

### TRUE BLUE AIR ACTUATOR LIMIT STOP ASSEMBLY & ADJUSTMENT INSTRUCTIONS

#### A) Spring Limit Stop Assembly

If spring return is not yet installed, disconnect compressed air, then refer to section C of Air Actuator Installation instructions. Proceed if spring return is installed:

- 1) Disconnect compressed air; relieve pressure.
- 2) Unscrew the spring adjusting cap & remove it from the housing. Place it aside.
- 3) Insert the movable stop into the spring.
- 4) Screw the spring adjusting cap (limit stop version) into the housing until it cannot go any further.

#### B) Air Limit Stop Assembly

- 1) Disconnect **ALL** compressed air fittings.
- 2) Refer to Air Actuator instructions for an explanation of "Parallel Mounting" & "Perpendicular Mounting".
- 3) For parallel mounted limited open valves:
  - a) Remove the union nut and air cap from the left side of the actuator.
  - b) Slide the union nut over the air cap (limit stop version). Check to make sure face o-ring is in place.
  - c) Thread the union nut with the air cap back onto the actuator.
- 4) For parallel mounted limited closed valves:
  - a) Remove the union nut from the right side of the actuator. b & c are the same as above.
- 5) For perpendicular mounted limited open valves:
  - a) Remove the union nut from the right side of the actuator. b & c are the same as above.
- 6) For perpendicular mounted limited closed valves:
  - a) Remove the union nut from the left side of the actuator. b & c are the same as above.

#### C) Limit Stop Adjustment

- 1) Connect compressed air to side opposite of limited open/close.
- 2) Cycle to position (open, closed) to be limited. Take note of the position of the valve indicated by the handle on the actuator.
- 3) By threading the adjusting bolt in or out the position being limited should change.
- 4) Continue adjustment until the desired position is reached (watch flow meter or pressure gage).
- 5) Screw (do not slide) the thread seal washer (air limit stop only) down until it meets the air cap. Sliding the washer may damage the seal.
- 6) Tighten the lock nut against the air cap (or adjusting cap) to secure the position of the limit stop adjustment.
- 7) Reconnect compressed air to limited open/close side (air limit stop only).

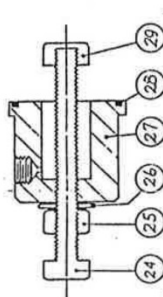


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## Parts List for True Blue™ Air Actuator

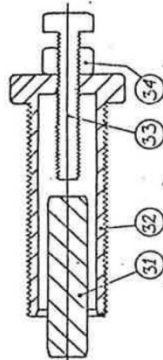
ITEM NUMBER	PART NUMBER	PART NAME	NO. PER ASSEMBLY
1	4386-TF	COVER BEARING	1
2	3017B	UPPER SHAFT O-RING SEAL	1
3	9700-RL/-OR	VALVE (SUPPLIED WITH BALL VALVE)	1
4	4518-VA	COVER	2
5	4245B	GASKET	1
6	4231B	BODY	2
7	4127-VA	UNION NUT	2
8	3046-VA	AIR CAP O-RING SEAL	2
9	0226B	AIR CAP O-RING SEAL	2
10	4526-VA	AIR CAP	2
11	4246-VA	PISTON	1
12	4233-VA	SHAFT	1
13	0922B	LOWER SHAFT O-RING SEAL	1
14	5087-VA	BASE ASSEMBLY SCREW	1
15	5117M3M62-S	BASE BEARING	1
16	4372-TF	SPACER	2
17	4953-01-VA	MOUNTING BOLT	2
18	5418-SS	SPRING-RETURN KIT	OPTIONAL
19	4278-SE	ADJUSTING CAP	1
20	4314-VA	ADJUSTING BOLT	1
21	4517-VA	AIR SIDE LIMIT-STOP KIT	OPTIONAL
22	4514-VA	LOCKING NUT	1
23	4860-01-CAD	LOCKING BOLT	1
24	4860-01-CAD	LIMIT-STOP AIR CAP	1
25	F-NFM37C-2	AIR CAP O-RING SEAL	1
26	F-NFM37C-2	BOLT CAP	1
27	4852-PV	SPRING GUIDE	OPTIONAL
28	0026B	SPRING GUIDE ADJUSTING CAP	1
29	4852-PV	ADJUSTING BOLT	1
30	4854-PV	LOCKING NUT	1
31	4854-PV	SEAL KIT (INCLUDES ITEM #2,5,8,9,613)	OPTIONAL
32	4860-01-CAD		
33	F-NFM37C-2		
34	F-NFM37C-2		
35	F-NFM37C-2		



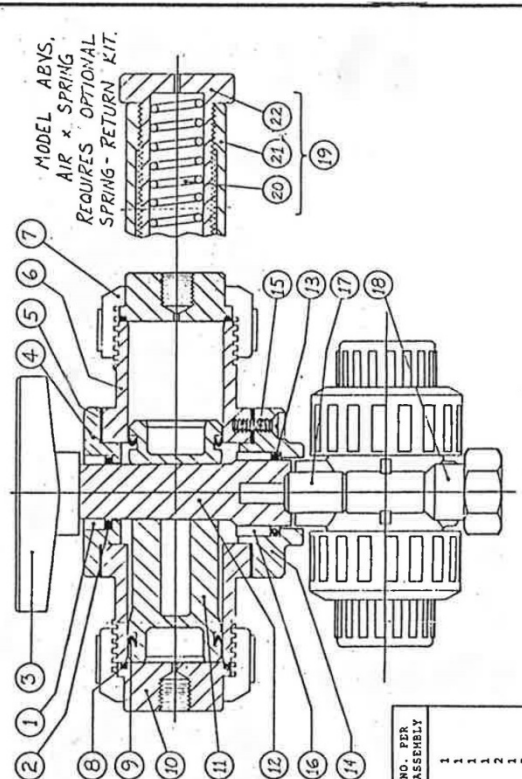
OPTIONAL LIMIT-STOP KIT FOR AIR SIDE OF ACTUATOR.

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OPTIONAL LIMIT-STOP KIT FOR SPRING SIDE OF ACTUATOR.

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MODEL ABVS, AIR x SPRING REQUIRES OPTIONAL SPRING-RETURN KIT.

STANDARD "ABVA" MODEL



**TRUE BLUE™**

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ALS-SLS-1.2-I-0221-2