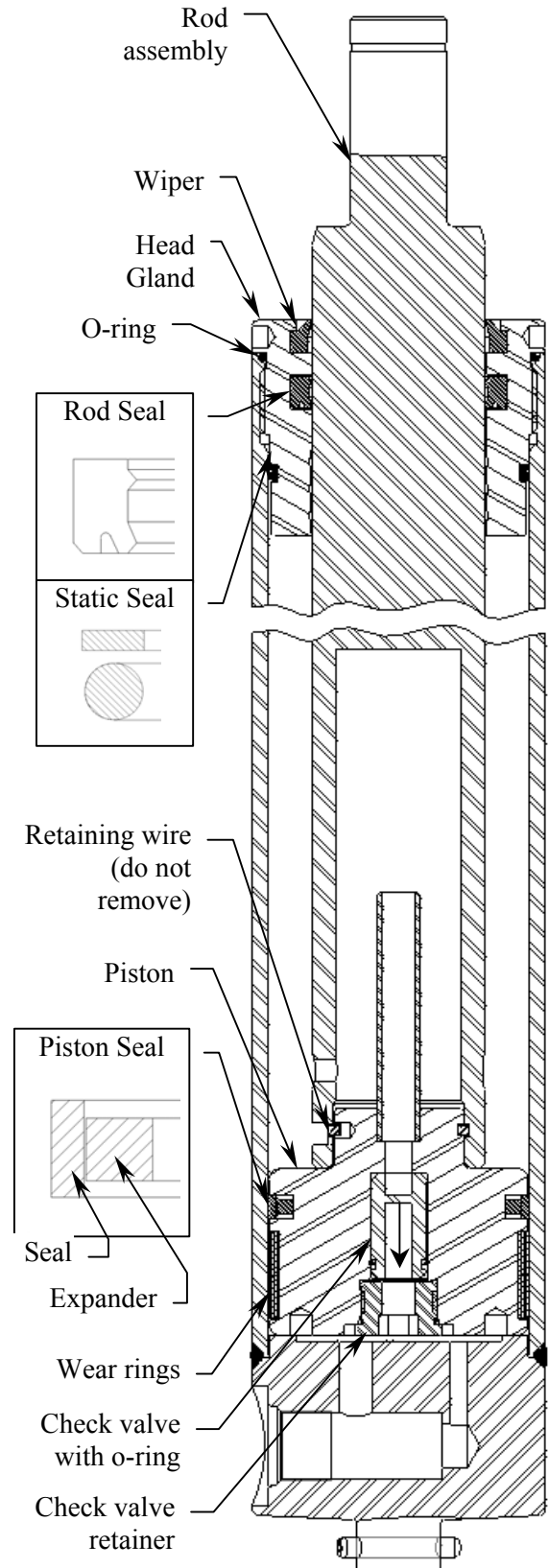


Installation Instructions

45D Quad Free Lift Cylinder

Cylinder Seal Kit P/N 1002524

1. Retract the cylinder fully, open the port, and drain excess oil.
2. Remove the head gland using a pin type OD spanner wrench. Spanner holes are ¼ inch diameter.
3. Remove the rod assembly from the cylinder barrel.
4. Remove the head gland from the rod. Do not remove the piston from the rod.
5. Remove the check valve retainer plug from the piston and remove the check valve.
6. Remove the seals from all components. Insert a blunt tipped screwdriver into the cup of the rod seal and pry out. Cut the top seal element of the piston seal, then remove the rubber expander beneath it. Use caution not to scratch the seal grooves.
7. Inspect cylinder bore, rod, head, and piston for nicks and burrs. Minor nicks and burrs can be removed with 400 grit emery cloth. A light hone can be used on the cylinder bore. If a hone is used, the bore should not be more than 2.379" after honing. The finish should be between 10-20 µinches RMS.
8. Thoroughly clean all parts. Very small contaminants can compromise the performance of the new seals.
9. Install the new seals and bearings into the component parts. Note the correct seal directions.
10. Apply petroleum jelly or hydraulic oil to all seals before assembly.
11. Install the check valve into the piston. Make sure the valve is installed with the o-ring toward the outside and the arrow pointing out as shown. Replace the check valve retainer and lock with one drop of Loctite® 242.
12. Install the head gland onto the rod.
13. Apply petroleum jelly or hydraulic oil to the piston seal, head o-ring, and tube ID.
14. Insert the rod assembly into the cylinder barrel. After inserting, inspect the barrel thread area for cut seal material. If any traces of seal material are found replace the seal again.
15. Put 35mL ± 5mL of hydraulic oil into the rod side of the cylinder.
16. Push the rod in to within 2 inches of full retract before proceeding.
17. Thread in the head gland and torque to 100 ft-lbs.



For Technical Information Contact:
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