

ASSEMBLY / DISASSEMBLY INSTRUCTIONS "HDL" SERIES ACTUATOR SPRING RETURN EXTEND (SRE) APPLICATION See Dwg. # 6042

ASSEMBLY:

1. Place spring cartridge assembly (Item 13) on a flat surface with the "O" ring groove facing up.
2. Install "O" ring (Item 12) in head groove with a light coat of grease.
3. Install the bolts (Item 5) into upper head. Be sure that threads do not extend above upper head (Item 13) top surface.
4. Install cylinder tube (Item 6) on upper head.
5. Install wear ring (Item 8) and quad seal (Item 9) on the piston (Item 7).
6. Install "O" ring (Item 10) on piston rod (Item 11).
7. Thread the piston rod (Item 11) into the piston (Item 7).
8. Install piston and piston rod assembly into cylinder (Caution: care must be taken as not to cut the piston wear ring and quad seal).
9. Install "O" ring (Item 4) on lower head (Item 3) with a light coat of grease.
10. Install the lower head (Item 3) on the cylinder tube (Item 6).
11. Adjust the bolts (Item 5), if necessary, so that the lock washer (Item 1) and the nut (Item 2) will have enough thread engagement. Tighten securely then torque to recommended specs using a crisscross pattern. See Fig. 1 on the following page for Torque specs.
12. Install bearing seals (Items 14, 16 & 17) on rod bearing (Item 15).
13. Install rod bearing over piston rod (Item 11) and into lower head (Item 3).
14. Install bearing retaining ring (Item 18) into groove on lower head (Item 3).
15. Cycle actuator and check for smooth operation and leaks.

DISASSEMBLY:

1. Reverse Assembly Instructions.