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## Procedure for Replacing the Actuator

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### ■ Removing the actuator

1. Shut off the air sent into the chuck.  
(In a state that air pressure is not applied to either of the both ports.)
2. Remove the cap bolts used for fixing the actuator. Then, apply air pressure to the push-out side of the chuck. (For the A port in the operation system diagram and outer-diameter clamping, the unclamp side is used.) The actuator is pushed out about 1.5 mm.
3. Rotate the mating mark on the actuator from the (C) position to the (O) center position. The actuator comes off from the main body. After that, hold the actuator with hand and pull it out.

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#### **Note 1:**

**Do not use a screwdriver for this purpose. The actuator and the cylinder surface may be damaged, greatly affecting the restoration precision after replacement.**

#### **Note 2:**

**For the air circuit diagram, see page 23.**

#### **Note 3:**

**Be sure to perform the air cleaning to the replacing parts (actuator and cylinder spigot part) and at steps 1, 2, and 3 for attaching the actuator.**

#### **Note 4:**

**For replace procedure, see the photos on rear side of the catalog.**