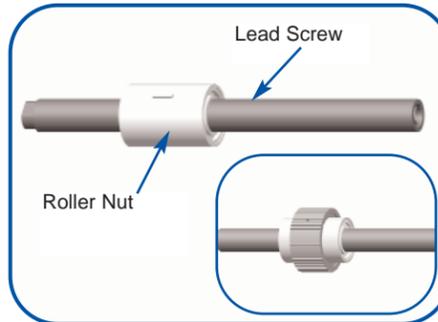


Servo Actuator Assembly

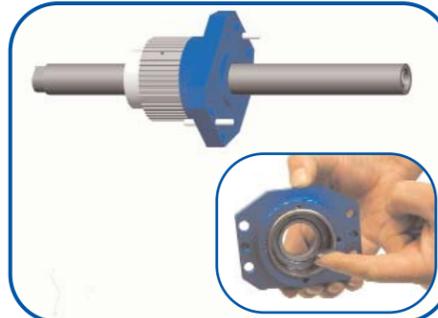
Step 1

Thread the Roller Nut on the Lead Screw. Keep the Lead Screw and Roller Nut together, they are a matched set. Insert the Pulley on the Roller Nut. The Lead Screw has five parallel threads (starts) and it is required to find the one combination that turns most freely.



Step 2

Lubricate the interior of the Bearing End Cap with Pull Dowels (contains pre-installed bearings) using Shell Alvania® Grease EP 2 (or equivalent) and position on to the Lead Screw with the circular side towards the Pulley and Roller Nut.

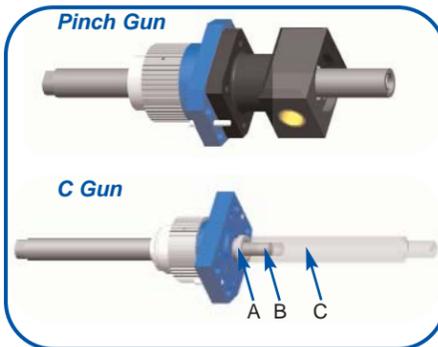


Step 3

Pinch Gun Style
Situates the Front Block on to the Lead Screw.

C Gun Style
Install the Front Connecting Stop (A) and Stud Connecting Rod (B).

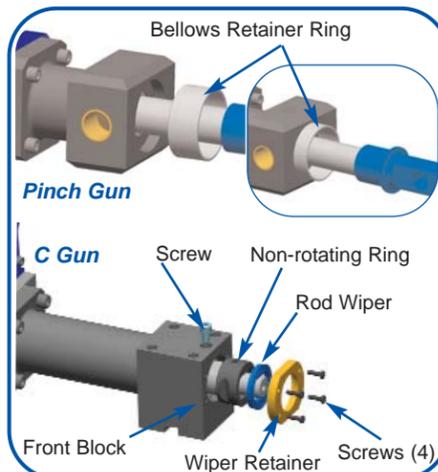
Note: The use of a removable strength liquid threadlocker is recommended.
Position the Working Rod (C) on the Stud Connecting Rod.



Step 4

Pinch Gun Style
Insert the Bellows Retainer Ring into the front block, inserting the end with the wider raised land.

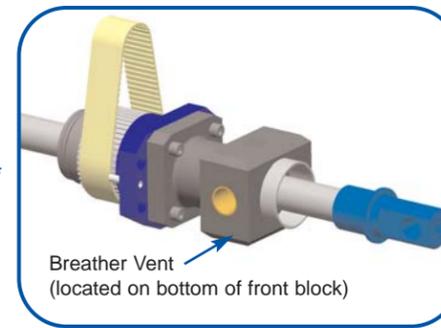
C Gun Style
Situates the Front Block onto the Working Rod and fasten the Non-Rotating Ring. Insert the Rod Wiper, then the Wiper Retainer over the Working Rod. Fasten the four screws.



Step 5

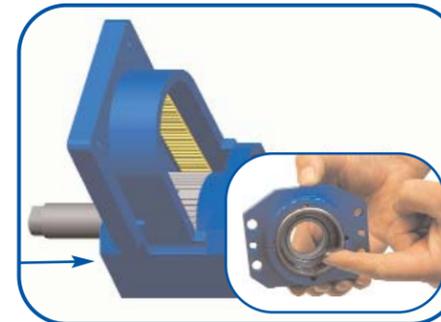
Situates the Belt around the Pulley. Place Servo housing around the Belt and Pulley.

Note: The Breather Vent is located on the bottom of the front block. This helps to keep out any contaminants.



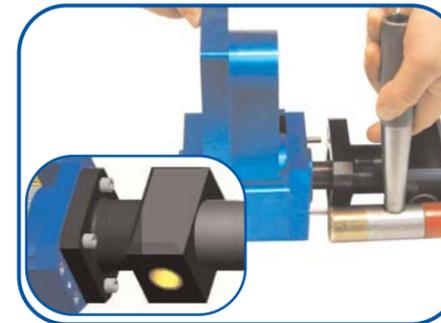
Step 6

Lubricate the interior of the Bearing End Cap without Pull Dowels (contains pre-installed bearings) using Shell Alvania® Grease EP 2 and position on the Lead Screw with circular side toward the Servo Housing. Pull the two Bearing End Caps and Servo Housing together.



Step 7

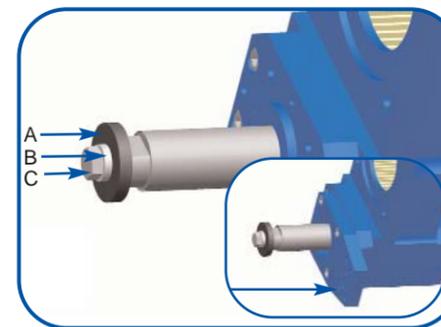
Lightly hammer the Pin-Pull Dowels into the Servo Housing Assembly using a soft hammer. Tighten the socket head screws on the Bearing End Caps to create the Servo Housing Assembly. Align the Front Block Assembly to the Servo Housing Assembly and install and tighten the socket head screws.



Step 8

Insert and tighten the Rod End Stop (A), using Lock Washer (B) and Retaining Bolt (C). Position the Rear Cover over the Lead Screw behind the Servo Housing Assembly.

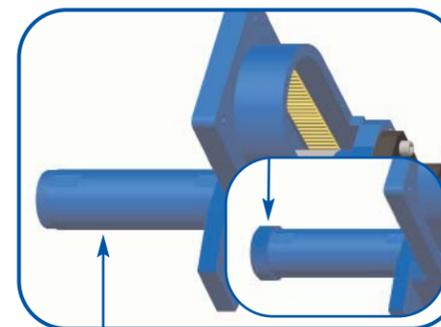
Note: The use of a removable strength liquid threadlocker is recommended for the Retaining Bolt.



Step 9

Position the Rear Cover Tube on to the Lead Screw. Install the Cover Tube End. Do not over tighten.

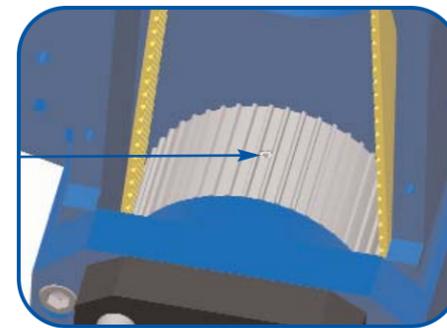
Note: The use of a removable strength liquid threadlocker is recommended.



Step 10

Tighten the set screw on the Pulley in the Servo Housing Assembly.

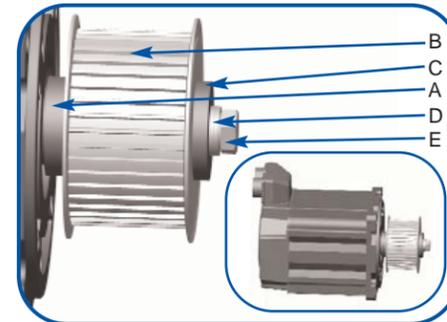
Note: The use of a removable strength liquid threadlocker is recommended.



Step 11

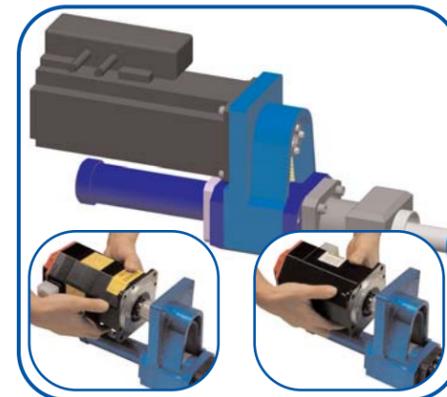
Install the Motor Pulley Spacer (A), Pulley (B), Pulley Retainer (C), Lock Washer (D) and Retaining Bolt (E) on the Servo Motor.

Note: The use of a removable strength liquid threadlocker is recommended for the Retaining Bolt.
Not all CenterLine Servo Actuators have Motor Pulley Spacers.
Some CenterLine Servo Actuators have two or four Retaining Bolts.



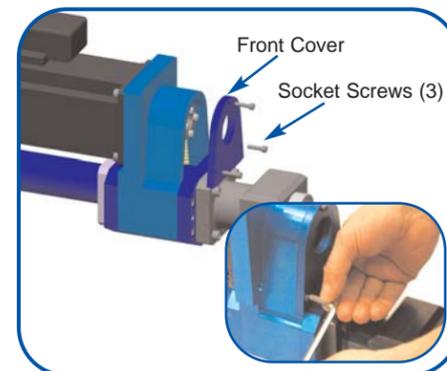
Step 12

Install the Servo Motor by slipping the Servo Motor Pulley under the Belt in the Servo Housing Assembly. Tighten the socket screws to fasten to the Servo Housing Assembly. CenterLine's Servo Actuator enables multiple orientations for numerous brands of Servo Motors to suit nearly any application.



Step 13

Situates the Front Cover on the front of the Servo Housing Assembly and tighten the socket screws.



Step 14

Install the Override Plug (with O Ring) and tighten accordingly. Slide both the Gear Clamp and Bellows over the Bellows Retainer Ring. Tighten the Screw on the Gear Clamp.

