
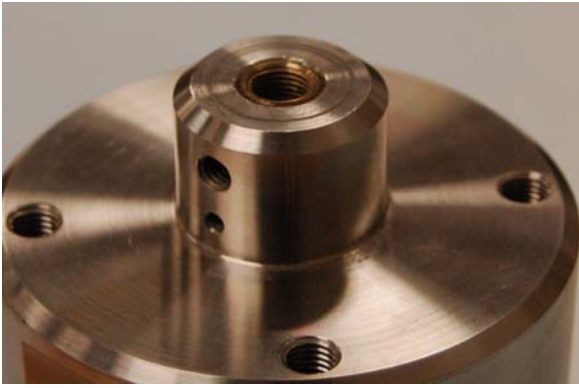
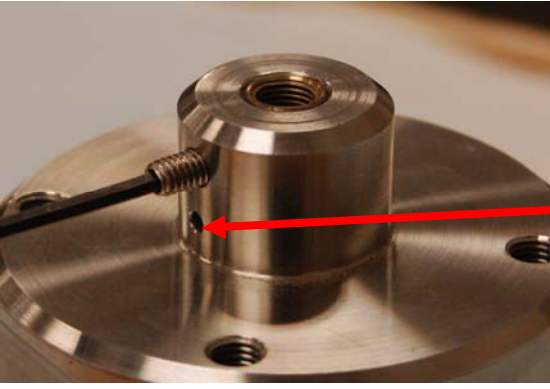








Step by Step Assembly Instruction

SF10000 D

	<p>Step 1</p> <p>Apply Red Loctite 27131 to threads of Bushing, P/N 20096.</p>
	<p>Step 2</p> <p>Install Brass Bushing, P/N 20096 in Body, P/N 20093</p>
	<p>Step 3</p> <p>Install SHSC M6 X 8, P/N 71002101 in Body, P/N 20371 and Tighten Firmly</p> <p>NOTE: If fluid comes out this hole, the Seat Holder ATM "O" Ring is leaking.</p>
	<p>Step 4</p> <p>Install Seat Holder Seal "O" Ring on Seat Holder.</p> <p>Use "O" Ring Installation Tool, P/N 20104 to prevent damage to "O" Ring</p>

Step by Step Assembly Instruction

	<p>Step5</p> <p>Install Seat Holder Seal BU Ring on Seat Holder.</p> <p>Use "O" Ring Installation Tool to prevent damage to BU Ring</p>
	<p>Step 6</p> <p>Install ATM "O" Ring on Seat Holder.</p> <p>Use "O" Ring Installation Tool, P/N 20103 to prevent damage to "O" Ring</p>
	<p>Step 7</p> <p>Install ATM BU Ring on Seat Holder.</p> <p>Use "O" Ring Installation Tool to prevent damage to BU Ring</p>
	<p>Proper Placement of "O" Rings and BU Rings Shown.</p>
	<p>Step 8</p> <p>Apply Parker Lube to "O" Rings prior to installing Seat Holder</p>

Step by Step Assembly Instruction



Step 9

Install Seat Holder Assy in
Body



Step 10

Use Seat Holder Install Tool, P/N 20097
to press Seat Holder Assembly into Body



Seat Holder Properly installed.

Step by Step Assembly Instruction



Step 11

Install Spring Set (2 ea. Light 2 ea. Heavy) in Body.

**ORIENTATION : All springs oppose;
NOT "Nested"**



Piston, P/N 20100
Pin, P/N 20006
Pin Spring, P/N 71002068
Pin Holder, P/N 20101



Step 12

Install Pin Spring, P/N 71002068 in Piston, P/N 20100.

Step by Step Assembly Instruction



Step 13

Install Pin, P/N 20006 in
Pin Holder, P/N 20101.




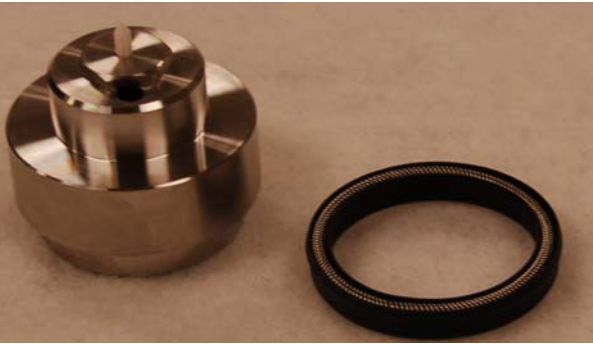
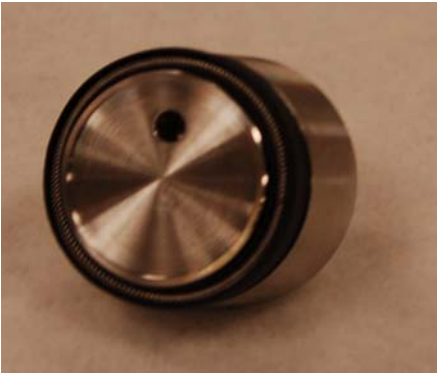

Step 14

Place Pin Holder & Pin in
Piston.

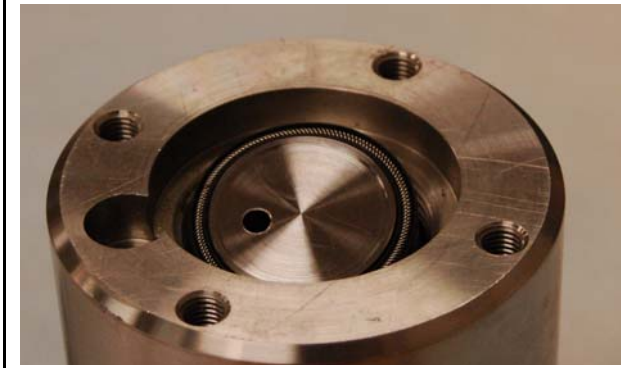


**Secure Piston in Collett Chuck to tighten
Pin Holder.**

Step by Step Assembly Instruction

	<p>Step 15</p> <p>Tighten Pin Holder to Piston</p> <p>10 Ft/Lbs</p>
	<p>Step 16</p> <p>Install Cup Seal, P/N 71001872 on Piston.</p>
	<p>Cup Seal Properly Installed.</p>
	<p>Step 17</p> <p>Apply Parker Lube to Cup Seal</p>

Step by Step Assembly Instruction



Step 18

Place Piston Assembly in Body .



Step 19

Use Piston Install Tool, P/N 20085 to push Piston Assembly into Body.



Piston Assembly properly installed in Body.

Step by Step Assembly Instruction



Step 20

Install BU Ring on Base Cap



Step 21

Install "O" Ring on Base Cap



Step 22

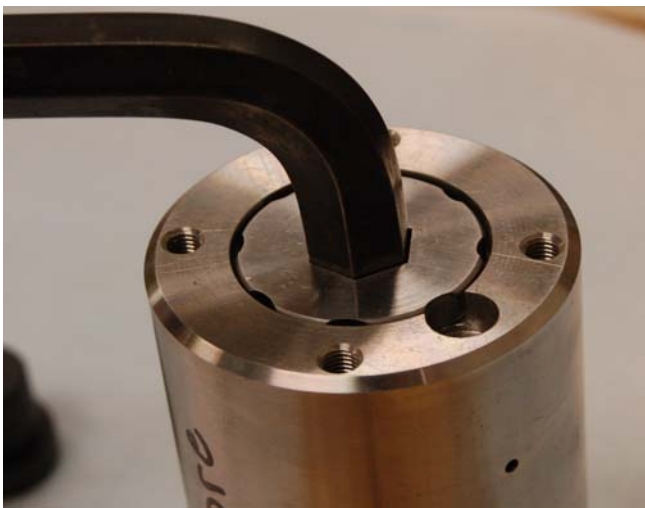
Apply Parker Lube to "O" Ring and BU Ring on Base Cap

Step by Step Assembly Instruction



Step 23

Install Base Cap in Body



Step 24

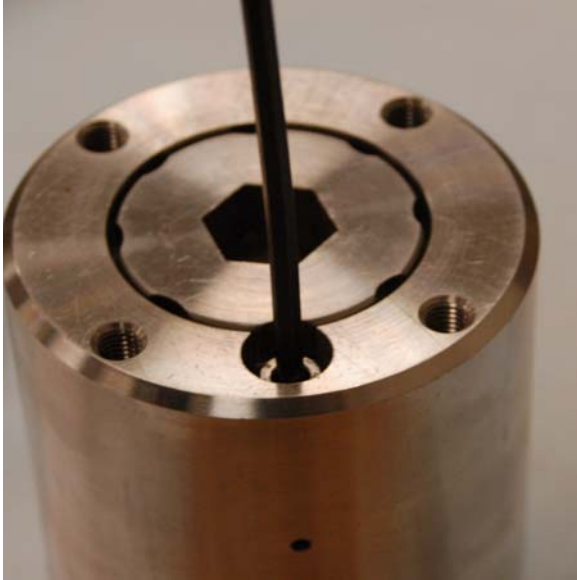


Align Base Cap Notch with
Lock Bolt Hole



Step 25

Apply SynLube to Base Cap Bolt

Step by Step Assembly Instruction

	<p>Step 26</p> <p>Install Base Cap Bolt</p>
	<p>Step 27</p> <p>Apply SynLube to threads on Handle Assembly</p>
	<p>Step 28</p> <p>Install Handle Assembly in Body.</p>
<p>COMPLETED UNIT READY FOR TESTING</p>	