

Step 3



- A) Install ram guide and seal on ram piston, install circlip.
- B) Install wiper seal into ram stop sleeve, place compression spring over ram piston.
- C) Compress whole assembly in an arbor press or equivalent and install retaining ring.

Step 4



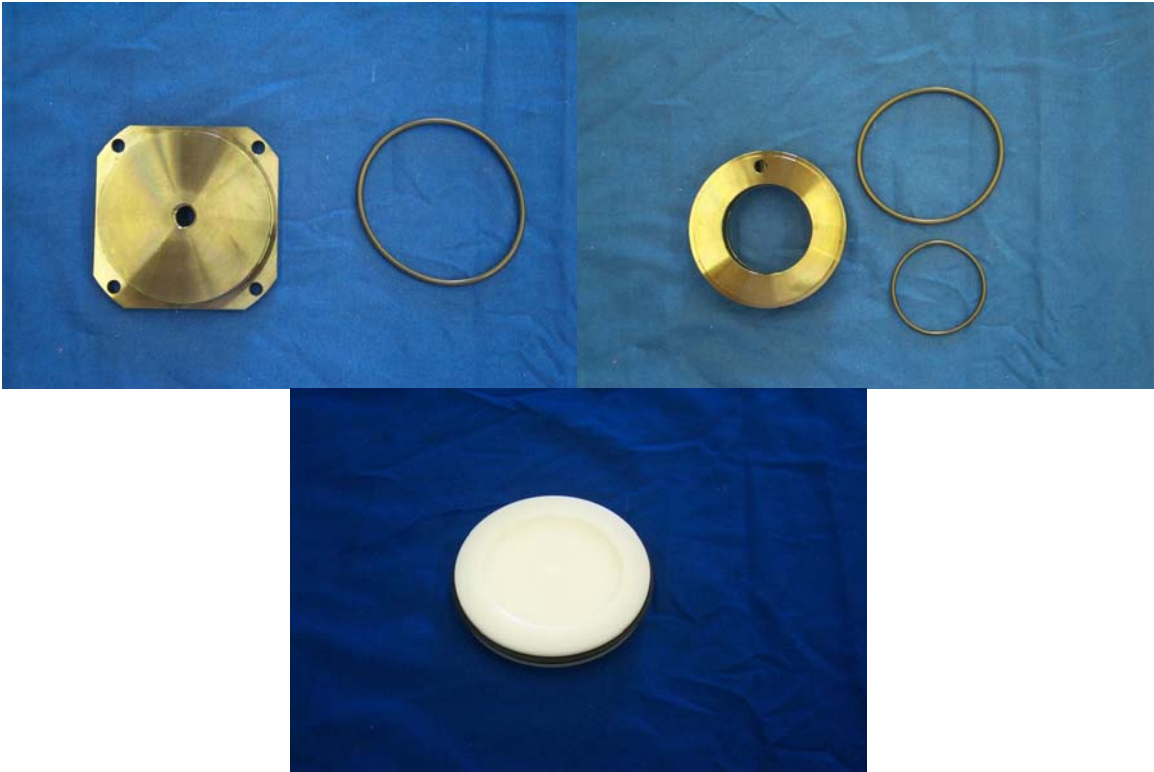
Install piston ring onto low pressure piston, secure with circlip.

Step 5



- a) Install O-ring seals onto main body
- b) Install orange seal into the bottom of the main body, followed by the third stage seal cover, and o-ring plus accompanying flat ring seal.
- c) Install wiper seals plus retaining washer and circlip into main bearing.

Step 6



- a) Install o-ring seal on air cylinder head

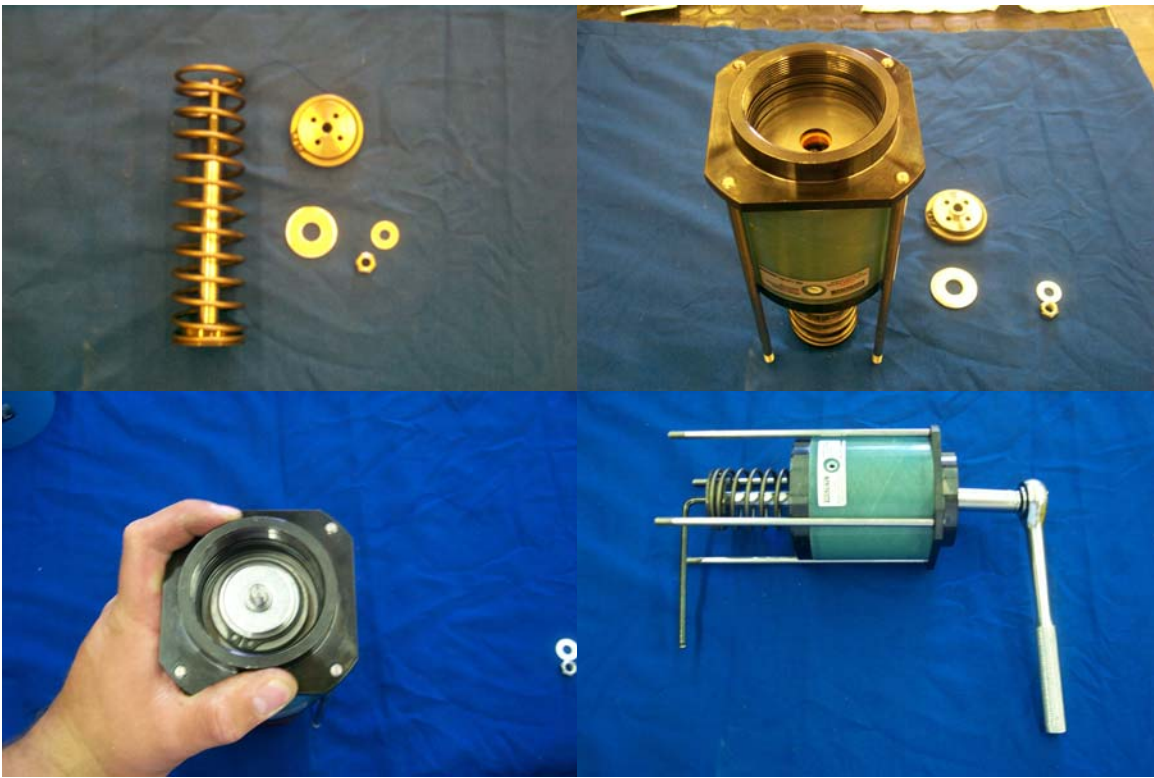
- b) Install o-rings on divider plate
- c) Install seal on air piston (check seal breakdown included with seal kit to see orientation)

Step 7



- a) Install oil cylinder tube onto main body, taking care to position the filler hole 180 degrees from the oil pickup holes in the main body
- b) Install spacer tube
- c) Press divider plate onto assembly

Step 8



- a) Place air spring onto piston rod assembly
- b) Place piston rod and spring assembly onto the main body assembly
- c) Compress the spring assembly and place Low pressure piston over the piston rod stud, followed by washer and locknut
- d) Tighten lock nut and hold the piston rod assembly with a hex wrench.

Step 9



- a) Place air cylinder tube over main body assembly
- b) Press by hand the air piston (make sure seal is well greased) into air cylinder tube
- c) Tighten lock nuts

Step 10



- a) Grease bottom seal on ram assembly and tap using a soft mallet into the High pressure cylinder
- b) Tighten assembly into cylinder and replace the set screw (blue loctite recommended on setscrew)
- c) Re-attach ram cap.

Step 11



- a) Fill high pressure cylinder with **AW32 non-detergent oil**
- b) Hold high pressure cylinder assembly in a SOFT jawed vice (wood or aluminum) and thread and tighten main body assembly onto high pressure cylinder.
- c) Fill with AW32 non-detergent oil to the fill line.