



H0013 Refitting procedure for piston in Mk6 Bottom arm cylinder (Item S6-25801).

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This procedure applies to the 360 Bottom arm cylinder with the tapered nut style of piston connection.

To avoid leaking problems it is vital that the correct procedure is used when re-fitting the piston to the cylinder rod.

1. Torque the nut (by measuring force) to 70Nm. This will seat the nut into the piston. Mark this position at zero degrees.
2. Continue to torque the nut (by measuring angle) by another 65 to 68 degrees beyond zero.
3. Completely un-screw the nut
4. Re-seat the nut to 70Nm, and mark a new zero position
5. Continue to torque the nut by a further 65 to 68 degrees beyond the new zero point.

Testing is required to verify correct seating of the nut.

1. Remove air
2. Test at 150psi to check for pressure drop and leaks
3. Test at 3000psi and check for pressure drop and leaks
4. Test on the retract side at 5000psi with a stroke restricting spacer between the head and the eye