



## H0020 Cylinder Overhaul Instructions Threaded Head

H0020	Version 2.0	Hydraulics	14-07-05
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Cylinder General overhaul Instructions for:

Part	Model
HC-31628	SB360
HC-31629	SB330
HC-31630	SB300

- Remove cylinder head (gland) by turning anticlockwise (when looking at the cylinder from the rod end)
- Cleanliness is critical, wash all parts and ensure all traces of solvent are removed
- Check seals, rod & bore of tube for any damage
- Piston will need to be removed to change the head seals
- Lightly coat all surfaces with oil. The head & tube contacting surfaces should be lightly greased



It is essential that the piston to rod connection is correctly tightened during assembly, or the cylinder will fail.

For Blind Piston design: (bore diameters 4" and greater)

- The piston nylon lock ring must be replaced every time the piston is removed
- Fit head on to shaft first! (wrap tape around the rod thread to avoid damaging head seals)
- Lightly grease piston thread
- Fit piston by hand and turn until hand tight
- Tighten to 800 to 1000 Nm (you will need approximately a 1.2m extension handle to achieve this)
- Wait for trapped air to escape (approximately 5 seconds)
- Tighten again to 800 to 1000 Nm

1000Nm=85 kg person on a 1.2m extension handle

Do not over tighten head when reassembling (max approximately 200 Nm)

Complete SEAL KITS, which include a replacement SHCS, are available ex-stock from STEELBRO. Please quote bore & shaft diameters when ordering (also note the cylinder number, generally stamped by the port, so we can confirm these sizes for you)



Some seal kits may contain extra components due to the evolution of our hydraulic cylinder designs.