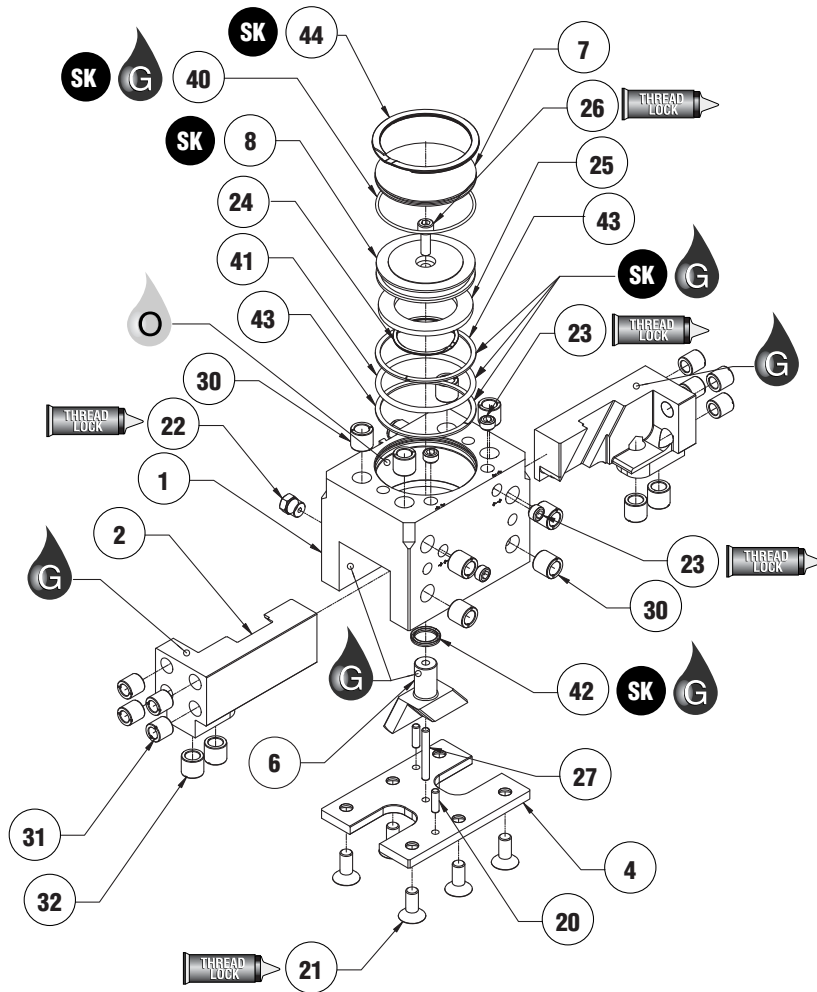
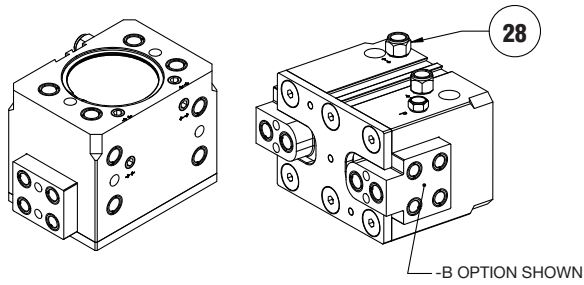


DPDS SERIES EXPLODED VIEW



Item	Qty	Name
01	1	Body
02	2	Jaw
04	1	Bottom Plate
06	1	Shaft Wedge
07	1	Cap
08	1	Piston
20	2	Bottom Plate Locating Dowels
21	6	Bottom Plate Screws
22*	1	Breather Vent Plug (Purge)
23	4	Manifold Port Plugs
24	1	Piston Mag. Ret. Ring
25	1	Piston Magnet
26	1	Piston Mounting Screw
27	1	Shaft guide dowel pin
28*	2	Plumbing Fitting - Adapter - 1/8NPT male to 1/8BSPP female
30*	8	Threaded Inserts (Body)
31*	8	Threaded Inserts (Jaw - End Mount)
32*	4	Threaded Inserts (Jaw - Bottom Mount "B" option only)
40	1	Cap O-ring
41	1	Piston O-ring
42	1	U-cup
43*	2	Piston Teflon Ring
44	1	Cap Ret. Ring

NOTES:*

- 1) Contact the Robohand Sales Department for a complete spare parts list with order numbers and prices.
- 2) Item #30 is for size -175 and -250 only.
- 3) Item #31 and #32 are for size -250 only.
- 4) Item #22 Breather vent plug is a set screw plug for sizes -047 & -056.
- 5) Item #43 is for size -175 and -250 only.
- 6) Item #28 is for metric size -175M and -250M only.

SK Seal Repair Kit Order #'s See Product Data Sheets

Assembly Procedure:

- 1) Install #23 airport plugs with thread-locker.
- 2) Press pins #20 & #27 Into Plate #4.
- 3) Install threaded inserts #30, #31, & #32.
- 4) Install #22 vent or plug with thread-locker.
- 5) Mount magnet #25 to piston #8 with retainer Ring #24.
- 6) Install #28 metric plumbing fitting adapters.
- 7) Lubricate body #1 (jaw cavity & bores).
- 8) Lubricate & install all seals into body, piston, & cap.
- 9) Sub-assemble the #2 jaws on either side of the #6 shaft wedge with lubrication.
- 10) Insert the jaws and shaft wedge sub-assembly into body.
- 11) Insert piston #8 into the body bore and fasten it to the shaft wedge with Mounting screw # 26 using thread locker.
- 12) Install cap #7 into body with retaining ring #44.
- 13) Insert #4 bottom plate with pressed-in pins onto the body and fasten with #21 screws with thread-locker.



Seal Kit Items



Thread Locker



Krytox™ Lubricant



Lightweight Machine Oil



Teflon™ Based Grease



Super Bonder



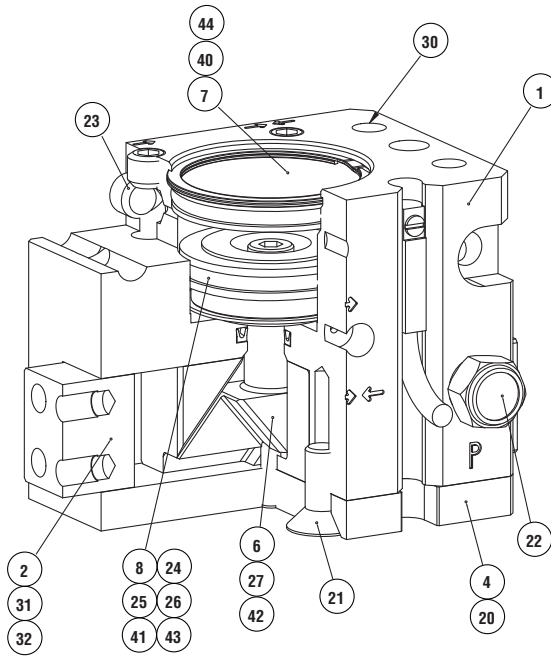
Third Angle Projection



Robohand

DPDS SERIES ASSEMBLED VIEW

DPDS SERIES
MAINTENANCE
1.111



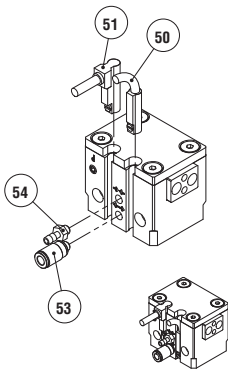
Item	Qty	Name
01	1	Body
02	2	Jaw
04	1	Bottom Plate
06	1	Shaft Wedge
07	1	Cap
08	1	Piston
20	2	Bottom Plate Locating Dowels
21	6	Bottom Plate Screws
22*	1	Breather Vent Plug (Purge)
23	4	Manifold Port Plugs
24	1	Piston Mag. Ret. Ring
25	1	Piston Magnet
26	1	Piston Mounting Screw
27	1	Shaft guide dowel pin
28*	2	Plumbing Fitting - Adapter - 1/8NPT male to 1/8BSPP female
30*	8	Threaded Inserts (Body)
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40	1	Cap O-ring
41	1	Piston O-ring
42	1	U-cup
43*	2	Piston Teflon Ring
44	1	Cap Retainer Ring

NOTES:*

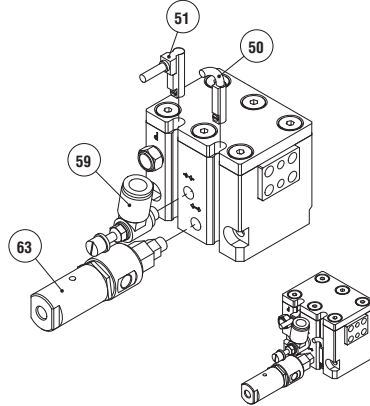
- Contact the Robohand Sales Department for a complete spare parts list with order numbers and prices.
- Item #30 is for size -175 and -250 only.
- Item #31 and #32 are for size -250 only.
- Item #22 breather vent plug is a set screw plug for sizes -047 & -056.
- Item #43 is for size -175 and -250 only.
- Item #28 is for metric size -175M and -250M only.

Accessory Installation & Adjustment Instructions

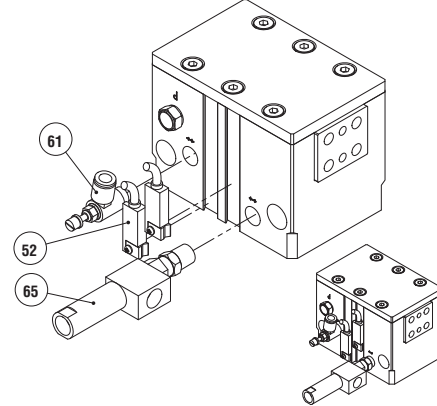
DPDS-047 & DPDS-056



DPDS-088 & DPDS-125



DPDS-175 & DPDS-250



Item	Qty	Name
50	1 or 2	Magneto Resistive Sensor (short barrel) w/Qk. Disconnect
51	1 or 2	Magneto Resistive Sensor (90° barrel) w/Qk. Disconnect
52	1 or 2	Magneto Resistive Sensor (12mm Dovetail) w/Qk. Disconnect
53	1,2 or 3	Plumbing Fitting - M3 male to 3mm OD Push-in Style
54	1,2 or 3	Plumbing Fitting - M3 male to 2mm ID Barb Style
59	1 or 2	Adjustable Flow Control (Metric) M5 elbow - 6mm OD Push-in Style
61	1 or 2	Adjustable Flow Control (Metric) G1/8 elbow - 6mm OD Push-in Style
63	1	Fail Safe Valve (Metric) M5
65	1	Fail Safe Valve (Metric) G1/8 (1/8 BSPP)

NOTE: Other Plumbing Fittings are available for each size - Consult Factory

Magneto-Resistive Sensors:

- Insert sensors #50 or #51 from either end of the profile slots and set the sensor with the integrated screw.
- Insert sensor #52 into the dovetail slot at a 90 degree point and set the sensor with the integrated screw & locking shoe.

Plumbing Fittings:

- M3 plumbing fittings #53 & #54 can be used in any airport or purge/scavenge port.
- Flow controls can be inserted and used in any open or closed airport to help control the stroke action.
- Fail-safe valve can be used in either the open or closed airport to help limit the possibility of dropping the part if air pressure is lost.