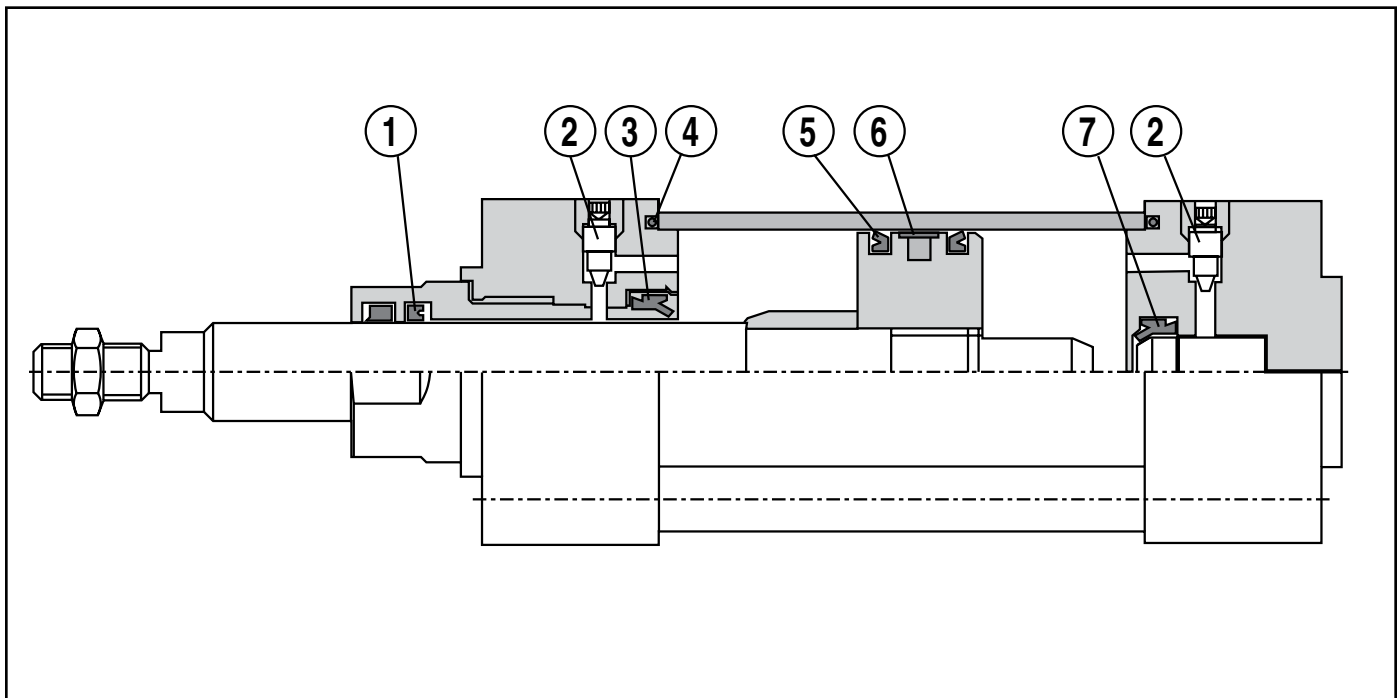


RCS Rod Cylinder Slide – ISO Cylinder Service

RCS20 - 3/4" (20mm) bore • RCS25 - 1" (25mm) bore • RCS32 - 1.25" (32mm) bore

RCS40 - 1.5" (40mm) bore • RCS50 - 2" (50mm) bore



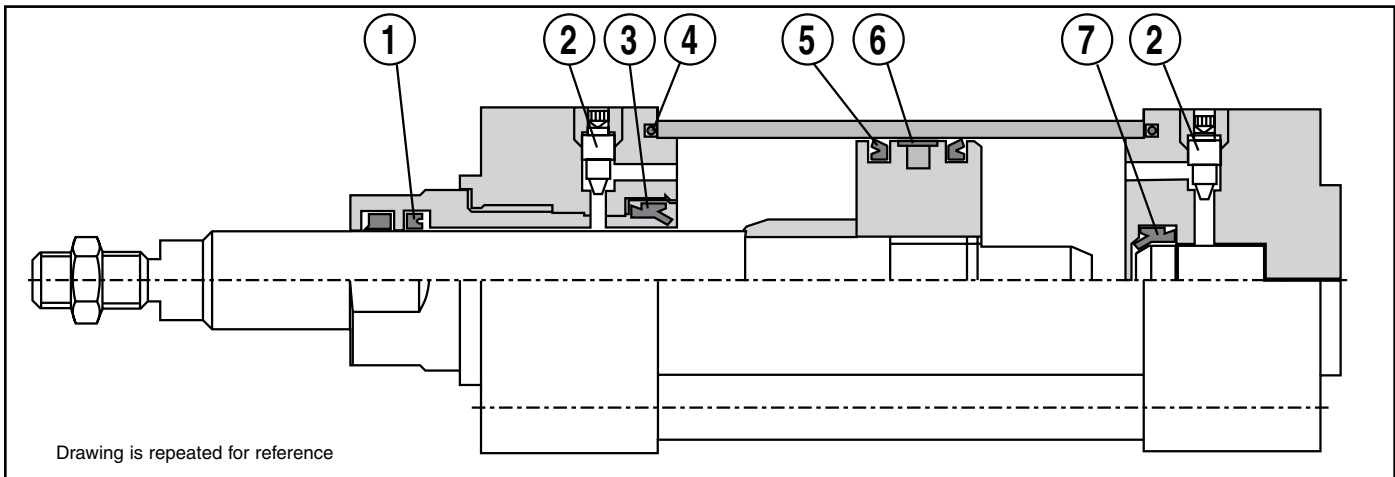
Model Code	Bore Size	Cylinder Seal Kit Number
RCS20	0.75	2220-9008
RCS25	1.00	2225-9008
RCS32	1.25	2230-9008
RCS40	1.50	2240-9008
RCS50	2.00	2250-9008

No longer available
(Feb.2011)

Included Parts

Item #	Description	Qty.
1.	Rod Wiper Seal	1
2.	O-Ring Needle Valve	2
3.	End Cushion Seal, Head	1
4.	O-Ring, Head / Tube	2
5.	Piston Seal	2
6.	Wear Ring	1
7.	End Cushion Seal, Cap	1

▲ NOTE: All components have limited availability



Cylinder Seal Kit - Servicing

1. Disassemble the cylinder completely, remove the old seals and clean all the parts. The cylinder bore, rod and piston should then be examined for evidence of scoring. (The light scratch marks usually present on both cylinder bore and piston will generally have no detrimental effects on the performance of the cylinder.) The piston and rod are securely locked together with anaerobic adhesive. This threaded connection should only be disassembled or reassembled by factory trained personnel.
2. Apply MagnaLube® G or equivalent lubricant to O.D. of piston and all grooves. Install one Piston Seal (#5) in the groove nearest the rod. The two "lips" of this seal should face toward the rod end of the piston. If required, install the magnetic ring in the bottom of the middle groove. Next, install the Wear Strip (#6) in the top of the middle groove.
3. Coat the inside of the cylinder body with lubrication and insert the piston - cap end first - into the cylinder body.
4. Next, turn the cylinder body on its side and push the piston and rod assembly through the barrel just far enough to expose the groove for the second Lip Seal (#5). Be careful not to move the piston too far so as to expose the Wear Strip (#6). If the piston should move too far, push the piston and rod assembly completely through the cylinder body and again start the piston from the original end. Now install the second Lip Seal (#5) in the exposed groove with the two "lips" facing away from the rod and pull the piston into the cylinder body.
5. Clean and lubricate the surface of the piston rod.
6. Lubricate gland seal groove and new Rod Wiper Seal (#1) and install in gland groove. The seal should be installed oriented as shown above.
7. Lubricate and install O-Rings (#4) and Cushion Seals (#3 & #7) onto head and cap.
8. Slide the Head onto the piston rod, being careful not to cut or damage the seals.
9. Install cap onto opposite end, being careful not to damage seals.
10. Install end cap fasteners or tie rods and tighten to appropriate torque.

NOTE: An extreme pressure lubricant should be used on the tie rod threads and bearing faces to reduce friction and tie rod twist.

Model Code	Tie Rod Torque	
	In. / Lbs.	N / m
RCS20	18	2.0
RCS25	25	2.8
RCS32	32	3.0
RCS40	65	7.3
RCS50	80	9.0

Magnalube®-G is a registered trademark of the Carleton-Stuart Corporation, www.magnalube-g.com



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