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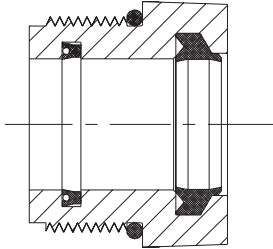
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## SEAL KIT NO. 27787

### FOR 1" SINGLE ACTING, GLAND NUT RAMS

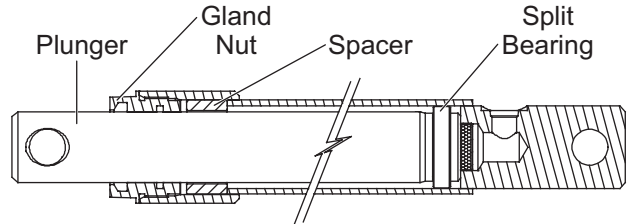
#### SEAL INSTALLATION INSTRUCTIONS

1. Lubricate seals with oil.
2. Install seals in the **exact** orientation as shown in diagram.



3. Assemble gland nut over split bearing end of plunger to prevent damage to seals.

4. Carefully reassemble ram.



5. Insert a 0.015" feeler gauge between front surface of cylinder tube face and hex of gland nut. Tighten gland nut until it is snug against the feeler gauge.
6. Remove feeler gauge and tighten gland nut an additional **1/4 turn**. This adjustment procedure will provide a torque range of 120-150 ft-lbs.

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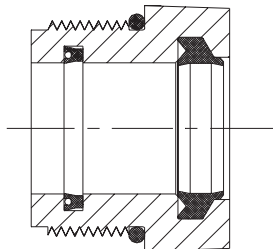
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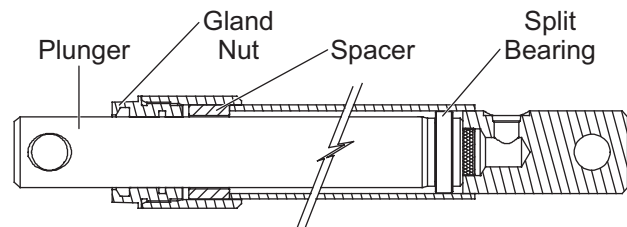
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## Procedure for Installing SAE O-Ring Hydraulic Fittings and Hoses

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**NOTE: Over torquing JIC hose fitting ends will result in a fractured fitting.**

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Do not use any type of sealant or tape on the fittings or hoses. This could damage product. Always use two wrenches to ensure proper tightening of fittings and hoses.

**Use the following procedure to install SAE o-ring fittings in valve block and rams.**

1. Turn jam nut on fitting as far back as possible.
2. Lubricate O-Ring with clean hydraulic oil.
3. Screw fitting into port by hand until the washer contacts port face and shoulder of the jam nut threads.
4. Unscrew fitting to proper position no more than one full turn.

Douglas Dynamics, L.L.C. reserves the right under its Product Improvement Policy to change construction or design details and furnish equipment when so altered without reference to illustrations or specifications used herein.

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5. Using two wrenches, hold fitting body in position and tighten jam nut until the washer again contacts port face, then tighten an additional 1/8 to 1/4 turn to lock fitting in place. Final torque on the jam nut should be approximately 20 ft-lbs.

**Use the following procedure to install hydraulic hoses.**

1. Screw flare nut onto fitting flare and hand tighten.
2. Align hose so there are no twists or sharp bends and so it will not be pinched or pulled by moving parts.
3. Using two wrenches, hold the hose in position and tighten flare nut 1/8 to 1/4 turn beyond hand tight. Final torque on the flare nut should be approximately 20 ft-lbs.

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