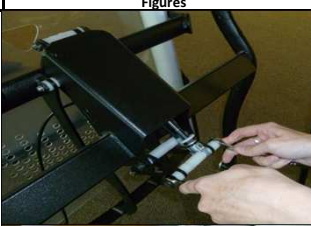






Instruction: 930 Dual Hub Tilt Cylinder - Adding a second cylinder

Approval: Rob Deans






Document Number:	SWI-07-074
Revision No.:	0
Revision Date:	15-May-12
Written By:	Kim Gignac

Step	Tools	Qty	Hardware	Qty	Broda Part	Execution	Figures
Step 1	1/2" Wrench					Remove the 5/16" mounting bolt from the bottom end of the cylinder. Leave the stem of the cylinder assembled to the actuator. Remember the sequence of the plastic spacers.	
Step 2	1/2" wrench					Remove the 5/16" mounting bolt from the top end of the cylinder. Remember the sequence of the plastic spacers.	
Step 3	Scissors or knife					Clip to remove the cable tie that hold the cable to the actuator	
Step 4						Remove cable from actuator	
Step 5						Remove cable	

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Step 6	square head screwdriver				Remove Tilt cable handle	
Step 7				2xPAB 15 2xcabact	New part to be attached	
Step 8					Place cylinders through hub, actuator pins need to face the seat of the chair.	
Step 9		5/16"x3" bolt 2x0.6200D plastic spacer 2x0.6300D Plastic spacer Plastic spacer Nylon nut 5/16"			Attach top end of cylinders to the chair, paying attention to spacer and cylinder configuration	
Step 10		5/16"x3" bolt 2x 0.6250D Plastic Spacer 2x0.6300D Plastic spacer nylon nut 5/16"			Attach bottom end of cylinder (with actuators) paying careful attention to spacer configuration	

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Step 11	Square head screwdriver			CABHAND	Attach Tilt Cable handle to the Push bar	
Step 12				2Xblack cable ties	Place cables around seat frame bar and through cylinder hub. Attach cables to actuators, attach black cable ties around cable and actuator	
Step 13				black cable tie	Attach cable to the TPU seat with a black cable tie	

Hardware List		
Check	QTY	ITEM
	2	5/16"x3" bolt
	2	5/16" nylon nuts
	2	0.620OD Plastic spacer
	2	0.625OD Plastic Spacer
	4	0.630OD Plastic Spacer
	3	black cable ties