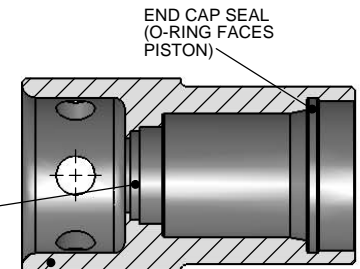
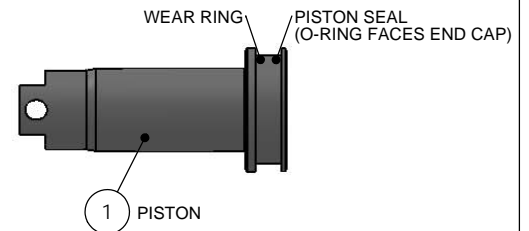
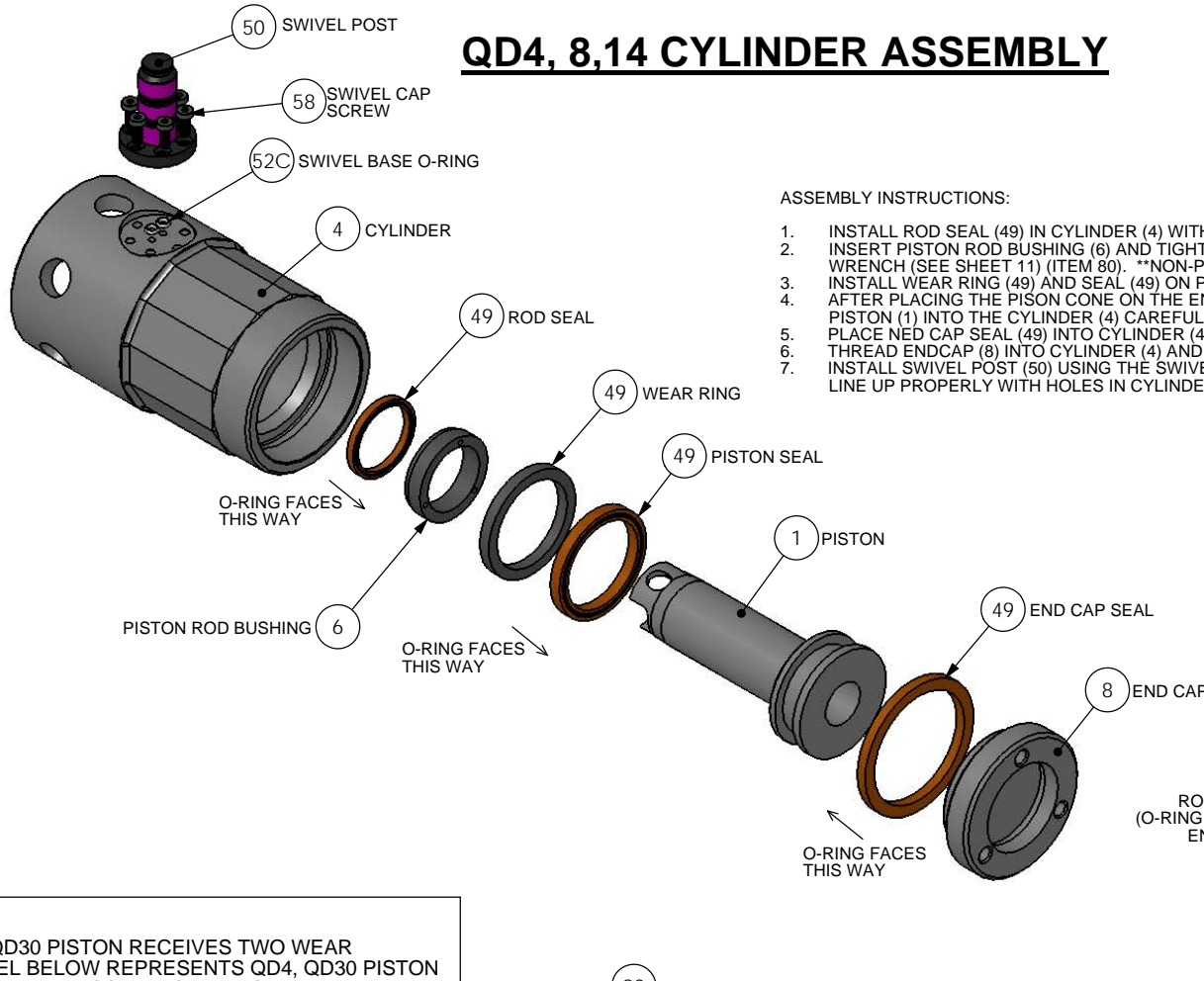


# QD4, 8,14 CYLINDER ASSEMBLY

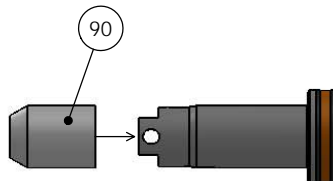
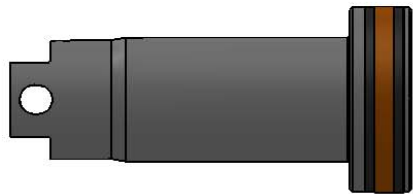
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED

## 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 (1) (SEAL SHOULD FACE ENDCAP).
4. AFTER PLACING THE PISTON CONE ON THE END OF THE PISTON, PRESS THE PISTON (1) INTO THE CYLINDER (4) CAREFULLY (DO NOT DAMAGE SEALS).
5. PLACE END CAP SEAL (49) INTO CYLINDER (4) WITH O-RING FACING PISTON (1).
6. THREAD ENDCAP (8) INTO CYLINDER (4) AND TIGHTEN WITH END CAP WRENCH (SEE SHEET 18) (ITEM 81).
7. INSTALL SWIVEL POST (50) USING THE SWIVEL CAP SCREWS ASSURING THE O-RINGS (52C) LINE UP PROPERLY WITH HOLES IN CYLINDER (4).



NOTE: QD4, QD30 PISTON RECEIVES TWO WEAR RINGS. MODEL BELOW REPRESENTS QD4, QD30 PISTON WITH BOTH WEAR RINGS AND SEAL INSTALLED.



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	<p>The Perfect Union of People, Products and Services</p>
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES/(MM) FRACTIONAL +/- 1/32" ANGULAR +/- 1/2 DEGREE TWO PLACE DECIMAL +/- 0.01 THREE PLACE DECIMAL +/- 0.005	DRAWN		
MATERIAL	CHECKED		
HEAT TREAT	ENG APPR.		
FINISH	MFG APPR.		CUSTOMER:
PROPRIETARY AND CONFIDENTIAL THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF BOLTTECH-MANNINGS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF BOLTTECH-MANNINGS IS PROHIBITED.			TITLE:
SCALE: 1:2		WEIGHT:	DWG. NO.
			REV
			SHEET 4 OF 11