

GH-BETTIS
INSTRUCTIONS FOR
INITIALLY SETTING TRAVEL STOP SCREWS
ON
CB & NCB DOUBLE ACTING SERIES ACTUATORS

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INSTRUCTIONS FOR INITIALLY SETTING TRAVEL STOP SCREWS ON CB & NCB DOUBLE ACTING SERIES ACTUATORS

PURPOSE

These instructions are to be used when setting travel stops on CB Double Acting actuators prior to mounting on operated devices, i.e. valves and dampers, etc.

REFERENCE GH-BETTIS MATERIALS

CB315, CB420, and CB525 Assembly Drawing Part Number 41005.

CB520 and CB725 Assembly Drawing Part Number 35053.

PROCEDURE

Using a wrench, manually rotate the torque shaft clockwise. The actuator must be positioned such that the cylinder is to the left of the housing and the milled flats on the torque shaft are approximately parallel to the cylinder axis (horizontal).

Ensure the actuator is positioned correctly by leveling the cylinder. Using a level on the cylinder, align the actuator to be horizontal. All adjustments must be made with the actuator in this leveled position.

Make sure that the housing stop screw is screwed in all the way to the hex nut. Apply air pressure to the cylinder post so that the actuator is stroked against the housing stop screw. Using a level, adjust the housing stop screw so that the milled flats are horizontal and level.

Ensure that the cylinder stop screw is screwed in all the way to the hex nut. Apply air pressure to the housing port so that the actuator is stroked against the cylinder stop screw. Using a level, adjust the cylinder stop screw so that the milled flats are vertical.

CAUTION: Do not exceed air pressure rating on name tag at any time. It may be necessary to relieve air pressure while adjusting the stop screw.

When the above procedure is performed correctly the actuator will have a travel of 90° centered in its travel range. This will permit a maximum of 5° overtravel in both directions.

COMPLETION

The stop screw setting is now complete. Release the air pressure and disconnect the air supply. The actuator is now ready to install.

CAUTION: The stop screws must not be rotated counter clockwise more than five full turns. Actuator malfunction may result from improper adjustment of travel stops. Torque shaft may become disconnected from internal mechanism.

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