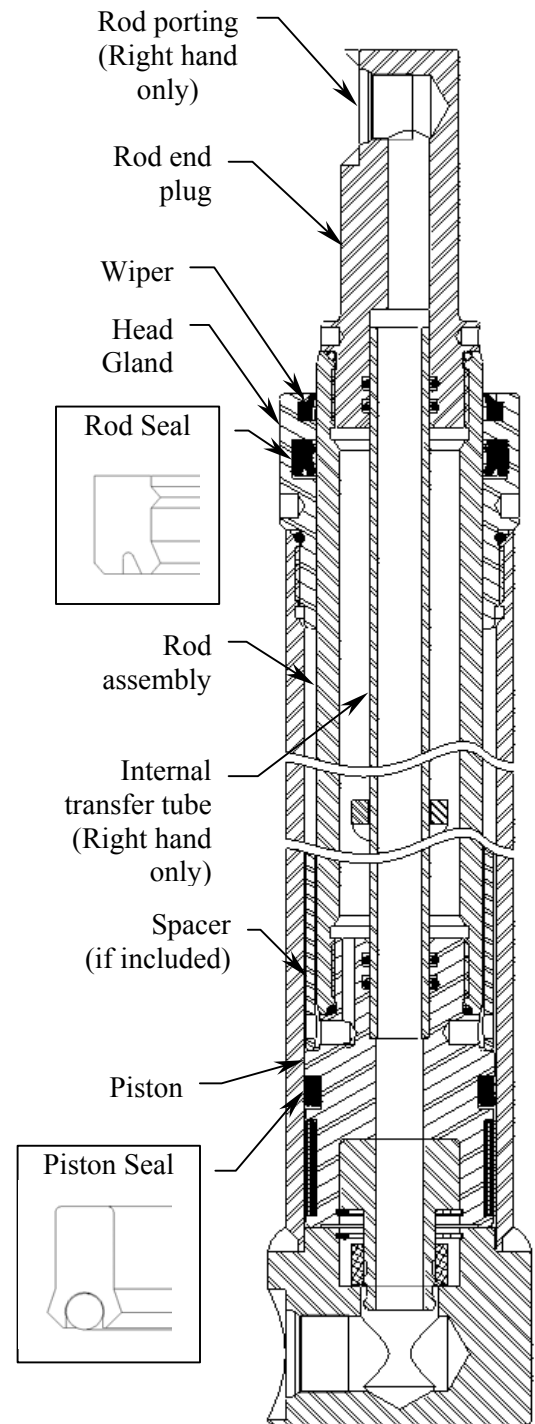


1. Retract the cylinder fully, open all ports, and drain excess oil.
2. Remove the head gland using a pin type OD spanner wrench. Spanner holes are ¼ inch diameter.
3. Remove the rod assembly from the cylinder barrel.
4. Place the rod assembly in a soft jaw vise. Never clamp the chromed rod in a steel vise. Remove the head gland from the rod. Remove the piston and rod end plug from the rod using a pin type OD spanner wrench. Spanner holes are ¼ inch diameter. The piston and rod end plug are locked with a chemical thread locker. If necessary, heat can be applied to the thread area using a propane torch to soften the thread locker. Remove the internal transfer tube, if included (right hand cylinders only).
5. Remove the seals from all components. Insert a blunt tipped screwdriver into the cup of the rod seal and pry out. Pry the piston seal up with a blunt tipped screwdriver and cut the seal to remove it. Use caution not to scratch the seal grooves.
6. Inspect cylinder bore, rod, head, and piston for nicks and burrs. Minor kicks 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 2.004" or 2.379" after honing (depending on model). The finish should be between 10-20 µinches RMS.
7. Thoroughly clean all parts. Very small contaminants can compromise the performance of the new seals.
8. Install the new seals and bearings into the component parts. Note the correct seal directions.
9. Apply petroleum jelly or hydraulic oil to all seals before assembly. Install the head gland onto the rod, wiper end first. Note that the rod is symmetrical from end to end. Install the spacer onto the rod if one was included. Install the rod end plug, internal transfer tube, and piston. Lock the piston and rod end plug with Loctite® 242 and torque to 50 ft-lbs.
10. Apply petroleum jelly or hydraulic oil to the piston seal, head o-ring, and tube ID.
11. 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.
12. Thread in the head gland and torque to 50 ft-lbs.



Right Hand cylinder shown

For Technical Information Contact:
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