

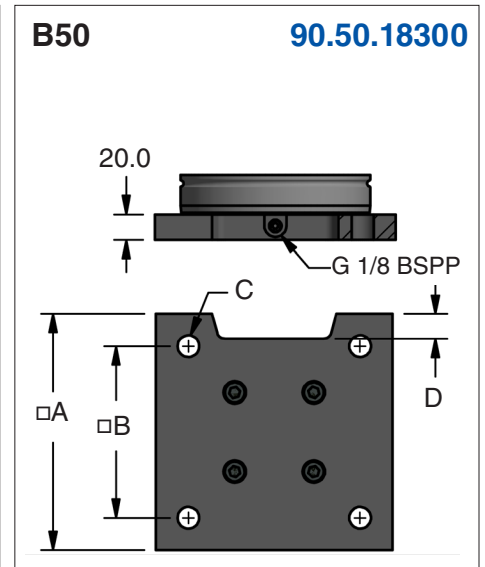
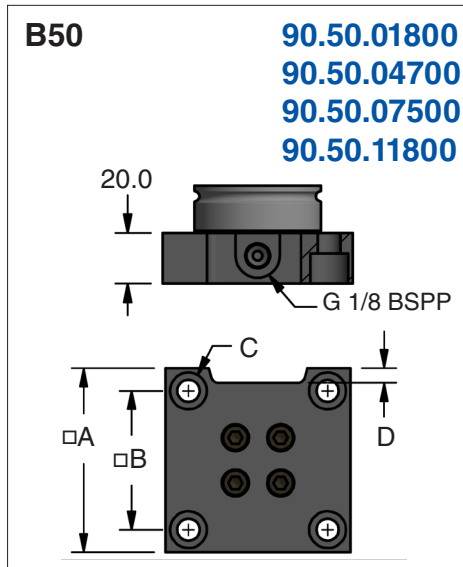
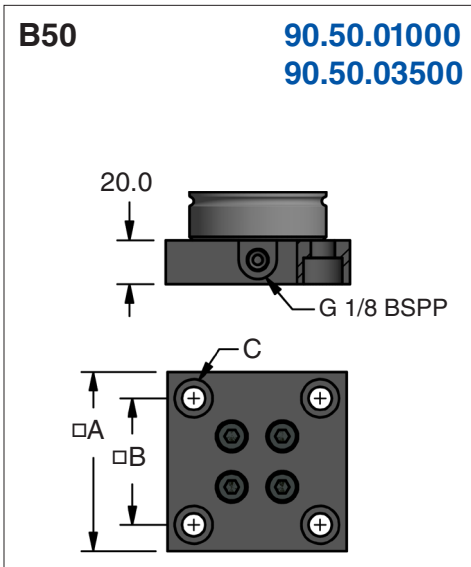
Super Compact Nitrogen Gas Springs

Square Sub-Plate Mount - 90.50.___ / B50

The 90.50.___ / B50 Square Sub-Plate Mount facilitates piping of SC Series Gas Springs with an integrated base flange mount configuration.



Mount	A	B	C	D
90.50.01000	52.0	37.5	4 X M6	-
90.50.01800	75.0	56.5	4 X M8	6.0
90.50.03500	85.0	60.0	4 X M10	-
90.50.04700	100.0	73.5	4 X M10	12.0
90.50.07500	120.0	92.0	4 X M12	12.5
90.50.11800	140.0	109.5	4 X M12	10.0
90.50.18300	190.0	138.0	4 X M16	20.0



Ordering Examples:

Cylinder with Square Sub-Plate Mount Attached	Mount Kit* Only
SC.01000.(stroke).B50.0	90.50.01000
SC.01800.(stroke).B50.0	90.50.01800
SC.03500.(stroke).B50.0	90.50.03500
SC.04700.(stroke).B50.0	90.50.04300
SC.07500.(stroke).B50.0	90.50.07000
SC.11800.(stroke).B50.0	90.50.11800
SC.18300.(stroke).B50.0	90.50.18300

*Mount Kit includes: Cap Screws, Serrated Lock Washers, and Piping Adapter

Installation Instructions

To convert a self-contained SC-Series Gas spring for piped operation using a B50 square base mount, follow the step-by-step instructions below. If you require additional training or have any questions please contact DADCO for assistance.

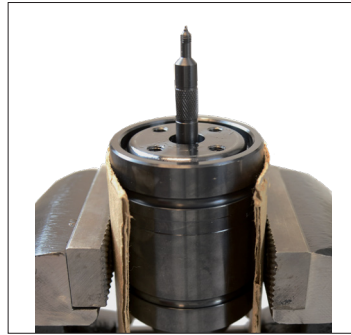
CAUTION: Always wear safety goggles when performing any maintenance work.



1. To exhaust pressure, secure the gas spring upside down in a vise body. Be sure to wrap the cylinder in cardboard to protect from damage.



2. Remove the port plug located on the bottom of the spring with a 90.320.8 Port Servicing Tool.



3. Keeping face and hands clear of the port, use either the 90.320.8 Port Servicing Tool or the 90.360.4 Valve Bleed Tool to depress the 90.260 Compact Valve. Cover the port with a cloth to absorb discharge.



4. After all the gas pressure is exhausted, remove the gas spring from the vise. Be sure that the piston rod will freely retract into the tube manually. If not, try depressing the valve again. If still unsuccessful, **STOP** and contact DADCO.



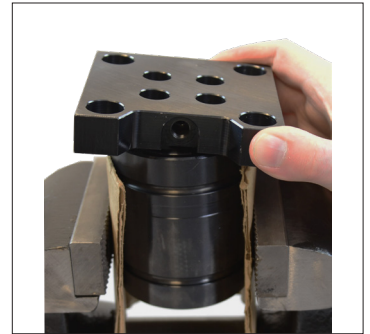
5. Remove the 90.260 Compact Valve using a 90.320.8 Port Servicing Tool.



6. Position the gas spring upside down in a vise to secure. Be sure to wrap the cylinder body in cardboard to protect from damage.



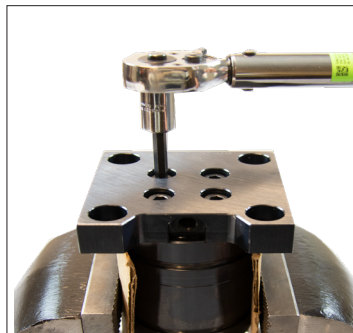
7. Apply oil to the piping adapter, then install into the bottom center port using a hex key. Use a torque wrench to tighten adapter to appropriate value listed in the table below.



8. Align the B50 mount so that the piping adapter matches the hole in the mount, and cap screw holes align.



9. Apply serviceable thread locker to the bottom three threads of the cap screws with lockwashers.



10. Fasten the mount by installing the cap screws with lock washers. Alternate tightening each screw 1/4 turn at a time (like a tire) to avoid pinching the adapter o-ring. With a torque wrench tighten the screws to the appropriate value listed in the table.

Model	Mount Kit*	Cap Screw	Qty	Screw Torque		Piping Adapter	
				in-lbs	N•m	in-lbs	N•m
SC.01000	90.50.01000	M6 X 22	2	103	11.6	36	4.1
SC.01800	90.50.01800	M6 X 22	4	103	11.6	84	9
SC.03500	90.50.03500	M8 X 20	4	252	27.9	84	9
SC.04700	90.50.04300	M8 X 18	4	252	27.9	84	9
SC.07500	90.50.07000	M8 X 20	4	252	27.9	84	9
SC.11800	90.50.11800	M10 X 20	4	492	27.9	84	9
SC.18300	90.50.18300	M10 X 20	4	492	27.9	84	9

*Mount Kit includes: Cap Screws, Serrated Lock Washers, and Piping Adapter