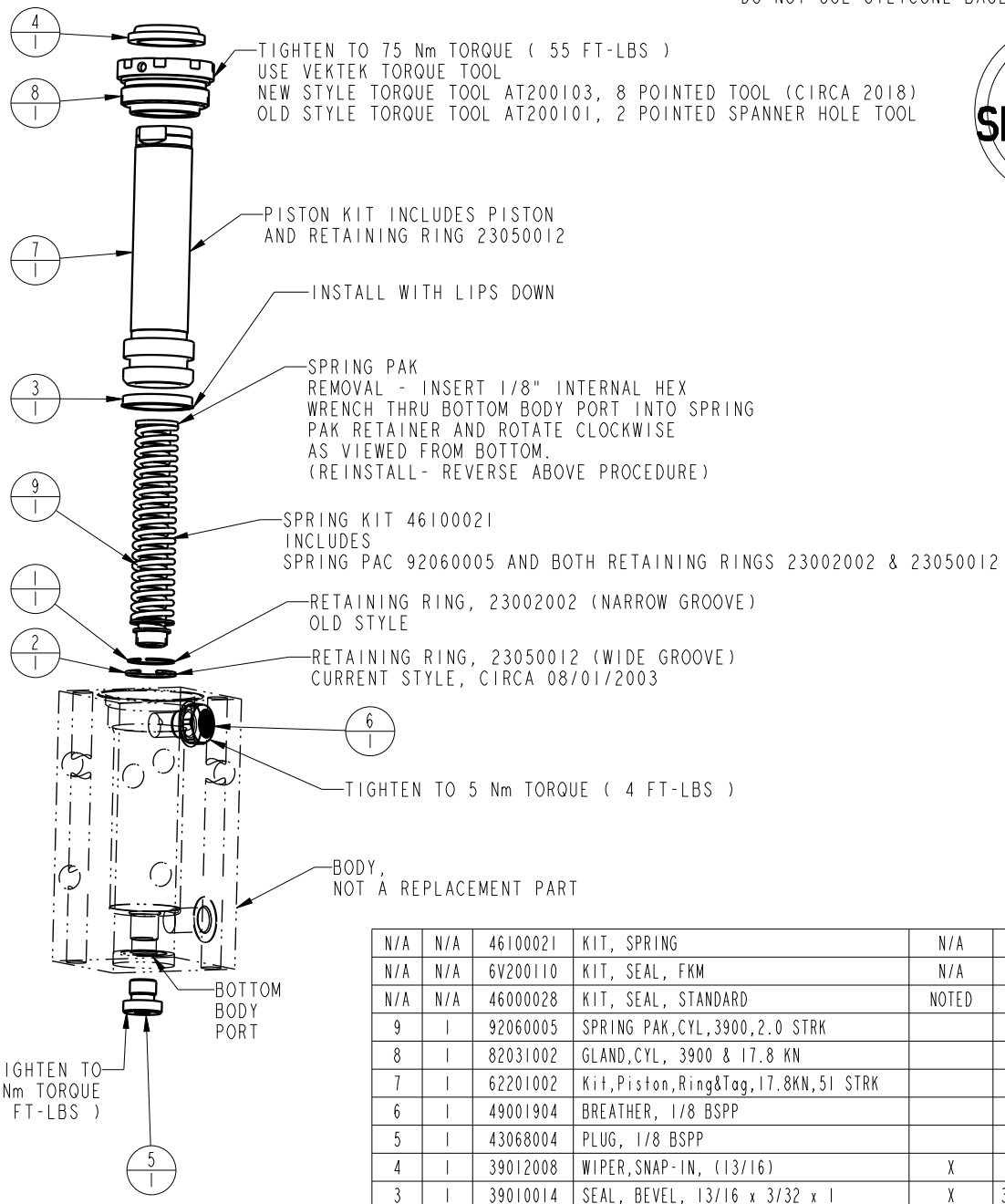


LUBRICATE ALL SEALS WITH CLEAN HYDRAULIC OIL PRIOR TO ASSEMBLY.
DO NOT USE SILICONE BASED LUBRICANTS.



TIGHTEN TO 75 Nm TORQUE (55 FT-LBS)
USE VEKTEK TORQUE TOOL
NEW STYLE TORQUE TOOL AT200103, 8 POINTED TOOL (CIRCA 2018)
OLD STYLE TORQUE TOOL AT200101, 2 POINTED SPANNER HOLE TOOL

PISTON KIT INCLUDES PISTON AND RETAINING RING 23050012

INSTALL WITH LIPS DOWN

SPRING PAK REMOVAL - INSERT 1/8" INTERNAL HEX WRENCH THRU BOTTOM BODY PORT INTO SPRING PAK RETAINER AND ROTATE CLOCKWISE AS VIEWED FROM BOTTOM.
(REINSTALL- REVERSE ABOVE PROCEDURE)

SPRING KIT 46100021 INCLUDES SPRING PAC 92060005 AND BOTH RETAINING RINGS 23002002 & 23050012

RETAINING RING, 23002002 (NARROW GROOVE) OLD STYLE

RETAINING RING, 23050012 (WIDE GROOVE) CURRENT STYLE, CIRCA 08/01/2003

TIGHTEN TO 5 Nm TORQUE (4 FT-LBS)

BODY, NOT A REPLACEMENT PART

TIGHTEN TO 24Nm TORQUE (18 FT-LBS)

N/A	N/A	46100021	KIT, SPRING	N/A	N/A	NOTED
N/A	N/A	6V200110	KIT, SEAL, FKM	N/A	NOTED	N/A
N/A	N/A	46000028	KIT, SEAL, STANDARD	NOTED	N/A	N/A
9	I	92060005	SPRING PAK,CYL,3900,2.0 STRK			X
8	I	82031002	GLAND,CYL, 3900 & 17.8 KN			
7	I	62201002	Kit,Piston, Ring&Tag,17.8KN,51 STRK			
6	I	49001904	BREATHER, 1/8 BSPP			
5	I	43068004	PLUG, 1/8 BSPP			
4	I	39012008	WIPER,SNAP-IN, (13/16)	X	X	
3	I	39010014	SEAL, BEVEL, 13/16 x 3/32 x 1	X	39012001	
2	I	23050012	SNAP RING, INTERNAL			X
1	I	23002002	SNAP RING, INTERNAL			X
No.	QTY	PART No.	DESCRIPTION	Standard Seal Kit	FKM Seal Kit	Spring Kit

PARTS LIST



VEKTEK, INC.
1334 E. SIXTH AVE. P.O. BOX 625
EMPORIA, KS. 66801 U.S.A.

ASSEMBLIES AFFECTED
42011004

PARTS LIST, ASSY,CYL,BB,17.8KN,51 STRK,SA

SIZE A MPL2053

REV J

J	4249	RELEASE	JDW	08/11/20
REV	IN ACCORDANCE WITH ECN	EFFECTIVE DATE	REVISED BY	DATE
DRW BY:	BUSH	DRAWING STATUS: Released		
DATE:	12/15/94	PRODUCTION APPROVED FOR RELEASED STATUS ONLY		