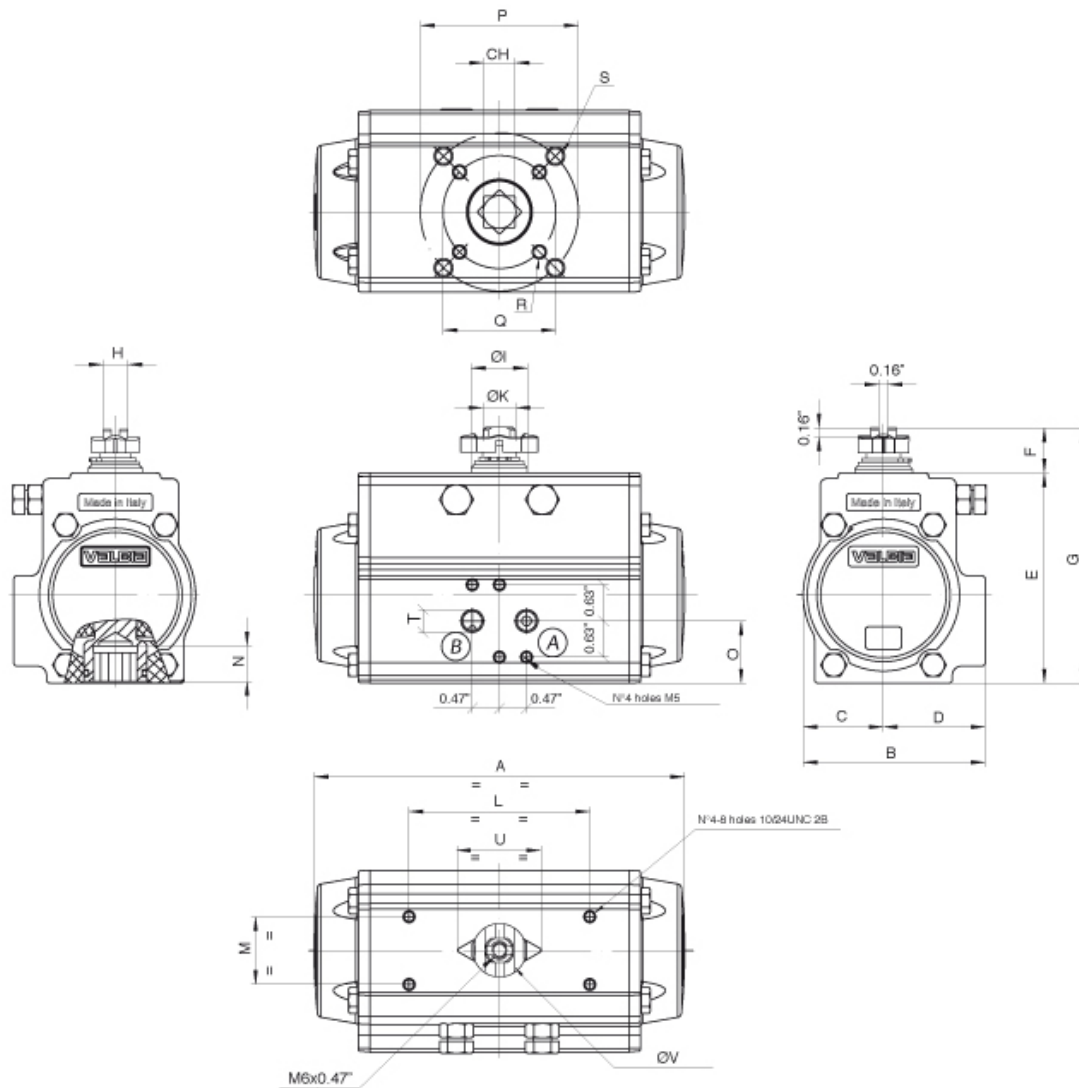


ITEM	DESCRIPTION	MATERIAL	TREATMENT	Q.TA' DA	Q.TA' SR
1	Body	Extruded aluminium	Hard anodized	1	1
2	Anti-blowout pinion	Steel	Nickel plated	1	1
• 3	O-ring	NBR		1	1
• 4	spacer ring	POM		1	1
• 5	O-ring	NBR		1	1
• 6	O-ring	NBR		1	1
7	Cam	Stainless steel		1	1
8	Spacer	POM		1	1
• 9	Spacer	POM		1	1
10	Washer	Stainless steel		1	1
** 11	Snap ring	Steel	Nickel plated	1	1
12	Piston	Die cast aluminium		2	2
• 13	O-ring	NBR		2	2
• 14	Antifriction ring	POM		2	2
• 15	Thrust block	POM		2 [4]	2 [4]
16	Stop bolt retaining nut	Stainless steel		2	2
17	Stop bolt	Stainless steel		2	2
18	External spring	Steel	Painted	0	
*** 19	central spring	Steel	Painted	0	See spring
20	internal spring	Steel	Painted	0	
21	Left end cap	Die cast aluminium	Painted	1	1
22	Right end cap	Die cast aluminium	Painted	1	1
23	End cap seats	NBR		2	2
24	O-ring	NBR		2	2
25	End cap fixing screw	Stainless steel		8	8
26	Position indicator	Thermoplastic rubber TPE		1	1

* Parts subject to wear

** Reinforced series DIN 471 - UNI 7436

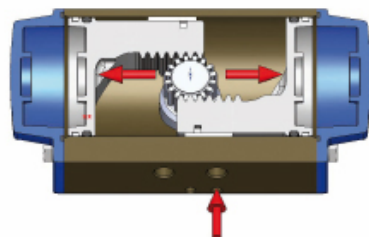


• F04 upon request

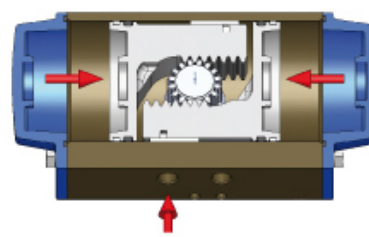
(A) CCW rotation

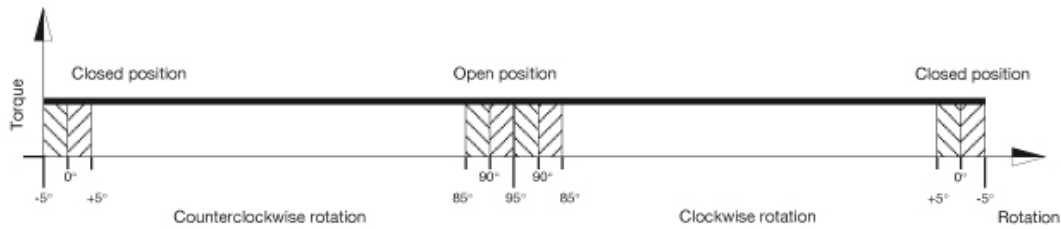
(B) CW rotation

MOD.	DRILLING ISO 5211	CH	A	B	C	D	E	F	G	H	ØI	ØK	L	M	N	O	P	Q	R	S	T NPT	U	ØV
52	F03-F05 *	0.43	5.55	2.80	1.18	1.61	3.37	0.79	4.15	0.39	0.83	0.47	3.15	1.18	0.47	1.04	1.97	1.42	10-24 UNC 2Bx0.29"	1/4-20 UNC 2Bx0.35"	1/8"	1.36	0.87



Top view

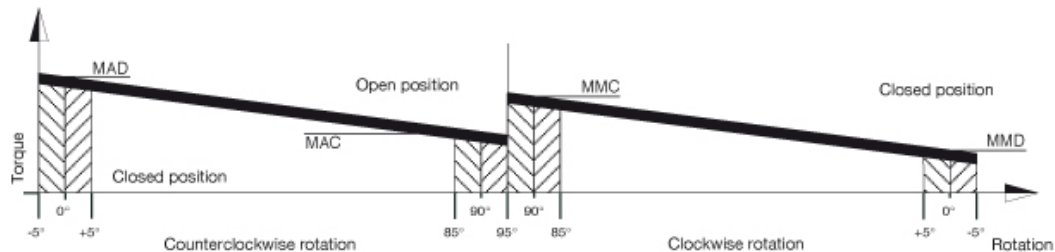
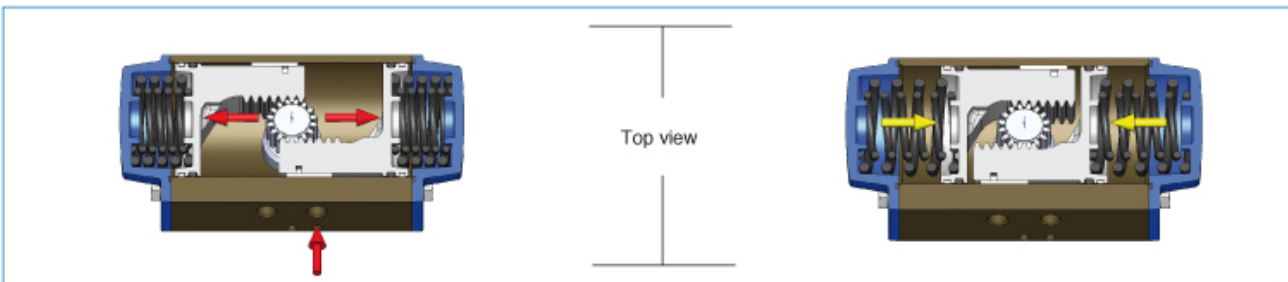




With reference to the above diagram it can be noted that the torque of a double acting actuator remains constant through-out the complete action. The user can decide on which model to choose according to his/her own specific requirements, using the following guidelines:

1. Define the maximum torque of the valve to automate.
2. To obtain a safety factor increase the torque value chosen by 25-50% (subject to the type of valve and working conditions).
3. Once the torque value suggested is obtained consult the torque chart and in relation to the corresponding air pressure find a torque value exact to or exceeding the one obtained.
4. Once the torque value is determined move horizontally to the column "model" to find the actuator model required.

TYPE	AIR SUPPLY PRESSURE (psi)							
	40	50	60	70	80	90	100	115
TORQUE OUTPUT DOUBLE ACTING ACTUATORS (in-Lbs)								
DA 52	88	112	133	158	178	201	227	263



With reference to the above diagram the torque of a spring return actuator is not constant but decreasing. This is due to the action of the springs that when compressed during air actuation counteract the piston movement and accumulate energy which will be available in a decreasing way during the rotation inversion. The torque given by the actuator is defined by four fundamental values.

Opening rotation

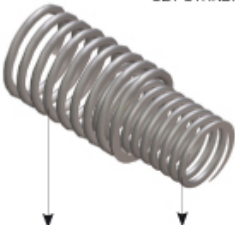
MAD = Actuator torque with unfolded springs
 MAC = Actuator torque with compressed springs.

Closing rotation

MMC = Torque with compressed springs.
 MMD = Torque with unfolded springs

The user can decide on which model to choose according to his/her own specific requirements, using the following guidelines:

1. Define the maximum torque of the valve to automate.
2. To obtain a safety factor increase the torque value chosen by 25-50% (subject to the type of valve and working conditions).
3. Once the torque value suggested is obtained consult the torque chart and in relation to the corresponding air pressure find the torque value exact to or exceeding the one obtained, taking account of the lower value between the MMD and MAC values.
4. Once the torque value is determined move horizontally to the column "model" to find the actuator model required.

SPRING SETTING		
SET STANDARD 05		
		
SET	EXTERNAL SPRING	INTERNAL SPRING
01	1	1
02	2	-
03	1	2
04	2	1
05	2	2

MOD	SET	SPRING TORQUE (Nm)		AIR SUPPLY PRESSURE (psi)															
				40		50		60		70		80		70		100		115	
		0° MMD	90° MMC	0° MAD	90° MAC	0° MAD	90° MAC	0° MAD	90° MAC	0° MAD	90° MAC	0° MAD	90° MAC	0° MAD	90° MAC	0° MAD	90° MAC	0° MAD	90° MAC
SR52 *	1	32	44	48	23	72	47	95	70										
	2	42	59			61	31	84	54	108	77								
	3	46	66					80	47	104	70	127	94	150	117				
	4	57	82					70	31	93	55	116	78	140	101	163	125		
	5	72	105							78	32	101	55	125	78	148	102	183	137

WORKING TIME (SEC)		
COUNTERCLOCKWISE ROTATION (DA)	CCW	0,07
CLOCKWISE ROTATION (DA)	CW	0,05
COUNTERCLOCKWISE ROTATION (SR)	CCW	0,07
CLOCKWISE ROTATION (SR)	CW	0,07

WEIGHT CHART (Lbs)	
DOUBLE ACTING	2,47
SPRING RETURN	2,87

ACTUATOR AIR CONSUMPTION CHART		
COUNTERCLOCKWISE ROTATION (DA/SR)	CCW	6,1
CLOCKWISE ROTATION (DA)	CW	7,93

To obtain the air consumption in NI/min multiply the value in the chart for the correct parameters. That is to say for the supplied absolute pressure and the number of strokes in a minute.