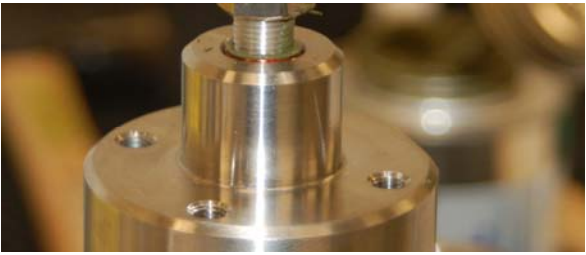



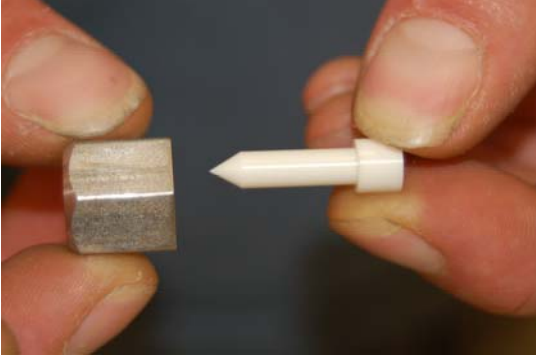





# Step by Step Assembly Instruction

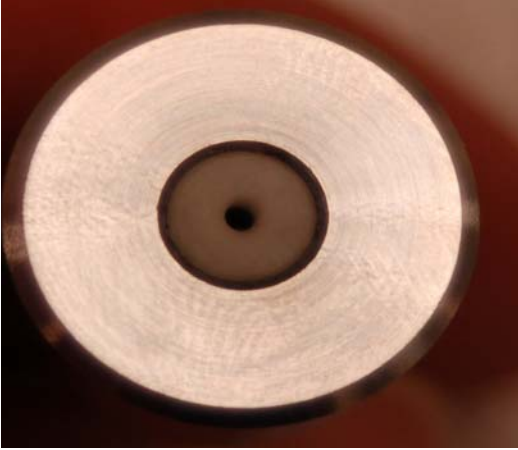
## BPR5000D

	<p>Step 1</p> <p>Install Brass Bushing 20096 in Body 20233 Apply Red LocTite 27131 to threads of Bushing.</p>
	<p><b>Piston Assembly</b></p> <p>Piston PN 20237 Pin Holder, PN 20238 Pin, PN 20200 Spring, PN 71002074 Cup Seal, PN 71001871 (Item # 13)</p>
	<p>Step 2</p> <p>Place Cup Seal (Item # 13) Onto Piston Body</p>
	<p>Step 3</p> <p>Place Pin Spring into Piston</p>

## Step by Step Assembly Instruction

	<p>Step 4</p> <p>Place Pin into Pin Holder</p>
	<p>Step 5</p> <p>Place Pin and Pin Holder Onto Piston.</p>
	<p>Step 6</p> <p>Completed Piston Assembly</p>
	<p>Step 7</p> <p>Place Piston Assembly in Aluminum Jaw Vice and Tighten Pin Holder.</p> <p>Torque to 10 Ft/Lbs</p>

# Step by Step Assembly Instruction

	<p>Step 8</p> <p>Use "O" Ring Install Tool, P/N 20104 and P/N 20103 to slide "O" Rings onto Seat Holder</p>		
	<p>Proper Placement of "O" Rings and BU Rings Shown.</p>		
<p>Item # 12 "O" Ring</p>	<p>Item # 16 BU Ring</p>	<p>Item # 11 "O" Ring</p>	<p>Item # 15 BU Ring</p>
	<p>Step 9</p> <p>Install Seat into Seat Holder.</p> <p><b>PROPER ORIENTATION is REQUIRED :</b> Small Hole Faces Outward</p>		

## Step by Step Assembly Instruction



**BPR5000D Body - P/N 20233**  
**Complete Piston Assembly**  
**Complete Seat Holder**



Step 10

Place Base Cap "O" Ring Onto Groove of Body  
as shown



Step 11

Apply Parker Lube to "O" Rings on Seat Holder



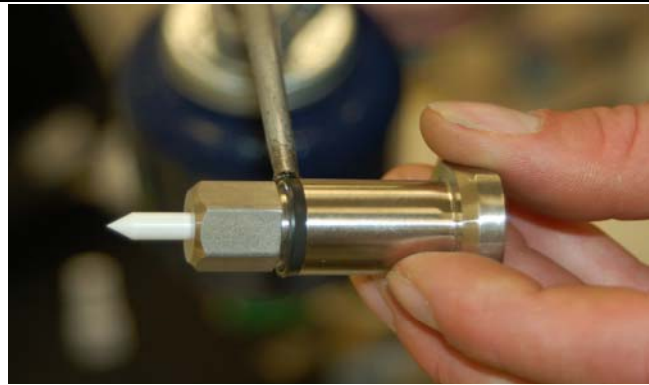
Step 12

Install Seat Holder in Body

## Step by Step Assembly Instruction



Use Seat Holder Install Tool to ensure Seat Holder is properly pressed into place.



Step 13

Apply Parler Lube on Piston Cup Seal.



Step 14

Install Piston Assembly in Body.

Be CAREFUL to push evenly on the Piston to prevent damage to outer lip of Cup Seal



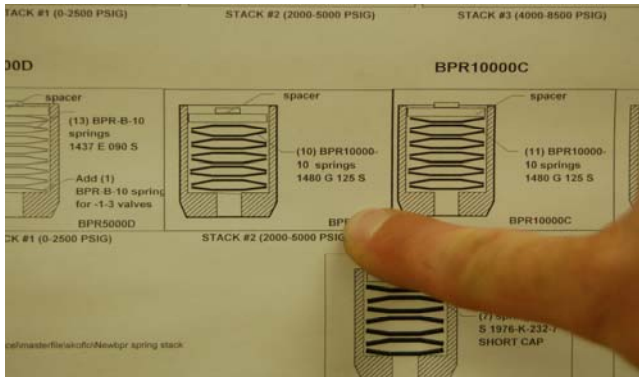
# Step by Step Assembly Instruction



Piston properly installed.

MAT'L	BU RINGS	SEALS	PRESS SETTING	SPRING STACK	SEAT	PIP
	TEFLON	TEFLON	2000-5000	2	0.050	0.20
	TEFLON	TEFLON	2000-5000	2	0.050	0.20
	TEFLON	TEFLON	2000-5000	2	0.050	0.20
			2000-5000	2	0.050	0.20

**REVIEW WORK SHEET TO DETERMINE WHICH SPRING STACK IS SELECTED**



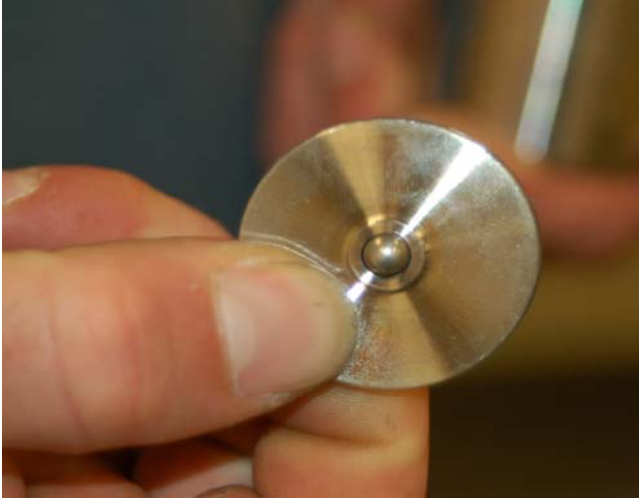


**REVIEW SPRING STACK CHART TO DETERMINE WHICH SPRINGS TO SELECT**

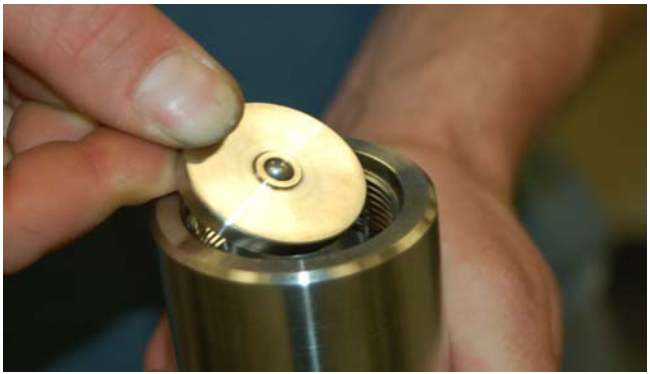




Stack Belleville Springs so that they oppose each other.

# Step by Step Assembly Instruction

	<p>Step 15</p> <p>Place Spring Stack in Spring Cap.</p>
	<p><b>Springs Properly Installed.</b></p>
	<p>Locate Spring Washer, P/N 10179</p>

# Step by Step Assembly Instruction

	<p>Step 16</p> <p>Install Spring Washer in Spring Cap.</p> <p>PROPER ORIENTATION is REQUIRED : 1/4" Ball Bearing Faces Outward</p>
	<p>Spring Washer Properly Installed.</p>
	<p>Step 17</p> <p>Apply Anti-Seize to Bearing in Spring Washer</p>



## Step by Step Assembly Instruction



### Step 18

Place Spring Cap in aluminum jawed vice

Install Spring Cap onto Body Assembly.



### Step 19

Tighten Spring Cap until contact with Body is achieved.



### Step 20

Apply anti-sieze to threads on Handle Assembly

## Step by Step Assembly Instruction



Step 21

Install Handle Assembly in Body.

**COMPLETED UNIT READY FOR TESTING**