



Service Instructions

DISASSEMBLY PROCEDURE

1. Remove cylinder from vehicle by disconnecting necessary fluid lines, disconnecting push rod and removing mounting bolts. Drain fluid from assembly.
2. Remove end housing assembly (30) by removing assembly nut (25).
3. Remove split ring (24), o-ring (23), and assembly nut (25) from body (27).
4. Remove retaining ring (18).

⚠ CAUTION

Retaining ring (18) is under spring (26) tension.

5. Remove rear piston assembly (29) from body (27). Disassemble piston assembly (29).
6. Remove spring (26) from body (27).
7. Remove front piston (6) and cup (5) by pressing on push rod (1). Pull piston (6) and cup (5) out of threaded end of cylinder bore.

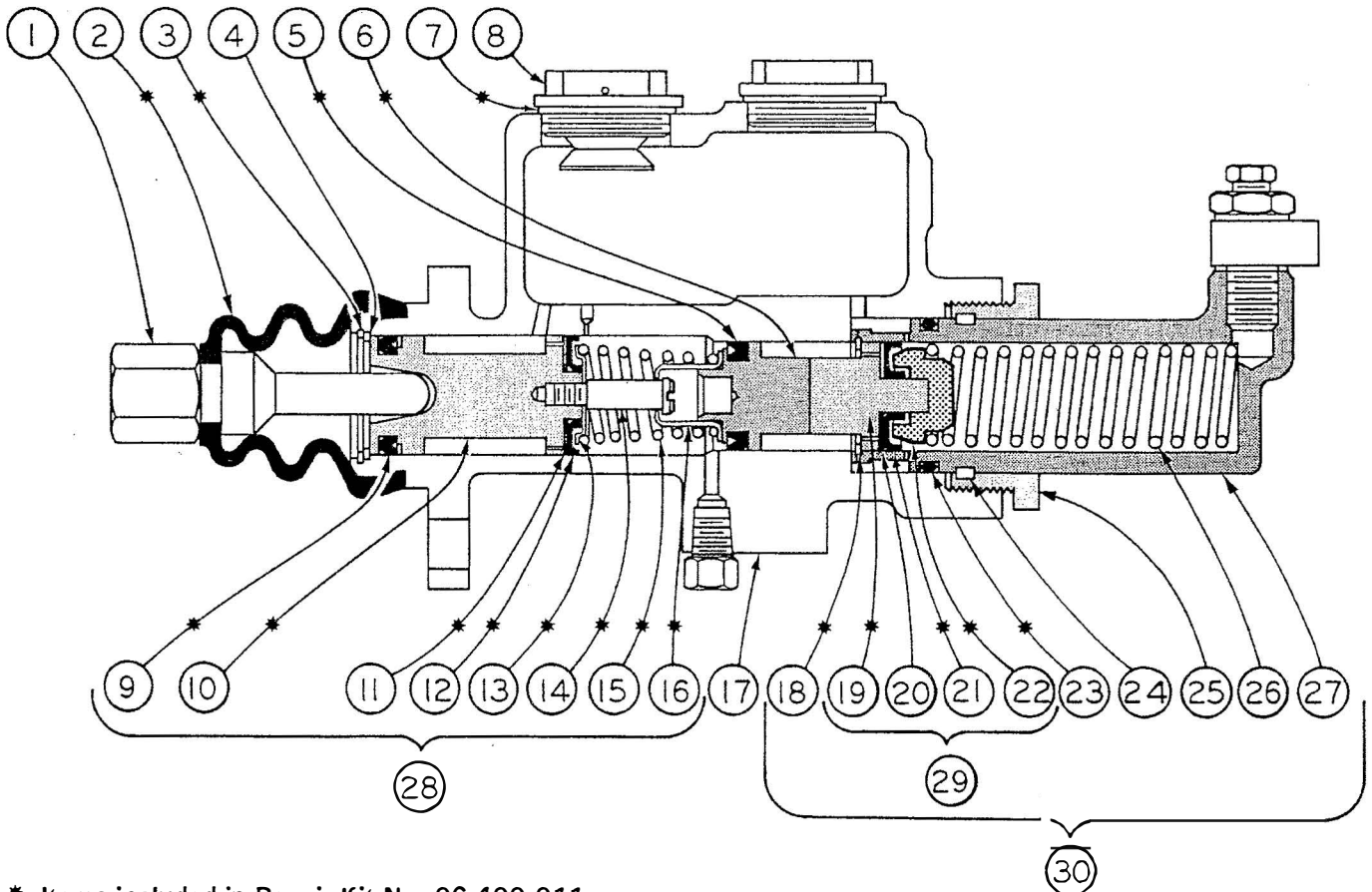
8. Remove push rod (1) and boot (2).
9. Remove retainer (3) and spacer (4) from housing (17).
10. Remove piston assembly (28) by inserting a wooden dowel into threaded end of housing (17). Push piston assembly (28) out boot end of housing (17).
11. Remove filler caps (8) and gaskets (7).

ASSEMBLY PROCEDURE

CLEAN ALL RUBBER COMPONENTS FROM REPAIR KIT WITH CLEAN TYPE FLUID USED IN THE SYSTEM

1. Clean all parts thoroughly and allow to dry before assembling.
2. Insert spring (26) into body (27).
3. Lubricate new rear piston (19), washer (20) and new retainer (22) with clean type fluid used in the system. Assemble washer (20), new cup (21), and new retainer on new rear

continued...



* Items included in Repair Kit No. 06-400-011

- piston (19). Install rear piston assembly (29) into body (27), depress and install new retaining ring (18).
4. Install split ring (24), assembly nut (25) and new o-ring (23) on body (27).
 5. Install end housing assembly (30) on housing (17) and tighten assembly nut (25).
 6. Lubricate new front piston (6) with clean type fluid used in the system. Install new cup (5) on new front piston (6). Note direction of cup (5).
 7. Install front piston (6) assembly in boot (2) end of housing (17) bore.
 8. Lubricate new piston assembly (28) with clean type fluid used in the system. Insert new piston assembly (28) into boot (2) end of housing (17) bore.
 9. Install spacer (4) and new retainer (3) in housing (17) bore.
 10. Install new gaskets (7) and filler caps (8).
 11. Install new boot (2) and push rod (1).
 12. Install cylinder on vehicle. Connect push rod (1) to vehicle. Be sure there is 1/32" free-play between push rod (1) and piston (10). Connect fluid lines. Bleed system of air. Tighten fittings if leaks occur. Make several applications to be sure the Inching Cylinder is working properly. **NOTE: All fittings must be inspected for leaks and tightened if leaks occur.**

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