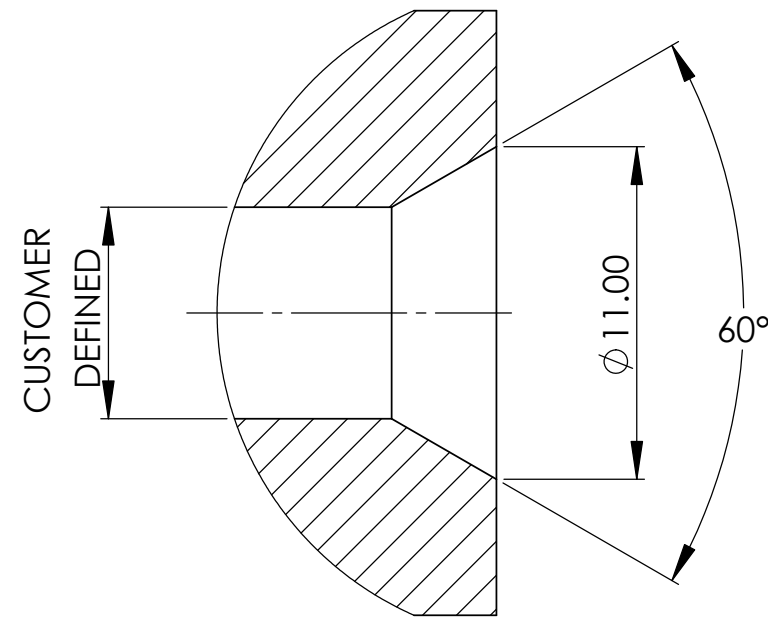


METRIC
IF IN DOUBT ASK

PISTON ROD END DETAIL TO ASSIST
BLIND LOADING OF LONGER STROKE
INTERNAL FLANGE OPTIONS



| ITEM NO. | DESCRIPTION | P&G PART No. | QTY. |
|----------|----------------------------|--------------|------|
| 1 | THIN NUT M5x0.8 | X63-072-050 | 1 |
| 2 | FULL NUT 0.190-32 UNF | X63-111-003 | 1 |
| 3 | WAVEY WASHER - ELP2 | X63-112-002 | 2 |
| 4 | SHIM WASHER | P55044/3 | 1 |
| 5 | CIRCLIP D1300-0130 | X69-005-109 | 1 |
| 6 | O'RING BROWN(7.65x1.63) | X64-194-114 | 1 |
| 7 | O'RING (8.1x1.6) | X64-194-015 | 1 |
| 8 | O'RING (7x2) | X64-194-016 | 1 |
| 9 | ANTI EXTRUSION RING | X64-081-001 | 1 |
| 10 | M3x0.5 CONICAL SET SCREW | X63-096-305 | 1 |
| 11 | COPY OF AI203558 | AI203558 | 1 |
| 12 | LABEL (SUPPLIED LOOSE) | P200919 | 1 |
| 13 | INSTALATION KIT LABEL | P204986 | 1 |
| 14 | ALTERNATE CABLE GLAND SEAL | X61-213-202 | 1 |

| ISS | DATE | DRAWN | ECR No. | CHK | APP |
|-----|----------|-------|----------|-----|-----|
| 2 | 16/11/07 | DJT | 10426/11 | MWB | MWB |

BECAUSE OF THE MULTIPLICITY OF POTENTIAL APPLICATION, THE
INSTALLATION DETAILS SHOWN ARE SUGGESTIONS ONLY.
THE USER SHOULD ENSURE THAT THE DESIGN, METHOD OF ASSEMBLY
AND MATERIALS USED ARE SATISFACTORY FOR THE INSTALLATION.

ITEM 12, LABEL, IS SUPPLIED FOR THE CUSTOMER TO RECORD ICT ORDERING CODE
AND TO BE FITTED IN VISIBLE LOCATION ADJACENT TO SENSOR FOR RE-ORDERING REFERENCE.

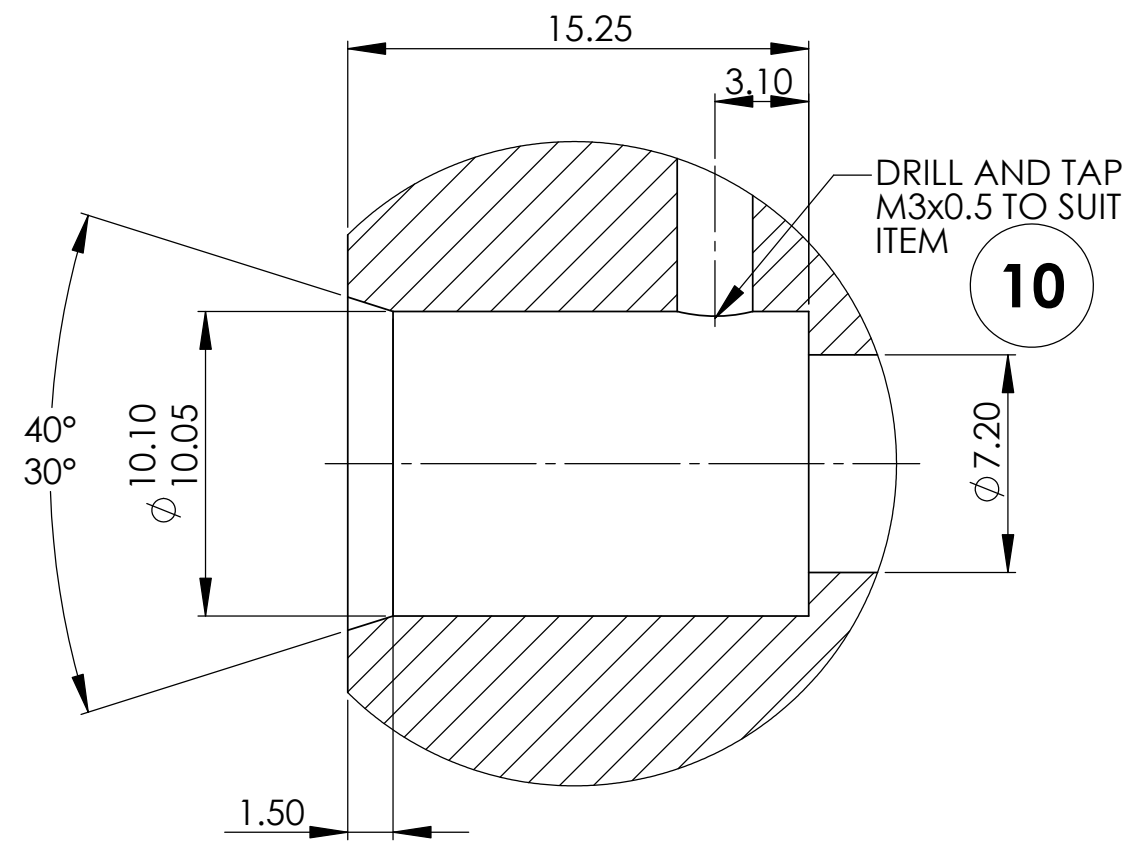
ITEM 14, ALTERNATE CABLE GLAND SEAL, IS SUPPLIED FOR CONNECTING ICT050 DIRECT TO EICTM.

MACHINING DETAILS FOR UNIFIED FLANGE.
PORT CONFORMS TO SAE J1926/1, CONNECTIONS FOR FLUID POWER AND GENERAL
USE - PORTS AND STUD ENDS WITH ISO 725 THREADS AND O'RING SEALING - PART 1:
THREADED PORTS WITH O'RING SEAL IN TRUNCATED HOUSING

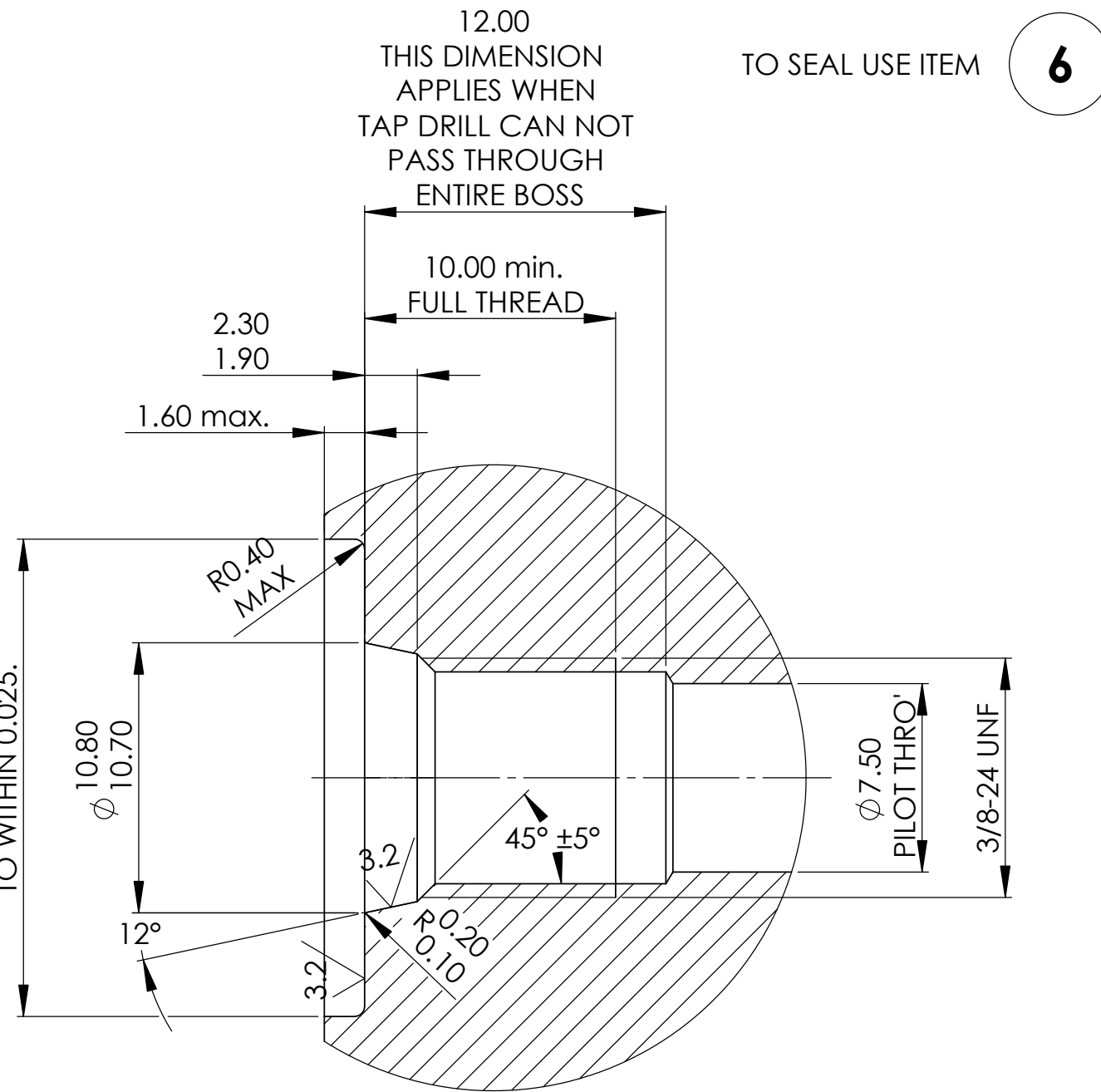
SUITABLE PORT CUTTERS ARE AVAILABLE FOR THESE DETAILS.....

INTERNAL FLANGE
MACHINING DETAILS

TO SEAL USE ITEMS **8** & **9**



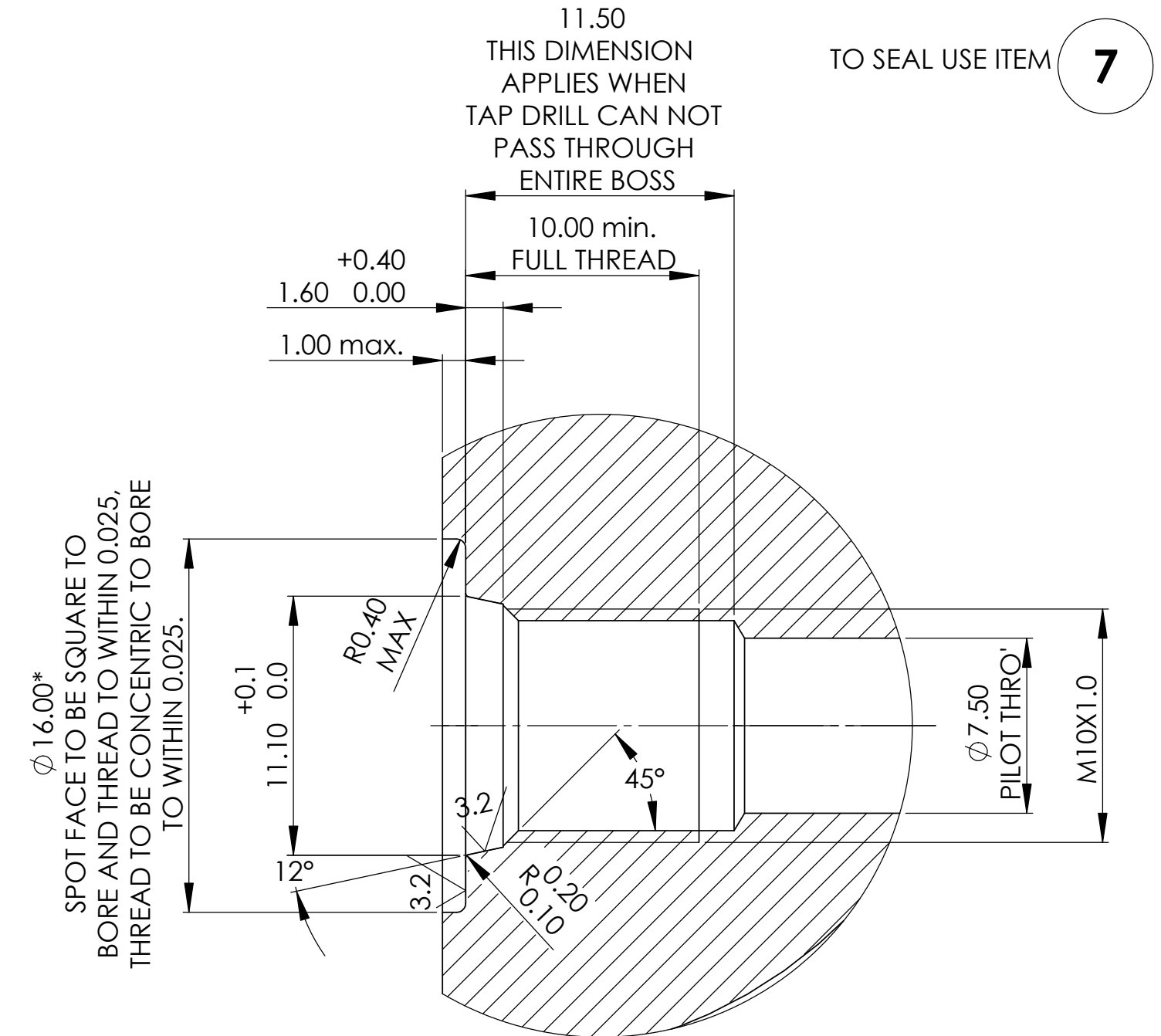
SPOT FACE TO BE SQUARE TO
BORE AND THREAD TO WITHIN 0.025.
THREAD TO BE CONCENTRIC TO BORE
TO WITHIN 0.025.



* IF FACE OF PORT IS MACHINED DIMENSIONS $\phi 19.00 \times 1.6 \text{ max}$ NEED NOT
APPLY AS LONG AS R0.2/0.1 IS MAINTAINED TO AVOID DAMAGE TO O-RING
DURING INSTALLATION.

MACHINING DETAILS FOR METRIC FLANGE.
PORTS CONFORM TO ISO 6149-1:1993, CONNECTIONS FOR FLUID POWER AND GENERAL
USE - PORTS AND STUD ENDS WITH ISO 261 THREADS AND O'RING SEALING - PART 1:
PORTS WITH O'RING SEAL IN TRUNCATED HOUSING

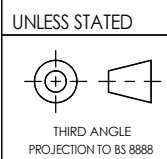
SUITABLE PORT CUTTERS ARE AVAILABLE FOR THESE DETAILS.....



SPOT FACE TO BE SQUARE TO
BORE AND THREAD TO WITHIN 0.025.
THREAD TO BE CONCENTRIC TO BORE
TO WITHIN 0.025.

* IF FACE OF PORT IS MACHINED DIMENSIONS $\phi 16.00 \times 1.00 \text{ max}$ NEED NOT
APPLY AS LONG AS R0.2/0.1 IS MAINTAINED TO AVOID DAMAGE TO O-RING
DURING INSTALLATION.

SCALE
2:1



MASS (g)
45.46

VOL. (mm³)
45463.43

D No.
ICT050

REF.
AI56140

MATERIAL

FINISH

TOLERANCES: IN-LINE WITH PENNY & GILES STANDARDS 55-301
SURFACE TEXTURE VALUES IN MICROMETRES (µm)
TO BS1134:PT2. ALL MACHINED SURFACES TO BE

| ANGULAR | LINEAR | (MACHINING) | BREAK EDGE |
|---------|---------|-------------|---------------|
| ± 1° | 0. mm | +/- 0.5 mm | 0.05 - 0.15mm |
| | 0.0 mm | +/- 0.2 mm | FILLET RADS |
| | 0.00mm | +/- 0.1mm | 0.1 - 0.3mm |
| | 0.000mm | +/- 0.01mm | |

UNLESS OTHERWISE STATED

TITLE

SUGGESTED ICT050
INSTALLATION DETAILS

PENNY + GILES

PART NUMBER:
AI203558

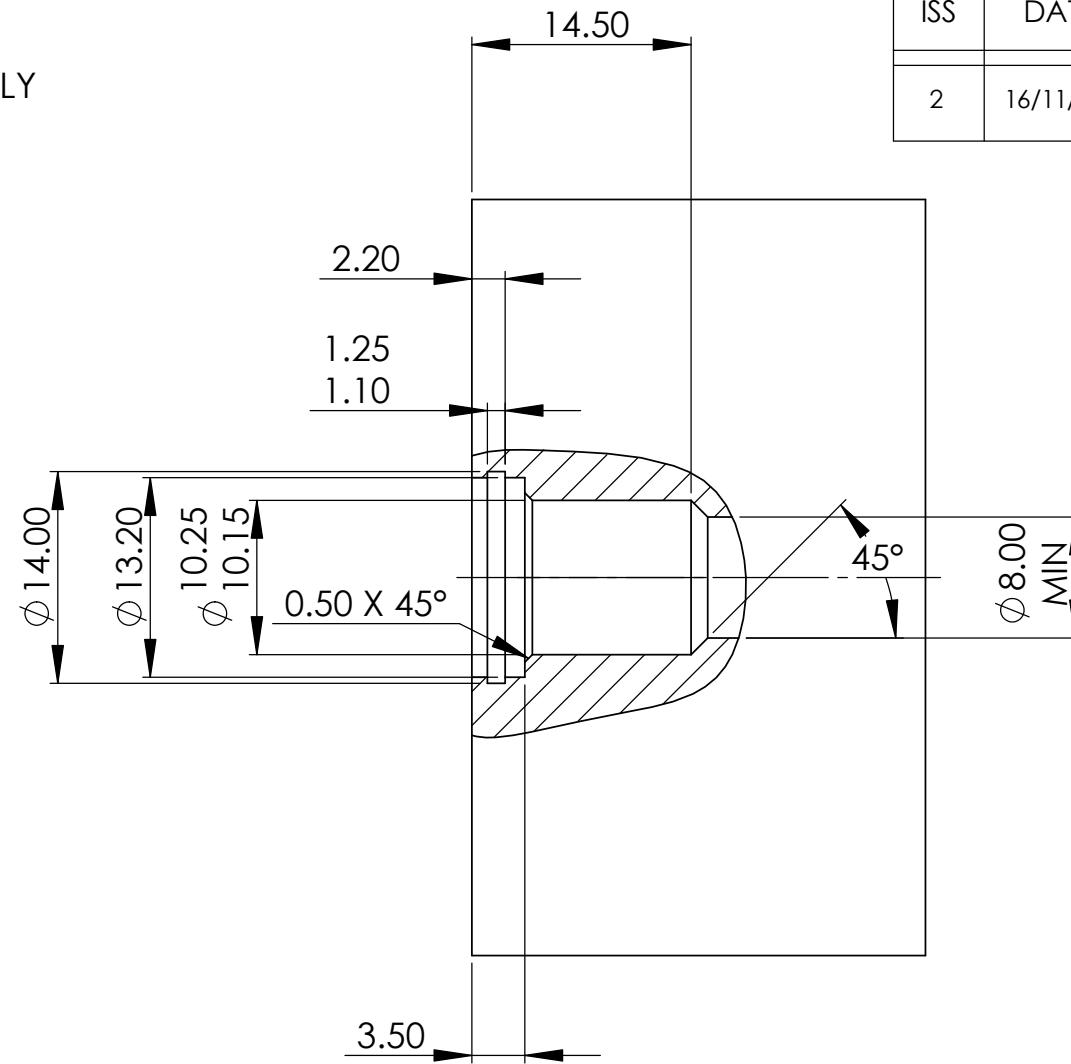
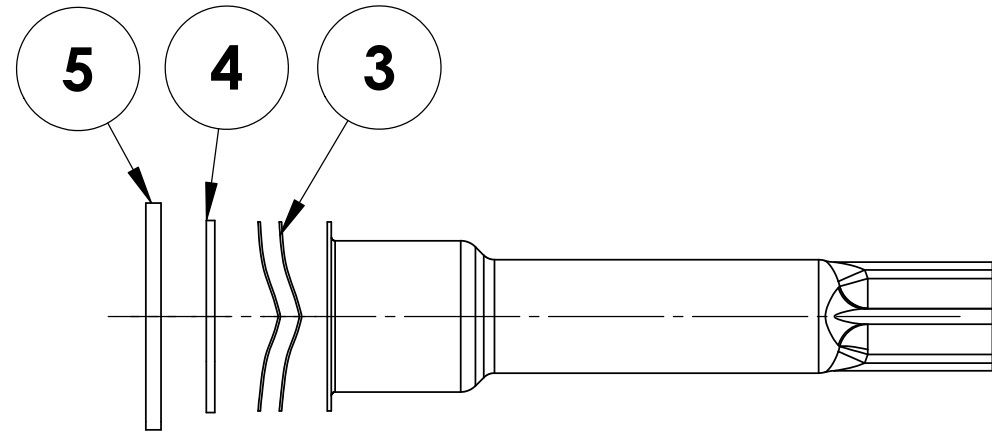
A2

SHT 1
OF
2 SHTS

METRIC
IF IN DOUBT ASK

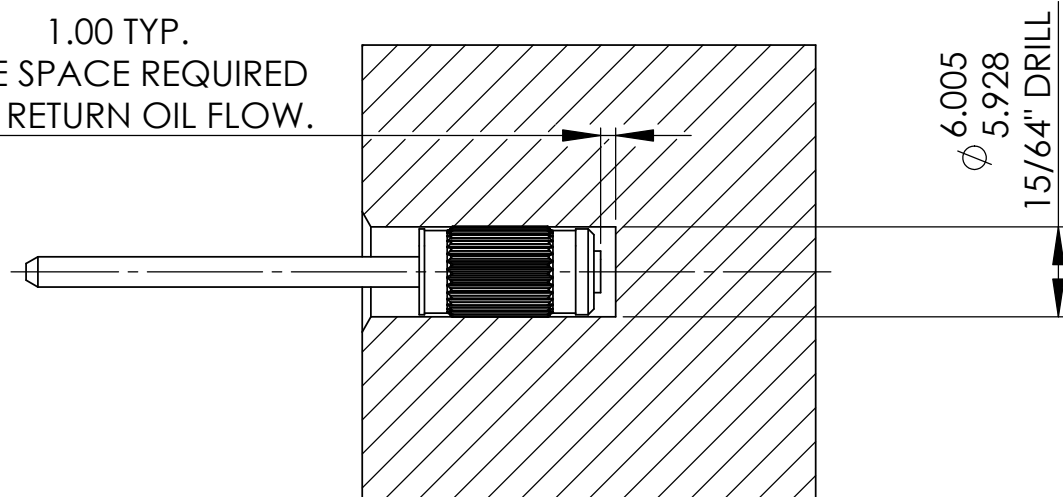
SLEEVED CORE ASSEMBLY
MACHINING DETAILS

| | | | | | |
|-----|----------|-------|----------|-----|-----|
| ISS | DATE | DRAWN | ECR No. | CHK | APP |
| 2 | 16/11/07 | DJT | 10426/11 | MWB | MWB |



FORCE FIT CORE
MACHINING DETAILS

1.00 TYP.
FREE SPACE REQUIRED
FOR RETURN OIL FLOW.

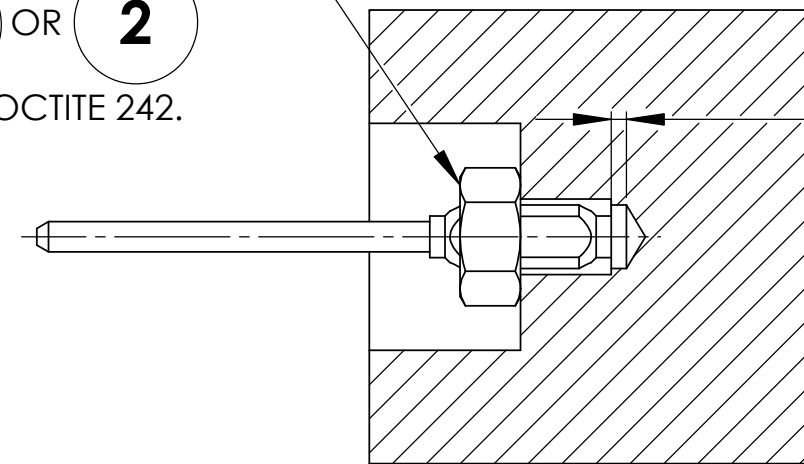


NOTE- INSTALLATION TOOL
REQUIRED SEE P&G DRAWING T56725

THREADED CORE ASSEMBLY
M5 x 0.8 OR 0.190-32 UNF

LOCK CORE ASSEMBLY
WITH NUT
1 OR **2**
AND LOCTITE 242.

1.00 TYP
FREE SPACE REQUIRED
FOR RETURN OIL FLOW.



| | | | | | | | | |
|-----------------------------------|-------------------------------------------------------------------------------------------------------------------|----------------------------------------------------|--------|------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------|---------------------------------------------------------|------------------------------|
| SCALE 1:1 UNLESS STATED | IF CONTROL DIMENSIONS (Kc) ARE SPECIFIED THEY ARE TO BE SUBJECT TO 100% INSPECTION OR STATISTICAL PROCESS CONTROL | | D No | MATERIAL | TOLERANCES: IN-LINE WITH PENNY & GILES STANDARDS 55-301 SURFACE TEXTURE VALUES IN MICROMETRES (µm) TO BS1134:PT2. ALL MACHINED SURFACES TO BE 1.6 ALL SCREW THREADS TO BS3643 PT.2: EXTERNAL CLASS: 6g INTERNAL CLASS: 6H ANGULAR ± 1° LINEAR (MACHINING) BREAK EDGE 0.05 - 0.15mm 0.0mm +/- 0.5mm 0.0mm +/- 0.2mm 0.00mm +/- 0.1mm 0.000mm +/- 0.01mm FILLET RADS 0.1 - 0.3mm UNLESS OTHERWISE STATED | TITLE | PENNY + GILES PART NUMBER: A1203558 | A3 SHT 2 OF 2 SHTS |
| | MASS (g) 58.11 VOL. (mm ³) 57530.01 | D No ICT050 FIRST USED ON REF. A156140 | FINISH | SUGGESTED ICT050 INSTALLATION DETAILS | | | | |