure the position of the locknut.

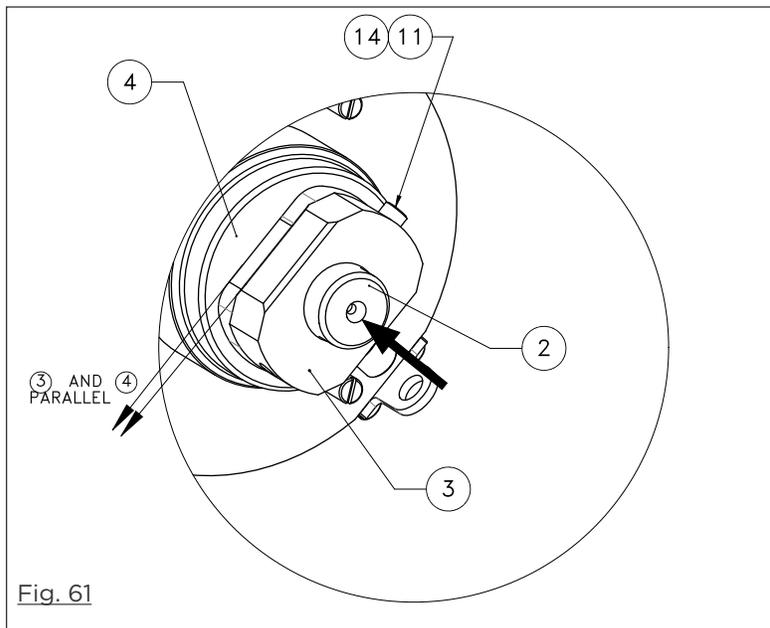


Fig. 61

5. With the device in UNLOCKED position, power the actuator to turn counterclockwise. Observe for free movement of the locknut through the sleeve's profile and that the locknut does not rub against the sleeve while moving in. If necessary, reverse the direction and realign the locknut. Fit the tubular cover (6) back on.

 **CAUTION**

Be wary of the pinch points and keep fingers clear off the locknut while setting and testing.

6. With the actuator in CCW end position or the valve in open position, pull up the index plunger and turn the device handle down and up, to ensure there is no resistance or any rubbing of the sleeve's inner face with the locknut. Set the lever to the LOCKED position ensuring the index plunger secures this position.

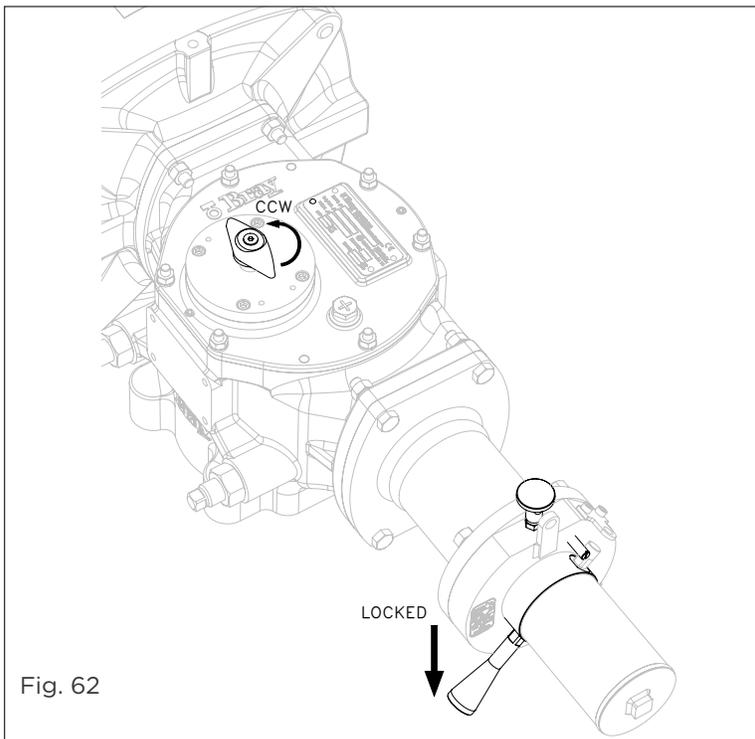


Fig. 62

7. Clockwise rotation of the actuator by pressurizing in this condition will be prevented by the outer face of locknut bearing on the sleeve's inner face, thus mechanically locking the actuator in its CCW end position.

 **CAUTION**

Do not try to unlock the device in this state of locknut loaded on the sleeve by the pressurized actuator.

8. To unlock the actuator, switch the direction of the actuator rotation to unload the locknut off the index sleeve and then pull up the indexing plunger to turn the handle to the UNLOCKED position, ensuring the indexing plunger sits in and secures this position. Now pressurizing the actuator should restore the normal operation.

23.4 Configuring as a Partial Stroke Test Device at CCW end

ESD valves are periodically required to be tested by partial stroke actuation when the valve is in open position for extended periods of time. The PST&LD on S98 is configured to do this partial stroke test at the counterclockwise end or in valve's open position, by setting the device as a locking device at CW end, as described in Section 23.2. This same setting allows PST at CCW end.

1. Follow steps 23.2.1 through 23.2.4 to set the locknut position.
2. With the actuator at the CCW end position, engage the partial stroke by pulling up the indexing plunger and turning the handle downwards to the PST ON position, ensuring the indexing plunger seats into the position and that the handle cannot be turned in this indexed position.
3. Clockwise rotation of the actuator by pressurizing (valve closing) in this condition will happen only for a partial stroke of about 20 degrees and further rotation prevented by the locknut's outer face bearing on the sleeve's inner face, thus mechanically restraining further rotation.



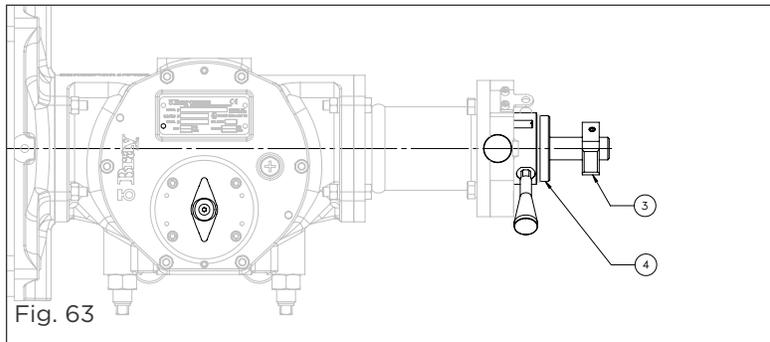
Do not try to turn the device handle in this state of locknut loaded on the sleeve by the pressurized actuator.

4. To restore normal state of the actuator, switch the direction of the actuator rotation to unload the locknut off the index sleeve and then pull up the indexing plunger to turn the handle to the PST OFF position, ensuring the indexing plunger sits in and secures this position.
5. Refer to 23.2.8 and 23.2.9 for position feedback and padlock provisions.

23.5 Configuring as a Partial Stroke Test Device at CW end

Just as with ESD valves, partial stroke test actuation can be done in closed position of quick venting valves, that remain closed for extended periods of time. The PST&LD on S98 is configured to do this partial stroke test at the clockwise end or in valve's closed position.

1. With the actuator at CW end and the device in PST OFF position, set the locknut (3) in alignment with the sleeve profile, as described in step 23.3.2 with a gap between the sleeve's outer face and the locknut's inner face. Secure the locknut's position with set screws.



2. With the actuator at the CW end position, engage the partial stroke by pulling up the indexing plunger and turning the handle downwards to the PST ON position, ensuring the indexing plunger seats into the position and that the handle cannot be turned in this indexed position.
3. Counterclockwise rotation (valve opening) of the actuator by pressurizing in this condition will happen only for a partial stroke and further rotation prevented by the locknut's inner face bearing on the sleeve's outer face, thus mechanically restraining further rotation.
4. To restore normal state of the actuator, switch the direction of the actuator rotation to unload the locknut off the index sleeve and then pull up the indexing plunger to turn the handle to the PST OFF position, ensuring the indexing plunger sits in and secures this position.

23.6 Installing PST & LD module on a standard SR actuator

NOTICE

The PST&LD module configuration shall be carried out only after the valve-actuator assembly has been first set for proper seating of valve closure element (disc/ball/plug) by the actuator's travel stops.

The PST&LD module on the S98 SR actuators require the standard spring rod to be replaced with the extended spring rod that is supplied with this module. Assembling the PST&LD module on a standard SR actuator will require the spring module to be first taken off the actuator to replace this part. The actuator shall be taken off the valve, if already mounted on the valve, to retrofit with the PST&LD module.

In case of a stand- alone actuator having been fitted with a PST&LD module, ensure the device is configured to the application only after the actuator is installed on the valve and it's travel stops are set and locked in position.

To fit the module on a standard SR actuator that is without any accessories/manual overrides on the spring module, follow the below procedure to fit the PST&LD module and set it as a default assembly.

1. Ensure the actuator is at its fail-safe position. Connect through a pressure regulator and pressurize the actuator's adaptor side port just enough to start the rotation. Loosen the spring module side Travel Stop Bolt's seal lock nut, mark the position and then back off stop bolt fully. Depressurize the actuator.
2. Remove the spring module end cover by unfastening the end cover bolts.

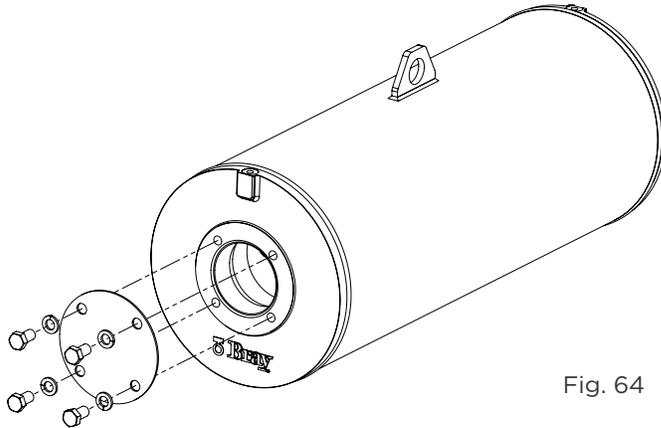


Fig. 64

3. With an extended socket wrench, loosen the spring rod completely.
4. Support the spring module with a sling from the welded lifting lug and unfasten the nuts holding the spring module to the torque module flange.
5. Pull off the spring module from the actuator, rest it firmly on the ground or a bench and take the retainer ring off the spring rod. Slide off the spring rod out of the module.

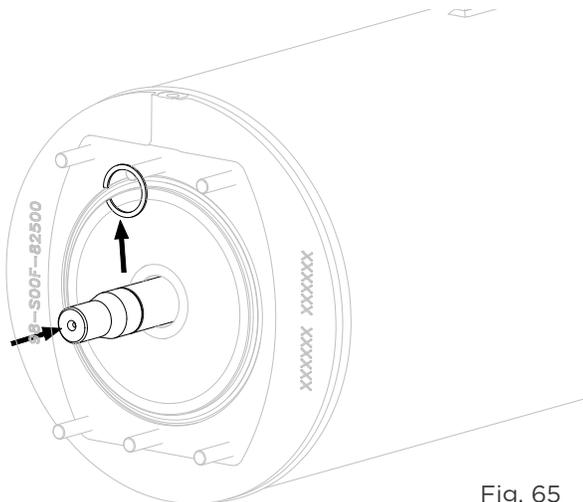


Fig. 65

6. Take the tubular cover (6) off the PST&LD module, slacken the set screws (11) and unscrew the lock nut (3) off the extended spring rod (2). Take care not to loose the plastic buttons (15).
7. Lubricate the rod with grease and slide it into the spring module, through the bushing.

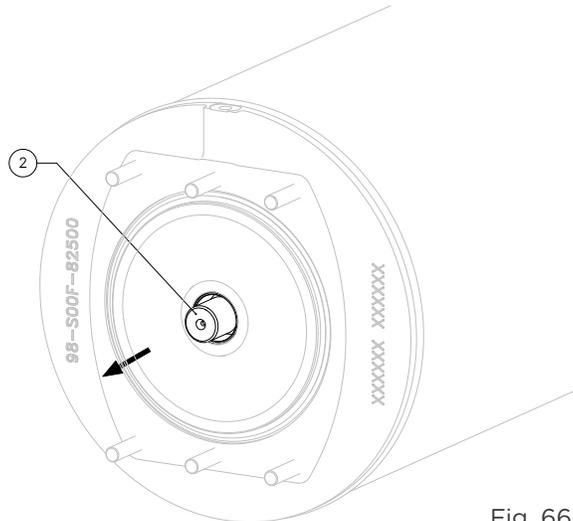


Fig. 66

8. Ensure the face sealing O-ring is secure in the spring module adaptor face groove. Lift and mount the spring module back on the actuator, taking care not to damage the rod threads and ensure the spring rod does not slide back out of the module. Tighten the mounting flange stud nuts with spring washers and torque them per table.

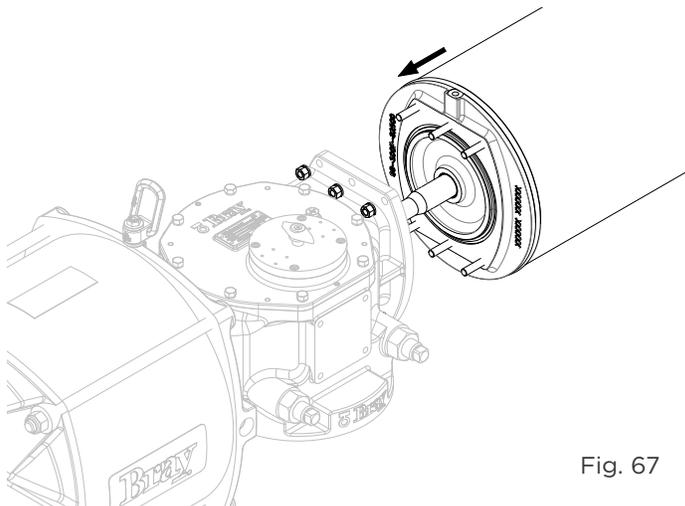


Fig. 67

9. Gently push the extended spring rod in and rotate clockwise to engage into the threads in guide block in the torque module. Tighten and torque it to value per below table:

PST & LD - Extended Spring Rod								
MODEL	12 E2	18 E2	45 E2	73 E2	14 E3	24 E3	45 E3	10 E4
Rod Thread	M20x2	M24x2	M24x2	M27x2	M30x2	M36x3	M48x3	M60x4
PST & LD - Extended Spring Rod Hex A/F, mm	27	27	27	30	41	41	60	75
Torque, Nm	165	220	220	220	275	275	385	500
Piston Rod Min. No of Turns	10	12	10	14	15	12	16	15

10. Apply thread lock compound on the studs from the mounting kit and thread them tight in the tapped holes on spring module's end plate. Secure the O-ring in the groove on the end plate.
11. Slide in the PST&LD module housing on the extended spring rod and orient the device with the indexing plunger (11) at the top. Secure the assembly to the spring module with nuts (17) and washers (18).

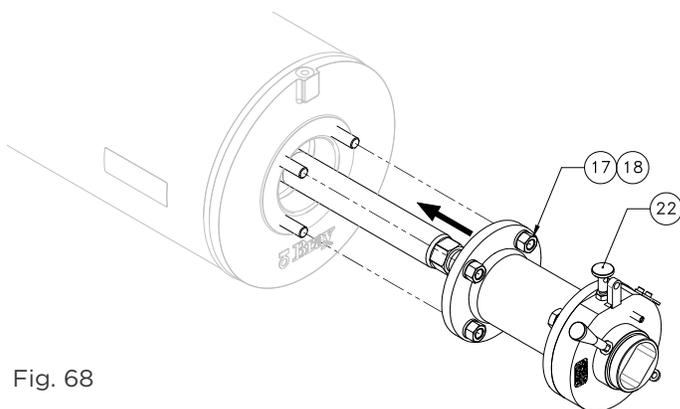


Fig. 68

12. 12 Set the PST &LD to “Unlocked” position if not already indexed to this position, by pulling up the index plunger knob(22) and turning the handle (7) upwards till the plunger seats.

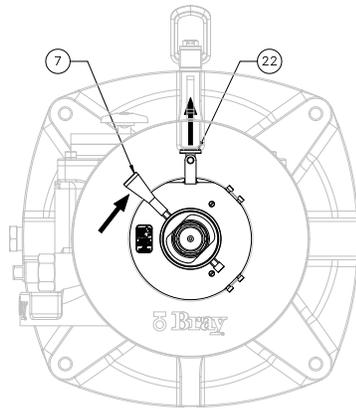


Fig. 69

13. Pressurize the adaptor port just enough to rotate the yoke 20 to 30 degrees. Thread in the travel stop bolt to its previously marked position and tighten the seal locknut. Depressurize to get the actuator to its fail-safe position.
14. Thread in the stopper nut (3) on the spring rod end till it bears on the sleeve face and back it off half to one turn to align the nut profile to the sleeve bore profile, such that the nut will slide through the profiled bore without interference, when actuated. Lock the setting of the profiled nut by the two set screws.

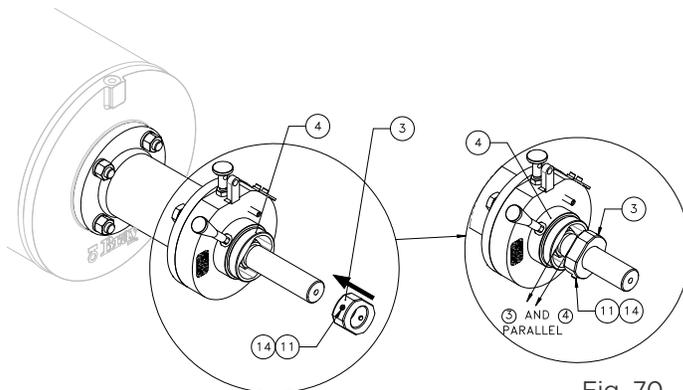


Fig. 70

15. Fit back the tubular cover, threading it fully over the sleeve threads and the O-ring

23.7 Configuring as a Locking Device to Lock at CW End

The valve is sometimes required to be locked in the clockwise end position, which is usually the valve's closed position, during maintenance or for safety reasons. The PST&LD on S98 is easily configured to do this.

1. On the standard assembly, ensure the actuator is at clockwise end, stopped by it's travel stop and that both travel stops have been set and locked to the valve's requirement. Turn the handle (7) on the device to the UNLOCKED position, if not already in this position, by pulling up the index plunger and then turning the handle upwards until the index plunger locks in this position.

 **CAUTION**

Be wary of the extension rod moving in /out of the device and keep hands away while actuating the assembly on power.

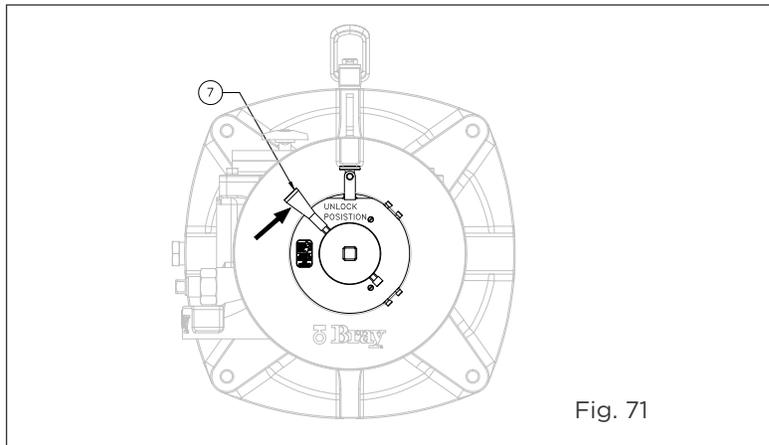
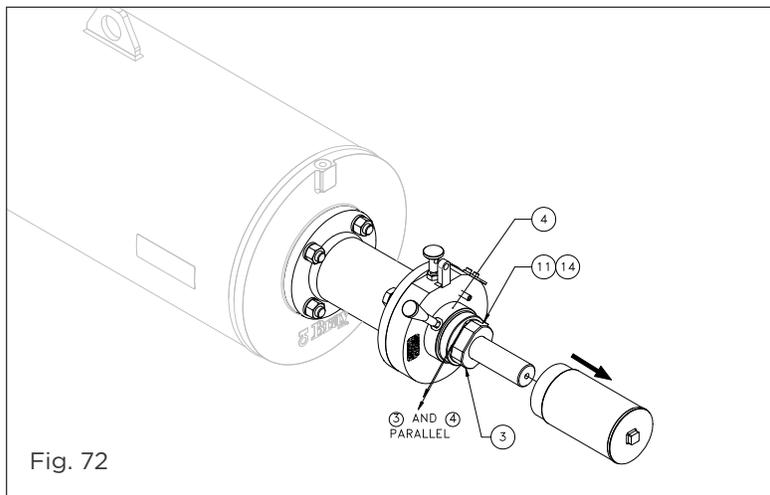


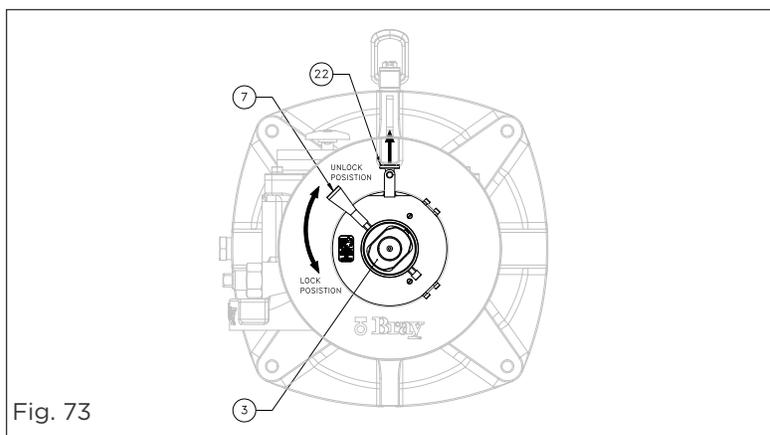
Fig. 71

2. Unscrew and remove the tubular cover. Thread in the lock nut (3) on the extension rod threads with the inside face of locknut right up to the face of the index sleeve (4). Turn the nut a bit counterclockwise, to align the flat sides on the lock nut with the flats in the sleeve, so that the nut will enter the sleeve without any interference when the extension rod (2) moves inwards.

Note: Do not turn the nut clockwise to align it with the sleeve, as this could compromise the working clearance required between the locknut's inner face and the sleeve face.



3. Tighten the set screws (11) to jam the plastic buttons (14) on the extension rod threads to secure this position of the locknut.
4. Pull the index plunger up and turn the handle up and down, to check for smooth movement without the locknut rubbing on the sleeve face. If necessary, reset the locknut (3) by loosening it half turn and realign it with the index sleeve's profiled bore. Restore the device to UNLOCKED position and thread in the tubular cover (6) on the index sleeve threads.



5. Actuate the assembly with compressed air at working pressure a couple of times in the UNLOCKED position of device, to ensure there is no restriction or any rubbing noise from the device side and that the actuator works full stroke, as normally would.
6. With the actuator at the Spring end position, engage the locking by pulling up the indexing plunger and turning the handle downwards to the LOCKED position, ensuring the indexing plunger seats into the position and that the handle cannot be turned in this indexed position.

7. Rotation of the actuator by pressurizing in this condition will be prevented by the locknut bearing on the sleeve face, thus mechanically locking the actuator in its end position.

 **CAUTION**

Do not try to unlock the device in this state of locknut loaded on the sleeve by the pressurized actuator.

8. To unlock the actuator, depressurize the actuator to unload the locknut off the index sleeve and then pull up the indexing plunger to turn the handle to the UNLOCKED position, ensuring the indexing plunger sits in and secures this position. Now pressurizing the actuator should restore the normal operation.
9. Proximity switches can be fitted on the plates (22) to provide feedback on the position of the device.

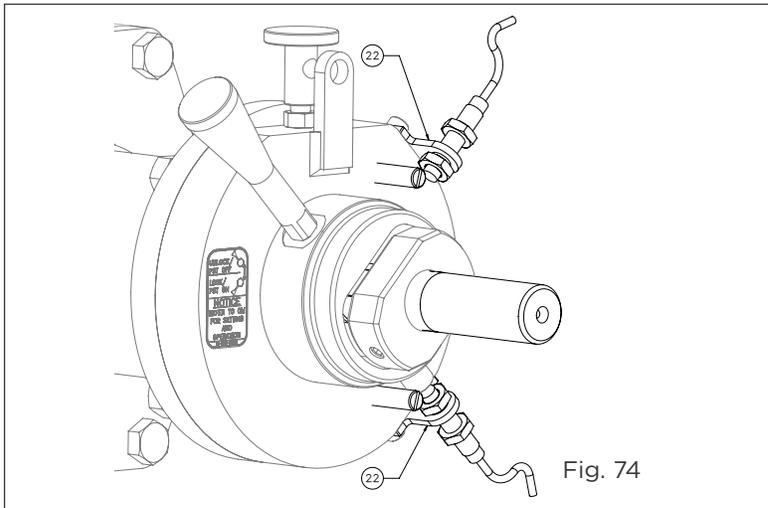


Fig. 74

10. The two indexed positions of the device can be physically locked with a padlock through the indexing plunger, to prevent inadvertent or unauthorized operation of the device.

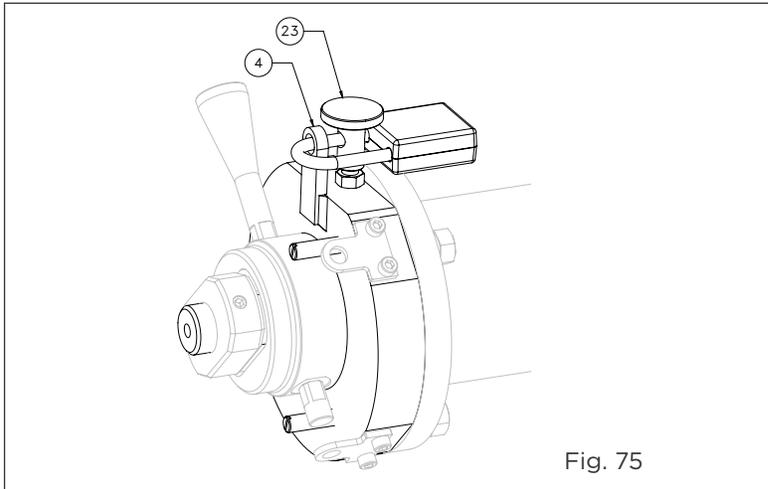


Fig. 75

23.8 Configuring as Locking Device at CCW end

At times, the valve may be required to be locked in the counterclockwise end position, which is usually the valve's open position. The locking device on S98 is capable of being configured to do this as well.

1. First, ensure the travel stops on the actuator have been set and locked to the valve's requirement. Turn the actuator to its CW end position and turn the handle (7) on the device upwards to the UNLOCKED position, if not already in this position. Ensure the position is secured by the indexing plunger sitting in and the handle will not turn in this indexed position.

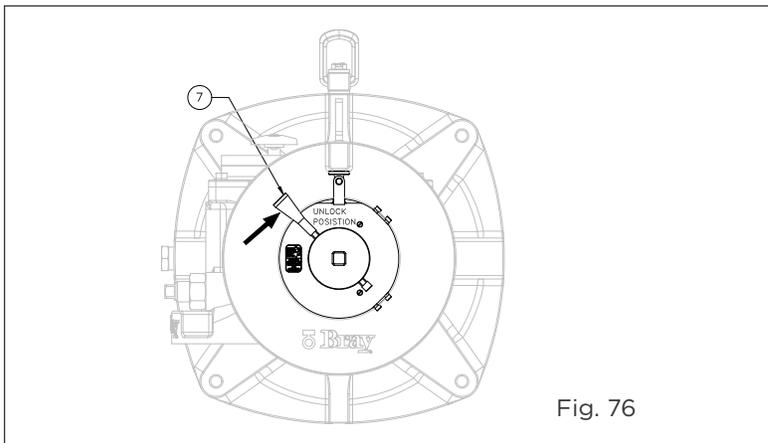
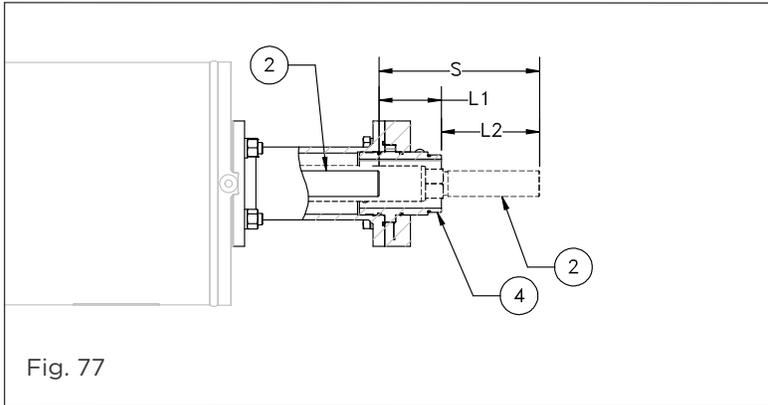


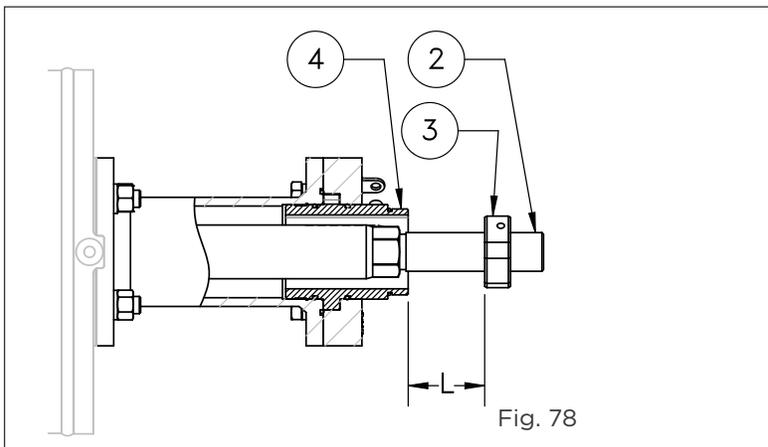
Fig. 76

2. Measure the total stroke (S) of the spring rod. First measure the projected length of the spring rod end from the sleeve face. Next, operate the actuator to CCW position and measure the depth of the spring rod face from the sleeve face. Add the two to get the total stroke length.

$$S=L1+L2$$



3. Loosen the locknut (3) by first slackening the set screws (11). Set the distance 'L' between the index sleeve's outer face and the inner face of the locknut per the below table.



$$L=S-A, \text{ mm}$$

S, Stroke Measured, mm

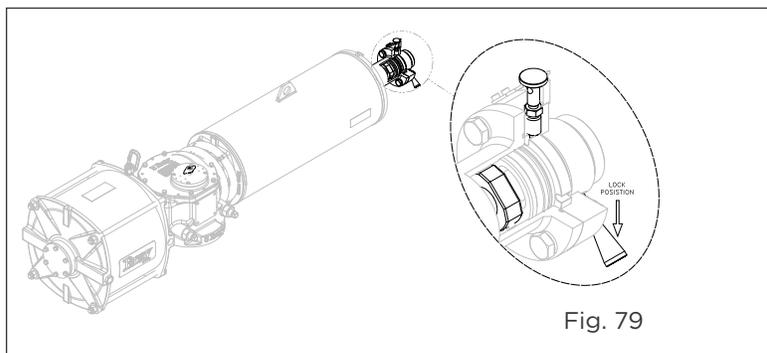
SI No	Model	A, mm
1	12E2	60
2	18E2	74
3	45E2	97
4	73E2	118
5	14E3	140
6	24E3	191
7	45E3	234

4. Return the actuator to the CW end. Turn the locknut a bit clockwise to align the locknut's flat faces to the sleeve's flat sides, so that the sleeve's profile will not interfere with the locknut when the spring rod moves inwards. Lock the set screws to secure the position of the locknut.
5. With the device in UNLOCKED position, actuate the actuator to turn to counterclockwise end . Observe for free movement of the locknut through the sleeve's profile and that the locknut does not rub against the sleeve while moving in. If necessary, reverse the direction and realign the locknut. Fit the tubular cover (6) back on.

CAUTION

Be wary of the pinch points and keep fingers clear off the locknut while setting and testing.

6. With the actuator in CCW end position (or the valve in open position), pull up the index plunger and turn the device handle down and up, to ensure there is no resistance or any rubbing of the sleeve's inner face with the locknut. Set the lever to the LOCKED position ensuring the index plunger secures this position.



7. Clockwise rotation (to failsafe position of a fail close actuator) of the actuator by depressurizing in this condition will be prevented by the outer face of locknut bearing on the sleeve's inner face, thus mechanically locking the actuator in its CCW end position.

CAUTION

Do not try to unlock the device in this state of locknut loaded on the sleeve by the spring load

8. To unlock the actuator, pressurize to unload the locknut off the index sleeve and then pull up the indexing plunger to turn the handle to the UNLOCKED position, ensuring the indexing plunger sits in and secures this position. Now depressurizing the actuator should restore the normal operation of the spring stroke, to the failsafe position.

23.9 Configuring as a Partial Stroke Test Device at CCW end

ESD valves are required to be periodically tested by partial stroke actuation when the valve is in open position for extended periods of time. The PST&LD on S98 is configured to do this partial stroke test at the counterclockwise end or in valve's open position, by setting the device as a locking device at CW end, as described in section 23.7. This same setting allows PST at CCW end.

1. Follow steps 23.7.1 through 23.7.4 to set the locknut position.
2. With the actuator pressurized to turn to the CCW end position, engage the partial stroke by pulling up the indexing plunger and turning the handle downwards to the PST ON position, ensuring the indexing plunger seats into the position and that the handle cannot be turned in this indexed position.
3. Clockwise rotation (valve closing) of the fail-close spring return actuator by depressurizing in this condition will happen only for a partial stroke of about 20 degrees and further rotation prevented by the locknut's outer face bearing on the sleeve's inner face, thus mechanically restraining further rotation.



Do not try to turn the device handle in this state of locknut loaded on the sleeve by the spring load.

4. To restore normal state of the actuator, pressurize to switch the direction of the actuator rotation to unload the locknut off the index sleeve. Pull up the indexing plunger to turn the handle to the PST OFF position, ensuring the indexing plunger sits in and secures this position.
5. Refer to 23.7.9 and 23.7.10 for position feedback and padlock provisions.

23.10 Configuring as a Partial Stroke Test Device at CW end

1. Just as with ESD valves, partial stroke test actuation can be done in closed position of quick venting valves, that remain closed for extended periods of time. The PST&LD on S98 is configured to do this partial stroke test at the clockwise end or in valve's closed position.
2. With the actuator at CW end and the device in PST OFF position, set the locknut (3) in alignment with the sleeve profile, as described in step 23.8.3 with a gap between the sleeve's outer face and the locknut's inner face. Secure the locknut's position with set screws.
3. With the actuator at the CW end position, engage the partial stroke by pulling up the indexing plunger and turning the handle downwards to the PST ON position, ensuring the indexing plunger seats into the position and that the handle cannot be turned in this indexed position.

4. Counterclockwise rotation (valve opening) of the actuator by pressurizing in this condition will happen only for a partial stroke and further rotation prevented by the locknut's inner face bearing on the sleeve's outer face, thus mechanically restraining further rotation.
5. To restore normal state of the actuator, switch the direction of the actuator rotation to unload the locknut off the index sleeve and then pull up the indexing plunger to turn the handle to the PST OFF position, ensuring the indexing plunger sits in and secures this position.

24.0 APPENDIX-A

24.1 Special Requirements for Actuators in Extended Temperature Service

In some service conditions, especially continuous and extended low temperature service, it is recommended to flush out the air with humidity from inside of the actuator's modules, with gaseous Nitrogen at low pressure. This is to avoid any humidity inside the modules from condensing or freezing to ice crystals, which may damage the sealing or contaminate lubricants applied in assembly.

Note: The media shall be dry and free from any moisture with the dew point maintained at least 10deg. Celsius below the ambient to avoid condensation/ice formation within the pressure module.

The actuators for such service are provided with flushing/venting ports on the torque module and the spring module.

Prior to installation of the actuator in the stated service conditions, the actuator's modules may be flushed with Nitrogen gas, as described below.

24.1.1 Torque Module

The torque module on such actuators has two threaded ports on the housing cover, with one port fitted with a venting valve and the other port with a pipe plug.

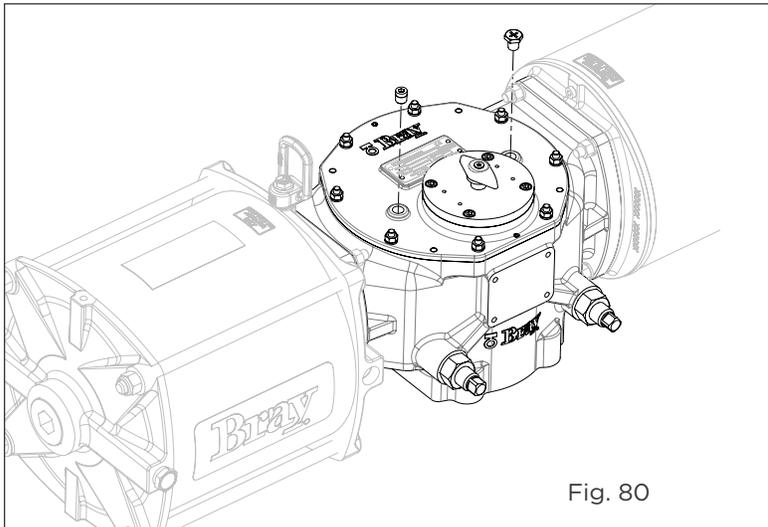


Fig. 80

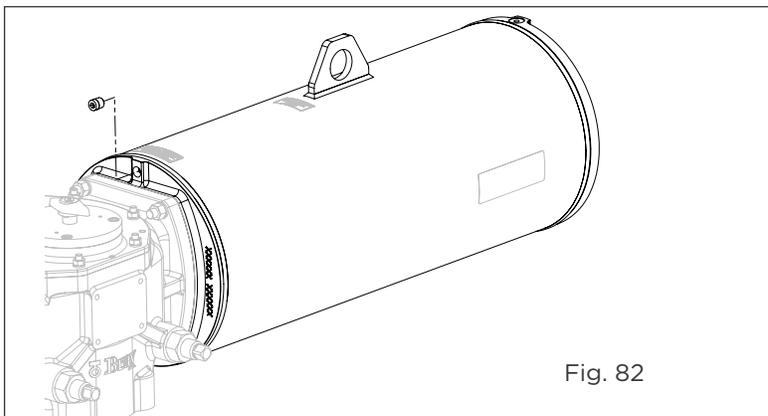
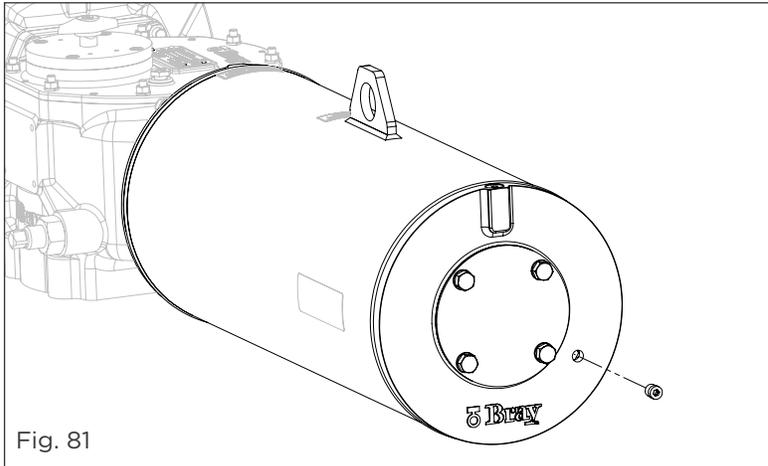
Remove both and fit a pneumatic tube fitting into one of the ports and leave the other one open.

Supply low pressure Nitrogen gas at 5 to 7 psi pressure through the tube fitting to the torque module housing for about a minute, to ensure all/most of the air inside is replaced with Nitrogen.

Disconnect the Nitrogen line, remove the tube fitting and fit back the plug and the vent valve, using a thread sealant on the threads.

24.1.2 Spring Module

On the Spring module, there are two ports provided, one each on the adaptor plate and on the end cap of the module and plugged with pipe plugs.



Remove the plugs and connect a pneumatic pipe connector to the port on adaptor, leaving the port on the end cap open.

Supply nitrogen gas at 5psi through the connector for about a minute to flush out the air and moisture from the module through the end cap port.

Disconnect the line and fit back the plugs.

25.0 APPENDIX B - LUBRICANTS

Modules/ Overrides	Temperature Range		
	Standard	Low Temp	High Temp
	-20°F to 200°F (-29°C to 93°C)	Down to -50°F (-46°C)	Up to 300°F (149°C)
Torque Module	Shell Alvania Grease EP(LF)2 or Mobiltemp SHC 100	Mobiltemp SHC 100 or Mobilith SHC 100 {-40°F (-40°C)} For Extreme Low Temperatures Molykote 33 Medium {-100°F (-73°C)}	Mobiltemp SHC 100 or Shell Gadus S3 T220-2
Pressure Module	Dow Corning Molykote 55		
Spring Module	Shell Alvania Grease EP(LF)2 or Mobiltemp SHC 100	Mobiltemp SHC 100 or Mobilith SHC 100 {-40°F (-40°C)} For Extreme Low Temperatures Molykote 33 Medium {-100°F (-73°C)}	Mobiltemp SHC 100 or Shell Gadus S3 T220-2
Manual Overrides	Shell Alvania Grease EP(LF)2 or Mobiltemp SHC 100	Mobiltemp SHC 100 or Mobilith SHC 100 {-40°F (-40°C)} For Extreme Low Temperatures Molykote 33 Medium {-100°F (-73°C)}	Mobiltemp SHC 100 or Shell Gadus S3 T220-2
Hydraulic Fluids	ISO-L-HV 32 or ISO-L-HV 46	ISO-L-HV 15 or Equivalent	Mobil Pyrograd 53 or Equivalent (Only for Hydraulic Overrides)

26.0 REFERENCE DRAWINGS

Description	Drg #
Hydraulic Override Assembly DA	ES 00094
Hydraulic Override Assembly SR	ES 00095
Jackscrew Assembly, DA Direct Drive	ES 00105
Jackscrew Assembly, DA Gear Drive	ES 00106
Jackscrew Assembly, SR Direct	ES 00113
Jackscrew Assembly, SR Gear Drive	ES 00114
Sandwich Gearbox	ES 00126
Extended Stoppers, SR	ES 00127
Extended Stoppers, DA	ES 00201
Hydraulic Damper SR	ES 00443
Hydraulic Damper DA	ES 00602
Partial Stroke Test & Locking Device-DA	ES 00614
Partial Stroke Test & Locking Device - RA	ES 00650

27.0 TROUBLE SHOOTING POTENTIAL PROBLEMS

Fault	Possible Causes	Recommended Actions
Erratic Movement	Inconsistent supply /dirty operating media/clogged filters	Check media supply pressure and line filters, correct as necessary. Refer to Introduction section in this manual for operating media requirements.
	Compromised lubrication due to condensate inside pneumatic cylinder(S98) or over extended maintenance cycles	Disassemble and service the Pressure Module after eliminating problems with operating media quality. Refer to Maintenance section in this manual for lubricant specs.
	Worn/damaged parts	Disassemble and inspect. Replace worn/damaged parts. Refer to Disassembly, Service & Reassembly of Modules section in this manual.
	Seal set due to long periods of inactivity	Operate for 5-10 cycles and check. Replace seals if not resolved. Refer to the procedures under Pressure Module section in this manual, for replacement and testing procedures.
	Mechanical problems with Valve/ Actuator/ Mounting Kits /Accessories - bearing/seal friction, damaged parts	Refer to valve manufacturer's IOM. To resolve problems with valve. Refer to Maintenance section of this manual for disassembly of Torque Module to investigate any issues in the actuator.
Incomplete Stroke	Stoppers set incorrectly	Check and adjust.
	Foreign object left inside during maintenance	Disassemble, inspect for damages and correct.
	Manual override in wrong position	Check and fully retract manual override devices for proper automatic operation.
	Valve problem - Restriction, friction, incorrect valve stopper	Refer to valve manufacturer's IOM.
	Piston Rod / Spring Rod partially loosened	Check/ tighten rods to required torque.
Loss of power	Supply pressure inadequate	Check and correct supply pressure to operating pressure.
	Inadequate flow	Check flow control devices and adjust for sufficient flow. Repair any kinked tubing.
	Constrictions in tubing / hydraulic return line filter (S98H) choked / exhaust vents blocked.	Check/ clean / replace vents, filter element, silencers, etc. as required.
	Pressure Module seals leaking	Check leaks and replace seals. Refer to the procedures under Pressure Module section in this manual, for replacement and testing procedures.
	Defective Accessories/Inadequate capacity	Refer to accessory manufacturer's IOM manual and specs.
	Valve jammed or requires higher torque	Refer to valve manufacturer's IOM.

No response to actuation signal	Altered schematic	Check if the control circuit is as per the supplied schematic. Correct the circuit, if altered.
	Solenoid valve/positioner/control elements malfunction	Check /Refer to accessory manufacturer's IOM manual for troubleshooting.
	Disengaged piston rod/ broken connection/ jammed mechanism	Refer to Maintenance section for module/ actuator disassembly procedures to disassemble appropriate module for inspection.
	Valve problem - jammed	Refer to valve manufacturer's IOM.
Fails to go to the failsafe position	Altered schematics	Check if the control circuit is as per the supplied schematic. Correct the circuit, if altered.
	Control component malfunction/failure	Check and replace
	Choked exhaust silencer/foreign object blocking exhaust line	Remove vent to confirm normal operation. Clean/ replace exhaust silencer.
	Hydraulic return line (S98H) kinked/ blocked or return line filter choked.	Check for damaged hydraulic tubing and repair as required, clean/ replace choked return line filter.
	Spring rod disengaged/connection broken	Refer to Maintenance section for module/ actuator disassembly procedures to disassemble appropriate module for inspection.
	Valve problem - jammed	Refer to valve manufacturer's IOM.

Potential Misuse	Prevention Measures
Use in unintended conditions	Refer to Introduction & Installation sections in this manual and supporting product documentation. If in doubt, contact manufacturer.
Supply pressure greater than the actuator MOP to compensate for valve problems / incorrect selection.	Use of appropriate pressure limiting devices in the supply pressure line to limit the pressure to actuator's MOP is highly recommended and shall be ensured by the end user. Refer to the Maximum Operating Pressure sections in this manual. Actuator MOP is printed on the name plate for ready reference.
Actuator subjected to temperatures out of permissible limits	Refer to name plate and to General Specifications section for the limits of service temperature of the supplied trim. Ensuring the environmental conditions do not cause over the limit temperatures, is end user's responsibility.
Used with operating media that does not conform to specification	Clean dry media of instrumentation grade for pneumatic and for the hydraulic actuator, only the recommended grade of fluids shall be used. Refer to Introduction section of this manual for specs.
Lifting actuator-valve-accessories assembly using lifting lugs on actuator that are meant only for the actuator	Read Warnings in the Installation section of this manual and on the stickers pasted on actuators. Use slings and tackles of sufficient capacity appropriately for lifting assemblies. Actuator weight is printed on the name plate for ready reference.
Pressurizing cap end port on spring return actuators to overcome valve jamming or to compensate valve sealing problems	Refer to Operation Guidelines section of this manual. Pressurizing cylinder to aid spring may cause over load on valve stem and actuator parts resulting in damages to valve/actuator. Do not substitute the vent provided on cap end port of cylinder with a pipe fitting.
Maintenance by unauthorized personnel	See Safety Information section. Do not permit anyone, other than qualified technicians who have read and fully understood the installation and maintenance instructions, to perform any maintenance/adjustments on the actuator.
Maintenance without de-energizing	Refer to Disassembly, Service & Reassembly of Modules section of this manual. Under no circumstances shall attempt be made to disassemble the pressure module or any fastener/plug be loosened, without isolating supply pressure and venting the cylinder ports to atmosphere.
Operating the actuator without end covers	Never operate the actuator in partially disassembled condition or with the Spring Module / Pressure Module end plate removed.
Altering the design to increase spring end load for compensating valve seating problems	Strictly prohibit change of any component design or adding spacers to increase the spring end load. The Spring Rod thread engagement will be compromised and this can have disastrous consequences resulting in equipment damage and/or severe personal injury.

Residual Risks
This document does not cover every detail about every version of the product described. It cannot take into account every potential occurrence in installation, operation, maintenance and use.
End user shall devise and provide adequate protection against hazards such as:
External Fire
Impacts during installation/servicing
Hazardous emissions when Natural Gas is operating media
Contact with metal surfaces due to high/low ambient temperatures or conduction/ radiation
Static electricity.

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