

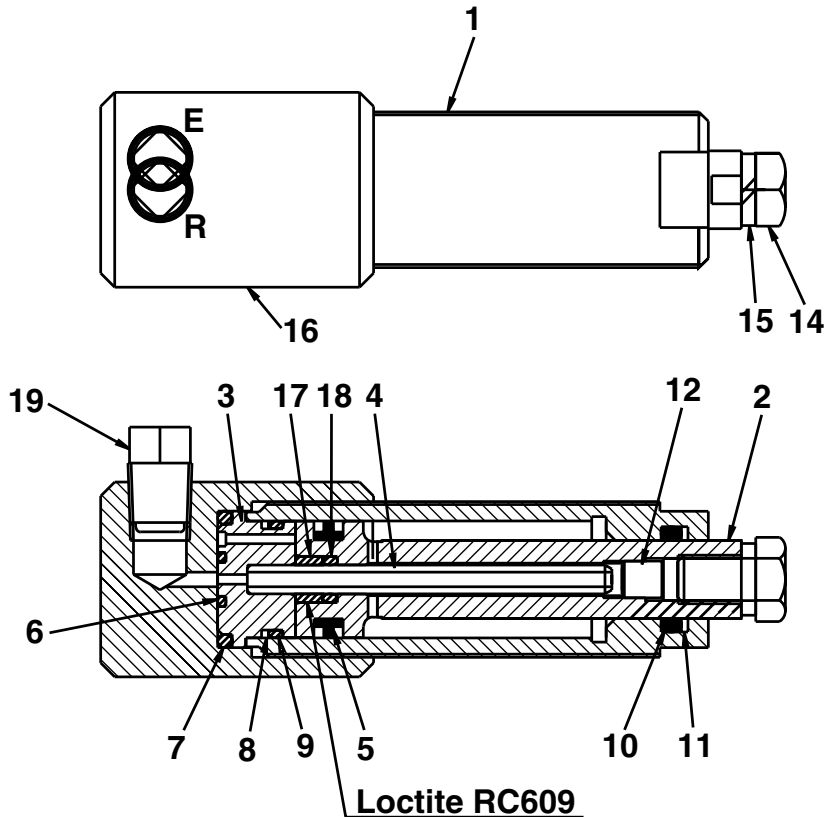
L1677
 Rev. A
 12/97
 PC5413

For Date codes beginning with "B."

INSTALL ALL KIT COMPONENTS TO INSURE A COMPLETE AND PROPER REPAIR.

Note:

Lubricate all seals prior to assembly.



Repair Parts List

Item	Part Number	Qty.	Description	Item	Part Number	Qty.	Description
1	401953	1	Cylinder Body	10	★ B1010503	1	O-Ring
2	PA1386051	1	Double Acting Piston	11	★ B1112564	1	Back-Up Washer
3	PA1387270	1	Stage Connector	12	F100009-60	1	Plug
4	PA1378268	1	Return Tube	14	401290	1	Hex Head Cap Screw
5	★ B1206513	1	GT Ring	15	401277	1	Spring Lock Washer
6	★ B1004503	1	O-Ring	16	401947	1	Manifold Cap
7	★ B1013503	1	O-Ring	17	PA1388566	1	Ring
8	★ B1016564	1	Back-Up Washer	18	B1008803	1	O-Ring
9	★ B1222503	1	O-Ring	19	A8004271	2	Shipping Plug

★ Indicates items included in Seal Kit HCS50E001K.

Disassembling CYDA-15

1. Disconnect hydraulic lines from unit and remove unit from fixture.
2. Secure CYDA-15 base in vise. Remove hex head screw (15) by holding piston (2) on the flats with an appropriate wrench.
3. Unscrew body (1) from its base (17) using a wrench at flats located at end of body.
4. Remove stage connector (3) and return tube assembly (4) together from body and piston.

CAUTION: Do not separate item corner and tube assembly. They are bonded together.

5. Push piston out of body.
6. Remove o-rings (6 and 7), back-up ring (8), and o-ring (9). From the outside of piston, remove T-seal (5). From inside of piston, remove ring (13) and o-ring (14). From the inside of the body, remove o-ring (11) and back-up ring (12).
7. Discard all seals and rings.

Cleaning and Inspection

1. Using O.S.H.A.-approved degreasing solvent, clean the parts thoroughly. Blow parts dry with clean moisture-free air and place them on a lint-free surface.
2. Inspect all parts for excessive wear. Replace if necessary.

Re-assembling CYDA-15

1. Install the seals and rings supplied in the Repair Kit.

CAUTION: If it is necessary to use a rigid tool (e.g. bar, rod, etc.) to aid installation of seals and rings, use one made of Nylon or other comparable soft material so that it will not scratch the fine finished surface of the components or tear the seals.

2. Install stage connector and return tube in base. Next install piston over return tube and on top of stage connector. Slide body over piston or into base.
3. Tighten body firmly into base. Install lock washer and hex screw onto piston and tighten with wrench on flats of plunger.

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