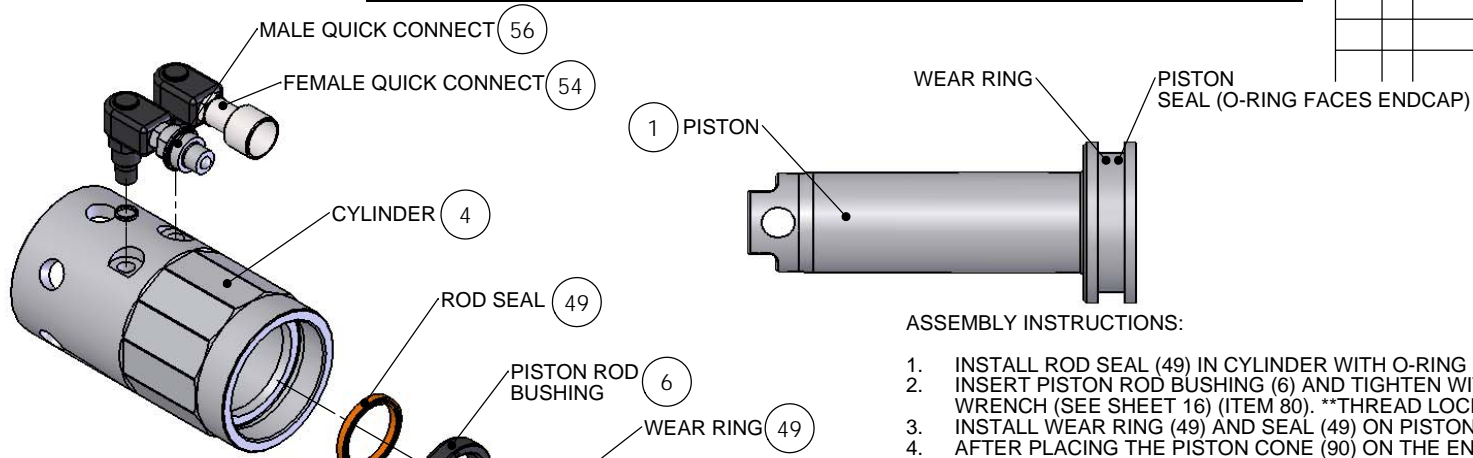


# QD20 & 30 SQDR CYLINDER ASSEMBLY

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED



### ASSEMBLY INSTRUCTIONS:

1. INSTALL ROD SEAL (49) IN CYLINDER WITH O-RING FACING ENDCAP (8).
2. INSERT PISTON ROD BUSHING (6) AND TIGHTEN WITH THE ROD BUSHING WRENCH (SEE SHEET 16) (ITEM 80). \*\*THREAD LOCKER SHOULD BE USED\*\*
3. INSTALL WEAR RING (49) AND SEAL (49) ON PISTON (1) (SEAL SHOULD FACE ENDCAP).
4. AFTER PLACING THE PISTON CONE (90) ON THE END OF THE PISTON PRESS THE PISTON (1) INTO CYLINDER (4) CAREFULLY (DO NOT DAMAGE SEALS).
5. PLACE ENDCAP SEAL (49) INTO CYLINDER (4) WITH O-RING FACING PISTON (1).
6. THREAD CYLINDER ENDCAP (8) INTO CYLINDER (4) AND TIGHTEN WITH CYLINDER ENDCAP WRENCH (81).
7. INSTALL THE MALE (56) AND FEMALE (54) FITTINGS INTO THE TOP OF THE CYLINDER AS SHOWN.

NOTE: ALL PARTS LABELD (49) ARE INCLUDED IN A COMPLETE SEAL KIT.

USE THIS ADDITIONAL WEAR RING ONLY FOR QD30 TOOLS

ROD SEAL (O-RING FACES ENDCAP)

END CAP SEAL (O-RING FACES PISTON)

PLACE PISTON CONE (90) ON END OF PISTON (1) BEFORE PRESSING THE PISTON INTO THE CYLINDER TO PREVENT SEAL DAMAGE

SOFTWARE: SOLID WORKS	DATE	NAME	<b>BOLTTECH</b> We Own the Future of Bolting Technology
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES FRACTIONAL +/- 1/32" ANGULAR +/- 1/2 DEGREE TWO PLACE DECIMAL +/- 0.01 THREE PLACE DECIMAL +/- 0.005	DRAWN	CHECKED	
MATERIAL	ENG APPR.	MFG APPR.	TITLE:
HEAT TREAT	O.A.		SIZE <b>B</b> DWG. NO. REV
FINISH	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BOLTECH. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BOLTECH IS PROHIBITED.		SCALE: 1:20 WEIGHT: SHEET 9 OF 17