An Oshkosh Corporation Company

Service Instructions

Assembly & Pressure Test Procedure for 1684292

1. During assembly of head to rod, use **Head Installation Sleeve** (JLG p/n: 1001106846) to prevent damage to seals while they pass over the rod threads. After head has passed on to rod, remove sleeve.

2. During assembly of piston to rod, use **Piston Installation Sleeve** (JLG p/n: 1001106847) to properly center piston and prevent damage to seals while they pass over the rod threads. After piston has been fully threaded onto rod, remove the sleeve.

3. Use **Piston Go-Gauge** (JLG p/n: 1001106848) to check position of piston. Gap should be present between back side of piston and go-gauge.

4. When installing valves insure that the cavity is not full of oil or damage to seals may occur during installation.

5. Install first test hose line to auxiliary port on barrel retaining ring.

6. Install second test hose line with manual valve in auxiliary port at C1 port.

7. Open valve on test line connected to C1 port.

8. Leave ports V1 and V2 open or with open test lines installed.

9. Test cylinder bi-directionally to check for weld leaks by cycling the cylinder fully retracted to fully extended, dwelling for 5 seconds at each position under 2500 psi pressure.

10. Extend cylinder to mid-stroke position.

11. Close valve on test line connected to C1 port.

12. Apply 2500 psi pressure to test line installed on auxiliary port of cylinder barrel retaining ring for 10 cycles comprised of 10 seconds with pressure applied and 2 seconds with pressure released each.

A 07/21/08
3128631
An Oshkosh Corporation Company

13. Check for leakage at V1 and V2 ports. No more than 6 drops per minute should be present. If leakage exceeds 6 drops per minute, cavity or valve is faulty.

14. Check for rod extension. Rod will move initially until force equalizes on the piston but then should stop. If rod continues to extend, piston seals may be faulty.

15. Fully retract cylinder, remove test lines, and install all required plugs.