

REGMATIC pneumatic actuators
Technical information and assembly and maintenance procedure

1.- OPERATING AND MAINTENANCE INSTRUCTIONS

1.1 STORAGE

1.1 The actuators should be stored on a dry and warm place in the original package or with the air inlets plugged

2.1 PRECAUTIONS BEFORE DISASSEMBLY

2.1.1 Ensure that the actuator and all of its accessories have been disconnected from the air system and the main electrical circuit.

2.1.2 Remove any solenoid valves from the actuator.

2.1.3 Dismantle the actuator from the valve and from its couplings.

WARNING!!

Wear adequate protective clothing. (Comply with the safety guide lines laid down by your company)

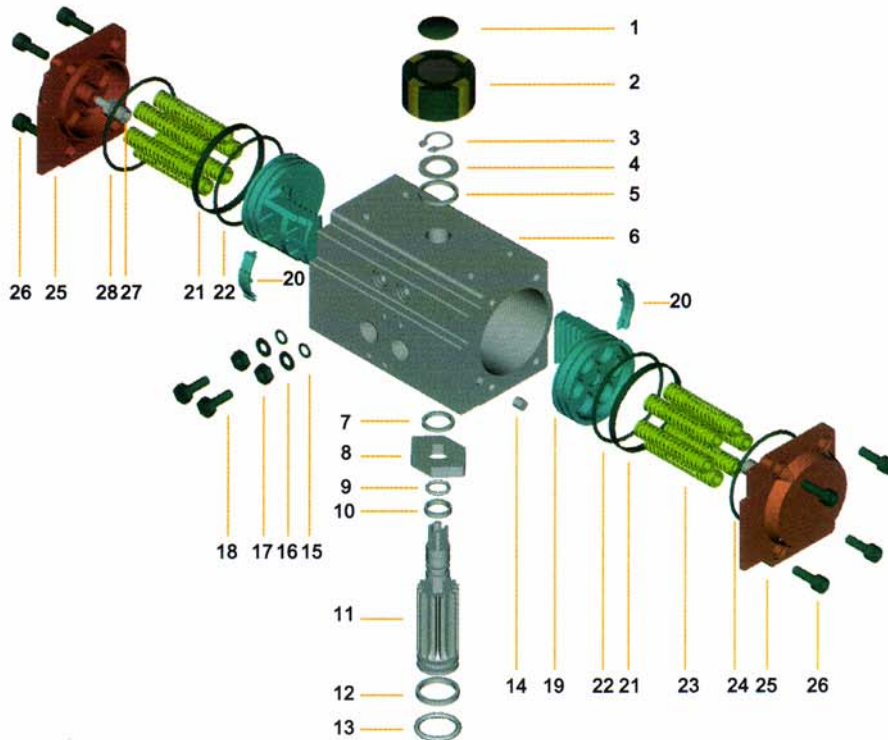
***Any exchange of parts should be made with original REGMATIC spare parts!!
The manufacturer will not be responsible for any malfunctioning of the actuator caused by not using REGMATIC original spare parts!***

3.- REASONS FOR REPAIRING AND PART REPLACEMENT

If a leakage over the O-rings should occur – internally or externally – that might result in higher air consumption and/or lower torque figures from the actuator. Dirt and contaminations in the pressurized air might cause wear on O-rings, on bearings and on metal parts.

On such occasions disassembly, cleaning and reassembly should be made in accordance with the instructions using recommended original spare parts.

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COMPONENTS

ITEM	DETAIL	Qty	MATERIAL	OPTIONS
1	Indicator screw	1	Plastic	
2	Indicator	1	Plastic	
3	Circlip	1	SS	
4	Washer	1	SS	
5	Washer	1	Plastic	
6	Body	1	Hard anodized Aluminium	
7	Washer	1	Plastic	
8	Travel stop	1	Alloy steel	
9	O-ring	1	NBR	Viton, silicone
10	Bearing	1	Plastic	
11	Shaft	1	Nickel plated Alloy steel	SS
12	Bearing	1	Plastic	
13	O-ring	1	NBR	Viton, silicone
14	Seal, air channel	2	NBR	Viton, silicone
15	O-ring	2	NBR	Viton, silicone
16	Washer	2	SS	
17	Locking nut	2	SS	
18	Adjusting screw	2	SS	
19	Piston	2	Hard anodized Aluminium	
20	Bearing plate	2	Plastic	
21	Bearing	2	Plastic	
22	O-ring	2	NBR	Viton, silicone
23	Spring cartridge	0 - 12	Coated spring steel	
24	O-ring	2	NBR	Viton, silicone
25	End cap	2	Polyester coated aluminium	
26	Cap screw	8	SS	
27	Stop screw	2	SS	
28	Nut	2	SS	

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4.- DISASSEMBLY OF THE ACTUATOR

Regarding details see part list on previous page.

4.1 Unscrew the capscrews and remove the end caps.

The capscrews are sufficiently long to ensure that no spring-tension ;on spring return Actuators; remains when the screws are unscrewed.

4.2 Turn the shaft counter clock wise until you can remove the two pistons from the body.

4.3 Disassemble the position indicator the circlip and the washers from the top of the shaft

4.4 Remove the shaft through the bottom of the actuator body.

4.5 Remove the O-rings and bearings and clean all components.

4.6 Inspect all components to detect possible wear. Damaged or worn parts should be replaced.

Please observe !!

Especially check the inside of the cylinder for scoring and damage.

4.7 Provided everything is OK, exchange the washers, O-rings and bearings using our repair kit .

4.8 Apply a film of Molycote B 2-2 plus on the O-rings and lubricate shaft and pistons with the same grease

5.- REASSEMBLY OF THE ACTUATOR

5.1 Assemble the O-rings and bearings and grease moving parts with Molycote B 2-2 according to 4.8

5.2 Insert the shaft and check travel stop (8) is set in the correct position.

5.3 Install the pistons and check that the shaft top is moving 90° correctly so that the top indicator shows "closed" when the pistons are in the inner position.

5.4 Assemble the end caps and the position indicator.

5.5 Operate the actuator to check that the it is working properly.

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6.1 RECOMMENDED SPARE PARTS

See component list on page 2.

Part No	Detail	Number
3	Circlip	1
4	Washer	1
5	Washer	1
9	O-ring	1
10	Bearing	1
12	Bearing	1
13	O-ring	1
14	Seal	2
15	O-ring	2
20	Bearing plate	2
21	Bearing	2
22	O-ring	2
24	O-ring	2

For spring return actuators spring replacement is normally not necessary.

However, they should be checked.

If one spring is damaged, exchange all spring sets on that side.

Check also that the same number of spring sets are used as before – up to 12 – are installed.

For further information, please contact the technical department of:

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