



H0017 Refitting procedure for piston in SB330 Bottom arm cylinder (Item HC-25900).

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This procedure applies to the SB330 Bottom arm cylinder with the blind screwed piston connection (Type 2 cylinder).

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

1. Ensure that the nylon ring and o-ring in the piston are in good condition
2. Clean both the piston and rod threads
3. Start the piston onto the rod by hand
4. Torque the nut (by measuring force) to 70Nm. This will seat the nut into the piston. Mark this position at zero degrees.
5. Continue to torque the nut to 14,800Nm.
6. Completely un-screw the nut
7. Re-seat the nut to 70Nm, and compare with the previous zero position.
8. Continue to torque the nut to 14,800Nm.

Testing is required to verify correct seating of the piston

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