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***You will need 5 quarts General Motors Dexron II/III or equivalent automatic transmission fluid.**



Step 4

Step 8

Step 7

Removal of old cylinder: **Horizontal**

1. Turn off power and air to the machine.
2. Open horizontal speed control valve.
3. Manually push horizontal carriage to far left of track.
4. Remove nut from end of cylinder rod.
5. Roll carriage to far right of track to clear work area.
6. Push cylinder rod completely into cylinder.
7. ***Drain oil from left hand reservoir. Use at 5 quart oil pan or larger.**
8. Brush dust and abrasive from tubing fitting at each end of cylinder. Release fittings on both ends.
Make sure no dirt gets into tubing or early cylinder failure will result.
9. Remove four mounting bolts.
10. Shift cylinder to the left about 6" to allow rod end to drop down to remove.

Installation of new cylinder:

1. Remove tubing fittings from old cylinder and install in new cylinder.
Turn fittings to the same angle to speed assembly.
2. Remove protective bellows from old cylinder rod. If necessary, rinse bellows in kerosene to remove oil and dust. Inspect for holes. Repair or replace if necessary.
3. Set new cylinder in place. Loosely install four mounting bolts.
4. Align cylinder rod with mounting hole. Center rod in hole when fully retracted and also when 2/3 extended. If necessary, use shim washers under front and rear feet to improve alignment.
Caution- misalignment of rod will lead to premature cylinder failure.
5. Tighten cylinder rod bolts.
6. Firmly tighten rod end nut.
7. Attach tubing connections.
8. ***Fill reservoir with approximately 5 quarts Dexron II/III or equivalent automatic transmission fluid to 1/2-3/4 up the sight tube.**
9. Test run and check connections for leaks. Purge air from cylinder by running full stroke for a few cycles.