



The piston is composed of two elements:

- lower cylinder element with inserted the higher ram element <2>.
- higher cylinder element <A> with inserted the lower ram element <1>

Assembly phase sequence

- I** Suspend the lower cylinder element with the special hook <3> and lean it on its base.
- II** Unscrew the hook <3> and cylinder cover <4>.
- III** Suspend the lower ram element <2> with the hook and pull it out 10-15 cm.
- IV** Attach the brackets <5> to part of the ram which protrudes, so that it can no go down, then unscrew and remove the hook <3>
- V** Suspend the upper cylinder element <A> with brackets <7> and remove the rubber protection <8> unscrewing the fixing screw or the plastic packaging.
- VI** Attach the brackets <10> to upper ram element <1>, then make the ram junction. Check that the joinings are perfectly clean and greased.. Otherwise clean perfectly both male and female and grease plentifully. **The presence of any foreign matter may cause the binding of the thread.** Screw without forcing, and constantly checking alignment. Stop one cm. before completion, degrease perfectly the ledge, then spread with Loctite. Continue screwing operation and, if necessary, using the bracket, give one firm sharp blow for final securing. Removed the brackets from the ram, to control with the hand that, of the joining point, there is not even the minimum step and, if necessary, remove it with the fine emery cloth..
- VII** Slowly lower the upper part of the cylinder <A> up to lead into the junction <11>. The O-ring is already in the higher part.
- VIII** Make the cylinder junction. to the stop without applying Loctite, then remove the bracket cylinder and the ram flange support <12>.

WAIT 24 HOURS BEFORE TO INTRODUCE OIL IN THE PISTON.

JOINING OF THE HOME PISTON IN TWO PIECES



Start Elevator