

Published Manual Number/ECN: HBBAB00100/99503N

- Publishing System: TPAS
- Access date: 1/22/01
- Document ECN's: Exact

Kit Instruction—

KBBAB00100

KCBAB00100

KCBAB00200

KDBAB00100

KFBAB00100

Please Read

About the Manual Identifying Information on the Cover

The front cover displays pertinent identifying information for this manual. Most important, are the published manual number (part number) /ECN (date code). Generally, when a replacement manual is furnished, it will have the same published manual number, but the latest available ECN. This provides the user with the latest information applicable to his machine. Similarly all documents comprising the manual will be the latest available as of the date the manual was printed, **even though older ECN dates for those documents may be listed in the table of contents.**

When communicating with the Milnor factory regarding this manual, please also provide the other identifying information shown on the cover, including the publishing system, access date, and whether the document ECN's are the latest available or exact.

References to Yellow Troubleshooting Pages

This manual may contain references to "yellow pages." Although the pages containing troubleshooting procedures are no longer printed on yellow paper, troubleshooting instructions, if any, will be contained in the easily located "Troubleshooting" chapter or section. See the table of contents.

Trademarks of Pellerin Milnor Corporation

The following, some of which may be used in this manual, are trademarks of Pellerin Milnor Corporation:

Ampsaver [®]	Dye-Extractor [®]	Gear Guardian [®]	Milnet [®]	Staph-Guard [®]
Autolint [®]	Dyextractor [®]	Hands-Off [®]	Milnor [®]	System 4 [®]
Auto-Purge [®]	E-P Express [®]	Hydro-Cushion [®]	Miltrac	System 7 [®]
Autovac	E-P OneTouch [®]	Mildata [®]	Miltron	Totaltrol [®]
CBW [®]	E-P Plus [®]			

Comments and Suggestions

Help us to improve this manual by sending your comments to:

Pellerin Milnor Corporation
Attn: Technical Publications
P. O. Box 400
Kenner, LA 70063-0400

Fax: (504) 469-1849

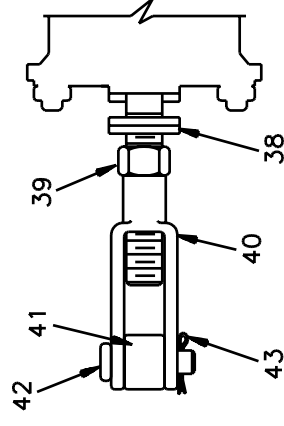
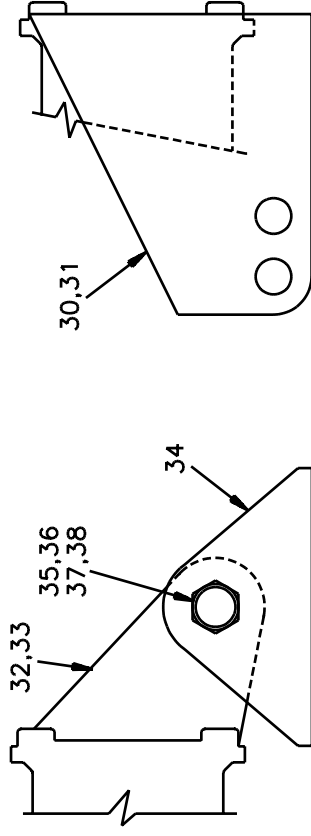
Air Cylinder Assemblies

BMP830078/2000133V
(Sheet 1 of 3)

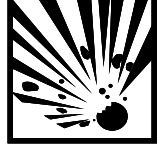


Pellerin Milnor Corporation
P. O. Box 400, Kenner, LA 70063-0400

Litho in U.S.A.

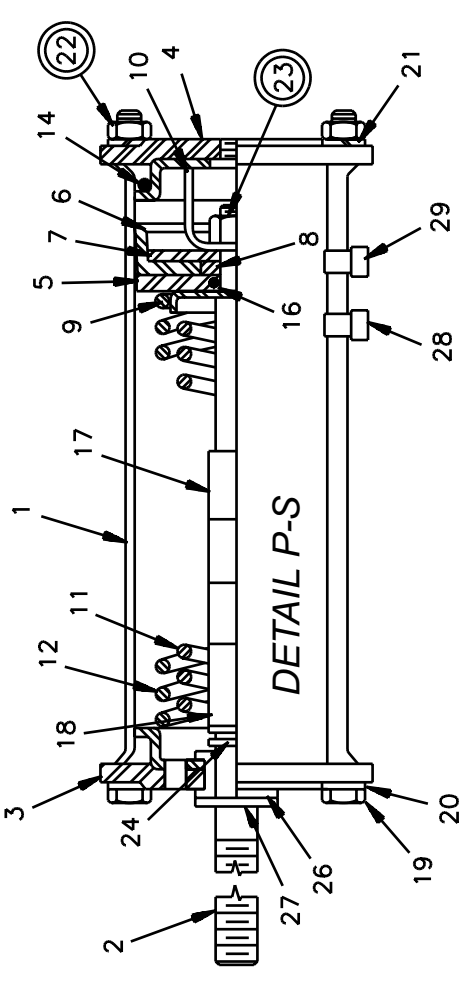
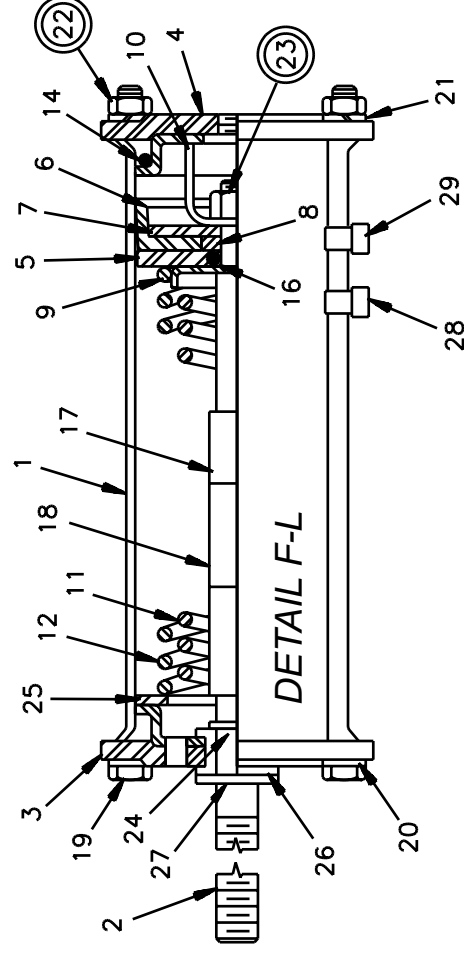
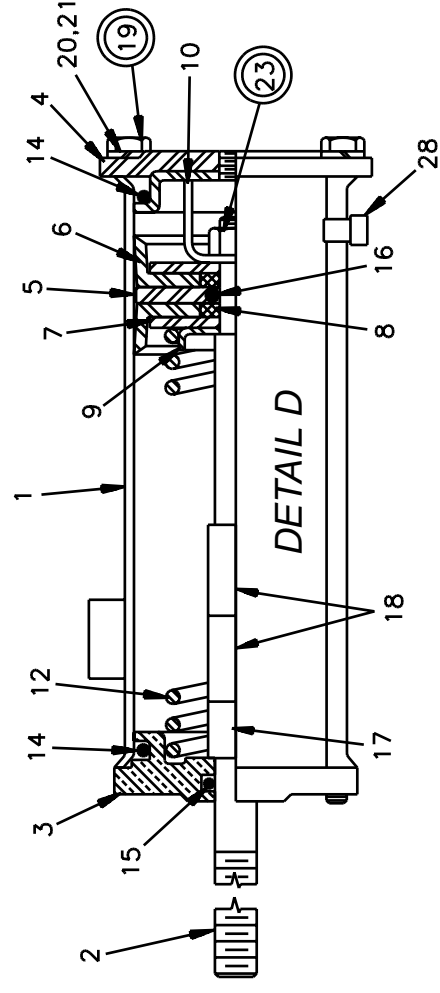
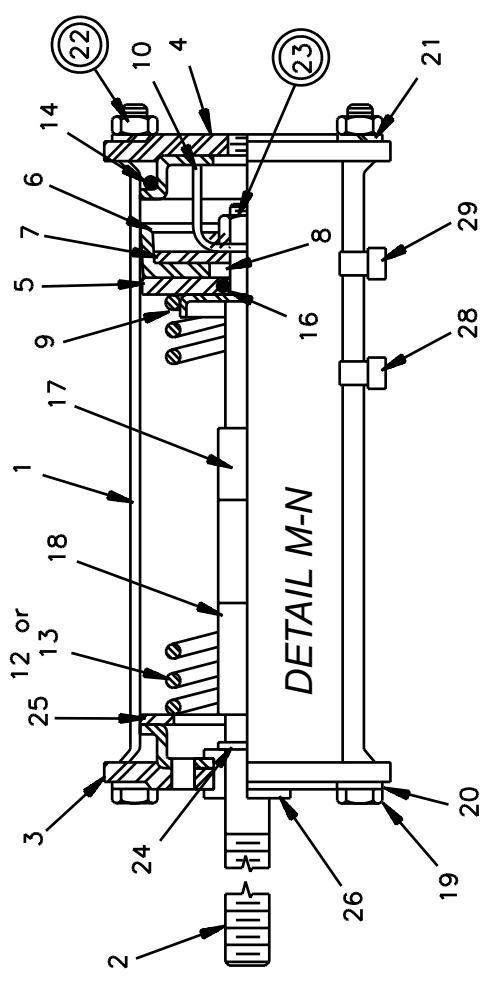
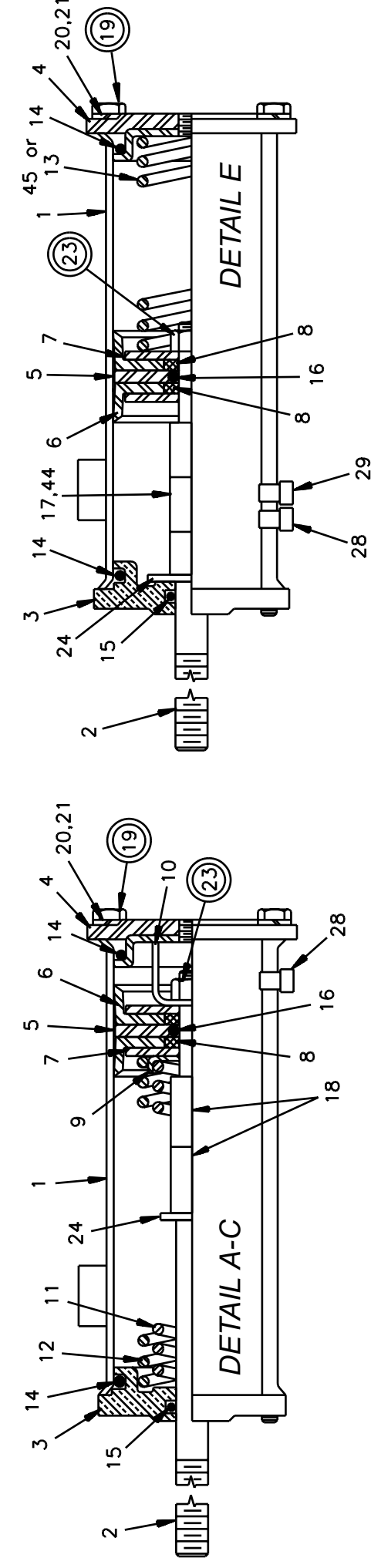


A WARNING



EXPLOSION HAZARD - Air cylinder can burst apart with great force.
Circled items are under high spring tension.
Follow maintenance instructions MSSM0130AE carefully.

AIR CYLINDER MOUNTING HARDWARE





Used In	Item	Part Number	Description	Comments
ASSEMBLIES				
A		SA 36 035	89483V* AIRCYL=BRAKE ASSY	72WP2,WP3,WE3
B		SA 28 128	89483T* BRAKE AIRCYL 2-WAY 60+72SGU	60+72SP2,SP3
C		SA 28 152	89483V* BRAKE AIRCYL 2-WAY 60WE2+3	60WP2,WP3,D3A,DA3
D		SA 10 019A	89483U* BRAKE AIRCYL,2-WAY=42WE+DAU	4231/4244 WP2/WP3 CP2/CP3 NP2/NP3 SP2/SP3
F		A52 00200	89463U* BRAKE AIRCYL=7244 TILT ONLY	72DA1/L/N,DBN, WTL/N,WP1
G		SA 10 019Q	89483T* BRAKE CYL ASSY=4226QWE+DYA	4226DP1,DA1,DYPD5P
H		AAC14001A	90000Z AIRCYL-LONG= 42S6P5G	3621+26Q6X 4226Q4X,Q6X
I		A76AC001A	89463T AIR CYL.2-3/8 BORE 2"STROKE	5840TG2,TS1,TT1
J		A76AC001B	89463@ AIR CYL.2-3/8 BORE 3"STROKE	5840TG2,TS1,TT1
K		A75 01200	89463T* AIR CYL. DAMPER = 3"STROKE	5858+80TG1/2,TS1,TT1
L		A75 01300	89463U* AIR CYL. DAMPER = 2"STROKE	5858+80TG1/2,TS1,TT1
M		SA 10 019	89497U* BRAKE AIRCYL=BALCOM+DIVCYL	
N		AAC14001	90041U* AIRCYL=RATE 50-91 STRK 2.09	3621F8P
P		A25 00600	89457V* BRAKE AIRCYL=52WE1 +52TILT	52LWN/H,WTL/N,WP/E1,DYA
Q		AAC64001	894613* AIRCYL=BRAKE ASSY 6442	64BTL,BTN,BHP, DA1,DAL,DAN
R		AAC65001	93481B AIRCYL=BRAKE ASSY 6446E6N	6446,7246,7258,M7E
S		AAC58001	95000Z AIRCYL=BRAKE ASSY 7258J2N	7258J2N
COMPONENTS				
A-D	1	W2 18646	93344L* CYLINDER-AIR=DOUBLEACT BRAKE	
F-S	1	02 02068	94266A AIRCYL-STAINLESS=DUMPVALVE	
A-D,F-G,S, I-K,M-Q	2	02 18650	96431B STEM=2 WAY AIRCYLINDER BRAKE	
H	2	03 06313A	96431# STEM=AIR CYL 304SS	
L	2	02 18650A	96417B STEM-AIRCYL,UPLOCK PRESS	
R	2	02 18650B	97362B STEM=2WAY AIRCYL BRAKE 7.88L	
A-D	3	02 18660	CYLHEAD-BRASS=2WAY AIRCYL	
F-Q	3	02 02546	CYLHEAD=SLIDESTEM	
R	3	06 20702E	91227B FLOW NOT ACTUATOR CYL HEAD	
S	4	02 02101	71334A CYLHEAD W/TAPPED HOLE	
ALL	5	02 02105	91522A PISTON CUP WASHER STNLS STL	
S	5	02 02105B	92253B 2.38"ACYL BRASS PISCUP WASHR	
ALL	6	02 02194	93217B PISTONCUP=DUMPVALVE 2+3/8"	
ALL	7	02 02085	75161A UP WASHER=2"OD=PISTONCUP	
ALL	8	02 02185	79237A WASHER=PISTON CUP COMP LIMIT	

Parts List, cont.—Air Cylinder Assemblies				
Used In	Item	Part Number	Description	Comments
A-D,F-Q,S	9	02 18651	73171A WASHER=2WAY BRAKECYL	
A-D,F-Q,S	10	03 01313	70219A STOP=AIR CYL W/2+11/16STROKE	
A-C,F-L,P-Q S	11	02 15880	96471B SPRING=BRAKE1.5OD10.3FL17#"	
A,D,F-M,Q,S	12	02 15881	96471# SPRING=BRAKE2.1OD11FL15.5#"	
N	13	02 17023	83392B SPRING-SS=DUMP 1.5OD8FL21#"	
ALL	14	60C132	ORING 2"IDX3/16CS BUNA70 #329	
A-D	15	60C110	ORING 1/2IDX3/32CS BUNA70 #112	
ALL	16	60C106	ORING 5/16ID 1/16CS BUNA70#011	
D,G-J,L-N Q,S	17	27B240	SPCRROLL.5ID.813L.062T STLZNC	
A,C-D,F-Q,L S	18	27B250	SPCRROLL.5ID1.5L.062T STLZNC	
S	19	02 10585E	91142# TIE BOLT=5/16-18X8.25LG PLTD	
ALL	19	02 10585E	91142# TIE BOLT=5/16-18X8.25LG PLTD	
R ONLY	19	W6 20702F	90293B*FLOW NOT VLV=AIR-CYL ROD WLD	
ALL	20	15U200	FLATWASHER(USS STD) 5/16"ZNC PLT	
ALL	21	15U210	LOKWASHER MEDIUM 5/16 ZINCPL	
F-Q	22	15G185	HXNUT 5/16-18UNC2B SAE ZINC GR2	
ALL	23	15G220	02Z LTHX THIN LOKNUT 3/8-24 SSNTE	
A,C,F-G,I-J L,Q,S	24	15U243	FLAWASHER 7/8ODX33/64IDX16GA ZINCPL	
F-N	25	15U520	FLAT WASHER 2+3/8X1+41/64X12GA ZINC	
F-Q,S	26	54E220	NYLNR 8L2FF BUSH 1/2X9/16X.140	
F,K,I-J,Q,S	27	17B012	EXTRETRING IND#1000-50-ST-ZD ZINC	
A	28	20L601R	ID TAG NATL #1614 ALUM EMB LET "R"	
B	28	20L601U	ID TAG NATL #1614 ALUM EMB LET "U"	
C	28	20L601P	ID TAG NATL #1614 ALUM EMB LET "P"	
D	28	20L601X	ID TAG NATL #1614 ALUM EMB LET "X"	
S	28	20L601J	ID TAG NATL #1614 ALUM EMB LET "J"	
F,H,Q,S	28	20L601A	ID TAG NATL #1614 ALUM EMB LET "A"	
G	28	20L601Q	ID TAG NATL #1614 ALUM EMB LET "Q"	
M	28	20L601F	ID TAG NATL #1614 ALUM EMB LET "F"	
N	28	20L601D	ID TAG NATL #1614 ALUM EMB LET "D"	
P	28	20L601V	ID TAG NATL #1614 ALUM EMB LET "V"	
K	28	20L601V	ID TAG NATL #1614 ALUM EMB LET "V"	
I-J,L	28	20L601E	ID TAG NATL #1614 ALUM EMB LET "E"	
F,I-L	29	20L601A	ID TAG NATL #1614 ALUM EMB LET "A"	
G-H	29	20L601F	ID TAG NATL #1614 ALUM EMB LET "F"	
N	29	20L601C	ID TAG NATL #1614 ALUM EMB LET "C"	

Parts List, cont.—Air Cylinder Assemblies

Find the correct assembly first, then find the needed components. The item letters (A, B, C, etc.) assigned to assemblies are referred to in the "Used In" column to identify which components belong to an assembly. The item numbers (1, 2, 3, etc.) assigned to components relate the parts list to the illustration.



Pellerin Milnor Corporation
P. O. Box 400, Kenner, LA 70063-0400

Litho in U.S.A.

Parts List, cont.—Air Cylinder Assemblies

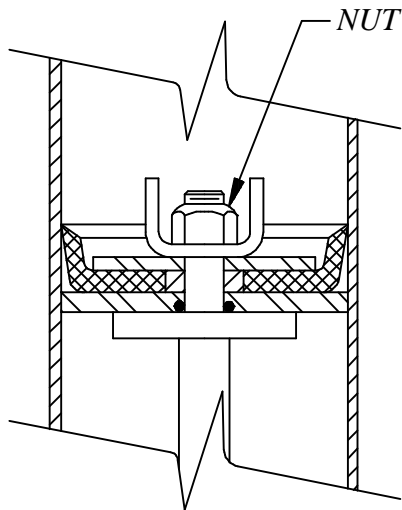
Used In	Item	Part Number	Description	Comments
Q	29	20L601D	ID TAG NAT'L #1614 ALUM EMB LET "D"	
ALL	30	03 06309	70310C RIGHTMOUNT=BRAKE CYL ZNC	RIGHT
ALL	31	03 06308	70310C LEFTMOUNT=BRAKE CYL ZINC	LEFT
ALL	32	02 02550	97437ABRKT=AIRCYL-RIGHT ZINC/CAD	RIGHT
ALL	33	02 02547	LT BRACKET=AIRCYL CAD	LEFT
ALL	34	02 02556	SUPPORT=AIRCYL CADSTL	
ALL	35	27B2750L0T	01Z SPC RROLL.562ID.937L.048T ZNK	
ALL	36	15K206	HEXCAPSCR M5-.8X40MM 18-8SS	
ALL	37	15G235F	HXFNJAMNUT 9/16-12UNC2B ZINC GR2	
ALL	38	15U280	01Z FL+WASHER(USS STD)1/2 ZNC PL+D	
ALL	39	15G230	HXNUT 1/2-13UNC2B SAE ZINC GR2	
ALL	40	17A020	ADJ CLEVIS MACHINED 1/2-13 ZINC PLT	
ALL	41	17A065	01Z EYEEND 1/2-13 X2.25 ZINC	
ALL	42	17A040	CLEVISPIN 1/2"X1+3/8" DRILLED	
ALL	43	15H030	STDCOTTERPIN 3/32X3/4 ZINCPL	
ALL	44	27B34010SZ	SPCROLL.512ID.625L.062T STLZC	
ALL	45	02 17024	94302B SPRING-SS=DUMP 1.5OD4FL40#"	



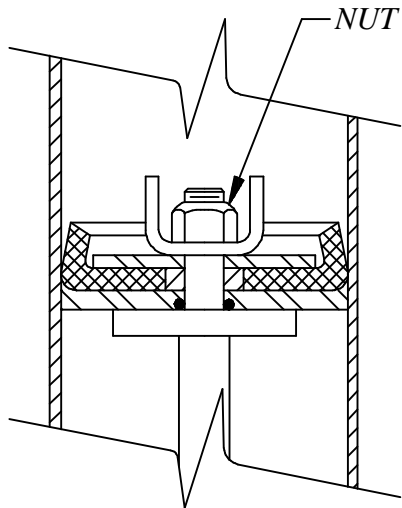
PISTON CUP AND WASHER INSTALLATION

BMP700051/84386V

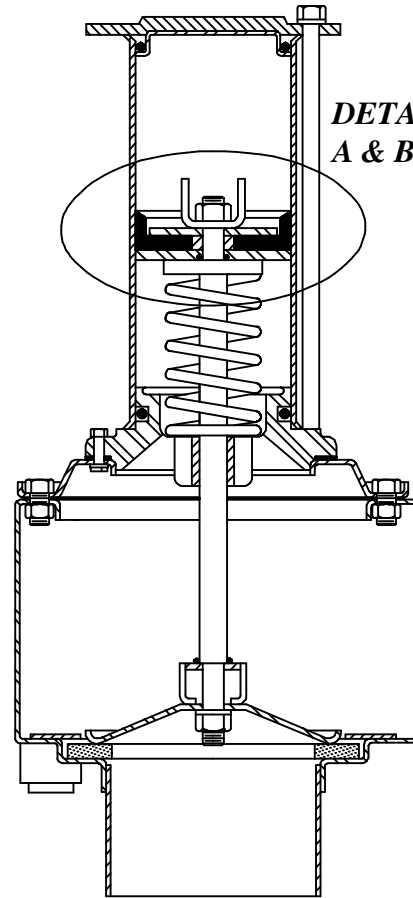
When installing new piston cups in MILNOR automatic dump valves, tighten nut until it is just barely possible to turn the piston cup and washer assembly on the valve. After tightening, the piston cup should appear as shown in Dump Valve Detail A.



**DUMP VALVE
DETAIL A**



**DUMP VALVE
DETAIL B**



DUMP VALVE

Tightening the nut too tight causes the piston cup to extrude to shape shown in Dump Valve Detail B and may cause piston to bind in cylinder.

Note: Nut is self-locking and does not need to be drawn fully tight to lock on to valve stem.