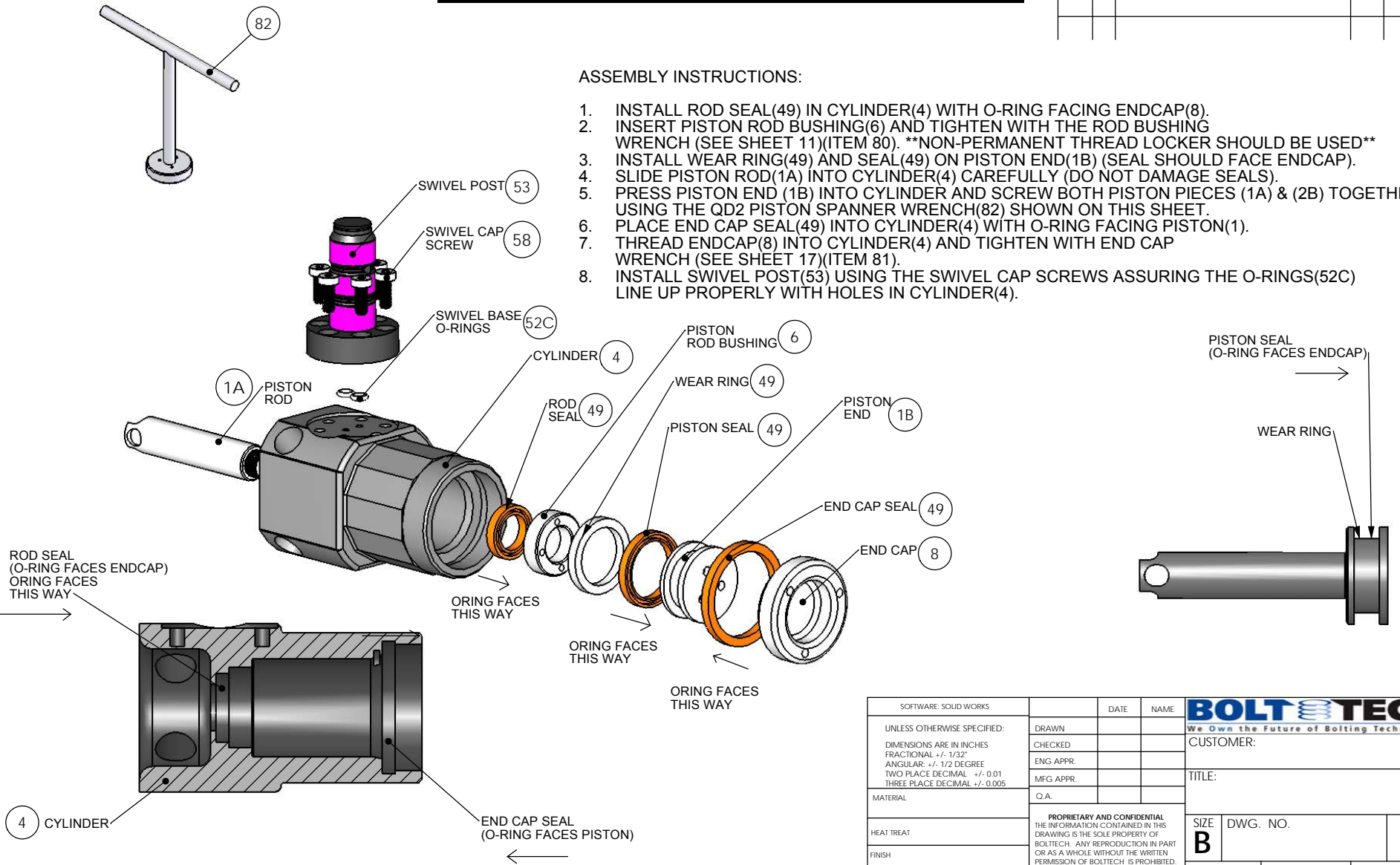


QD2 CYLINDER ASSEMBLY ONLY

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED

ASSEMBLY INSTRUCTIONS:

1. INSTALL ROD SEAL(49) IN CYLINDER(4) WITH O-RING FACING ENDCAP(8).
2. INSERT PISTON ROD BUSHING(6) AND TIGHTEN WITH THE ROD BUSHING WRENCH (SEE SHEET 11)(ITEM 80). **NON-PERMANENT THREAD LOCKER SHOULD BE USED**
3. INSTALL WEAR RING(49) AND SEAL(49) ON PISTON END(1B) (SEAL SHOULD FACE ENDCAP).
4. SLIDE PISTON ROD(1A) INTO CYLINDER(4) CAREFULLY (DO NOT DAMAGE SEALS).
5. PRESS PISTON END (1B) INTO CYLINDER AND SCREW BOTH PISTON PIECES (1A) & (2B) TOGETHER USING THE QD2 PISTON SPANNER WRENCH(82) SHOWN ON THIS SHEET.
6. PLACE END CAP SEAL(49) INTO CYLINDER(4) WITH O-RING FACING PISTON(1).
7. THREAD ENDCAP(8) INTO CYLINDER(4) AND TIGHTEN WITH END CAP WRENCH (SEE SHEET 17)(ITEM 81).
8. INSTALL SWIVEL POST(53) USING THE SWIVEL CAP SCREWS ASSURING THE O-RINGS(52C) LINE UP PROPERLY WITH HOLES IN CYLINDER(4).



SOFTWARE: SOLID WORKS	DATE	NAME	BOLTTECH 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		CUSTOMER:	
	CHECKED		TITLE:	
	ENG APPR.		SIZE DWG. NO. REV	
	MFG APPR.		SCALE: 1:2 WEIGHT: SHEET 3 OF 11	
MATERIAL			O.A.	
HEAT TREAT	PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BOLTTECH. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BOLTTECH IS PROHIBITED.			
FINISH				