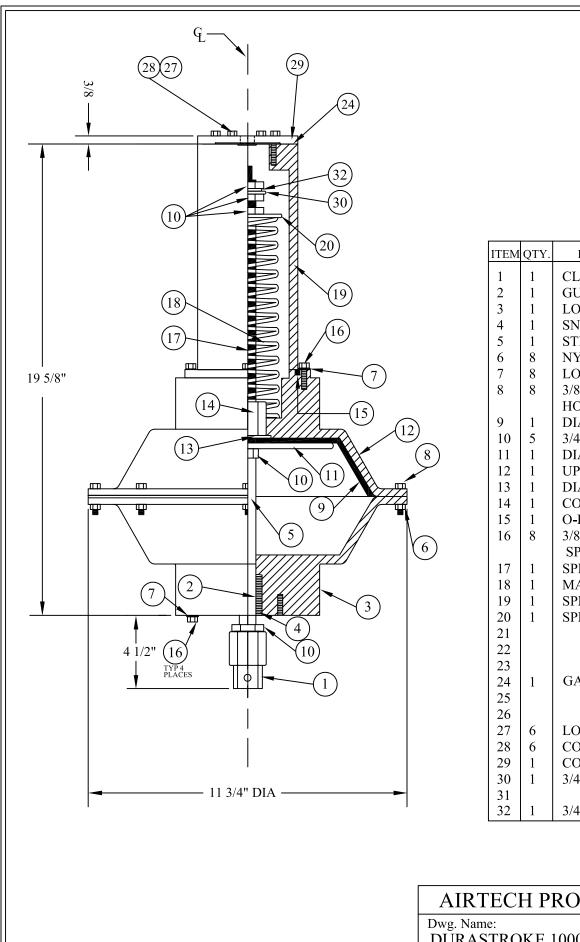


CONVERTING DURASTROKE 1100 PNEUMATIC ACTUTOR TO DURASTROKE 1000.

(Instruction for removing positioner and installing cover plate)

Installation

- 1. Observe all safety precautions make the proper lock outs to ensure the safety of manpower and protection of equipment.
- 2. Remove the six screws holding the positioner and gasket in place. At your option, these parts can be retained or discarded. none will be reused for this modification.
- 3. Remove the positioner (#25), gasket (#24), positioner spring (#22) and positioner washer (# 23) from actuator body.
- 4. Lay the cover gasket (#24) in place and set the cover on top of the actuator housing. Install the six cap screws and tighten in a star pattern until all are firm / snug.



ITEM	QTY.	DESCRIPTION		
1	1	CLEVIS		
2	1	GUIDE BUSHING		
3	1	LOWER HOUSING		
4	1	SNAP RING		
5	1	STEM		
6	8	NYLOCK HOUSING NUT		
7	8	LOCKWASHER		
8	8	3/8"-16 X 1.5"		
		HOUSING SCREW		
9	1	DIAPHRAGM		
10	5	3/4"-16 JAMBNUT		
11	1	DIAPHRAGM PLATE		
12	1	UPPER HOUSING		
13	1	DIAPHRAGM WASHER		
14	1	CONNECTOR NUT		
15	1	O-RING		
16	8	3/8"-16 X 1 1/4"		
		SPRING COVER SCREW		
17	1	SPRING ROD		
18	1	MAIN SPRING		
19	1	SPRING COVER		
20	1	SPRING WASHER		
21				
22				
23				
24	1	GASKET		
25				
26				
27	6	LOCKWASHER		
28	6	COVER PLATE SCREW		
29	1	COVER PLATE		
30	1	3/4" FLAT WASHER		
31				
32	1	3/4" SAE FLAT WASHER		

AIRTECH PRODUCTS, INC.					
Dwg. Name: DURASTROKE 1000-1049 ACTUATOR					
Date: 11-10-15	By: Stewart				
Customer:	File #:				
	AIR MOTOR				

$\begin{array}{ c c c c c c c c c c c c c c c c c c c$	ITEM QTY. 1 1 2 1 3 1 4 1 5 1 6 8 7 8 8 8 9 1 10 5 11 1	DESCRIPTION CLEVIS GUIDE BUSHING LOWER HOUSING SNAP RING STEM NYLOCK HOUSING NUT LOCKWASHER 3/8"-16 X 1.5" HOUSING SCREW DIAPHRAGM 3/4"-16 JAMBNUT DIAPHRAGM PLATE
	12 1 13 1 14 1 15 1 16 8 17 1 18 1 19 1 20 1 21 22 23 1 24 1 25 1 26 6 27 6 28 29 30 1 31 32 32 1	UPPER HOUSING DIAPHRAGM WASHER CONNECTOR NUT O-RING 3/8"-16 X 1 1/4" SPRING COVER SCREW SPRING ROD MAIN SPRING SPRING COVER SPRING WASHER POSITIONER SPRING POSITIONER SPRING POSITIONER WASHER GASKET POSITIONER SCREW 1/4"-20 X 3" POSITIONER SCREW 1/4" S.S. LOCKWASHER 3/4" FLAT WASHER 3/4" SAE FLAT WASHER BODUCTS, INC.
Date:	-11-15	1100-1149 ACTUATOR By: Stewart File #: AIR MOTOR