



## H0021 Piston Torquing Instructions Compact Extra

H0021	Version 2	Geenral Info	14 July 05
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### Torquing Procedure:

1. Torque to the setting in the table below to establish an initial zero point.
2. Torque by angle as per the table below from the zero point.
3. Untorque.
4. Torque to the same setting as in the table below.
5. Retorque to the same setting as in the table below.

Mark/model	Initial Torque Setting	Initial Torque Angle
HC-25801 SB 360 Bottom arm and early Top arm cylinders	70 Nm	65-68 degrees
HC-25900 SB 330	60 Nm	58-60 degrees
HC-25806 SB 300	50 NM	70-73 degrees

### Pressure Testing Procedure:

1. Cycle in and out (at least 3 times) to remove all trapped air.
2. Test at 150 psi. pressure (in both directions) for pressure drop and leaks.
3. Test at 3,000 psi. pressure (in both directions) for pressure drop and leaks.
4. Test on the retract side with a strock restricting spacer placed between the head and the eye at 4,800 psi; do not go any higher as the piston rod could be over stressed.