

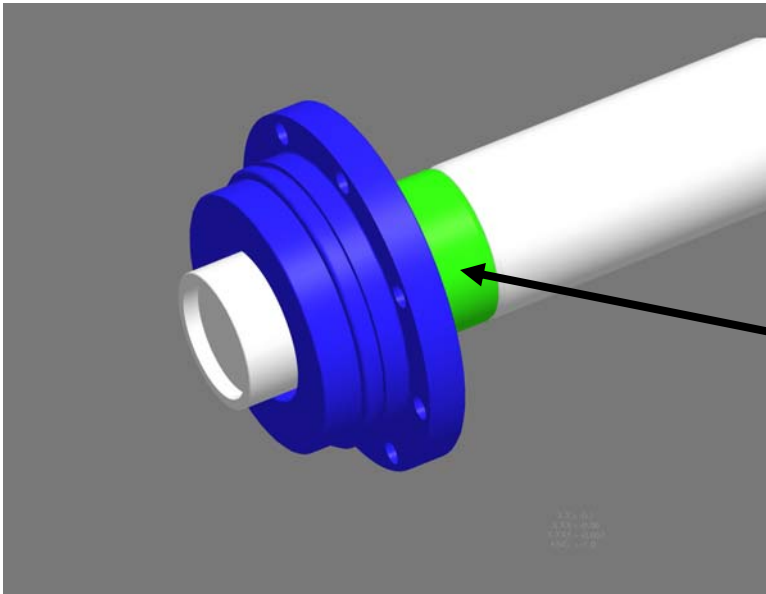


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# Service Instructions

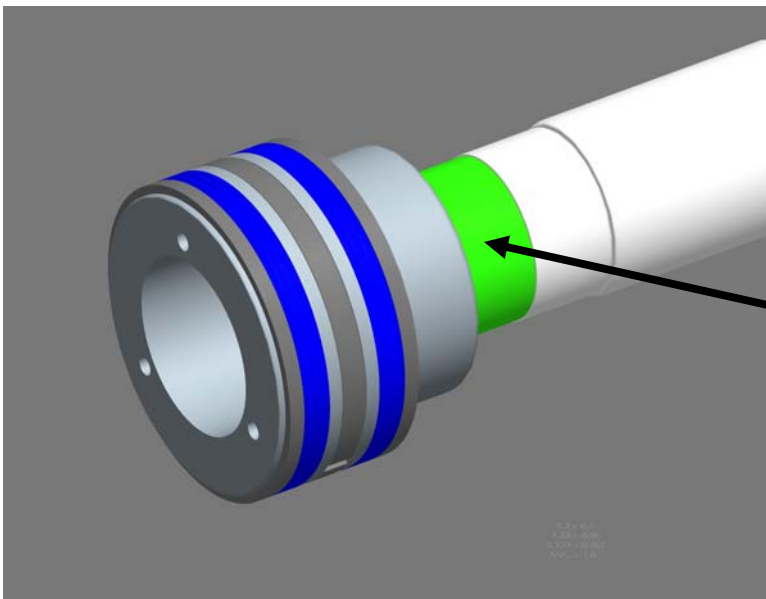
## Assembly Process for 1684318

1. During assembly of head to rod, use **Head Installation Sleeve** (JLG p/n:1001107000) to prevent damage to seals while they pass over the rod threads. After head has passed on to rod, remove sleeve.



Head  
Installation  
Sleeve

2. During assembly of piston, use **Piston Installation Sleeve** (JLG p/n: #1001107001) to prevent damage to seals while they pass over the rod threads. After piston has been installed, remove sleeve.



Piston  
Installation  
Sleeve

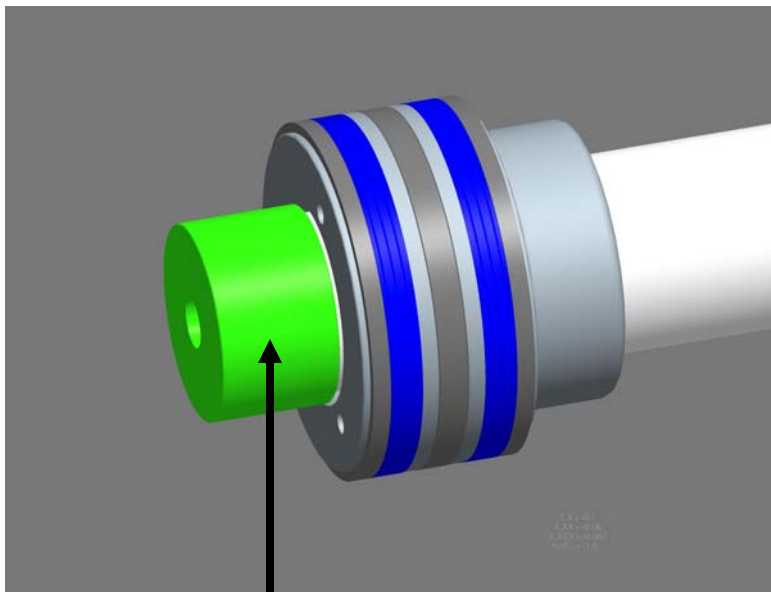
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3. Use **Piston Go-Gauge** (JLG p/n: 1001107002) to check position of piston. Gap should be present between back side of piston and go-gauge.



**Piston  
Go-Gauge**