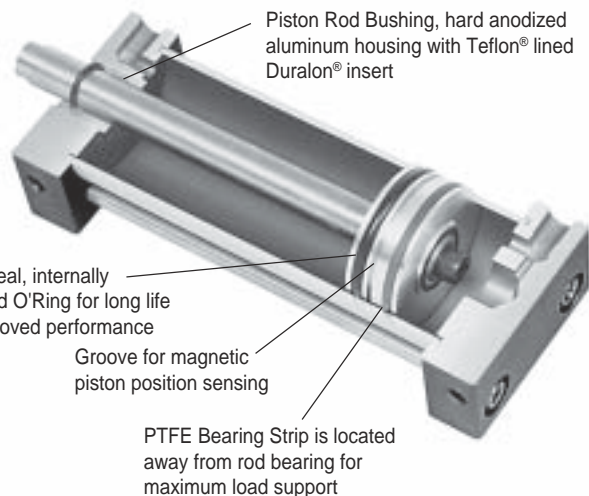
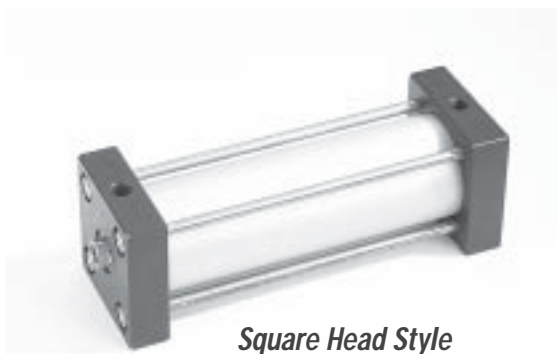


Round Head and Square Head Tie Rod Cylinders

	Page
Features & Benefits	3.2
General, Standard Ratings	3.2
Construction Information	3.3
How a Longstroke™ is built	
Model Number Chart	3.4
How to Order	
Option List	3.4
Standard Specifications	3.5 - 3.6
Option Specifications	3.7 - 3.9
Description of the Options	
Mounting Kits	3.10
Accessories	3.10
Air Spring Return	1.15
Position Sensors	3.9
Directional Control Valves	Section 11
Port Mounted Flow Control Valves	Section 12
Specials	ii & iii
2 Year Warranty	Inside back cover

Longstroke™ Cylinders

Available in 2 styles
4 Bore sizes 2" thru 4"
Strokes to 12"



3

Duralon® Rod Bearings Excel

Load Capacity (psi)		Friction Properties		
Machine Design 1972/73				Slip-
Bearing Reference Issue		Coefficient		stick
Porous Bronze	4,500	Steel-on-steel50	Yes
Porous iron	8,000	Bronze-on-steel35	Yes
Phenolics	6,000	Sintered Bronze-on-steel		
Nylon®	1,000	with mineral oil13	No
TFE	500	Bronze-on-steel		
Reinforced Teflon®	2,500	with mineral oil16	No
*TFE fabric	60,000	Copper lead alloy-on-steel	.22	Yes
Polycarbonate	1,000	Acetal-on-steel20	No
Acetal	1,000	Nylon-on-steel32	Yes
Carbon-graphite	600	Duralon-on-steel05 - .16	No

* Shows Duralon bearing classification. Not to be used for design purposes.

Printed with permission by Rexnord Corp.

Ratings – Standard Units all series

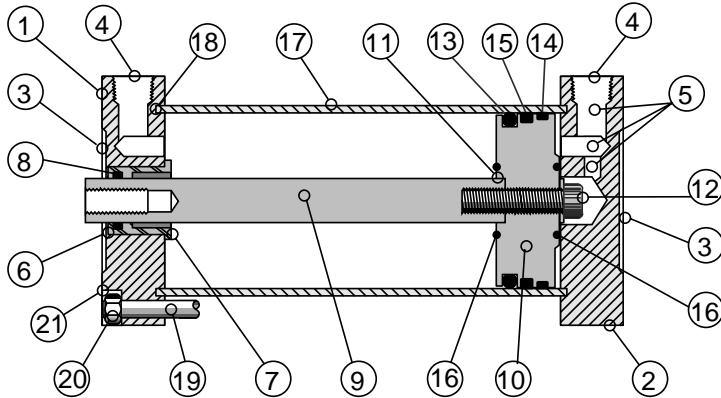
- Double acting, single rod
- Duralon® rod bushing
- Female rod end with wrench flats
- Internally lubricated Buna-N O-ring piston and rod seals.
- Ports at position #1
- Media Air
- Max. operating pressure 250 psi
- Min. operating pressure recommended 15 psi
- Ambient & media temperature range . . -25° to +250°F
- Prelubrication Magnalube®-G Grease
- Stroke tolerance ± 1/64"
- Optional – Hydraulic 500 psi *nonshock*

Sizing Guide

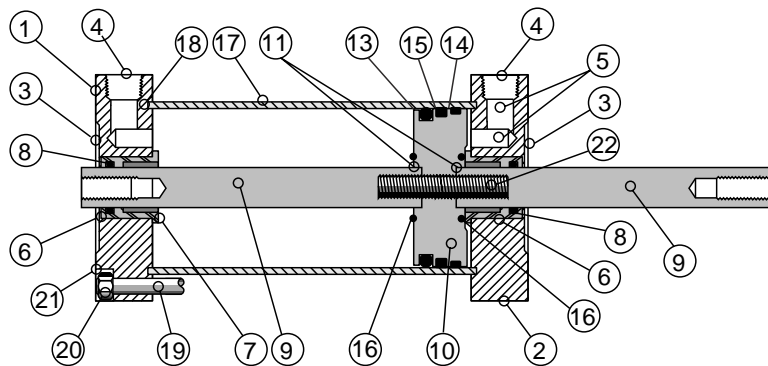
	2"	2-1/2"	3"	4"
Bore Diameter	2"	2-1/2"	3"	4"
Rod Diameter	0.75	0.75	0.75	0.88
Rod Area	0.44	0.44	0.44	0.79
Push Area (Single Rod)	3.14	4.91	7.07	12.57
Pull Area	2.70	4.47	6.63	11.97
Round Head Base Weight, lb.	2.21	2.83	3.66	5.98
Square Head Weight, lb.	2.34	3.08	3.27	5.20
Weight Per Inch, lb.	0.18	0.21	0.23	0.34

Standard Models

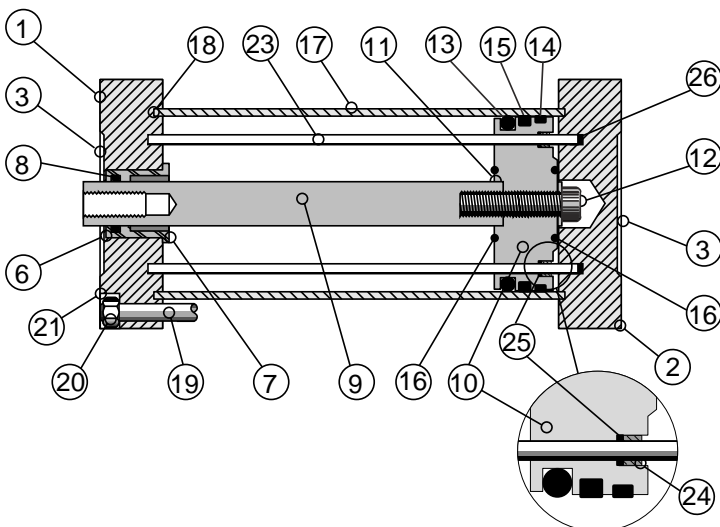
Standard: Single Rod, Double Acting



Option -DR: Double Rod, see page 3.7



Option -K: Nonrotating, see page 3.8



Basic Construction

Quick Reference to Components

No.	Description
1	Rod End Head, aluminum, black anodized
2	Cap End Head, aluminum, black anodized
3	Recessed faces assure flat mounting
4	1/4 NPT Ports
5	Full flow porting for fast response
6	Piston Rod Bushing, hard anodized aluminum housing with Teflon® lined Duralon® insert
7	Piston Stop
8	Rod Seal, internally lubricated O'Ring for long life
9	Piston Rod, stainless steel, centerless ground, polished, and hard chrome plated (68-72Rc)
10	Piston, aluminum
11	Counter bore locates piston rod to maintain precise concentricity
12	Piston Bolt, steel, Loctited® and torqued
13	Piston Seal, internally lubricated O'Ring for long life and improved performance
14	PTFE Bearing Strip is located away from rod bearing for maximum load support
15	Groove for magnet to activate position sensors
16	O'Ring bumpers reduce metallic slap of piston on piston stop for quiet operation
17	Cylinder Tube, aluminum Hard anodized ID (Rc60); Clear anodized OD
18	Cylinder Tube end seal
19	Stainless steel tie rods
20	Stainless steel hex nuts
21	Counterbore for nuts assures flat mounting
22	Steel double rod stud, Loctited® and torqued
23	Guide pin, precision ground tool steel
24	Guide pin bushing, SAE 660 bearing bronze
25	Guide pin seal, Urethane O'Ring
26	Rubber disk prevents guide pin movement

Cylinder OD – is clear anodized aluminum for corrosion resistance and an attractive appearance.

The Bore ID is Hard Anodized – Hard anodizing is an electrochemical process which provides a very dense surface of aluminum oxide that actually impregnates the base aluminum. It forms an extremely hard (60 Rc) surface with a low coefficient of friction. Hardness, corrosion resistance and wear resistance exceeds that of chrome plated steel.

An Extra Long Rod Bearing – provides long and rigid support for the piston rod. The bearing material is Duralon® on all bore sizes. See page 3 for a chart comparing the exceptional physical properties of Duralon® to other common, though less durable, bearing materials.

The Piston Rod – is Hard Chrome Plated Stainless Steel. The standard rod end is fine female thread tapped and has long wrench flats.

Model Number Code



Series	Bore	Specify
Round head	2	321
	2-1/2"	521
	3"	721
	4"	1221
Square head	2	S321
	2-1/2"	S521
	3"	S721
	4"	S1221

Stroke
Standard strokes: 1" Increments 4" minimum through 12" maximum
Optional Strokes: Shorter and fractional

Options			
Description	Specify	See Page	
Double Rod	-DR	3.7	
Nonrotating, Square Head only 150 psi max. operating pressure	-K	3.8	
Male Rod Thread		3.7	
Single Rod	-MR		
Double Rod, Rod End	-MR		
Double Rod, Cap End	-MR1		
Double Rod, Both Ends	-MR2		
Viton Seals (-15° to +400°F)	-V	3.7	
Hydraulic, Low Pressure to 500 psi NONSHOCK	-H	3.7	
Finish, Pro-Coat™ , Electroless Nickel	-N	3.8	
Rubber Bumpers		3.7	
Rod End	-BF		
Cap End	-BR		
Both Ends	-BFR		
Adjustable Extend Stroke 6" Stroke maximum Full stroke adjustment is standard	-AS	3.8	
3/8 NPT Ports	-P38	3.7	
Port Positions		3.5 & 3.6	
All Ports	Position #1 Position #2 Position #3 Position #4	Standard -PA2 -PA3 -PA4	
Rod End	Position #1 Position #2 Position #3 Position #4	Standard -PR2 -PR3 -PR4	
Cap End	Position #1 Position #2 Position #3 Position #4	Standard -PC2 -PC3 -PC4	
Any port not specified will be in Position #1 as shown on page 3.5 & 3.6			
Magnetic Piston for reed switches and Electronic Sensors (Order Sensors separately)	-E	3.9	

Mounting	
Rod end face, round head only	Standard
Cap end face, round head only	Standard
Side tap, square head only	Standard
Cap end clevis, round head only	
Ports in line with slot	-PM
Ports 90° to slot	-SM
Extended tie rods	
Rod end only	-WF
Cap end only	-WR
Rod & Cap end	-WFR

Mounting Kits for Square Head Series	
Type	See page
End Lug mount kit	3.10
Side Lug mount kit	3.10

Mounting Kits for Round Head Series	
Type	See page
Eye bracket kit	3.10
Rod clevis	3.10

How to Order

- Specify Series-Bore
- Specify stroke
Note standard strokes listed above.
Any stroke not listed is available,
to 12" maximum, at nominal increase
in delivery time and cost.
- Specify mounting if other than standard
- Specify options

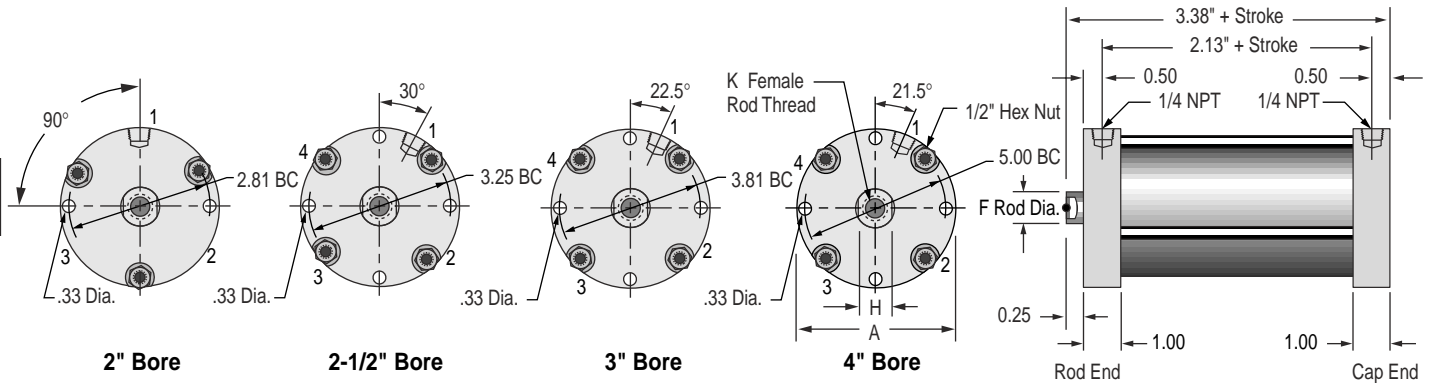
Examples

321 - 8 - MR
Round Head Longstroke, 2" bore, 8" stroke,
Standard Mount – Face Mount on Rod End and
Cap End, Male Rod Thread

S721 - 7 - E
Square Head Longstroke, 3" bore, 7" stroke,
Standard Mount – Side Tap Mount, Magnetic Piston

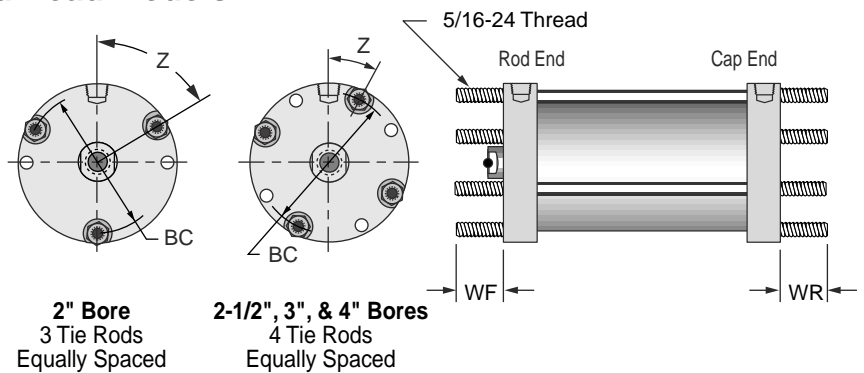
Round Head, Standard, Face Mount Rod and Cap End

3



Extended Tie Rod Mount for Round Head Models

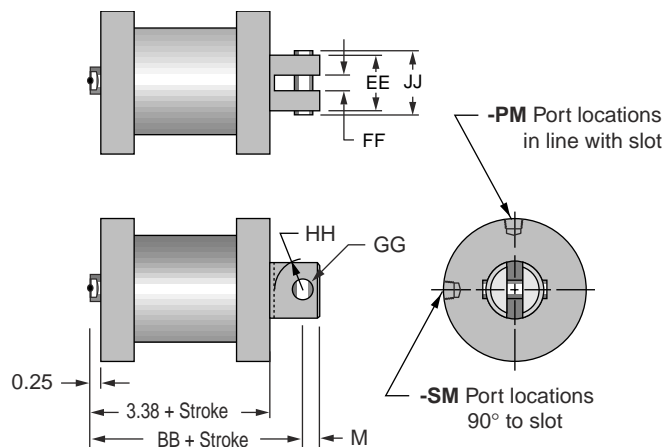
- Rod End Only -WF
- Cap End Only -WR
- Rod and Cap Ends -WFR



Round Head Clevis Mount Option

Specify mounting option

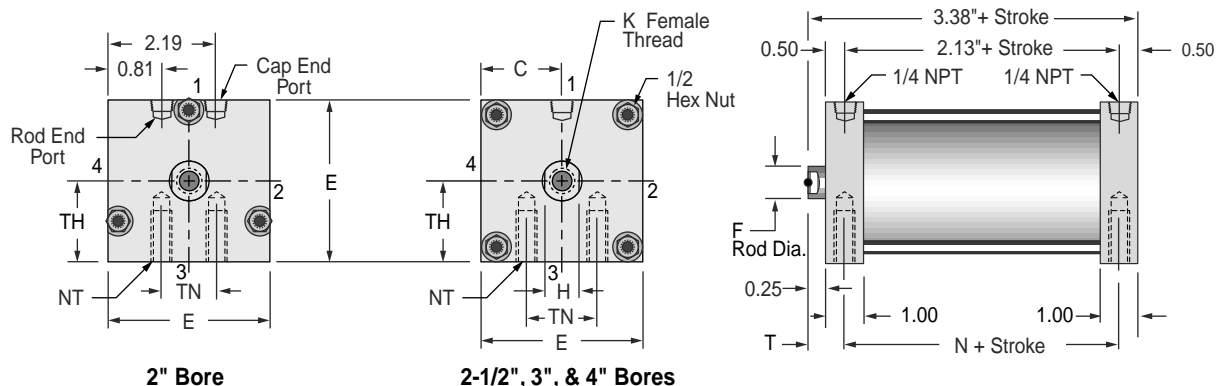
- Ports in line with slot -PM
- Ports 90° to slot -SM



Dimensions

Bore	A	BB	BC	C	E	EE	F Dia.	FF	GG Pin	GG Hole	H	HH
2"	3.25	4.13	2.81	NA	3.00	1.25	.750	.38	.3745	.376	.63	0.69
2-1/2"	3.75	4.38	3.25	1.75	3.50	1.63	.750	.50	.4995	.501	.63	0.97
3"	4.25	4.38	3.81	1.75	3.50	1.63	.750	.50	.4995	.501	.63	0.97
4"	5.50	4.63	4.63	2.25	4.50	2.00	.875	.63	.6245	.626	.75	1.22

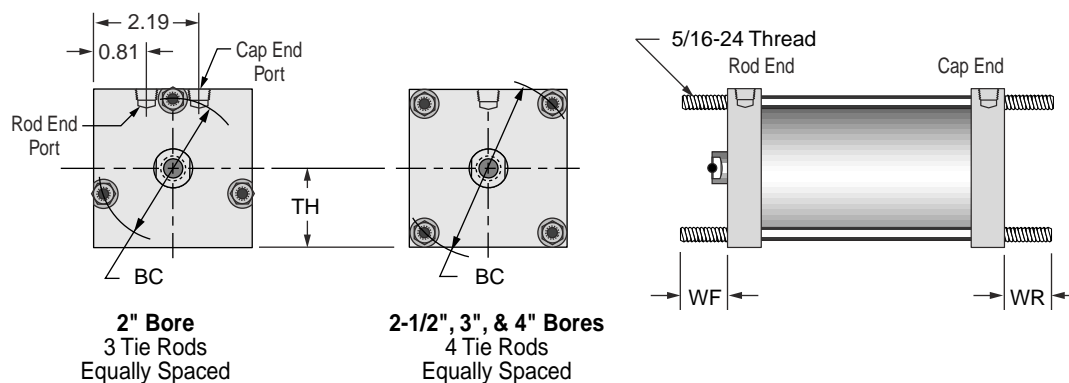
Square Head, Standard, Side Tap Mount



3

Extended Tie Rod Mount for Square Head Models

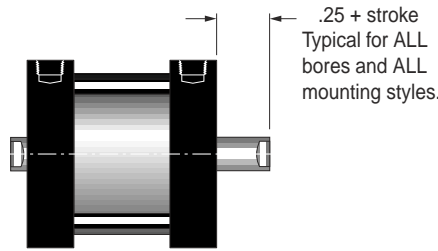
- Rod End Only - WF
- Cap End Only - WR
- Rod and Cap Ends - WFR



JJ	K	M	N	NT	T	TH	TN	WF	WR	Z
1.48	1/2-20 x 1.00	.38	2.25	5/16-18 x .62	.69	1.375	0.875	1.3	1.3	60°
1.86	1/2-20 x 1.00	.50	2.38	3/8-16 x .75	.63	1.750	1.250	1.3	1.3	30°
1.86	1/2-20 x 1.00	.50	2.13	1/2-13 x 1.00	.75	1.750	1.500	1.4	1.4	22.5°
2.24	5/8-18 x 1.25	.63	2.13	1/2-13 x 1.00	.75	2.250	2.060	1.4	1.4	23.5°

Double Rod

Option -DR



Standard piston rod and rod bushing on both ends of the cylinder.

Use when attachment to both ends of the cylinder is required, or to indicate piston position location. Also see Option -E on page 3.9.

3

Hydraulic

Low Pressure Service to 500 psi non-shock

Option -H

A U Cup rod seal is placed inboard in an SAE 660 bronze bushing to eliminate leakage past the rod seal. An additional O'ring is used as an out-board wiper.

Use with Air-Oil systems and low pressure hydraulic systems when the rigidity and precision smoothness of hydraulics and control is required.

Viton Seals

Option -V

Use for elevated temperatures (-15° to + 400°F) or compatibility with exotic media.

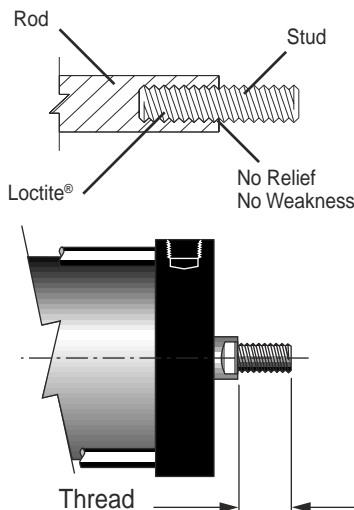
Consult engineering for compatibility information.

Male Rod Thread

- Single Rod
- Double Rod, Rod End Only
- Double Rod, Cap End Only
- Double Rod, Rod & Cap Ends

Option

- MR
- MR
- MR1
- MR2



A high strength stud is threaded into the standard female rod end and retained with Loctite®. This method eliminates the small diameter thread relief area normally required when machining male threads. This provides a much stronger rod end which can be repaired, rather than replacing the complete rod, should the thread be damaged.

BORE	THREAD
2"	1/2-20 x 1.00
2 1/2"	1/2-20 x 1.00
3"	1/2-20 x 1.00
4"	5/8-18 x 1.25

3/8 NPT Ports

Option -P38

Use 3/8 NPT ports for higher flows, air over oil systems, etc.

Rubber Bumpers

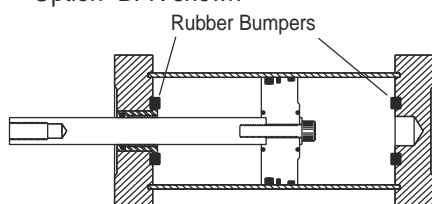
Option

- Rod End only
- Cap End only
- Both Rod & Cap Ends

- BF
- BR
- BFR

Temperature Range (-25° to + 220°F)

Option -BFR shown



Standard rubber mass will compress and give full stroke at 60 to 80 psi. This mass can be adjusted to meet your specific pressure and/or dynamic load requirements.

A rubber doughnut is bonded to the cylinder head to act as the piston stop and absorb the impact of the piston. This reduces noise and absorbs energy, thus reducing destruction of the cylinder and tooling due to pounding. The amount of rubber that extends beyond the normal piston stop is designed to compress and allow full stroke of the cylinder at 60 to 80 psi. If your application uses lower pressure or has high energy, consult engineering with application details so that rubber mass can be adjusted to meet your specific requirements.

Because of the temperature limitations of the adhesives involved (-25° to

+ 220°F) Rubber Bumpers are available in cylinders with standard internally lubricated Buna-N seals only.

Use to reduce noise and absorb impact.

Note! On applications such as punching, shearing, setting blind rivets, etc. where high forces are built up and then released very quickly, the proper method of "CATCHING" this type of load is to adjust the cylinder piston and the tooling so that at the point of breakthrough the piston is very close to the bumper. This reduces the dynamic load that the piston and bumper are required to absorb.

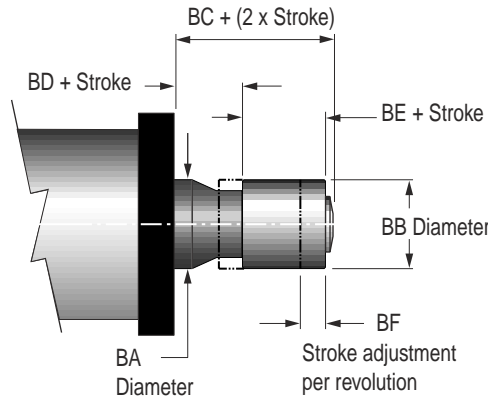
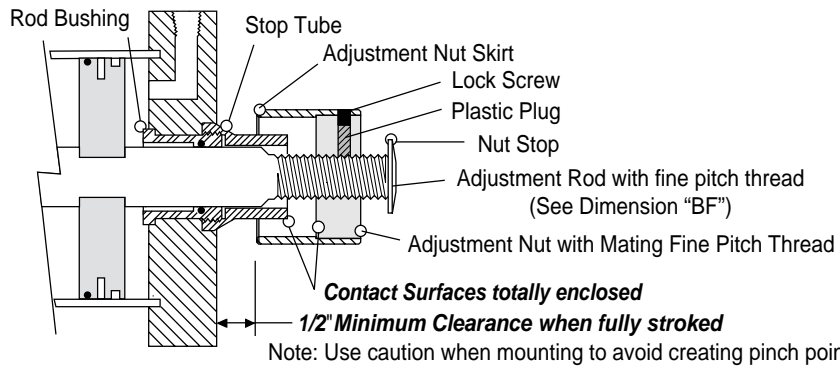
Adjustable extend stroke

Option -AS

For strokes through 6"
Full stroke adjustment is standard.

Note!

To maintain operator safety features of this option, it is **NOT** available with mounting styles: -WR and -WFR. Use caution when mounting to avoid creating pinch points.



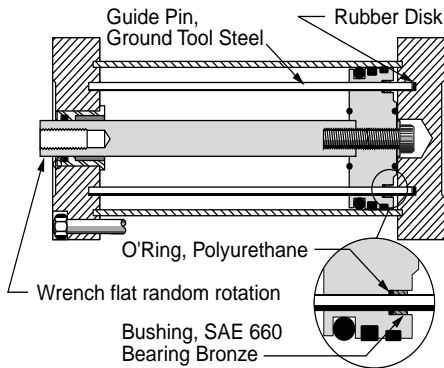
Bore	2"	2-1/2"	3"	4"	
BA	1.50	1.50	1.50	2.00	
BB	2.00	2.00	2.00	2.00	
BC	1.65	1.65	1.65	1.42	+ (2 x Stroke)
BD	0.75	0.75	0.75	0.50	+ Stroke
BE	0.75	0.75	0.75	0.75	
BF	.063	.063	.063	.063	

Nonrotating

Option -K

150 psi Max. Operating Pressure

Square Head Series only
in Single Rod and
optional Double Rod (-DR)



Two guide pins incorporated inside the cylinder pass through the piston head. These guide pins prevent rotation of the rod with a tolerance of $\pm 1^\circ$. The guide pins, being incorporated inside, are protected from the environment, physical damage, and are lubricated by the system lubrication, and require NO additional space, leaving the rod end area free for attachments and tooling as required by your application.

The guide pins are precision ground tool steel and run in SAE 660 bearing bronze bushings and Polyurethane O-rings. These features provide preci-

sion guiding and long, trouble free life. A rubber disk is included at the end of each guide pin to take up end play and firmly seat the pins in the precision guide pin holes.

An information label is applied to each cylinder to warn against damage.

WARNING

THIS CYLINDER HAS A NONROTATING ROD. TO PREVENT INTERNAL DAMAGE HOLD ROD BY WRENCH FLATS WHEN INSTALLING OR REMOVING ATTACHMENTS.

Use when any attachment to the piston rod must not rotate.

Finish

Plating; **Pro-Coat™**,
Electroless Nickel,
Heads & Tube

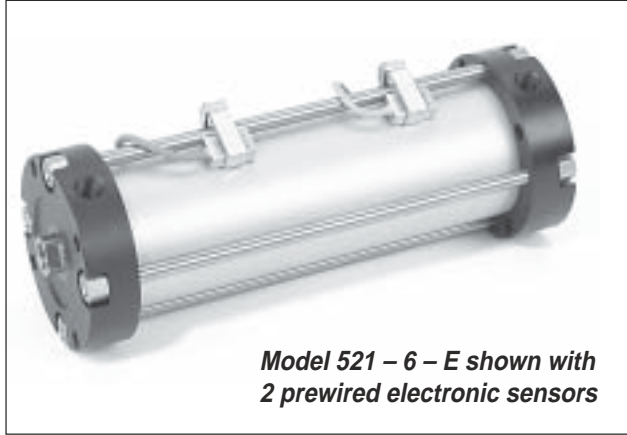
Option -N

Pro-Coat™, Electroless Nickel Plating is a hard, smooth, corrosion and wear resistant coating. It will often suffice for applications where stainless steel is specified. Its lasting luster provides high eye appeal.

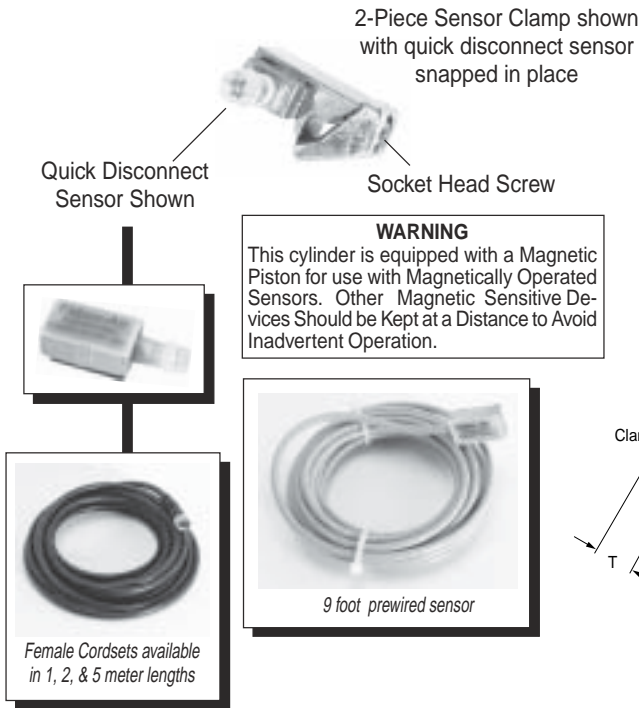
The coating is a high nickel, low phosphorous alloy deposited by chemical reduction without electric current that is "mil-for-mil" more corrosion resistant than electroplated nickel. The surface is virtually pore free. The thickness of the nickel deposit is constant over the entire surface. Blind holes, threads, small

diameter holes and internal surfaces all receive the same amount of plating. It has natural lubricity and a high resistance to abrasion. As shipped hardness of the coating is approximately 49 Rockwell C. Heat treating can increase hardness to approximately 60 Rockwell C. For specific applications, consult engineering.

The cylinder heads and tube, inside and outside, are plated. Tie rods and nuts are standard stainless steel. Rod bushing is standard hard anodized aluminum and Duralon®.



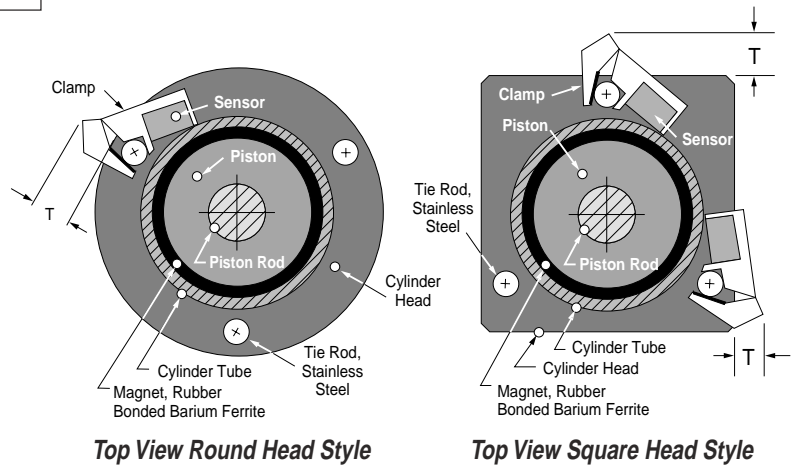
Model 521 – 6 – E shown with 2 prewired electronic sensors



Suffix Option E Specifies Magnetic Piston (Order Sensors and Sensor Clamps Separately)

- **Option -E** consists of a magnet bonded into the piston head. When the piston magnet moves past an external sensor, the magnetic field activates the sensor without physical contact.
- **Mounting** – The sensor snaps into a 2-part clamp that attaches rigidly to any of the tie rods and can be positioned anywhere along the length of the cylinder.
- **Reliability** – The annular piston magnet is permanently bonded into a groove in the piston. It is a polarized permanent magnet of rubber bonded barium ferrite that is very stable and is not affected by shock. Under normal usage it will remain magnetized indefinitely.
- **Warning** – External magnetic fields and/or ferrous objects may affect the strength of the piston magnet therefore affecting sensor actuation and piston position indication. Warning labels (shown left) are affixed to the cylinder.
- **Sensor clamps and sensors are ordered separately.**

Sensor Clamp Stick Out Dimensions								
Model	321	S321	521	S521	721	S721	1221	S1221
T	.50"	.50"	.50"	.10"	.50"	.30	.30"	.30"



Sensor & Clamp Ordering Guide

Temperature Range: -20° to + 80°C (-4° to + 176°F)

LED Lighted Magnetic Piston Position Sensors			
Product Type	Prewired 9 ft. Part No.	Quick Disconnect Part Number.	Electrical Characteristics
Reed Switch	9-2A197-1004	9-2A197-1304	5-120 VDC/VAC, 0.5 Amp Max., 10 Watt Max., SPST N.O., 3.5 Voltage Drop
Electronic	9-2A197-1033	9-2A197-1333	Sourcing, PNP, 6-24 VDC, 0.5 Amp Max., 1.0 Voltage Drop
Electronic	9-2A197-1034	9-2A197-1334	Sinking, NPN, 6-24VDC, 0.5 Amp Max., 1.0 Voltage Drop
Female Cordsets for Quick Disconnect			
Length	1 Meter	2 Meter	5 Meter
Part Number	CFC-1M	CFC-2M	CFC-5M
Sensor Mounting Clamp - for all Longstroke Models			
For all Longstroke Models Order Part Number 800-200-000			

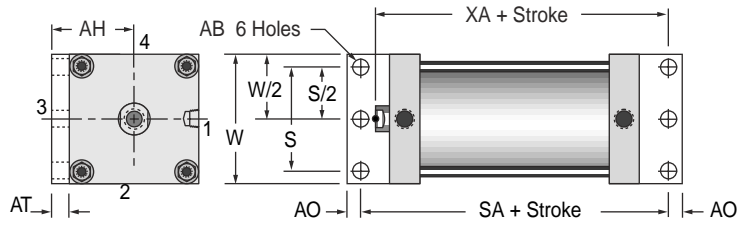
Warning!

Do not exceed sensor ratings. Permanent damage to sensor may occur.

Power supply polarity **MUST** be observed for proper operation of sensors.

See wiring diagrams included with each sensor.

End Lug Mount Kit

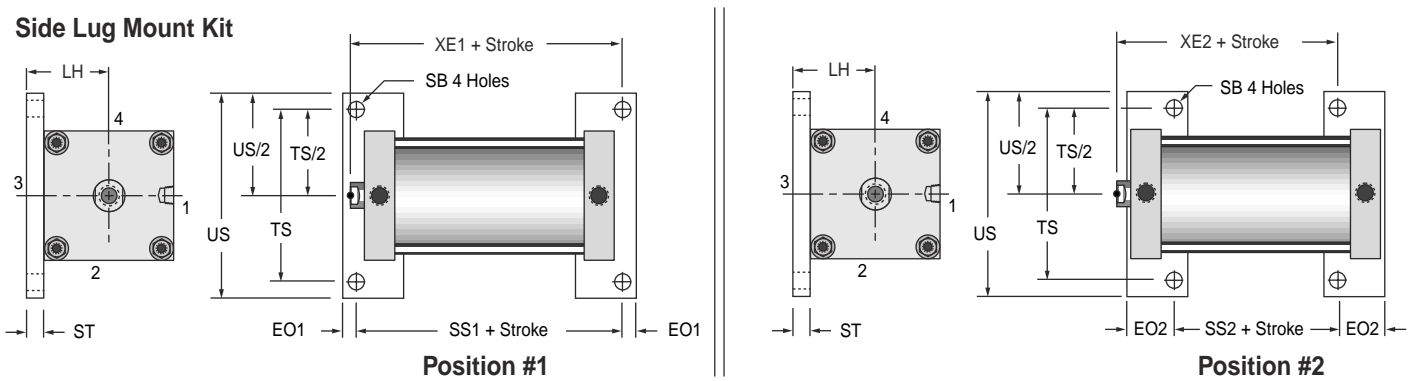


Kit includes:
2 brackets and 4 bolts for attaching the brackets to the cylinder heads.

Material:
Brackets, plated steel
Screws, Black Oxide Steel

Bore	Kit No.	S	W	AB	AH	AO	AT	SA	XA
2"	EL-20	1.75	2.50	.41	1.63	.44	.25	3.75	3.69
2-1/2"	EL-25	2.25	3.00	.41	2.00	.44	.25	3.88	3.75
3"	EL-30	2.75	3.50	.53	2.13	.56	.38	4.38	4.00
4"	EL-40	3.50	4.50	.53	2.63	.56	.38	4.38	4.00

Side Lug Mount Kit

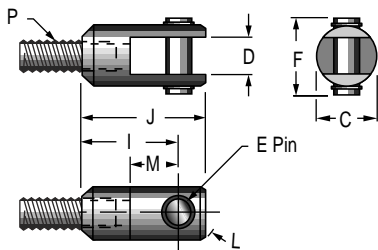


Kit includes:
2 brackets and 4 bolts for attaching the brackets to the cylinder heads.

Material:
Brackets, plated steel
Screws, Black Oxide Steel

Bore	Kit No.	EO1	EO2	LH	SB	SS1	SS2	ST	TS	US	XE1	XE2
2"	SL-20	0.50	0.50	1.63	.41	2.38	2.13	.25	3.75	4.50	3.00	2.88
2-1/2"	SL-25	0.50	0.63	2.00	.41	2.63	2.13	.25	4.25	5.00	3.13	2.88
3"	SL-30	0.56	1.19	2.13	.53	3.25	1.00	.38	4.75	5.88	3.44	2.31
4"	SL-40	0.56	1.19	2.63	.53	3.25	1.00	.38	5.50	6.63	3.44	2.31

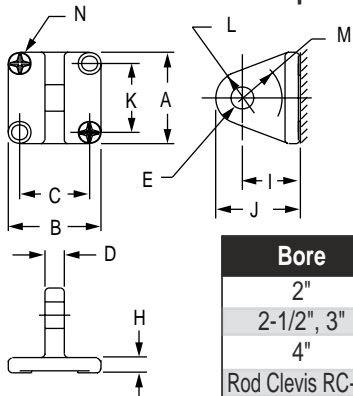
Rod Clevises



Materials
Clevis and Stud: Steel, black oxidized
Pin: 416 Stainless Steel
Clips: Steel, plated

Bore	Part #	C	D	E PIN	F	I	J	L	M	P	Mating Eye Bkt
2", 2-1/2", & 3"	RC-56	1.00	.32	.3120	1.21	1.31	1.69	.61	.63	1/2-20x.62	EM-121
4"	RC-63	1.38	.50	.4995	1.62	1.63	2.13	.80	.94	5/8-18x.75	EM-521

Eye Bracket Kits mate with Option -PM or -SM and Rod Clevis



Materials
Bracket: High strength Zinc die casting
Bushings: Oil filled powdered metal
Screws: 4, Steel, plated or black oxidized

Bore	Part #	A	B	C	D	E	H	I	J	K	L	M	N
2"	EM-321	2.50	2.50	2.00	.36	.376	.31	1.13	1.69	2.00	0.56	0.81	5/16-18x1.00FHSCS
2-1/2", 3"	EM-521	2.00	2.00	1.38	.47	.501	.38	1.50	2.25	1.38	0.75	1.13	5/16-18x1.00FHSCS
4"	EM-1221	2.50	2.25	1.50	.58	.626	.38	1.63	2.63	1.75	1.00	1.10	5/16-18x1.00FHSCS
Rod Clevis RC-56	EM-121	1.50	1.50	1.13	.30	.3135	.25	0.94	1.38	1.13	0.44	0.69	1/4-20X.75 FH(#12)MS