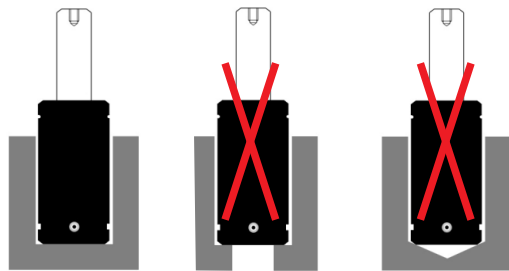
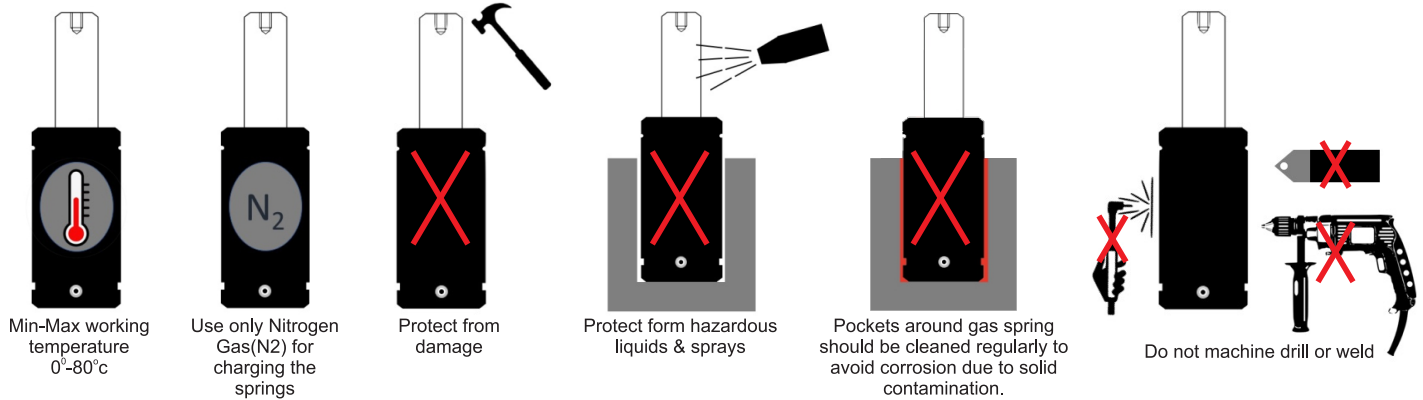
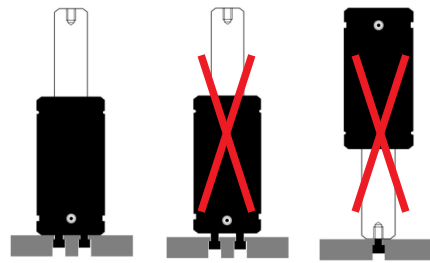


Safety Instructions

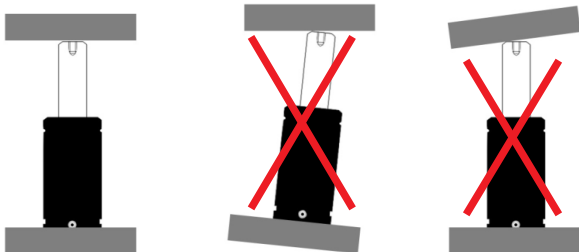
- All structural components of N-Force gas springs are designed and built, in full compliance with the regulation in force (PED 2014/23/CE/Article 3&4), for at least 2.000.000 complete cycle at the maximum pressure, temperature and for type of fixings.
- This component has been engineered only for industrial use as elastic element.
- The use of this component is only for skilled staff who must have read and understood this instruction sheet.
- Do not submit this component to performances over the given limit.
- Do not use this component in the presence of flames or heat sources.
- Use only N-Force maintenance kits for repair, or guarantee and responsibility failure.
- The cylinders misuse raises Pawan Precision from any responsibility.
- Avoid welding, drilling, machining, grinding, and any chemical spraying near Gas spring and on Gas spring also.



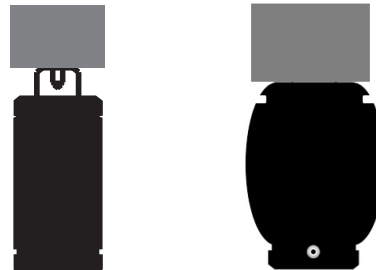
Mount the gas spring on perfect flat surface. Mounting gas spring on uneven surface can cause side loading, leading to structural damage.



Mount the gas spring on perfect flat surface. Ensure the bolts are tight and spring cannot move during use. Do not use piston hole taping for mounting the spring, it is only for maintenance purpose



Mount the gas spring between two perfectly parallel surface to ensure maximum life. Mounting gas spring in non parallel surfaces could lead to significant decrease in life.



It is strongly recommended that a minimum of 5 mm or 10% of the allowable stroke should not be used. This is to prevent over stroking.

Operating Instructions :

- **Do not charge pressure in the gas spring more than the specified limit (Laser etched on Gas spring).**
- While refilling, the gas spring should be completely discharged so as to avoid damage.
- Do not use cylinder over piston velocity of 1.6 m/sec. and 0.8 m/sec for NFS-S5 Model.
- Use N-Force gas spring as it is, do not alter the piston or the cylinder.
- With gas spring fully charged at high pressure gas, not following the above mentioned user guide may lead to accident, product damage, reduction in life, etc. Before using the gas spring, make sure to completely understand the user manual.
- During the Venting procedure, put the cylinder in upside-down position and direct the gas flow opposite to operators' position.
- **It is forbidden any uncontrolled piston return. It may cause damages, mechanical failures to spring or mountings.**

User Safety Instructions :

- It is recommended to check the correct fixing of cylinders after any operation on the tool. In case of loose or broken screws, cylinder might have been subject to uncontrolled return.
- It is recommended to replace cylinder and remove the cause of uncontrolled return.
- The maintenance of the cylinder must always be executed by authorized personnel, using exclusively the N-Force component kits.
- Before disposing of a cylinder, ensure that all residual pressure is fully exhausted.

Fixings

General Information

- You have always to fix the cylinders directly through the specific fixing components.
- You have always to use Loctite 243 type on all fixing screws.
- A correct fixing prevents damages to the products and serious dangers to the operators.

Mounting Guidelines

- Follow the correct tightening torques as indicated. Always check the state of cylinders and of fixings after each operation on the tool.
- The use of screws of higher class such as 9.8, 10.9 and 12.9, is always allowed.
- We recommend toolmarkers to deliver tools always with use and instructions sheets provided with N-Force products.

UNI EN ISO 21269:2007 B:B	Torque force Nm
M5	6
M6	10
M8	24
M10	50
M12	84
M16	205



User Manual



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