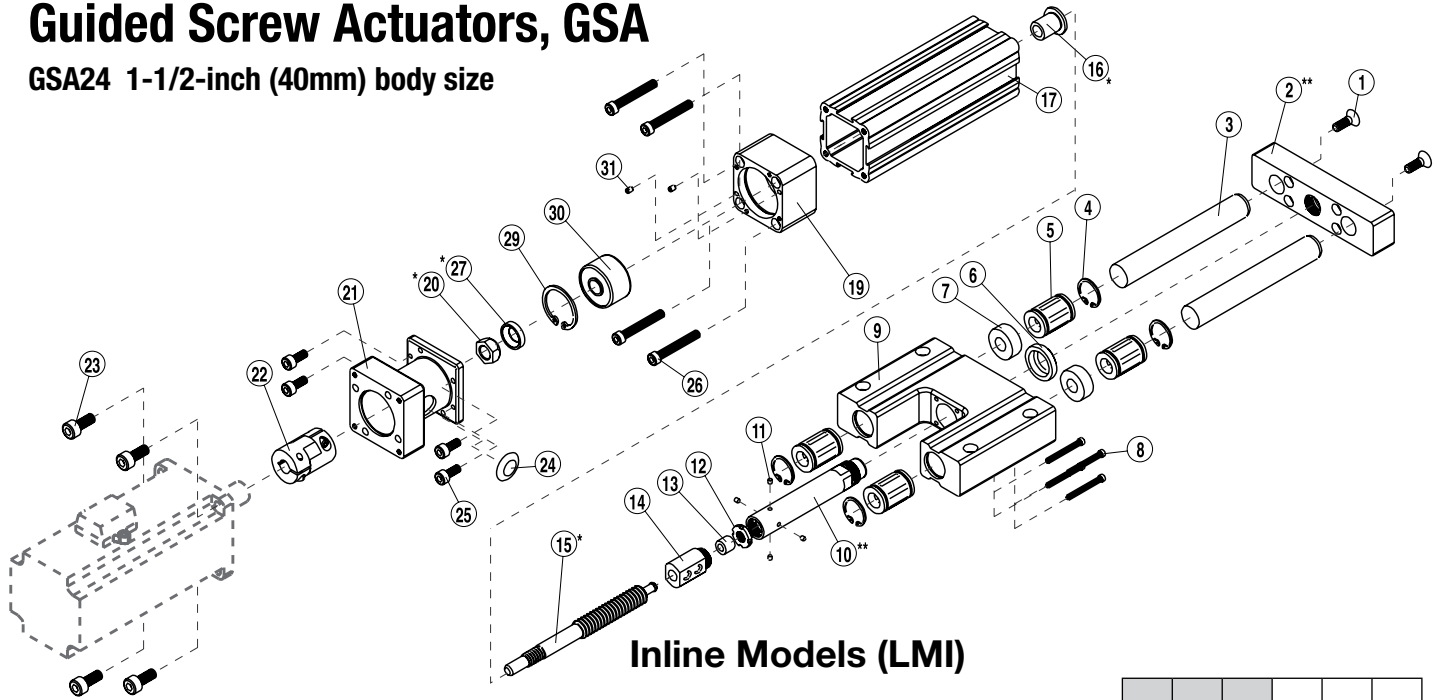


Guided Screw Actuators, GSA

GSA24 1-1/2-inch (40mm) body size



Inline Models (LMI)

ITEM	PART NUMBER	DESCRIPTION	SN02†	SN04†	SN08†	BN05	BNL05	BN10
◇1.	CONFIGURED	SOCKET HEAD FLAT CAP SCREWS	2	2	2	2	2	2
◇**2.	CONFIGURED	TOOLING PLATE	2	2	2	2	2	2
◇3.	CONFIGURED	GUIDE ROD	2	2	2	2	2	2
4.	2224-1007	RETAINING RING	4	4	4	4	4	4
◇5.	CONFIGURED	BEARING	1	1	1	1	1	1
6.	2120-1030	WIPER RING	1	1	1	1	1	1
◇7.	CONFIGURED	WICK ROD	2	2	2	2	2	2
8.	2224-1011	SOCKET HEAD CAP SCREW	4	4	4	4	4	4
◇9.	CONFIGURED	HOUSING	1	1	1	1	1	1
◇**10.	CONFIGURED	THRUST ROD	1	1	1	1	1	1
11.	2224-1019	MAGNET ROD	4	4	4	4	4	4
12.	0920-1060	LOCK NUT	1	1	1	1	1	1
13.	2224-1024	BEARING LEAD SCREW	1	1	1	1	1	1
◇14.	CONFIGURED	NUT LEAD NUT	1	1	1	1	1	1
◇*15.	CONFIGURED	SCREW, BALL LEAD	1	1	1	1	1	1
◇*16.	1124-1044	SLEEVE, TAPER	1	1	1	1	1	1
17.	2224-1004	CYLINDER BODY	1	1	1	1	1	1
◇18.	CONFIGURED	THIS NUMBER IS NOT USED	1	1	1	1	1	1
◇19.	CONFIGURED	BEARING PLATE	1	1	1	1	1	1
*20.	1124-1082	NUT, SPHERICAL	1	1	1	1	1	1
◇21.	CONFIGURED	MOTOR SPACER	1	1	1	1	1	1
◇22.	CONFIGURED	COUPLER KIT	1	1	1	1	1	1
◇23.	CONFIGURED	SOCKET HEAD CAP SCREW	4	4	4	4	4	4
24.	0910-1426	CAP PLUG	1	1	1	1	1	1
25.	0610-1033	SOCKET HEAD CAP SCREW	4	4	4	4	4	4
26.	2212-1095	SOCKET HEAD CAP SCREW	4	4	4	4	4	4
*27.	1124-1092	WASHER, SPHERICAL	1	1	1	1	1	1
28.	-	THIS NUMBER IS NOT USED						
29.	2100-1010	RETAINING RING	1	1	1	1	1	1
30.	3420-1222	BEARING, DBL ROW, ANGULAR	1	1	1	1	1	1
31.	1930-1024	DOWEL PIN	2	2	2	2	2	2

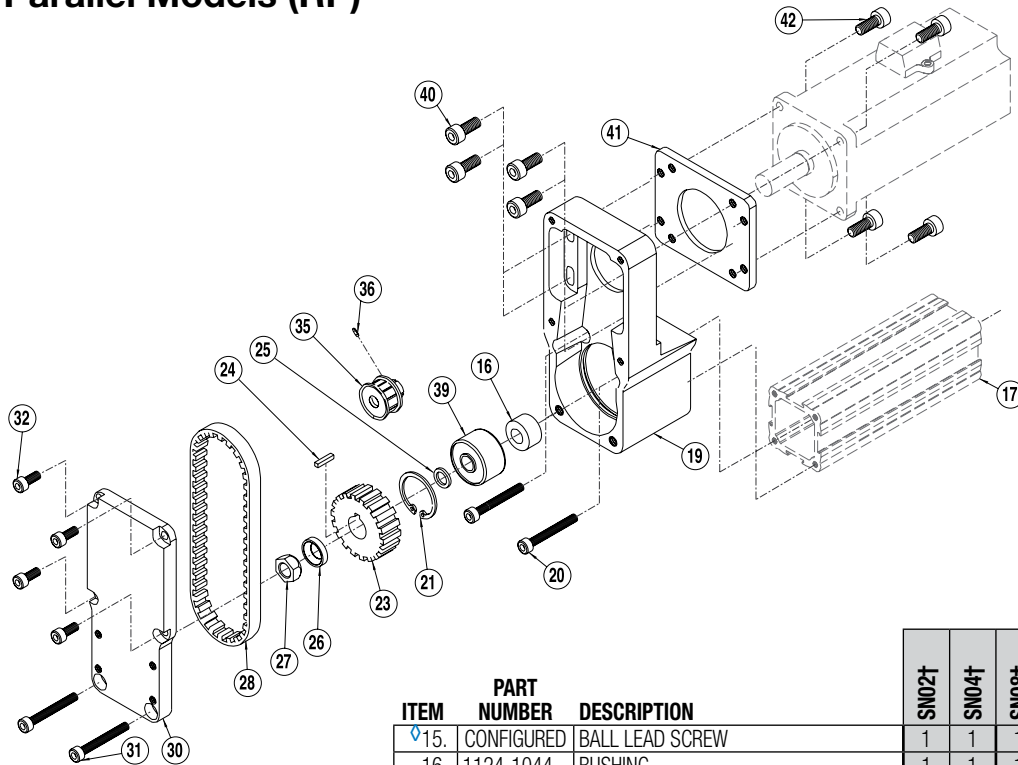
*Not backward compatible with units manufactured before 01/01/2003

**Not backward compatible with units manufactured before 03/01/2003

◇ Part number varies depending on YMH (Your Motor Here). Contact help@tolomatic.com for replacement part number.

† Discontinued Jan. 1, 2022. Email help@tolomatic.com for available replacement parts.

Reverse Parallel Models (RP)



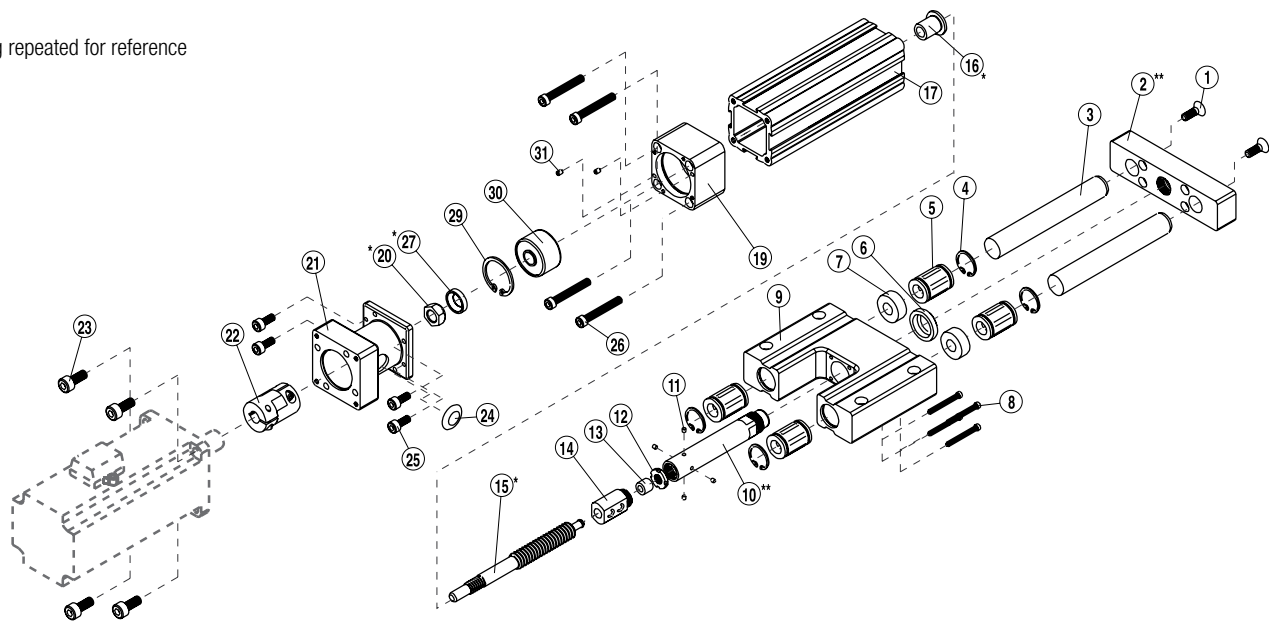
ITEM	PART NUMBER	DESCRIPTION	SN02†	SN04†	SN08†	BN05	BNL05	BN10
15.	CONFIGURED	BALL LEAD SCREW	1	1	1	1	1	1
16.	1124-1044	BUSHING	1	1	1	1	1	1
19.	CONFIGURED	REVERSE-PARALLEL HOUSING	1	1	1	1	1	1
20.	4910-1061	SOCKET HEAD CAP SCREW	2	2	2	2	2	2
21.	2100-1010	RETAINING RING	1	1	1	1	1	1
23.	CONFIGURED	LOWER PULLEY 1:1 REDUCTION OPTION	1	1	1	1	1	1
24.	1817-1044	SQUARE KEY	1	1	1	1	1	1
25.	2115-1017	WASHER (USED ON 1:1 UNITS ONLY)	1	1	1	1	1	1
26.	1124-1092	WASHER	1	1	1	1	1	1
27.	1124-1082	LOCKNUT	1	1	1	1	1	1
28.	CONFIGURED	BELT	1	1	1	1	1	1
30.	CONFIGURED	PLATE COVER	1	1	1	1	1	1
31.	2212-1100	SOCKET HEAD CAP SCREW	2	2	2	2	2	2
32.	2212-1093	SOCKET HEAD CAP SCREW	4	4	4	4	4	4
35.	CONFIGURED	UPPER PULLEY	1	1	1	1	1	1
36.	2006-1059	SPRING PIN	1	1	1	1	1	1
	2132-1022	SPRING PIN	1	1	1	1	1	1
39.	3420-1222	BEARING, DBL ROW, ANGULAR	1	1	1	1	1	1
40.	CONFIGURED	SOCKET HEAD CAP SCREW	4	4	4	4	4	4
41.	CONFIGURED	MOTOR PLATE	1	1	1	1	1	1
42.	CONFIGURED	SOCKET HEAD CAP SCREW	4	4	4	4	4	4

♦ Part number varies depending on YMH (Your Motor Here). Contact help@tolomatic.com for replacement part number.

† Discontinued Jan. 1, 2022. Email help@tolomatic.com for available replacement parts.

NOTE: Parts 1-18 (Except 15) of the Inline model listing are used in the reverse-parallel models.

Drawing repeated for reference



General Cylinder Disassembly Instructions

Begin with a clean work area. Be sure all replacement parts are present and have no visual damage or defects. The following tools are recommended for proper disassembly and assembly.

- Allen wrench set (metric)
- Socket wrench & socket set
- Retaining ring pliers (internal & external)

- 1. LMI Unit, Remove motor and motor spacer:** Remove the access plug (24) from the motor spacer (21) to gain access to the screws of the motor coupler (22). Loosen the coupler screw closest to the actuator. Remove 4 screws (25) that hold the motor spacer onto actuator body. Remove the motor spacer/motor assembly.

RP Unit, Remove motor and belt: Remove the RP Cover (30), loosen the four fasteners (40) attaching motor plate to the RP case. Remove the belt (28). The motor can now be removed if need be.

- 2. Remove the Tooling Plate Assembly:** Using a wrench, unscrew the thrust rod (10) from the tooling plate (2). Slide the tooling plate (shafts still attached) out from the housing.
- 3. Remove Bearing Plate/Leadscrew Assembly:** Remove the 4 screws (26) that hold the bearing plate (19) to the actuator body. Slide the bearing plate, leadscrew, thrust rod assembly out of the tube. Note: the thrust rod may need to be "unscrewed" from the wiper seal in the housing in order to do this.
- 4. Remove the Thrust Rod/Nut Assembly:** Remove the locknut (12) and guide bushing (13) from the non-motor end of the leadscrew.

Plastic nut style: The leadscrew can be threaded out of the nut at this point.

Ball nut style: Caution is required if removal of the nut or leadscrew is required. Contact the factory for available parts and procedures. Note: if ball nut is removed from screw, ball bearings will fall out!

- 5. Remove Bearing Plate from Leadscrew:** Hold the leadscrew in a smooth jaw vice and remove the locknut (20). Support the bearing plate, and press the leadscrew out of the bearing/sleeve. The sleeve is a press fit in the bearing and should not be re-used. Remove the snap ring (29) from bearing plate (19) and press the bearing out of the bearing plate.
- 6. Remove the Housing from the Tube:** Remove screws (8) from the housing (9) to detach it from the actuator body. The wiper ring (6) can be removed from the housing at this time.

- 7. Remove the Shafts from Tooling Plate:** Remove screws (1) from plate. Use a press and a tool that will fit inside the thread inside the shaft (3) and press out the shafts.

- 8. Guide Bearing & Wick removal (linear bearings only):** Remove retaining rings (4) from the housing. Slide out bearings (5). Using a screwdriver or similar tool, remove the lubrication wicks (7). Note: the composite style of bearings are pressed in the housing, they can't be removed.

General Cylinder Assembly Instructions

- 1. Install Wick and Guide Bearings (linear bearings only):** Apply a light amount of oil to each wick (7) so that they are damp. Install the wick into each groove of the housing (9). Install 4 bearings (5) into the housing. Rotate them such that the ball races are not aligned with each other on opposite ends of the housing. Install retaining rings (4) to hold them in place. The flat side of the ring goes against the bearing. Install wiper ring (6) into groove in housing. Make sure tapered edge of ring faces "out" of housing.
- 2. Install bearing into Bearing Plate:** Press sleeve (16) into bearing (30). Apply a coating of Loctite 641 to the ID of the bearing plate/RP case and the OD of the bearing. Locate the Bearing Plate/RP housing over the bearing and install the snap ring.
- 3. LMI:** Install Bearing onto Leadscrew: Clean ID of sleeve and OD of taper on leadscrew. Position bearing/sleeve over the leadscrew. Install the washer (27) over leadscrew. Apply Loctite 242 to threads of leadscrew and threads of locknut (20). Thread on the Locknut and torque to 200 in-lbs [22.6 N-m]. Hold leadscrew in machinist vice as needed.

RP: Install Bearing onto Leadscrew: Clean ID of sleeve and OD of taper on leadscrew. Position bearing/sleeve over the leadscrew. Install the key (24), pulley (23), washer (26) over leadscrew. Apply Loctite 242 to threads of leadscrew and threads of locknut (27). Thread on the Locknut and torque to 200 in-lbs [22.6 N-m]. Hold leadscrew in machinist vice as needed.
- 4. Install guide shafts into tooling plate:** Press shaft (3) into hole in tooling plate (2). The end of the shaft with the threads in it goes into the plate. Note: It is very important to press the shaft in straight! Use some sort of guide if possible. Repeat this for the other shaft. Apply blue Loctite 242 to the threads of each screw (1) and thread into guide rods. Hand tighten.
- 5. Install nut, thrust rod onto leadscrew:**
Plastic nut style: Temporarily thread the nut into thrust rod and drill w/ 1/8th bit. Remove nut from rod and thread the nut onto the leadscrew. Install the guide bushing and locknut on end of leadscrew. Apply a coating of

loctite 271 to the nut and thread into the thrust rod and tighten. Install pins thru thrust rod and into the nut.

Ball nut style: Ballnut is threaded into thrust rod w/ Loctite 271.

6. Lubricate the leadscrew:

Plastic Nut: Apply a liberal film of Christo-Lube® 405 grease along the leadscrew. Apply a thin film of the same grease along the ID of thrust rod.

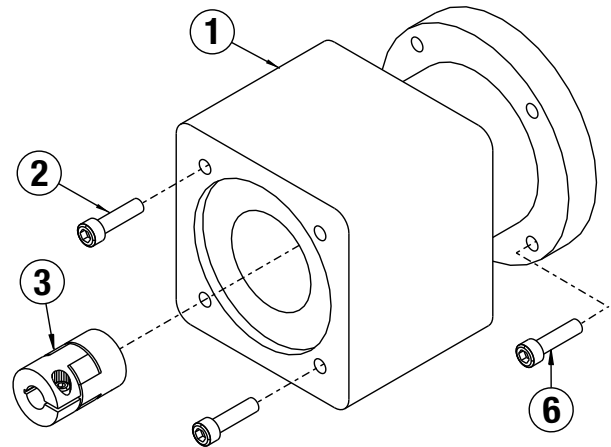
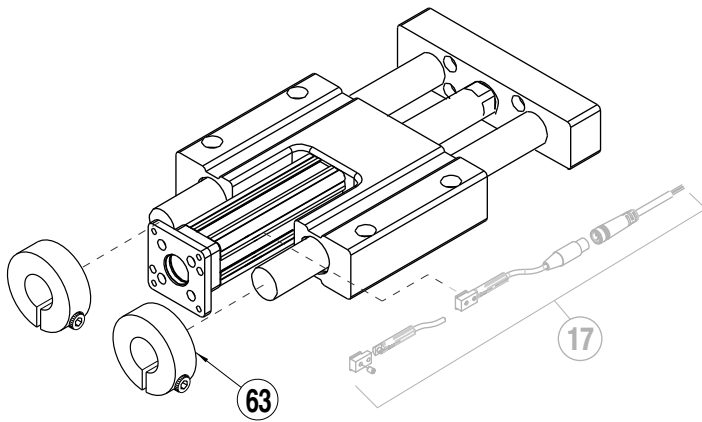
Ballnut: Apply a liberal film of Mobilgrease® HP (Mobil blue) along the lead-screw. Apply a thin film of the same grease along the ID of thrust rod.

7. Main actuator assembly: Locate the tube (17) over the thrust rod/lead-screw assembly. Position the Housing (9) over the thrust rod. Insert the tooling plate/guide rods (3) into the housing. Apply loctite 242 to the thread of the thrust rod. Thread into the tooling plate hand tight. With a wrench, tighten the thrust rod 1/2 turn. Then continue tightening until the nearest set of flats on the thrust rod align w/ the edges of the tooling plate. This is necessary in order to align the magnets w/ the switch slots in the tube. Install fasteners (8) thru housing and tighten. Install the bearing plate fasteners (26), and tighten.

8. LMI Unit, attach Motor: Attach coupler (22) to the actuator shaft. Attach motor spacer (21) to the actuator. Attach motor to the spacer and tighten down coupler fastener to motor shaft.

RP Unit, Attach Motor and Tension Belt:

1. Position motor/motor plate on RP case (19) and Install fasteners (40) but do not tighten.
2. Locate belt (28) over the pulleys.
3. Tension the belt following the procedures for the correct model number found listed in [RP Belt Tensioning 3600-4212](#). Tighten the motor fasteners while this force is applied to the motor.
4. Install the RP cover (30).



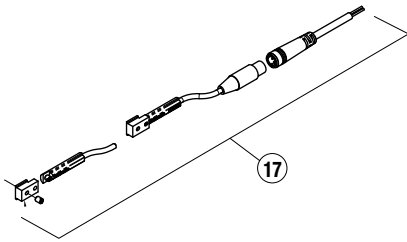
STOP COLLARS			
ITEM	PART #	DESCRIPTION	QTY
63.	2324-1005	STANDARD STOP COLLAR	2
	2324-1056	STAINLESS-STEEL STOP COLLAR	2
	2332-1005	OVERSIZE STOP COLLAR	2
	2332-1056	OVERSIZE STAINLESS-STEEL STOP COLLAR	2

Gearhead Mounting Kits

ITEM	PART #	DESCRIPTION	QTY
1.	CONFIGURED	SPACER	1
2.	CONFIGURED	SOCKET HD CAP SCREW	4
3.	CONFIGURED	COUPLER	1
6.	CONFIGURED	SOCKET HD CAP SCREW	4

Part number varies depending on YMH (Your Motor Here). Contact help@tolomatic.com for replacement part number.

Christo-Lube® is a registered trademark of Lubrication Technology, Inc., www.lubricationtechnology.com
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 Mobil grease® HP is a registered trademark of Mobil Oil Corporation, www.mobil.com



To order switch kits use configuration code for switch preceded by SW and actuator code.

EXAMPLE: SWRSA12KK3

KIT	ACTUATOR	SIZE	SWITCH CODE	QUANTITY
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The example is for 3 Solid State NPN, Normally Open Switches with Quick-disconnect couplers. Each switch is complete with Bracket, Set Screw, Switch and mating QD cable. Note that the bracket/switch size is common and may be used on any size RSA.

ITEM	ORDER CODE	LEAD	SENSOR TYPE	SWITCHING LOGIC	POWER LED	SIGNAL LED	OPERATING VOLTAGE	**POWER RATING (WATTS)	SWITCHING CURRENT (MA MAX.)	CURRENT CONSUMPTION	VOLTAGE DROP	LEAKAGE CURRENT	TEMP. RANGE	SHOCK / VIBRATION
17.	RY	5M	REED	SPST NORMALLY OPEN	—	RED	5 - 240 AC/DC	**10.0	100MA	—	3.0 V MAX.	—	14 TO 158°F [-10 TO 70°C]	50 G / 9 G
	RK	QD*												
	NY	5M		SPST NORMALLY CLOSED	—	YELLOW	5 - 110 AC/DC							
	NK	QD*												
	TY	5M	SOLID STATE	PNP (SOURCING) NORMALLY OPEN	GREEN	YELLOW	10 - 30 VDC	**3.0	100MA	20 MA @ 24V	2.0 V MAX.	0.05 MA MAX.		
	TK	QD*												
	KY	5M		NPN (SINKING) NORMALLY OPEN	GREEN	RED								
	KK	QD*												
	PY	5M		PNP (SOURCING) NORMALLY CLOSED	GREEN	YELLOW								
	PK	QD*												
	HY	5M		NPN (SINKING) NORMALLY CLOSED	GREEN	RED								
	HK	QD*												

SWITCH BRACKET, SET SCREW & MATING QD CABLE IS INCLUDED

*QD = Quick-disconnect

Enclosure classification IEC 529 IP67 (NEMA 6)

CABLES: Robotic grade, oil resistant polyurethane jacket, PVC insulation

**WARNING: Do not exceed power rating (Watt = Voltage x Amperage). Permanent damage to sensor will occur.

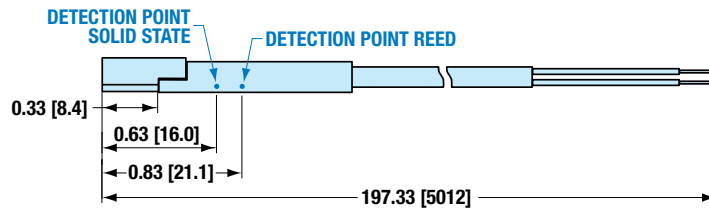
SWITCH INSTALLATION



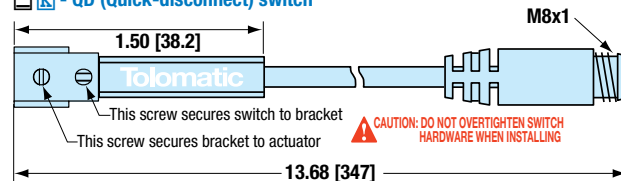
Place switch bracket into one of the four slots that run the length of the extruded tube. Note that there is a cutout on the actuator head (RSA) or tube (GSA) to allow insertion of the bracket. Insert the switch with the word "Tolomatic" facing up and slide it under the bracket. Position the bracket with the switch to the exact location desired, then lock them securely into place by tightening both set screws on the bracket.

SWITCH DIMENSIONS

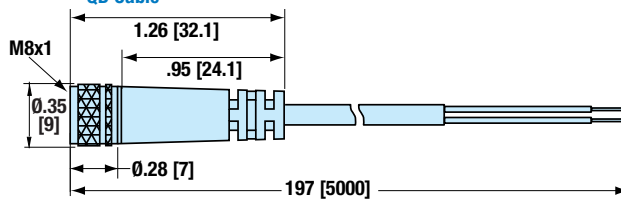
[V] - direct connect



[X] - QD (Quick-disconnect) switch

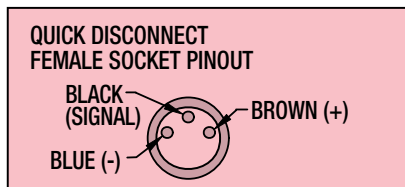
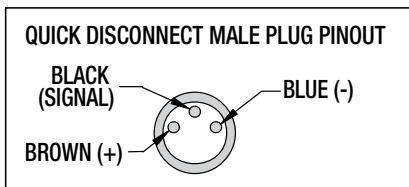
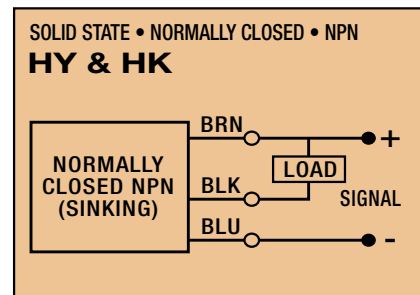
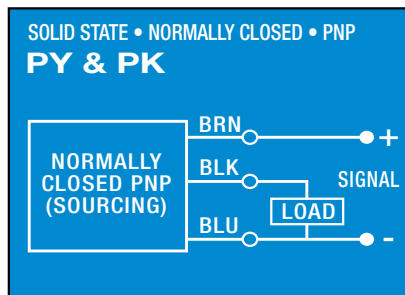
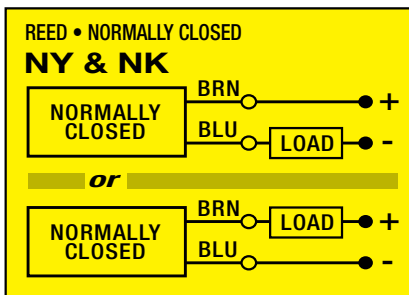
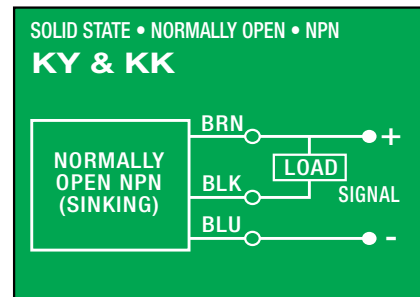
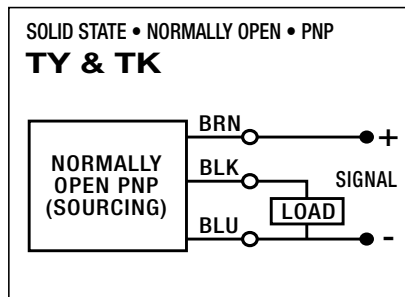
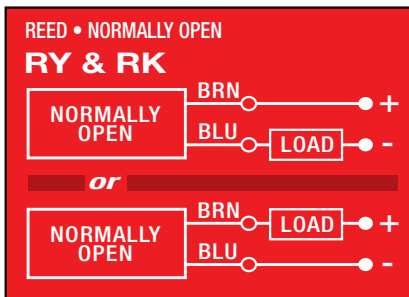


- QD Cable



Dimensions in inches [brackets indicate dimensions in millimeters]

SWITCH WIRING DIAGRAMS AND LABEL COLOR CODING (CE and RoHS Compliant)



Switches:

- Include retained mounting hardware
- In slot, sit below extrusion profile
- Same for all sizes



COMPANY WITH
QUALITY SYSTEM
CERTIFIED BY DNV GL
= ISO 9001 =

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