



Service Instructions

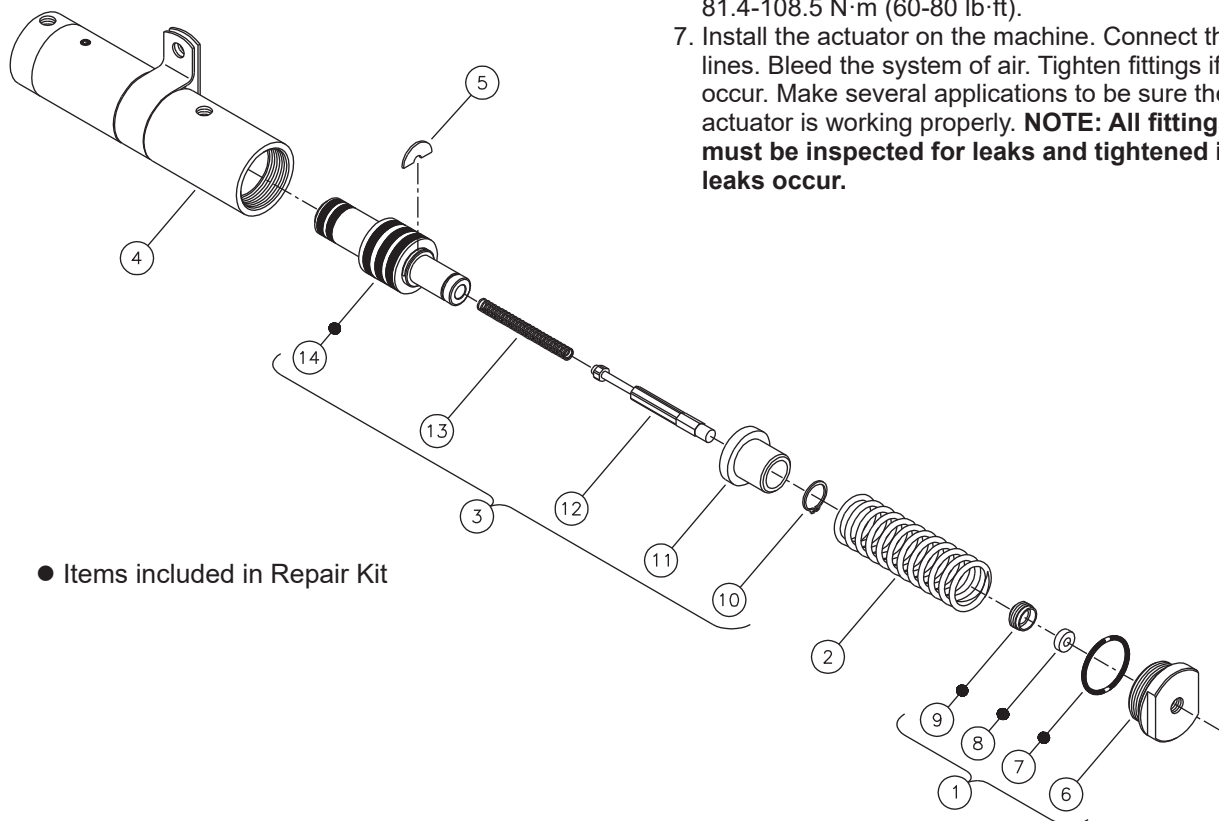
DISASSEMBLY

1. Disconnect necessary fluid lines. Drain fluid from the actuator and remove from the machine.
2. Remove end plug assembly (1) from housing (4). Remove o-ring (7), retainer (9), and seal (8) from end plug.
3. Remove spring (2) and piston assembly (3) from housing (4).
4. Remove retaining ring (10) and retainer (11) from piston (14).
5. Remove stop (5), stem (12) and spring (13) from piston (14). Discard piston (14).

ASSEMBLY

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

1. Thoroughly clean housing bore and all parts in clean system fluid.
2. Install spring (13) and stem (12) in new piston (14) and secure with stop (5).
3. Install retainer (11) and retaining ring (10) on piston (14).
4. Install new seal (8) and new retainer (9) in end plug (6). Torque retainer 10.9-16.3 N·m (8-12 lb·ft).
5. Install new o-ring (7) on end plug (6).
6. Install piston assembly (3), spring (2) and end plug assembly (1) in housing (4). Torque end plug 81.4-108.5 N·m (60-80 lb·ft).
7. Install the actuator on the machine. Connect the fluid lines. Bleed the system of air. Tighten fittings if leaks occur. Make several applications to be sure the actuator is working properly. **NOTE: All fittings must be inspected for leaks and tightened if leaks occur.**



● Items included in Repair Kit

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