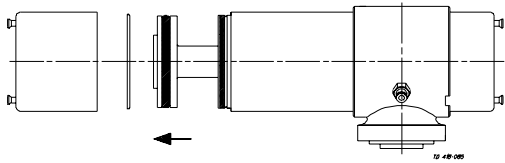


Study the instructions carefully.  
The items refer to the drawings and parts list on pages 28-39.

Handle scrap correctly.

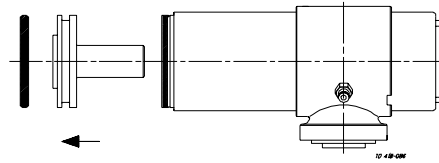
## 4. Dismantling of actuator, type 633

1



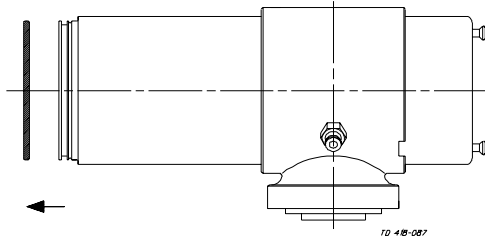
1. Turn auxiliary cylinder (28) anticlockwise to unhook lock wire (31).
2. Remove the auxiliary cylinder from cylinder (16).

2



1. Pull out auxiliary piston (29) from cylinder (16).
2. Pull off O-ring (11) from the auxiliary piston.

3

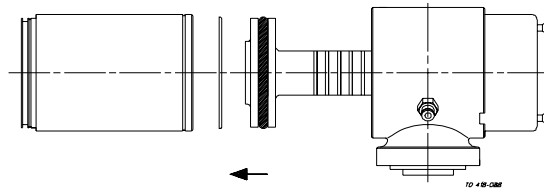


Pull off O-ring (30) from cylinder (16).

**NOTE!**

For sizes 89-101.6 mm/DN80-100, instructions 1-3 on this page are repeated.

4



1. Turn cylinder (16) anticlockwise to unhook lock wire (19). Use a strapping tool to turn the cylinder.
2. Remove the cylinder from chassis (1).
3. Repeat this procedure for cylinder (17), if necessary.

5

Continue the dismantling by following instructions 2-6 on page 15.

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

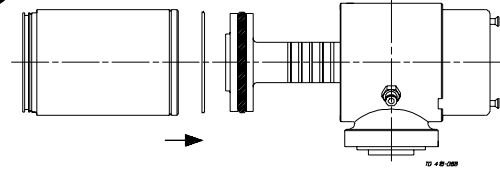
Lubricate all O-rings with silicone oil or similar before reassembly.

## 5. Reassembly of actuator, type 633

1

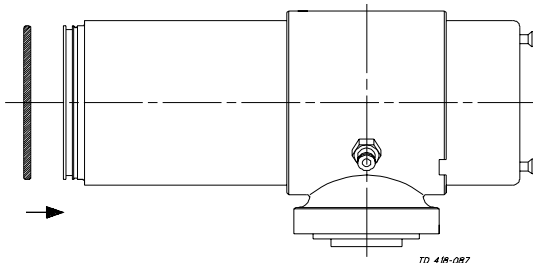
Reassemble the actuator by following instructions 1-3 on page 18. Then proceed by following instructions 2-5 on this page.

2



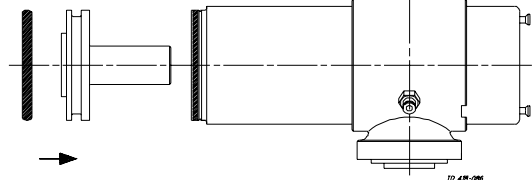
1. Fit cylinder (16) in chassis (1) (the notch in the chassis must be aligned with the dent in the cylinder).
2. Hook in lock wire (19) and turn the cylinder clockwise until the end of the lock wire slips into the notch in the chassis. Use a strapping tool (turn the cylinder slightly back to secure the lock wire).
3. Fasten cylinder (17) to the chassis the same way (if dismantled).

3



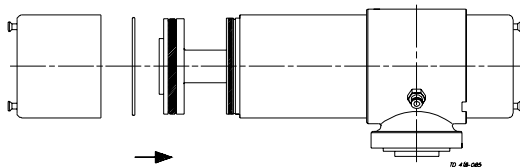
Fit O-ring (30) on cylinder (16).

4



1. Fit O-ring (11) on auxiliary piston (29).
2. Guide the auxiliary piston into cylinder (16).

5



1. Fit auxiliary cylinder (28) on cylinder (16).
2. Hook in lock wire (23) and turn the auxiliary cylinder clockwise until the end of the lock wire slips into the hole in the cylinder.

**NOTE!**

For sizes 89-101.6 mm/DN80-100, instructions 3-5 on this page are repeated.

# 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 633

36

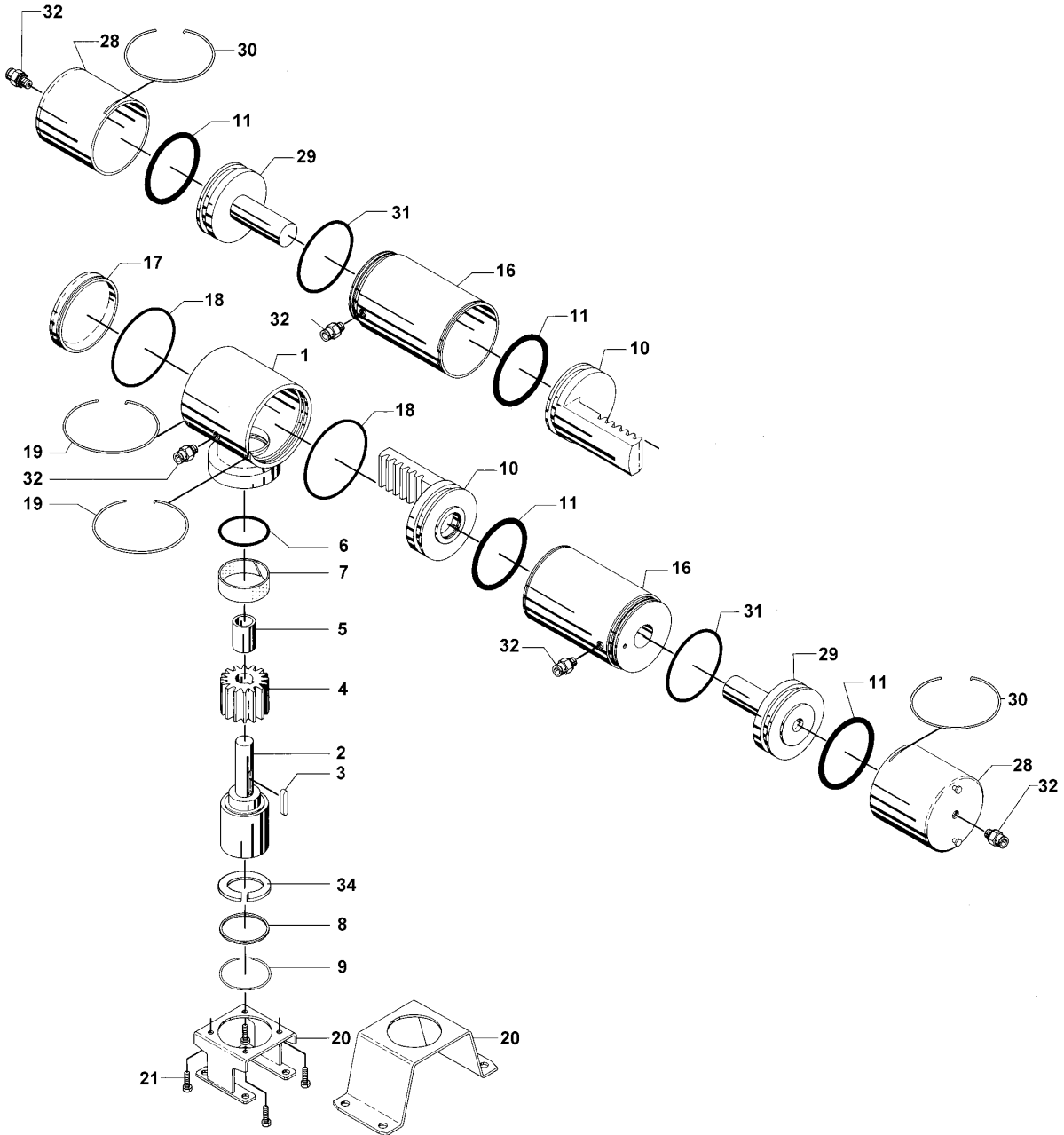
Item	Quant.	Denomination
1	1	Chassis
2	1	Spindle
3	1	Wedge
4	1	Gear wheel
5	1	Bearing
6 $\Delta$	1	O-ring
7 $\Delta$	1	Guide ring
8 $\Delta$	1	Bearing
9	1	Lock ring
10	1	Piston
	2	Piston (type 631, sizes 80-101.6)
	2	Piston (type 632, sizes 80-101.6)
11 $\Delta$	1	O-ring
	2	O-ring
	3	O-ring (type 633, 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 $\Delta$	1	O-ring
14	1	Circlip
15 $\Delta$	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 $\Delta$	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 $\Delta$	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)

$\Delta$  : 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



# 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 633

38

Item	Quant.	Denomination
1	1	Chassis
2	1	Spindle
3	1	Wedge
4	1	Gear wheel
5	1	Bearing
6 $\Delta$	1	O-ring
7 $\Delta$	1	Guide ring
8 $\Delta$	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 $\Delta$	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 $\Delta$	1	O-ring
14	1	Circlip
15 $\Delta$	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 $\Delta$	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 $\Delta$	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)

$\Delta$  : Recommended Spare Parts.

The drawing below shows KOLTEK actuator.

The items refer to the parts list on the opposite part of the page.

## Drawing

