

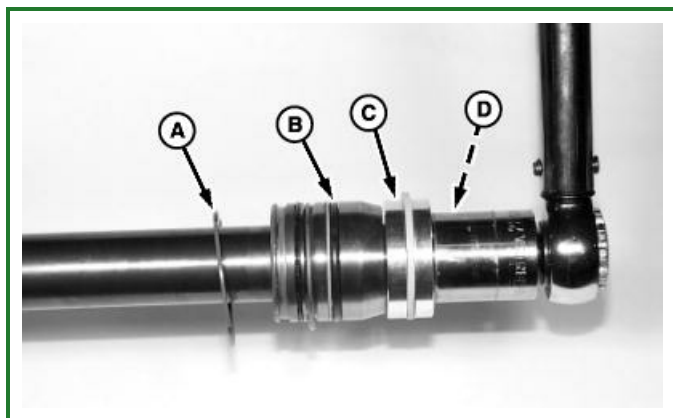
Assemble 100/120 Series External Retaining Ring Cylinder

1. IMPORTANT:

All parts must be thoroughly cleaned and dried prior to reuse. Any contamination can lead to leakage problems and part damage.

NOTE:

Install rod end in soft-jawed vise or pin rod end in order to tighten nut.



HCD1106-UN: Torque

LEGEND:

- A - External Retaining Ring
- B - Rod Guide
- C - Piston
- D - Nut

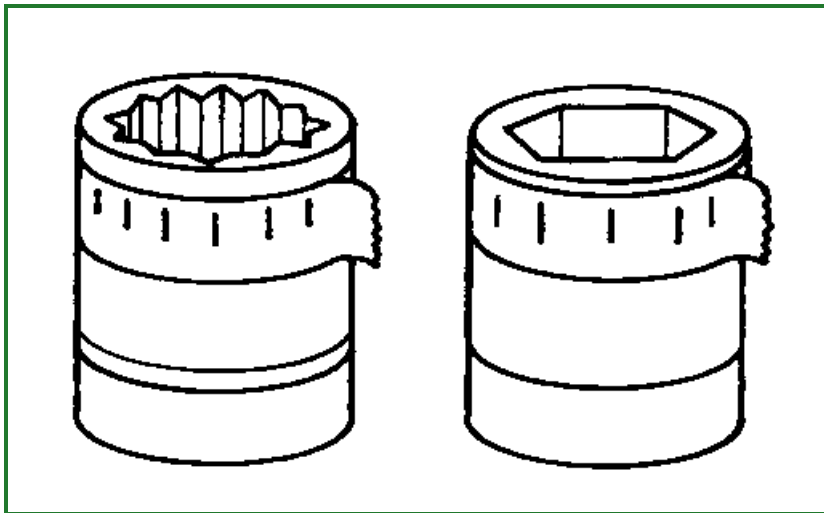
Install external retaining ring (A), rod guide (B), piston (C), and nut (D) on rod.

2. Apply light coat of Thread Lock and Sealer (Medium Strength) and tighten to specification. If torque turn is specified in appropriate table go to steps 3—5.

-: Torque

NUT TORQUE SPECIFICATIONS	
Thread Size	Torque
5/8-18 UNF-2A	130 N·m (96 lb.-ft.)
M12 x 1.5	100 N·m (74 lb.-ft.)
3/4-16 UNF-2A	210 N·m (155 lb.-ft.)
7/8-14 UNF-2A	320 N·m (236 lb.-ft.)
1-12 UNF-2A	463 N·m (341 lb.-ft.)
1-1/8-12 UNF-2A	492 N·m (363 lb.-ft.)
1-1/4-12 UNF-2A	965 N·m (712 lb.-ft.)

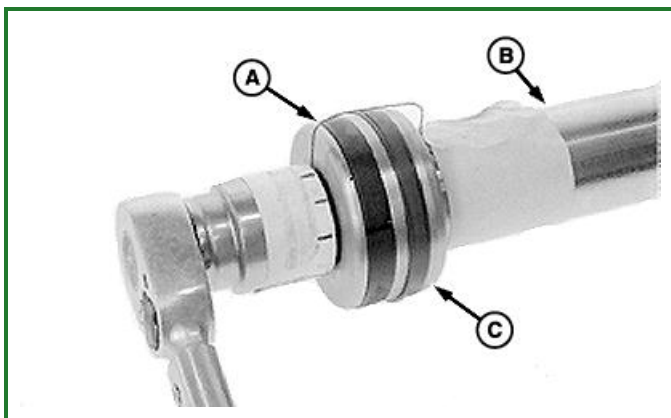
3.



T6149AG-UN: Tape Marks

Use an angle gauge to measure “Degrees Beyond Snug Torque.” If an angle gauge is not available, put tape around a socket. Make marks on the tape to divide the socket into 1/12 th increments. The indicator marks are 30° apart. Indicator marks serve as a visual reference for determining “Degrees Beyond Snug Torque”.

4.



HCD1128-UN: Point to Mark with Wire on Rod

LEGEND:

- A - Wire
- B - Rod
- C - Piston

Tape a piece of wire (A) on rod (B) pointing to one of the marks on the socket.

5. Turn piston nut beyond the snug torque, the number of degrees specified in the table.

-: Nut Torque Specifications

NUT TORQUE SPECIFICATIONS		
<i>Short Rod (shorter than 80 mm)</i>		
<i>Thread Diameter x Pitch</i>	<i>Snug Torque</i>	<i>Degrees Beyond Snug Torque</i>
M16 x 1.5	50 N·m (37 lb.-ft.)	45°
M20 x 1.5	100 N·m (74 lb.-ft.)	45°