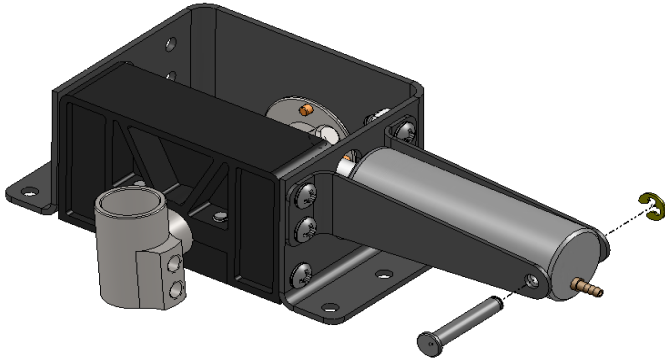
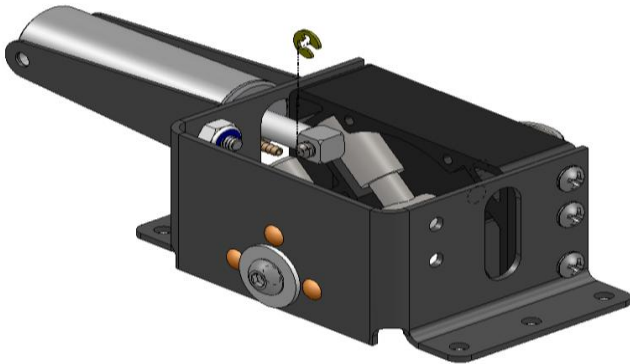


620 Series Conversion Instructions

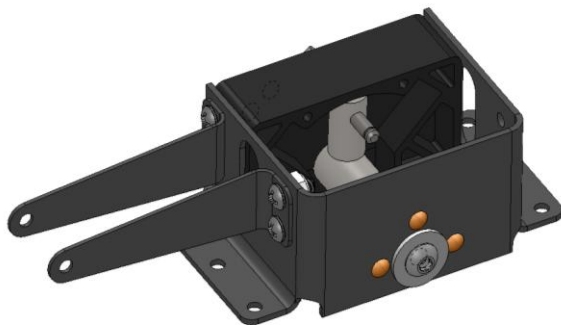
- 1) Remove strut from trunion.
- 2) Remove retaining ring and clevis pin at air cylinder.



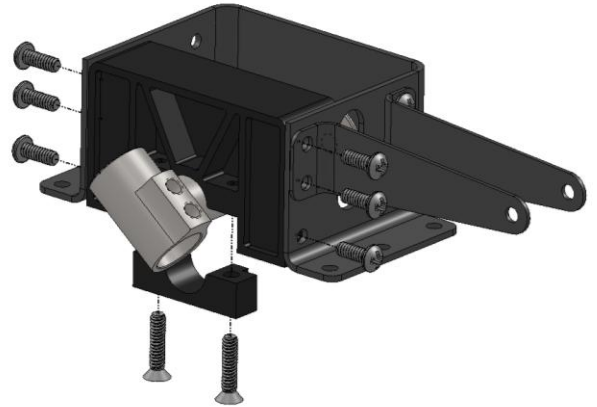
- 3) Remove retaining ring on cylinder piston rod and remove cylinder from assembly.



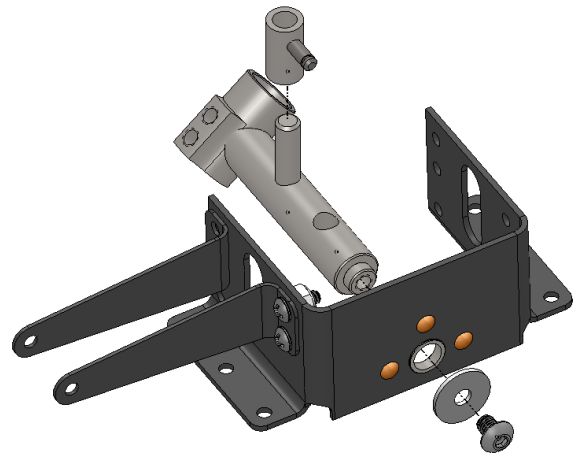
- 4) Rotate trunion pin to middle position.



- 5) Remove (2) clamp screws and clamp. Remove (6) pan head screws holding plastic housing into frame and remove housing.



- 6) Remove trunion pivot screw, washer, and pull trunion from frame bearing. Round cam follow will be replaced by square followers included with conversion kit.

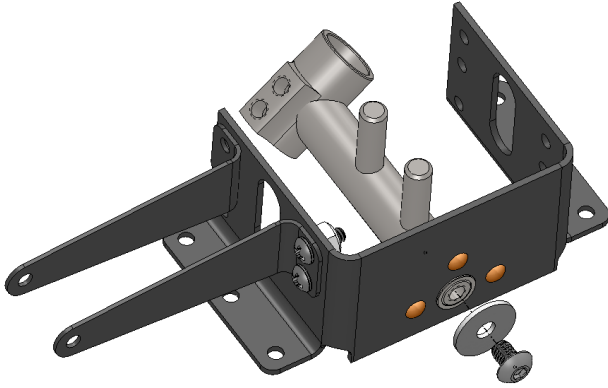


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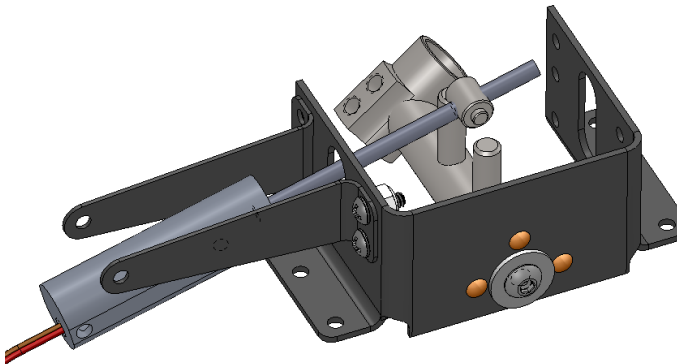
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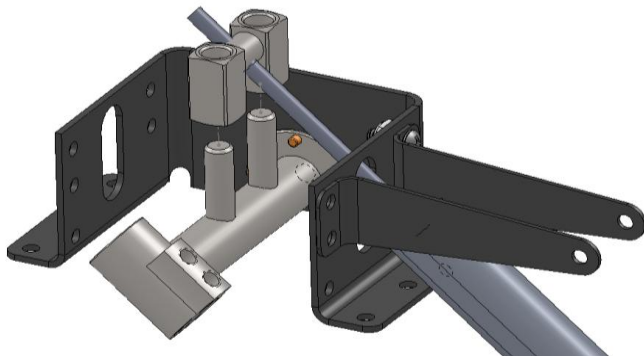
7) Re-assemble retrofit trunion into frame bearing with existing screw and washer. Apply Thread locker to threads.



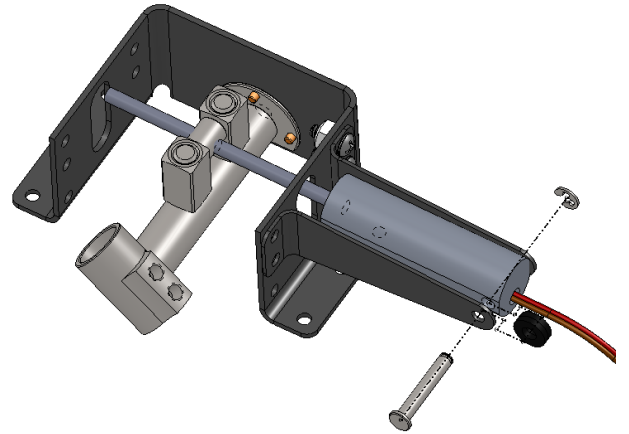
8) Slide actuator threaded rod with barrel through clearance hole in frame



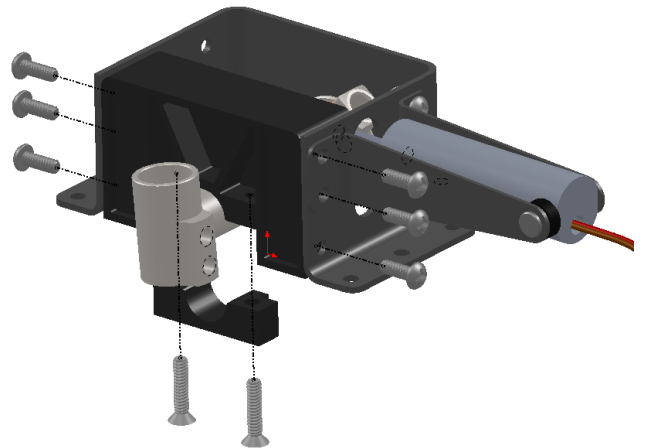
9) Locate square cam blocks onto barrel ears as shown, slide over pins in trunion



10) Spin actuator in or out to line up with mounting hole while still keeping trunion in middle position. Use provided spacers and locate as shown with clevis pin. Re-attached retaining rings.



11) Locate plastic housing and trunion clamp and tighten screws.



12) Re-assemble strut and tighten set screws.

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