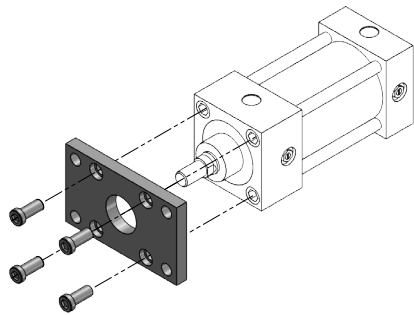


Pneumatic Cylinders - D2-Series Mounting Options

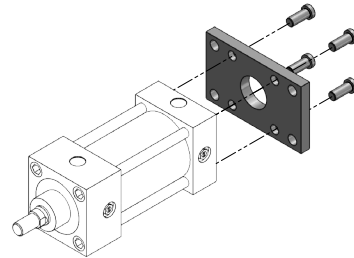
Front or Rear Flange Mount (MF1 or MF2)

For Front or Rear Flange mounting, use the Flange Mount Kit. Use the chart below to select the correct Flange mount for your D2-Series cylinder. Use the drawings below for installation reference.

Part Number	Description	Bore Size	Bolt Size		Torque
			MF1	MF2	
D2FM-1	Steel Flange Mount Kit	1½"	¼ - 28 SHCS x 5/8" Long		57 in-lbs.
D2FM-2	Steel Flange Mount Kit	2"	5/16 - 24 LHCS x ¾" Long		86 in-lbs.
D2FM-3	Steel Flange Mount Kit	2½"			
D2FM-4	Steel Flange Mount Kit	3¼"	3/8 - 24 SHCS x ¾" Long		157 in-lbs.
D2FM-5	Steel Flange Mount Kit	4"			



Front Mount

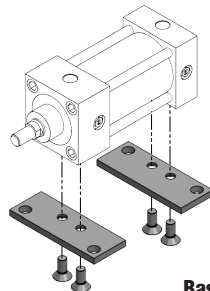


Rear Mount

Base Mount Bracket (Non NFPA)

For base mounting, use the Base Mount Bracket Kit. Use the chart below to select the correct Base Mount Bracket for your D2-Series cylinder.

Part Number	Description	Bore Size	Bolt Size	Torque
D2BB-1	Anodized Aluminum Base Mount Bracket	1½"	¼ -20 FHCS x 5/8" Long	57 in-lbs.
D2BB-2	Anodized Aluminum Base Mount Bracket	2"	5/16 - 18 FHCS x ¾" Long	86 in-lbs.
D2BB-3	Anodized Aluminum Base Mount Bracket	2½"	3/8 - 16 FHCS x 1" Long	
D2BB-4	Anodized Aluminum Base Mount Bracket	3¼"	½ - 13 FHCS x 1" Long	157 in-lbs.
D2BB-5	Anodized Aluminum Base Mount Bracket	4"		

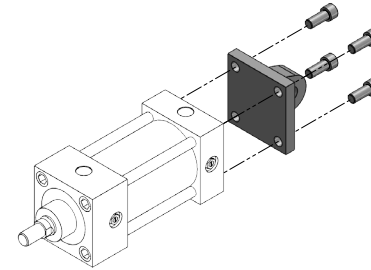


Base Mount

Rear Pivot Mount (MP4)

For Rear Pivot mounting, use the Pivot Attachment Kit. Use the chart below to select the correct Pivot Attachment for your D2-Series cylinder. Use the drawing below for installation reference.

Part Number	Description	Bore Size	Bolt Size	Torque
D2PA-1	Steel Pivot Attachment Mount Kit	1½"	¼ - 28 SHCS x ¾" Long	57 in-lbs.
D2PA-2	Steel Pivot Attachment Mount Kit	2"	5/16 - 24 SHCS x ¾" Long	86 in-lbs.
D2PA-3	Steel Pivot Attachment Mount Kit	2½"		
D2PA-4	Steel Pivot Attachment Mount Kit	3¼"	3/8 - 24 SHCS x 1¼" Long	157 in-lbs.
D2PA-5	Steel Pivot Attachment Mount Kit	4"		

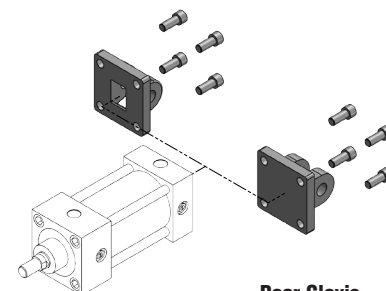


Rear Pivot

Rear Clevis Mount (MP1 or MP2)

For Rear Clevis mounting, use the Rear Clevis Mount Kit. Use the chart below to select the correct Rear Clevis mount for your D2-Series cylinder. Use the drawing below for installation reference.

Part Number	Description	Bore Size	Bolt Size	Torque
D2PC-1	Steel Rear Clevis Mount Kit	1½"	¼ - 28 SHCS x ¾" Long	57 in-lbs.
D2PC-2	Steel Rear Clevis Mount Kit	2"	5/16 - 24 SHCS x ¾" Long	86 in-lbs.
D2PC-3	Steel Rear Clevis Mount Kit	2½"		
D2PC-4	Steel Rear Clevis Mount Kit	3¼"	3/8 - 24 SHCS x 1¼" Long	157 in-lbs.
D2PC-5	Steel Rear Clevis Mount Kit	4"		
D2SPC-1	Steel Short Rear Clevis Mount Kit	1½"	¼ - 28 SHCS x ¾" Long	57 in-lbs.
D2SPC-2	Steel Short Rear Clevis Mount Kit	2"	5/16 - 24 SHCS x ¾" Long	86 in-lbs.
D2SPC-3	Steel Short Rear Clevis Mount Kit	2½"		
D2SPC-4	Steel Short Rear Clevis Mount Kit	3¼"	3/8 - 24 SHCS x 1¼" Long	157 in-lbs.
D2SPC-5	Steel Short Rear Clevis Mount Kit	4"		

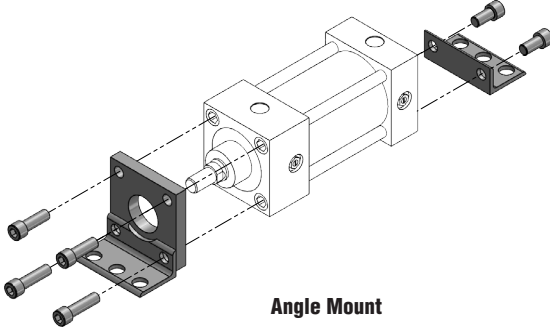


Rear Clevis

Angle Mount Bracket (MS1)

For angle mounting, use the Angle Mount Bracket Kit. Use the chart below to select the correct Angle Mount Bracket for your D2-Series cylinder.

Part Number	Description	Bore Size	Bolt Size	Torque
D2AM-1	Anodized Aluminum Base Mount Bracket	1½"	Head - top screws ¼ -28 SHCS x 7/8" Long Head - bottom screws ¼ -28 SHCS x 1" Long Cap - ¼ -28 SHCS x 5/8" Long	57 in-lbs.
D2AM-2	Anodized Aluminum Base Mount Bracket	2"	Head - top screws 5/16 - 24 SHCS x 15/16" Long Head - bottom screws 5/16 - 24 SHCS x 1 1/8" Long Cap - 5/16 - 24 SHCS x 5/8" Long	86 in-lbs.
D2AM-3	Anodized Aluminum Base Mount Bracket	2½"		
D2AM-4	Anodized Aluminum Base Mount Bracket	3¼"	Head - top screws 3/8 - 24 SHCS x 1 1/4" Long Head - bottom screws 3/8 - 24 SHCS x 1 3/8" Long Cap - 3/8 - 24 SHCS x 3/4" Long	157 in-lbs.
D2AM-5	Anodized Aluminum Base Mount Bracket	4"		

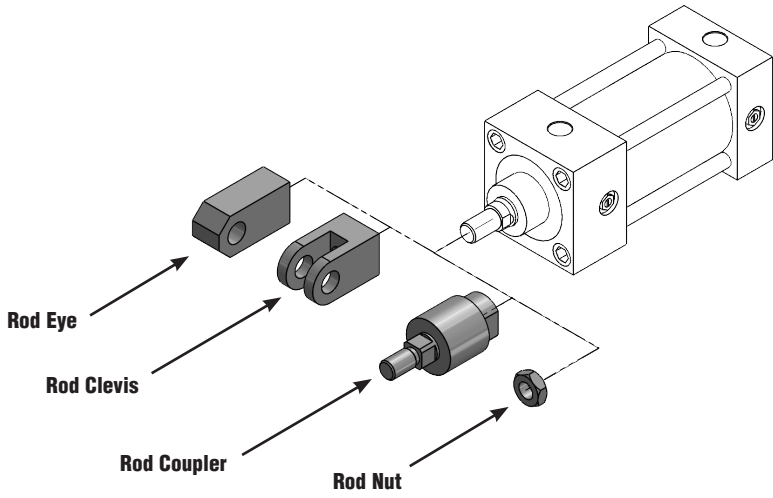


Angle Mount

Rod Accessories

There is a Rod Eye, Rod Clevis and Self-Aligning Rod Coupler to fit each size piston rod. 7/16-20 thread size fits 1-1/2", 2" and 2-1/2" bore cylinders. 3/4-16 thread fits 3-1/4" and 4" bore cylinders. Rod nuts are sold separately.

Part Number	Description	Thread Size	Torque
D2RC-1	Steel Rod Clevis	7/16-20 UNF	40 ft-lbs.
D2RC-2	Steel Rod Clevis	3/4-16 UNF	125 ft-lbs.
D2RE-1	Steel Rod Eye	7/16-20 UNF	40 ft-lbs.
D2RE-2	Steel Rod Eye	3/4-16 UNF	125 ft-lbs.
D2RCP-1	Steel Rod Self-Aligning Rod Coupler	7/16-20 UNF	40 ft-lbs.
D2RCP-2	Steel Rod Self-Aligning Rod Coupler	3/4-16 UNF	125 ft-lbs.
D2-716-20	Steel Rod Nut	7/16-20 UNF	40 ft-lbs.
D2-34-16	Steel Rod Nut	3/4-16 UNF	125 ft-lbs.



Rod Accessories

Torque Guidelines

Part Number	Bore Size	Torque	Part Number	Bore Size	Torque
<i>D24 T-M</i>	1½"	10 ft-lbs.	<i>D224 T-M</i>	1½"	10 ft-lbs.
<i>D32 T-M</i>	2"	15 ft-lbs.	<i>D232 T-M</i>	2"	15 ft-lbs.
<i>D40 T-M</i>	2½"	15 ft-lbs.	<i>D240 T-M</i>	2½"	15 ft-lbs.
<i>D52 T-M</i>	3-1/4"	25 ft-lbs.	<i>D252 T-M</i>	3-1/4"	25 ft-lbs.
<i>D64 T-M</i>	4"	25 ft-lbs.	<i>D264 T-M</i>	4"	25 ft-lbs.

Disassembly

Match the appropriate diagram with your D- or D2-Series cylinder.

Remove four tie-rods (1 or A) and separate cylinder components.

Remove and discard the piston wear strip (2 or B), piston seals (3 or C), tube seals (4 or D), rod seal (5 or E) and rod wiper (6 or F). On D2-Series also remove Bushing Seal (G).

Assembly

Install replacement rod seal (5 or E), rod wiper (6 or F), and piston seals (3 or C) in the orientation shown. On D2-Series replace Bushing Seal (G).

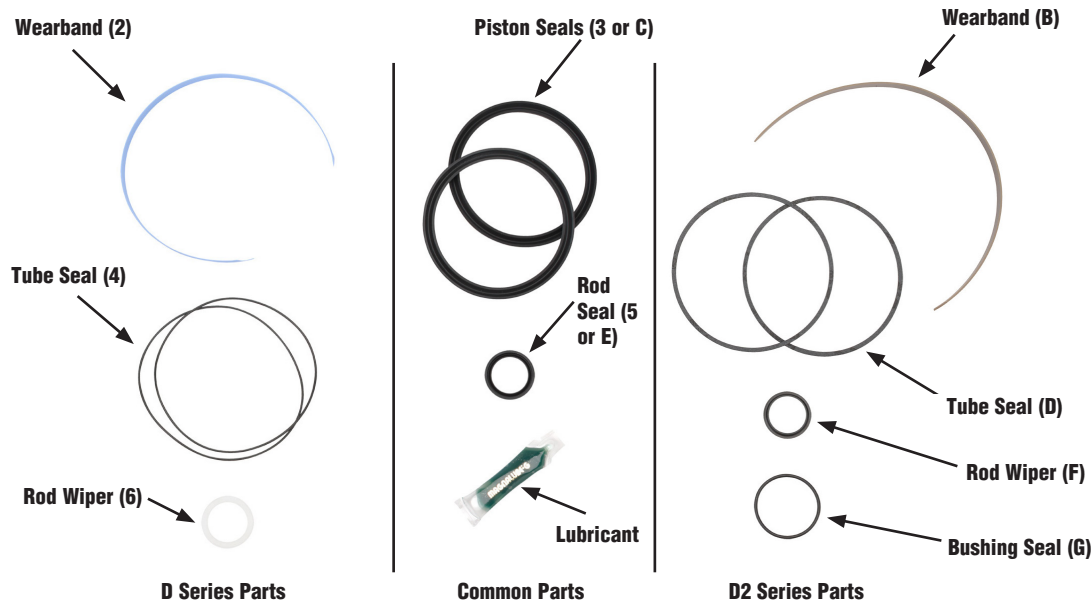
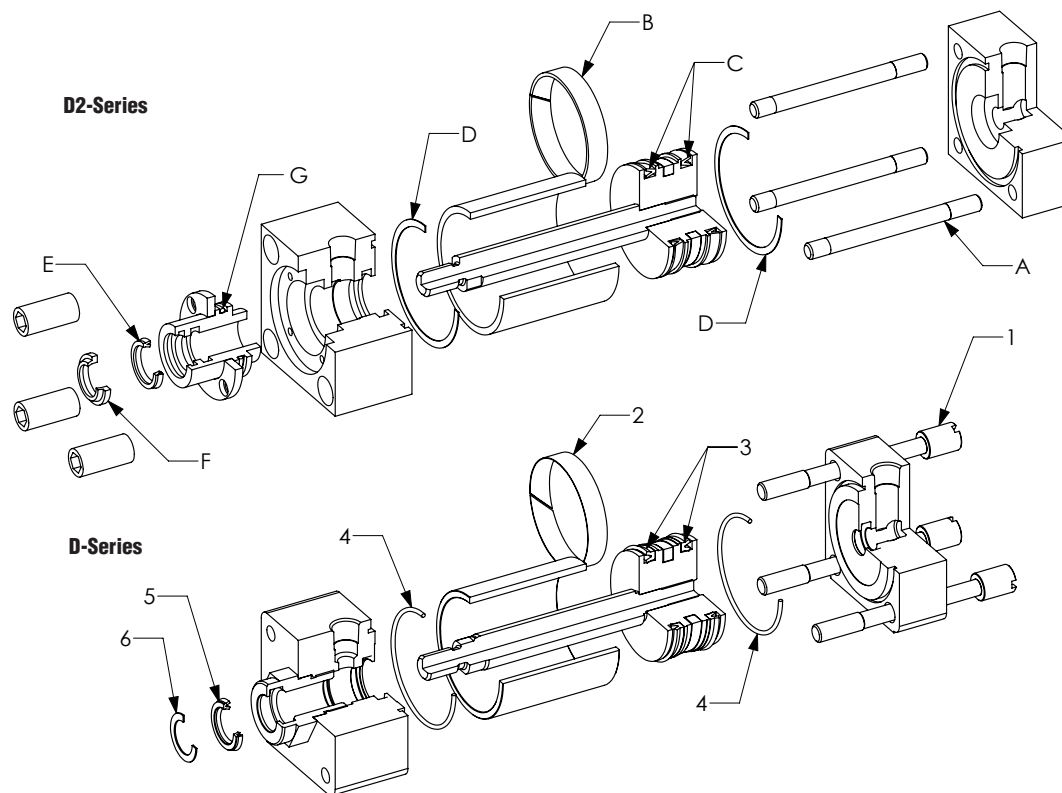
Install replacement tube seals (4 or D) in the grooves on each cylinder head.

Install replacement wear strip (2 or B) in the shallow groove on the piston.

Apply a thin coat of petroleum-based grease to the newly-installed seals to prevent damage while reassembling the cylinder.

Reassemble the cylinder taking care to avoid damaging the seals.

Alternate tightening tie-rods to evenly torque to the provided torque guidelines.



Part Number	Description	Bore Size
<i>D2SK-24</i>	Seal Kit	1½"
<i>D2SK-32</i>	Seal Kit	2"
<i>D2SK-40</i>	Seal Kit	2½"
<i>D2SK-52</i>	Seal Kit	3¼"
<i>D2SK-64</i>	Seal Kit	4"

The D2SK kits contain replacement parts for both D- and D2-series cylinders. Take care to match the appropriate parts for your cylinder.