

TWO PIECES PISTON HL-COMPACT 631 ASSEMBLY

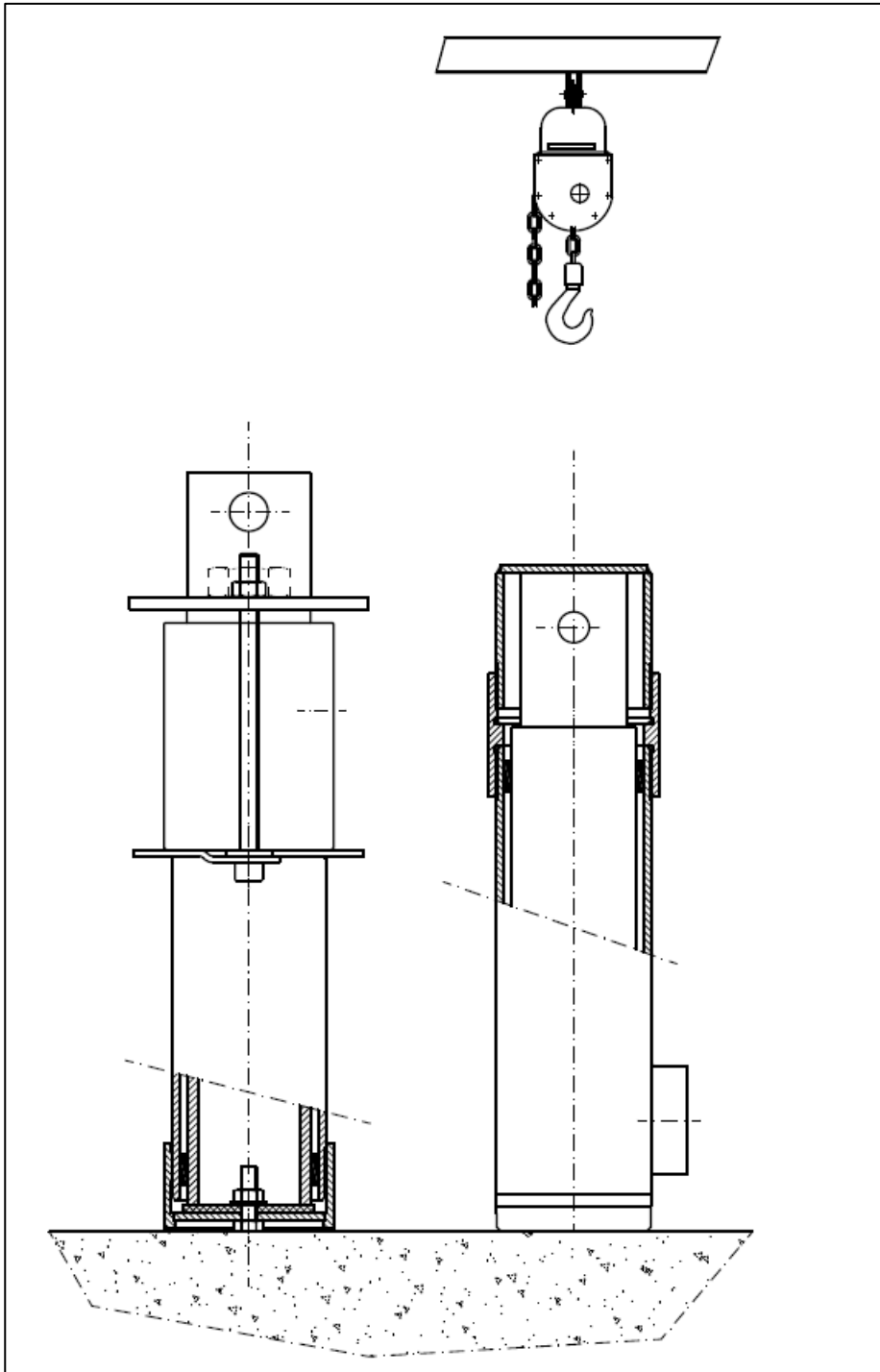


INDICE:

1. PRELIMINARY OPERATIONS.....	3
2. PLUNGER JUNCTION.....	4
2.1. Lower assembly preparation.....	4
2.2. Upper assembly preparation.....	4
2.3. Two halves junction.....	6
3. CYLINDER JUNCTION.....	7
3.1. Two halves preparation.....	7
3.2. Two halves junction.....	7
4. JACK COMPLETE ASSEMBLY.....	8

1. PRELIMINARY OPERATIONS

1. Install a lifting device suitable to the jack weight, fixed as high as possible inside the runway
2. Put the two half-jacks inside the pit



2. PLUNGER JUNCTION

2.1. Lower assembly preparation

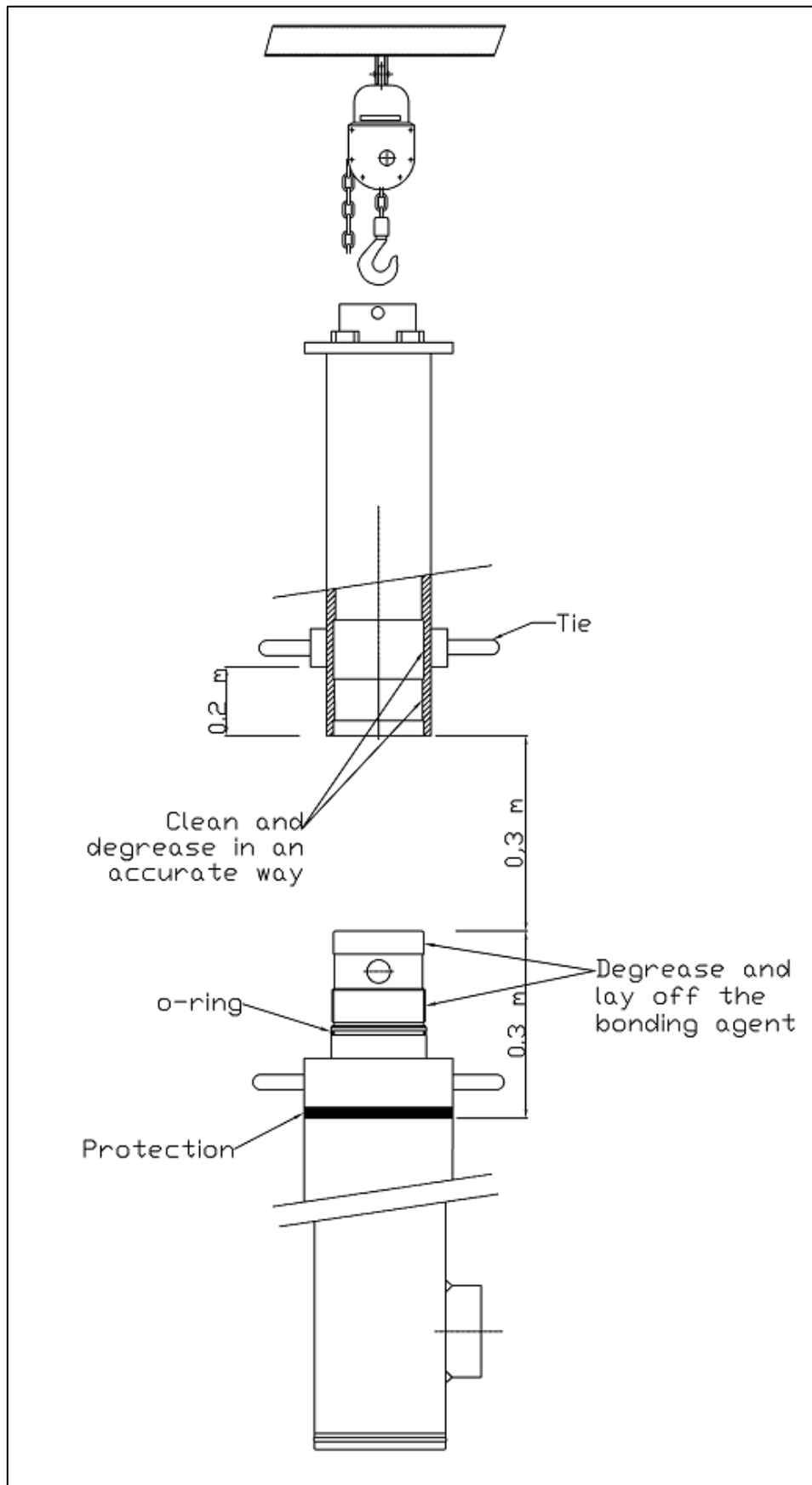
- Put the lower half-jack on the pilaster or appropriate basement
- Remove the lower half-jack metallic protection
- Remove the ring of the lower half-plunger tied with a red tape
- Extract the plunger from the cylinder so that it projects approximately 30 centimeters
- Tighten the tie on the plunger and let it lays slowly on the cylinder (interpose a protection between tie and cylinder)
- Check that the threads, the centering diameter of the lower plunger and the O-ring gasket are clean, lubricated and without damage signs



Lower half-jack metallic protection

2.2. Upper assembly preparation

- Remove the plastic film and the protection paper from the head. Unscrew the head and put it in a safe place
- Extract completely the plunger, paying attention to not damage the external surface
- Clean the plunger external surface with some clean rags
- Put the upper half-plunger over the lower one
- Protect the head of the upper half-jack with some rags
- Clamp the tie on the plunger approximately 20 centimeters over the lower end
- Check that the threads, the centering diameter of the upper plunger and the O-ring gasket are clean, lubricated and without damage signs



2.3. Two halves junction

- Before the final assembly is recommended to carry out a plunger assembly test
- Drop slowly the upper plunger until it fits the lower plunger. Continue the descent spinning the upper part until the threaded side gets into grip
- Screw until the junction is finished, without tighten the two parts in grip
- Unscrew the two parts until they come back to initial conditions
- Clean and degrease the threads and the centering seat of the upper plunger, checking that no damages are present
- Clean and degrease the threads and the centering seat of the lower plunger, checking that no damages are present: pay attention that the degreaser doesn't get in touch with the O-ring gasket
- Check the O-ring integrity and put a small amount of grease on it
- Put 5-6 vertical stripes of Loctite on the threads
- Drop slowly the upper plunger and proceed to the two halves junction with the same mode of the assembly test. Complete the tightening screwing with strength the junction, in order to get into grip the two parts. This operation must be done by two people, so that one clamps the lower assembly through the tie and the other one completes the plunger tightening
- Verify that the junction lines drawn on the plunger match each other and that no steps are present. Grind with emery cloth
- Remove the ties from the plunger and drop until it leans to the cylinder bottom
- Remove the lifting device

3. CYLINDER JUNCTION

3.1. Two halves preparation

- Clean the lower cylinder threads in an accurate way and assemble the tie close to the connection area
- Install the tie and lift up the upper cylinder
- Unscrew the lower protection of the upper half-jack and remove the cylinder centering ring connected with a red tape

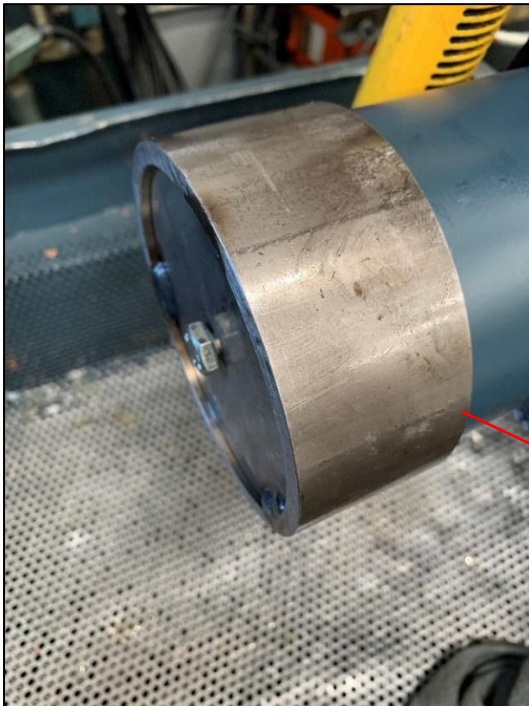
N.B: if the rubber protection is not removed, the system working is seriously compromised

- Clean carefully the cylinder threads
- Insert the cylinder on the plunger, paying attention to not create scoring

3.2. Two halves junction

- Drop slowly the upper cylinder until it reaches the lower one and then start the matching, following the same instructions used during the plunger assembly
- Remove the ties from the cylinders
- Clean the threads and reassemble the head
- Assemble the recover oil pipe on the head

ATTENTION: don't put loctite on the cylinder threads



Upper half-jack metallic protection

IMPORTANT: If the connection between jack and power unit is not immediately done, is required to close the oil entrance and cover the head in an accurate way.

4. JACK COMPLETE ASSEMBLY

