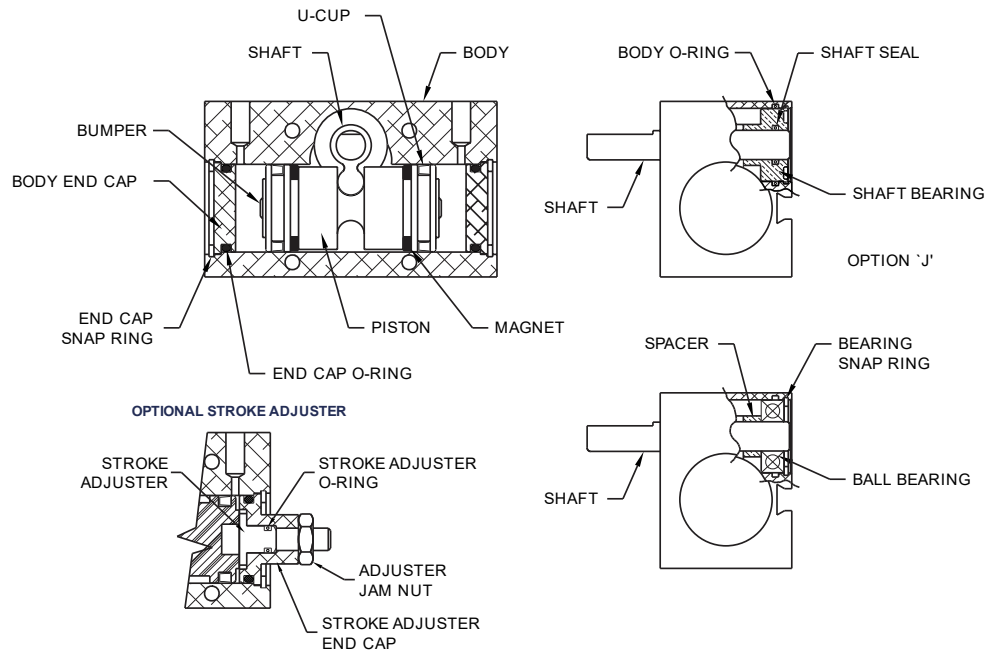


AL75

PART NUMBERS FOR SEAL REPAIR KITS

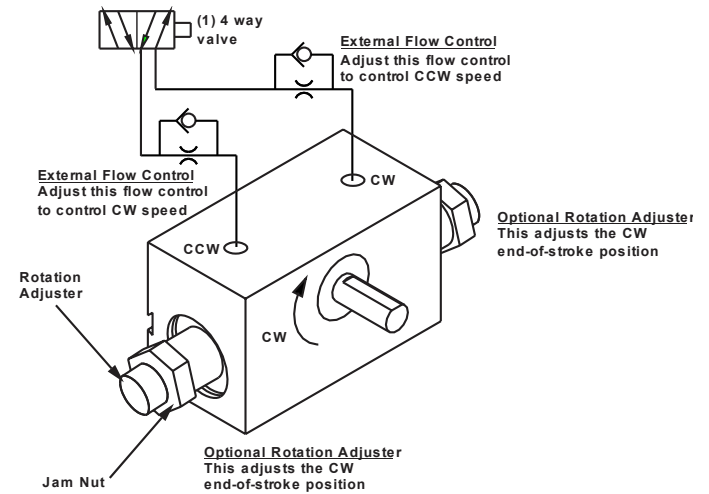
SRK - [AL75] - [A] - [V] If actuator doesn't have option, leave box blank
SERIES ROTATION FKM
ADJUSTERS

EXAMPLES:
SEAL KIT FOR AL75-60-TC-S25 = SRK-AL75-STD
SEAL KIT FOR AL75-90-TC-D25-3A = SRK-AL75-3A
SEAL KIT FOR SPECIAL, SUCH AS AL75-B004 = SRK-AL75-B004
IF PART NUMBER IS NOT KNOWN, PROVIDE UNIT SERIAL NUMBER FROM LABEL OR STAMPED INTO BODY UNDER LABEL.



NOTE:
ORDER PARTS BY PART NAME AND COMPLETE PART NUMBER OR SERIAL NUMBER.

AL75 ROTARY ACTUATOR INSTALLATION AND SETUP



INSTALLATION

Mounting and Alignment

Rotomation AL75 actuators can be mounted on the front and bottom face. The mount holes are tapped into the aluminum body. Tighten mount screws firmly, but do not exceed 19 in. lb. torque for #10-32 threads. Shaft alignment should be accurate and allow free rotation when the actuator ports are vented.

Plumbing

Rotomation AL75 actuators have straight #10-32 thread ports, located as specified. Align connecting plumbing accurately and tighten it carefully to avoid damage to the threads.

Cleanliness

Keep chips and other particulate matter out of ports and all connections to the unit. Remove solvents, adhesives, and sealing compounds from the entire piping system before connection. Include filtration in the system and provide water removal and lubrication facilities in a pneumatic system. If disassembly of a unit is required, do it in clean surroundings. Remove and replace old lubricant.

Adjustments

Rotation adjusters shorten the stroke of the unit. Make the adjustment using a suitable hex key wrench for the adjusting screw and a box or open-end wrench on the locking nut.

Clients Choose Us!

Rotomation's customers have been relying on our actuators and drives for their manufacturing needs for over 50 years. We provide high-quality, rugged products, built to your exact specifications, with unmatched reliability, and unrelenting support.



AL75

AL75 DISASSEMBLY & ASSEMBLY INSTRUCTIONS

DO NOT PERFORM THESE OPERATIONS UNNECESSARILY.

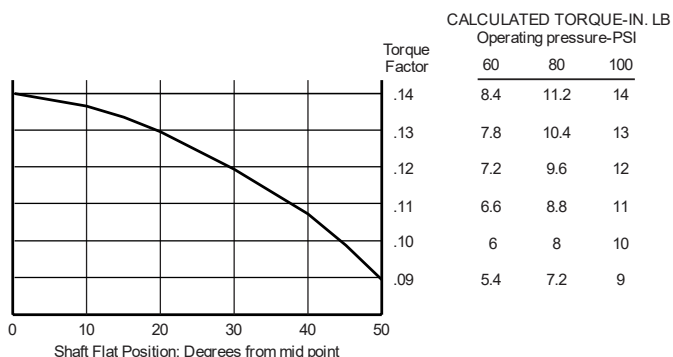
Although the AL75 is fairly simple in construction, care must be taken when disassembling. To disassemble, use the following procedure:

- Remove shaft/lug assembly:** Remove front and rear snap rings, rotate the shaft to mid-rotation starting from the front (shaft projecting side), push the shaft toward the back of the unit. The shaft should move approximately 1/16" which will pull the shaft toward the front of the unit to dislodge the front bearing and remove it. Now remove the shaft/lug assembly upward and out of the unit. See note on next page.
- Remove end caps and piston:** using a small pair of snap ring fliers remove the snap rings at either end of the unit. At this point, the end caps can be removed by rotating the shaft further. An alternate is to apply a small amount of air to one port which will pop the end cap free. Remove the end cap and push the piston through the unit to remove.

To reassembly an AL75 the following is the recommended procedure:

- Install the piston and end caps:** make sure all parts are properly oiled and greased per lubrication requirements. Remove one U-cup from the piston then start that end into the body bore, push the piston through the unit until the U-cup groove projects out of the body enough to allow installing the U-cup. Once the U-cup has been installed push the piston back into the unit until the driving groove is approximately at the center of the unit. It may be necessary to compress the U-cup slightly at the shaft cross bore intersection using a rounded probe so as not to tear the U-cup.
- Installing shaft/lug assembly and bearings:** with the piston centered in the unit, slide the shaft/lug into the bore and lower it into the piston drive groove. Slide the front and rear shaft bearings onto the shaft and into the body until they stop. Check the rotation for smoothness and return to the mid-point. Then install the snap rings.

OPERATING TORQUE CHARACTERISTICS



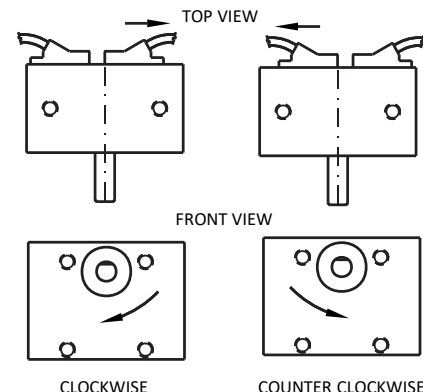
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SETTING MAGNETIC SWITCHES

At the factory, magnetic switches are set to operate at the extreme end of travel in each direction. If conditions require other settings, proceed as follows:

- Clockwise rotation: rotate the unit to the point of the desired sensing. Start with the switch edge approximately at the center of the unit, move the switch slowly to the right until the indicating light comes on. Using a small screwdriver lock the switch in place. Rotate the unit back and forth to check the sensing location. Refer to the view noted "CLOCKWISE" on the right.
- Counter Clockwise rotation: repeat the above procedure using the opposite switch per view noted "COUNTER CLOCKWISE" on the right.



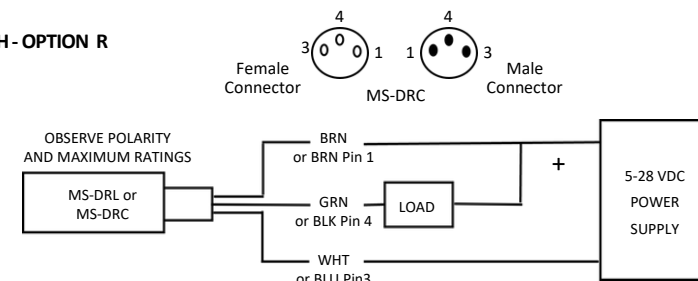
MAGNETIC CONTROL OPTIONS

Optional magnetic pistons and switches may be installed to provide position signals to the control system, usually at the end of the stroke.

ROTOMATION SINKING (NPN) SWITCH - OPTION R

Description and Rating

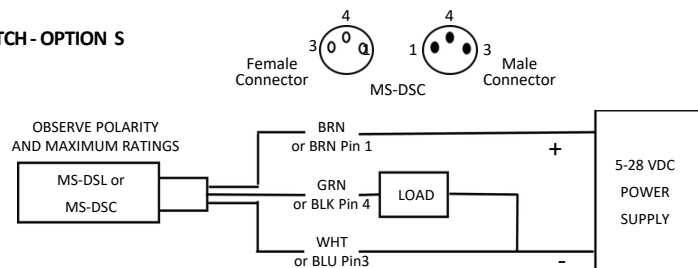
NO sinking (NPN), LED
Switching voltage 5 to 28 VDC
Switching current .2A, Max.
Switching power 4.8W, Max.
Voltage drop .1.0V
Temperature range -20 to +80C
Environment NEMA 6



ROTOMATION SOURCING (PNP) SWITCH - OPTION S

Description and Rating

NO sourcing (PNP), LED
Switching voltage 5 to 28 VDC
Switching current .2A, Max.
Switching power 4.8W, Max.
Voltage drop .1.0V
Temperature range -20 to +80C
Environment NEMA 6



SWITCH LEADS

Description	Specify:
9 ft. PVC cable, 3 conductors, color-coded	L
6 in. pigtail with 8 mm. quick	C

EXTENSION CABLES - ORDER SEPARATELY:

Cables have 8 mm locking connectors to connect to "C" switches, above 3 conductors color-coded brown, black, and blue.

Cable Length	Part Number
2 Meter	MS-CC2
5 Meter	MS-CC5
10 Meter	MS-CC10

ROTOMATION TESTS ALL SWITCHES FOR PROPER FUNCTION BEFORE SHIPMENT AND CANNOT REPLACE THEREAFTER. SWITCHES FROM OTHER MANUFACTURERS HAVE NO GUARANTEE OF COMPATIBLE PERFORMANCE BY ROTOMATION, INC.