PRESSURE INTENSIFIER

Installation and Service Instructions

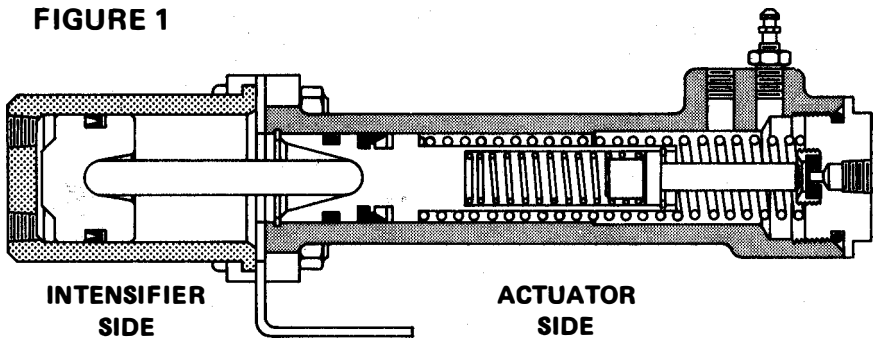
MODEL NO.		REPAIR KIT	RATIO
02-465-028	Intensifier – HO Actuator – HO	02-400-044	1 : 1
02-465-029	Intensifier – HO Actuator – BF	02-400-131	1 : 1

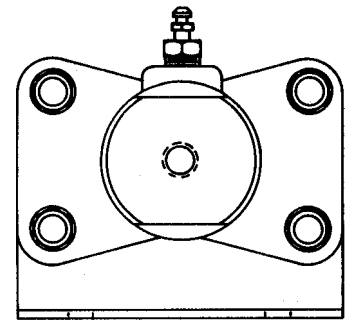
HO = Hydraulic Oil

MODEL NO.		REPAIR KIT	RATIO
02-465-031	Intensifier – HO Actuator – BF	02-400-045	2 : 1
02-465-032	Intensifier – HO Actuator – HO	02-400-046	2 : 1

BF = Brake Fluid

FIGURE 1



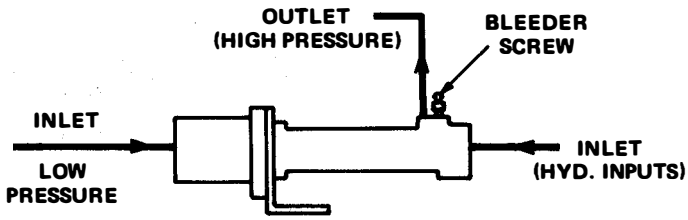


MOUNTING PROCEDURE

(Refer to Figure 2)

Mount the Pressure Intensifier in a horizontal position with the bleeder screw up.

FIGURE 2

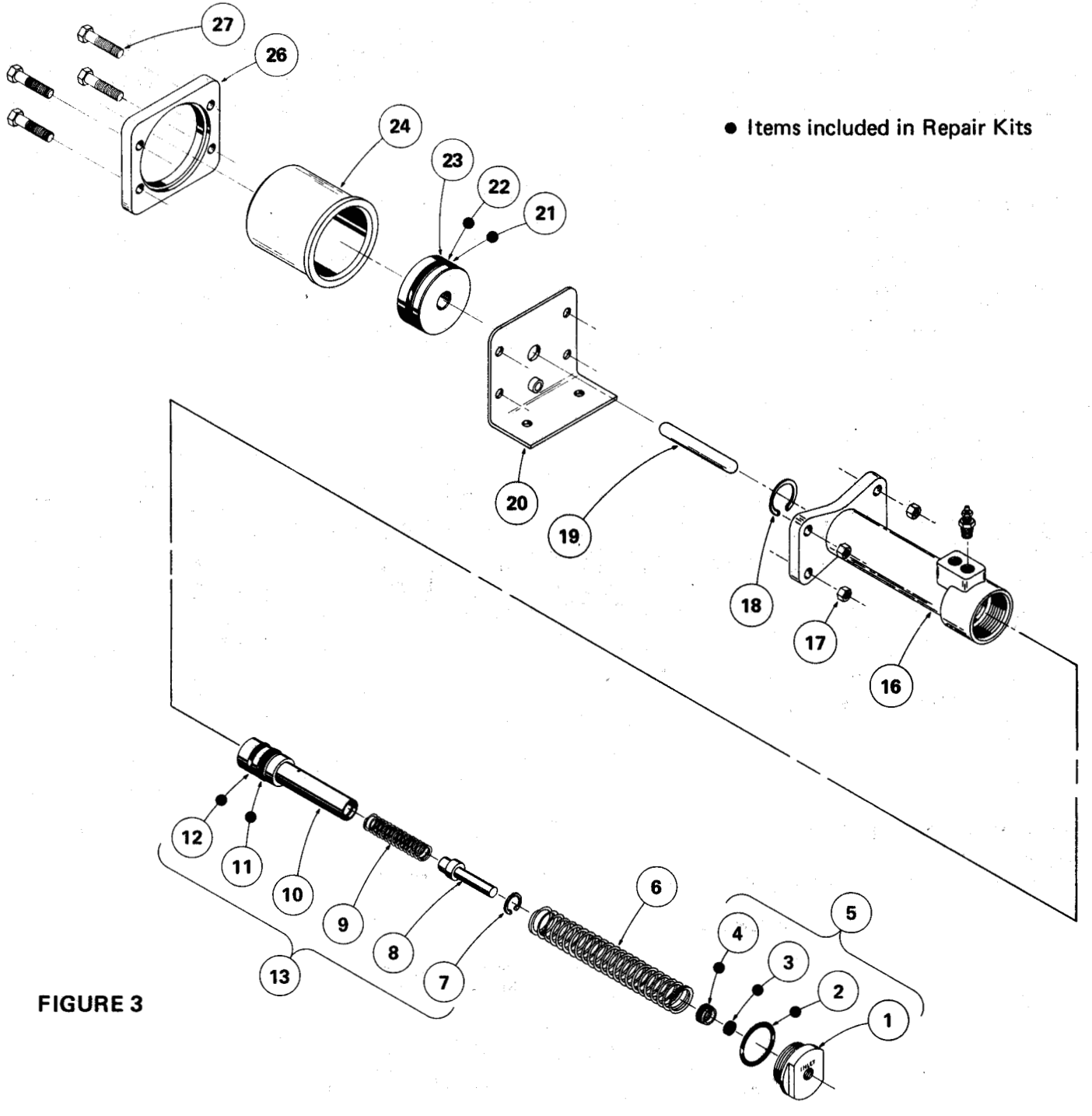


TYPICAL APPLICATIONS

To insure proper operation, please note the following:

1. Whenever possible use appropriate steel tubing on the outlet (high pressure) side. Hydraulic hose is not recommended as it will tend to expand creating a volume loss from a closed system.
2. Volume requirement of cylinder, brakes, etc., must not exceed that of the high pressure side or the high pressure may not develop.
3. Maximum recommended working pressure should not exceed 2000 psi on the outlet (high pressure) side of intensifier. This limitation will dictate the maximum input pressure depending on the intensifier ratio.

EXAMPLE: If the ratio is 2 – 1, the maximum input pressure should not be more than 1000 psi.


● Items included in Repair Kits
27
26
24
23
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19
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17
16
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10
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6
5
4
3
2
1
13

FIGURE 3

DISASSEMBLY PROCEDURE

(Refer to Figures 1 and 3)

1. Disconnect necessary fluid lines.
2. Remove unit from vehicle by removing mounting bolts.
3. Remove bolts (item 27) and nuts (item 17).
4. Separate intensifier housing (item 24) and bracket (item 20) from actuator housing (item 16).
5. Remove retainer (item 26).
6. Remove piston assembly (item 23) from intensifier housing (item 24).
7. Remove cup (item 22) and back-up ring (item 21) from piston (item 23).
8. Remove push rod (item 19) and retaining ring (item 18) from actuator housing (item 16).
9. Remove end plug assembly (item 5) from actuator housing (item 16).

   CAUTION: End plug is under tension of spring (item 6).

10. Remove retainer (item 4), valve seat (item 3) and o-ring (item 2) from end plug (item 1).
11. Remove spring (item 6) and piston assembly (item 13) from actuator housing (item 16).
12. Remove stem (item 8) and spring (item 9) from piston (item 10) by removing retaining ring (item 7).
13. Remove o-ring (item 12) and cup (item 11) from piston (item 10).

ASSEMBLY PROCEDURE

(Refer to Figures 1 and 3)

LUBRICATE ALL RUBBER COMPONENTS FROM THE REPAIR KIT PRIOR TO INSTALLATION WITH ONLY THE TYPE FLUID USED IN EACH SYSTEM SIDE. NOTE COVER PAGE.

1. Clean all parts thoroughly before assembling.
2. Install new o-ring (item 12) and new cup (item 11) on piston (item 10). Note direction of cup.
3. Insert spring (item 9) and stem (item 8) into piston (item 10) then secure with retaining ring (item 7).
4. Install retaining ring (item 18) in actuator housing (item 16).
5. Install piston assembly (item 13) and spring (item 6) into actuator housing (item 16). Note direction of piston assembly.
6. Insert new valve seat (item 3) into new retainer (item 4) and install in end plug (item 1). Tighten securely.
7. Install new o-ring (item 2) on end plug (item 1).
8. Thread end plug assembly (item 5) into actuator housing (item 16). Torque end plug 50 - 80 ft. lbs.
9. Install push rod (item 19) in actuator housing (item 16).
10. Install new cup (item 22) and new back-up ring (item 21) on piston (item 23). Note direction of cup.
11. Install new piston assembly in intensifier housing (item 24).
12. Install retainer (item 26) on housing then assemble to bracket (item 20) and actuator housing (item 16) with bolts (item 27) and nuts (item 17). Note direction of bolts. Torque bolts and nuts to 14 ft. lbs.

BLEEDING PROCEDURE

1. All air must be bled from intensifier, lines, cylinders, brakes, etc., for proper operation.

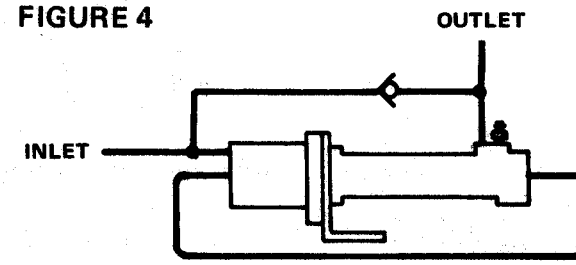
   NOTE: Inlet pressure should not exceed 6 psi when bleeding.

2. Continuous bleeding can be accomplished by cycling the intensifier with three-way or four-way valving.

THE FOLLOWING STEP IS FOR HO/HO UNITS ONLY

3. The continuous bleeding function can also be aided by installing a one-way check valve between the inlet and outlet ports of the intensifier. (CHECKED AGAINST THE OUTLET.)

FIGURE 4



TYPICAL PRESSURE INTENSIFIER CIRCUITS

NOTE: These circuits are for HO/HO Systems only.

FIGURE 5

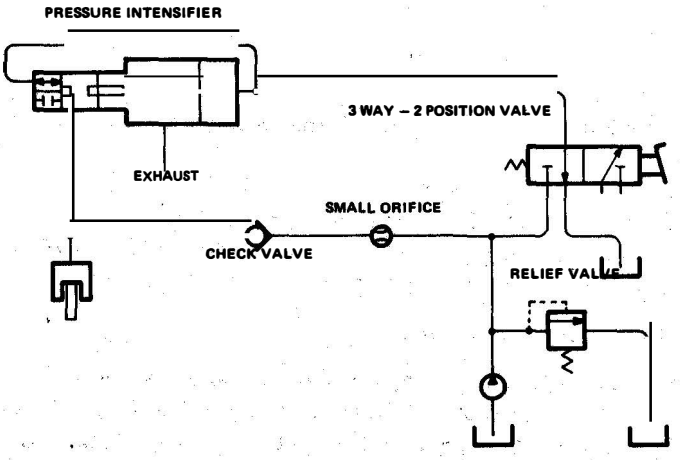


FIGURE 6

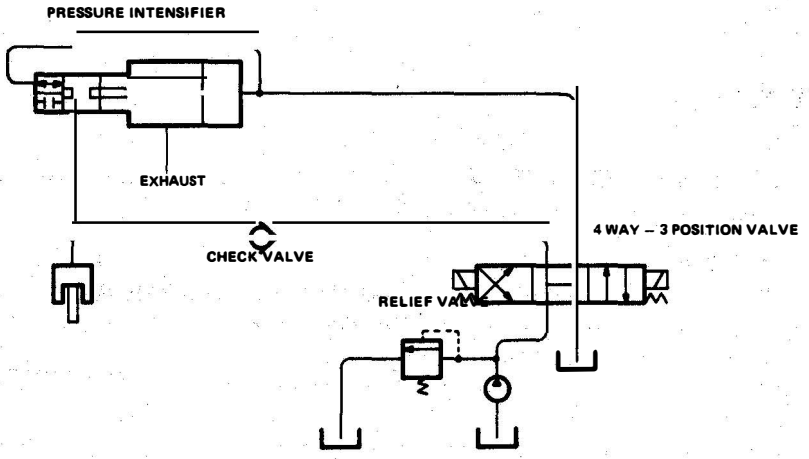
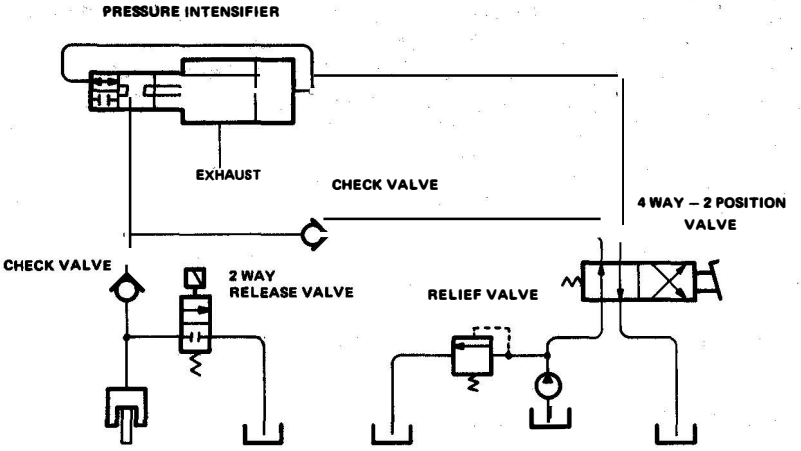


FIGURE 7



ZF Off-Highway Solutions Minnesota Inc.
1911 Lee Boulevard / North Mankato, MN U.S.A. 56003
Tel: +1 507 625 6426 **Fax:** +1 507 625 3212