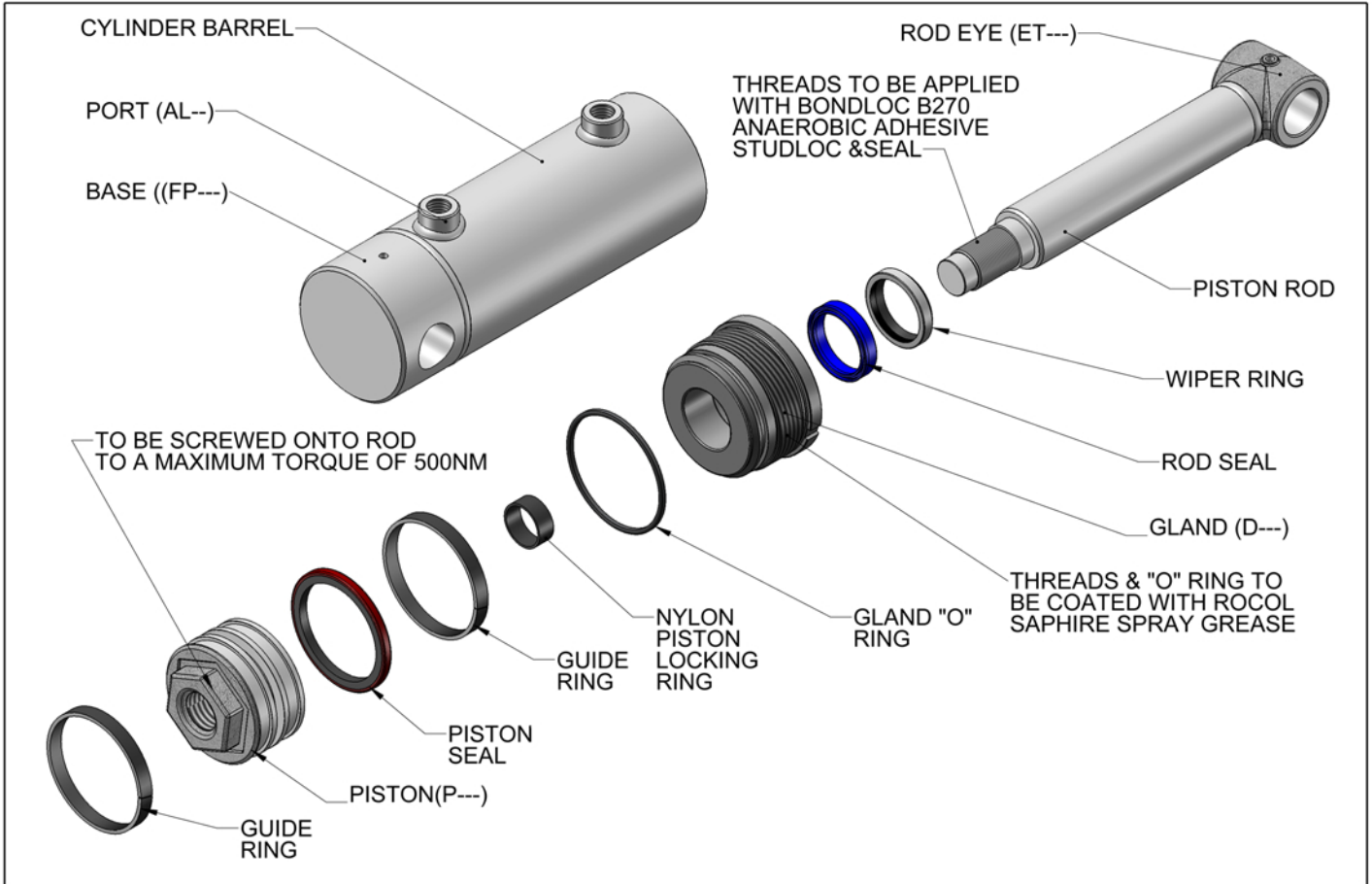




## Cylinder Assembly Instructions



- 1- Ensure that the area and all the components are thoroughly cleaned before commencing either assembly or dismantling of the hydraulic cylinder.
- 2- Place the rod in an appropriate device to hold it firmly without damaging the chrome finish.
- 3- Lubricate the gland both internally and externally and carefully ease the gland onto the rod with the wiper seal facing the rod end. You may need to apply some force with either a plastic or copper hammer on larger sizes.
- 4- Place some stud lock onto the threads of the rod end enough to cover the threads. Then with the nylon locking ring in place inside the piston begin to screw the piston onto the rod, you will notice that once the nylon ring begins to bite on the threads that it no longer becomes possible to screw the piston manually. At this point we recommend you use a torque multiplier set at the appropriate torque setting to screw the piston home.
- 5- Place the tube in an appropriate device to hold it firmly.
- 6- Lubricate the piston and carefully place into the tube assembly taking care not to damage the seals on the threads, again you may need to apply some extra force with either a plastic or copper hammer depending on the size of the cylinder. Once the piston has entered the tube slide it to an appropriate position that allows the gland to be screwed into the tube end, again be careful not to damage the 'O' ring on the threads. Using a 'C' spanner screw the gland home ensuring it's tight by hitting the 'C' spanner with a copper hammer.