



# INSTALLATION INSTRUCTIONS CONTINUED

## Anti-Rotation Pins- Optional

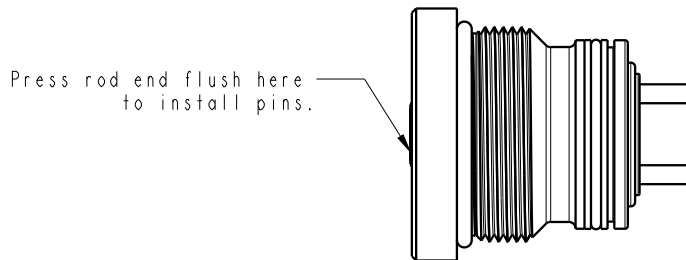
- Anti-Rotation Pins are included with all cylinders
- Anti-Rotation Pins are only to resist normal rotational force from cylinder actuation. The pins are not intended to resist torque from other applications.
- The use of anti-rotation pins are not required.
- Anti-Rotation Pins (included with each device) have sufficient length to fully engage in plunger as well as engage in the fixture greater than the total plunger stroke.
- Replacement anti-rotation pin part numbers are below for each size of cylinder.

MODEL NO.	PIN NO.
21-0206-0X	81-5905-09
21-0209-0X	23-5200-03
21-0210-0X	23-5200-04
21-0213-0X	23-5200-04
21-0216-0X	23-5200-05
21-0221-0X	23-5200-05

MODEL NO.	PIN NO.
21-0206-11	90-1999-83
21-0209-11	23-5200-11
21-0210-11	23-5200-12
21-0213-11	23-5200-12

## Installation of Anti-Rotation Pins- Optional

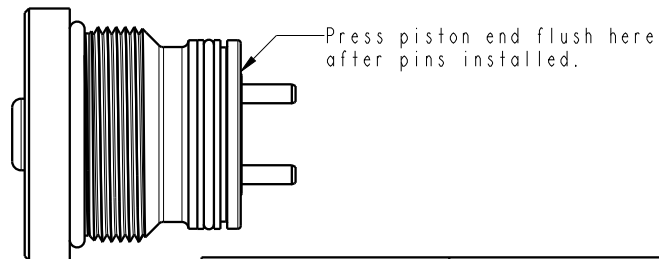
- Press rod end of plunger flush with the end of the cylinder body. See view below. Care must be taken not to push the rod out of the rod seal. Piston seal may be exposed in certain cylinder models.



- Press in the pins provided. Ensure pins start straight and are fully seated in the plunger. (An increase in resistance will be felt when pin is fully seated.)

NOTE: If piston seal was exposed during anti-rotation pin installation. Lubricate seal with non-silicone grease or clean hydraulic oil prior to reinstallation.

- With both pins installed, carefully press piston end of the plunger flush with end of body. See view below.



- Cylinder is ready for installation into fixture.

### INSTALLATION INSTRUCTIONS



VEKTEK, INC.  
1334 E. SIXTH AVE. P.O. BOX 625  
EMPORIA, KS. 66801 U.S.A.

B	5572	RELEASE	BDC	11/15/24
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY: DKC	<b>DRAWING STATUS: Released</b>			
DATE: 3/10/14	PRODUCTION APPROVED FOR RELEASED STATUS ONLY			

#### ASSEMBLIES AFFECTED

21-0206-XX 21-0209-XX  
21-0210-XX 21-0213-XX  
21-0216-XX 21-0221-XX

#### INSTRUCTIONS, INSTALL, CYL, CM, THREADED

THREAD IN

SIZE  
A

IS2101

REV  
B

