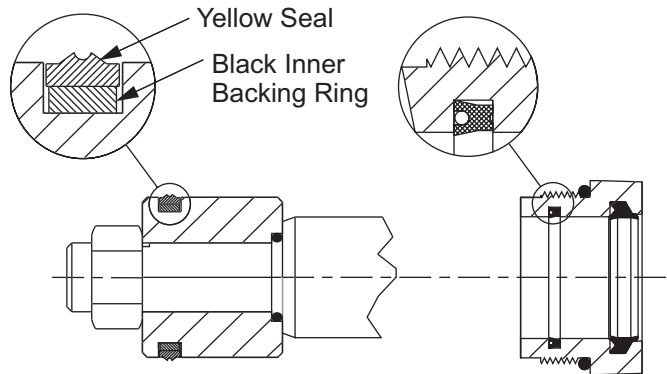


# SEAL KIT NO. 27788 INSTRUCTIONS

## FOR 1-1/2" BORE DOUBLE ACTING RAMS

### SEAL INSTALLATION

1. Lubricate seals with oil.
2. Install seals in the **exact** orientation as shown.
3. Slide gland nut over threaded end of the rod to prevent damage to seals.
4. Install piston and orient properly (see diagram). Torque piston locknut to 35-40 ft-lbs.
5. Carefully reassemble ram.
6. 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.
7. Remove feeler gauge and tighten gland nut an additional **1/4 turn**. This adjustment procedure should provide approximately 120-150 ft-lbs. of torque.



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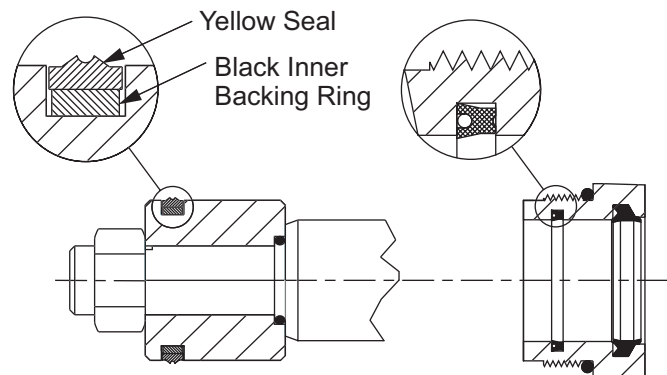
July 12, 2002

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