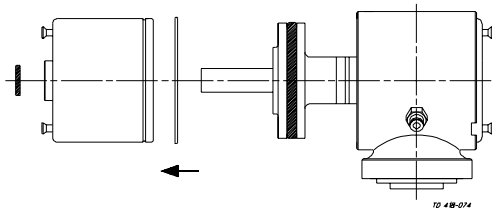


Study the instructions carefully.
The items refer to the drawings and parts list on pages 28-39.

Handle scrap correctly.

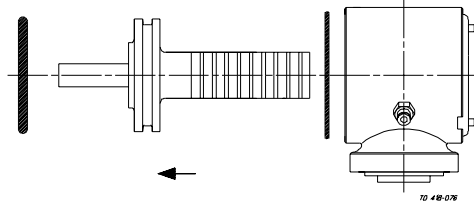
4. Dismantling of actuator, type 631/632

1



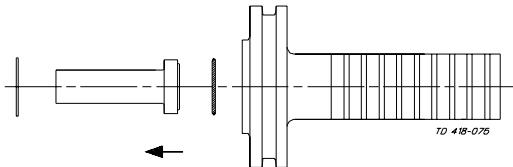
1. Turn cylinder (16 or 16a) anticlockwise to unhook lock wire (19) and remove the lock wire (turn the cylinder slightly clockwise to loosen the lock wire).
2. Remove the cylinder from chassis (1).
3. Pull out O-ring (15) from cylinder (16a) (only with indication) (only remove cylinder (17) if damaged).

2



1. Pull out piston (10) from chassis (1). (For sizes 89-101.6 mm/DN80-100: both pistons).
2. Pull off O-ring (11) from the piston. (For sizes 89-101.6 mm/DN80-100: both O-rings from both pistons).

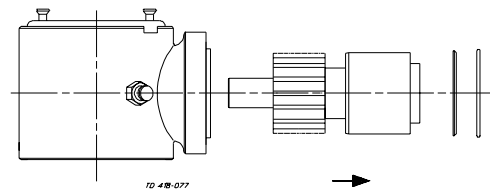
3



Only cylinders with indication:

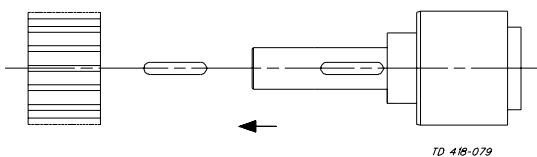
1. Remove circlip (14) from piston (10).
2. Take out indication stem (12) from the piston.
3. Pull off O-ring (13) from the indication stem.

4



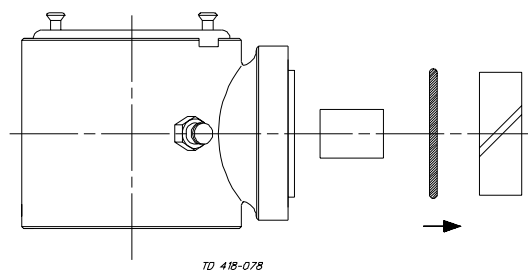
1. Remove lock ring (9) and bearing (8) from chassis (1).
2. Pull out spindle (2) from the chassis/piston.

5



Remove gear wheel (4) and wedge (3) from spindle (2).

6



Pull out guide ring (7), O-ring (6) and bearing (5) from chassis (1). Tap the bearing loose with a rubber hammer, if necessary.

Maintenance

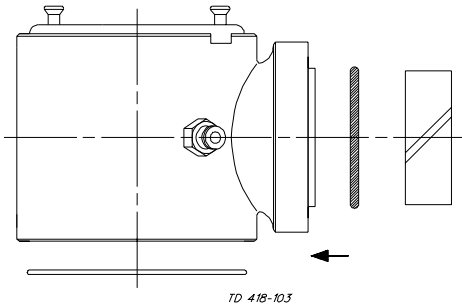
18

Study the instructions carefully.
The items refer to the drawings and parts list on pages 28-39.

Lubricate all O-rings with silicone oil or similar before reassembly.

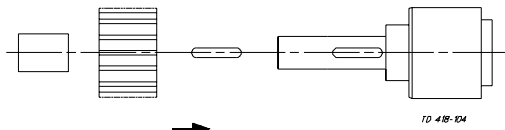
5. Reassembly of actuator, type 631/632

1



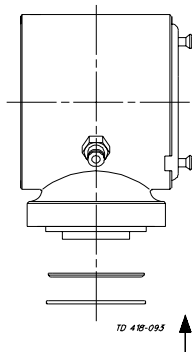
Fit guide ring (7) and O-rings (6,18) in chassis (1).

2



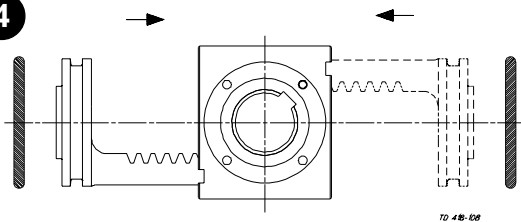
1. Fit wedge (3), gear wheel (4) and bearing (5) on spindle (2) (lubricate).
2. Guide/work the spindle into the chassis.

3



Fit bearing (8) and lock ring (9) into chassis (1).

4

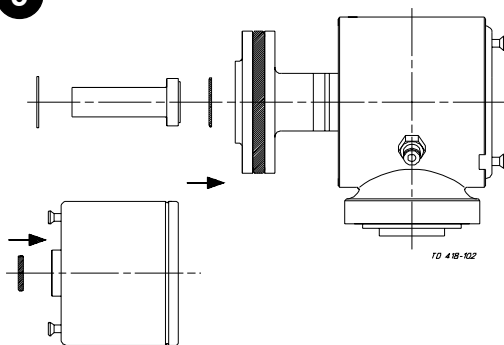


1. Adjust spindle (2) so that the notch has a 45° angle to piston(s) (10).
2. Position the piston(s) along the opposite inner sides of chassis (1) (lubricate teeth on piston(s) with grease type Longterm plus 2).
3. Press piston(s) into the chassis (at the same time for sizes 89-101.6 mm/DN80-100) (check that the notch has the correct angle to the piston(s)).
4. Slide O-ring(s) (11) onto the piston(s).

WARNING!

Make sure that the lock ring is fitted well in its groove.

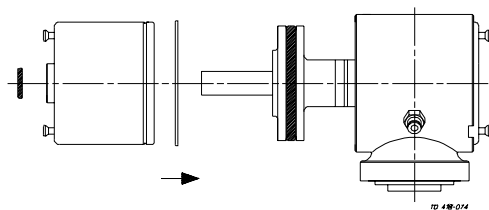
5



Only with indication:

1. Slide O-ring (13) onto indication stem (12).
2. Fit the indication stem in piston (10).
3. Fit circlip (14) in the piston.
4. Fit O-ring (15) in cylinder (16a).

6



1. Fit cylinders (16/17) in the chassis (the notch in the chassis must be aligned with the dent in each cylinder).
2. Hook in lock wires (19) and turn each cylinder clockwise until the end of the lock wire slips into the notch in the chassis (turn cylinder slightly back to secure lock wire).

Drawing/Parts list

The drawings and the parts list include all items.

The items are identical with the items in the Spare Parts List.

When ordering spare parts, please use the Spare Parts List!

Parts list Actuator type 631/632

28

Item	Quant.	Denomination
1	1	Chassis
2	1	Spindle
3	1	Wedge
4	1	Gear wheel
5	1	Bearing
6 Δ	1	O-ring
7 Δ	1	Guide ring
8 Δ	1	Bearing
9	1	Lock ring
10	1	Piston
	2	Piston (type 631, sizes 80-101.6)
	2	Piston (type 632, sizes 80-101.6)
11 Δ	1	O-ring
	2	O-ring
	3	O-ring (type 633, sizes 25-76.1)
	4	O-ring (type 633, sizes 89-101.6)
12	1	Indication stem
a	1	Indication stem for telescope indication
b	1	Spring for telescope indication
c	1	Screw for telescope indication
d	1	Extension stem for telescope indication
13 Δ	1	O-ring
14	1	Circlip
15 Δ	1	O-ring
16	1	Cylinder
	2	Cylinder (type 630, sizes 63-76.1)
	2	Cylinder (type 633, sizes 89-101.6)
a	1	Cylinder for indication
17	1	Cylinder
18 Δ	2	O-ring
19	2	Lock wire
20	1	Bonnet
21	4	Screw
22	1	Spring (type 630, sizes 25-51)
	2	Spring (type 630, sizes 63-76)
23	1	Lock wire (type 630, sizes 25-51)
	2	Lock wire (type 630, sizes 63-76.1)
24	1	Flange
25	1	Flange for indication
26	1	Cylinder lid
a	2	Screw
27	1	Screw for indication stem
28	1	Auxiliary cylinder (type 633, sizes 25-76.1)
	2	Auxiliary cylinder (type 633, sizes 89-101.6)
29	1	Auxiliary piston (type 633, sizes 25-76.1)
	2	Auxiliary piston (type 633, sizes 89-101.6)
30 Δ	1	O-ring (type 633, sizes 25-76.1)
	2	O-ring (type 633, sizes 89-101.6)
31	1	Lock wire (type 633, sizes 25-76.1)
	2	Lock wire (type 633, sizes 89-101.6)
32	1	Air fitting (type 630)
	2	Air fitting (type 631, 632)
	3	Air fitting (type 633, sizes 25-76.1)
	5	Air fitting (type 633, sizes 89-101.6)
33	1	Guide for indication
34	1	Spindle extension (only for size 25)

Δ : Recommended Spare Parts.

This page shows an exploded drawing of KOLTEK.

The drawing includes all items of the actuator.
They are identical with the items in the Spare Parts List.

Exploded drawing

