

# Step by Step Assembly Instruction

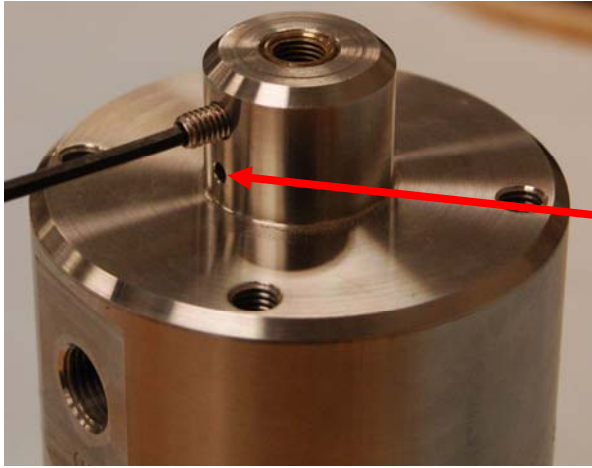
SF1000DRS



## Step 1

Install Bushing, P/N 20096 in  
Body, P/N 20371

Apply Red LokTite to threads



## Step 2

Install SHSC M6 X 8, P/N 71002101 in  
Body, P/N 20371 and Tighten Firmly

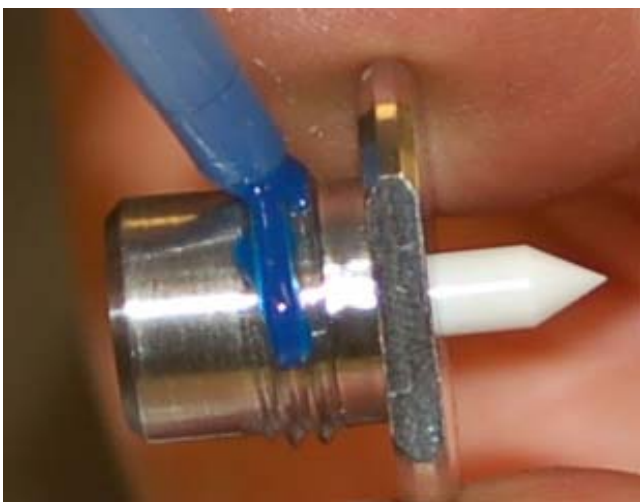



NOTE : If fluid leaks out this hole, the Seat  
Holder ATM "O" Ring is leaking



## Step 3

Install Pin Spring. P/N 71002067 in  
Piston, P/N 20845

## Step by Step Assembly Instruction

	<p>Step 4</p> <p>Install Pin, P/N 21523 in Pin Holder, P/N 20846</p>
	<p>Step 5</p> <p>Apply Blue LokTite to Pin Holder, P/N 20846</p>
	<p>Step 6</p> <p>Install Pin and Pin Holder in Piston</p>
	<p>Step 7</p> <p>Secure Piston in Collet Chuck and Tighten Pin Holder to Piston</p>

## Step by Step Assembly Instruction



### Step 8

Install Cup Seal, P/N 71001872 on  
Piston, P/N 20845



### Step 9





Install Cup Seal Retainer, P/N 20184 on  
Piston, P/N 20845







### Step 10

Install Spiral Ring, P/N 71001948 on  
Piston, P/N 20845




# Step by Step Assembly Instruction

	<p>Seat and "O" Ring</p>
	<p>Step 11 Install "O" Ring on Seat</p>
	<p>Step 12 Apply Parker Lube to "O" Ring</p>
	<p>Step 13 Install Seat in Seat Holder</p>

# Step by Step Assembly Instruction

	<p>Seat Retainer, P/N 20704</p>
	<p>Step 14 Install Seat Retainer in Seat Holder ORIENTATION : Recessed area out goes to Seat</p>
	<p>Step 15 Install Spiral Ring, P/N 71001946</p>
	<p>Seat Retainer and Spiral Ring properly installed.</p>

# Step by Step Assembly Instruction

		<p>Step 16</p> <p>Install Seat Holder Seal, ("O" Ring) on Seat Holder</p> <p>Using the Install Tool, P/N 20104 is a big help.</p>
		<p>Step 17</p> <p>Install Seat Holder Seal BU Ring on Seat Holder</p>
		<p>Step 18</p> <p>Install ATM Seal, ("O" Ring) on Seat Holder</p> <p>Tool P/N 20103</p>

# Step by Step Assembly Instruction



Step 19  
Install ATM Seal BU Ring on Seat Holder



Step 20  
Apply Parker Lube to "O" Rings



Step 21  
Install Seat Holder Assembly in Body

## Step by Step Assembly Instruction

		<p>Step 22</p> <p>Use Seat Holder Install Tool, P/N 20097 to properly push Seat Holder Assembly into place.</p>
		<p><b>Seat Holder Assembly properly installed.</b></p>
		<p>Step 23</p> <p>Feed Seat Holder Retainer Ring, P/N 71001947 into Spiral Ring Compression Sleeve</p> <p>NOTE : Tool is designed with a "Lip" that fits inside the Seat Holder Bore to guide Spiral Ring into groove.</p>



## Step by Step Assembly Instruction



### Step 24

Install Seat Holder Retainer Ring in Body

NOTE : Hold Compression Sleeve snugly in place and push Spiral Ring out with the Seat Holder Install Tool, P/N 20097



**Seat Holder Retainer Ring properly in place.**



### Step 25

Install Piston Spring Set -  
2 ea. Light, P/N 71001960  
2 ea. Heavy, P/N 71001962

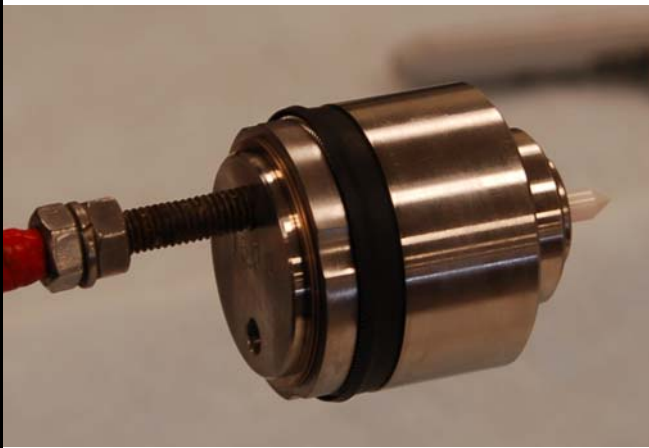
ORIENTATION : All oppose, NOT "Nested"

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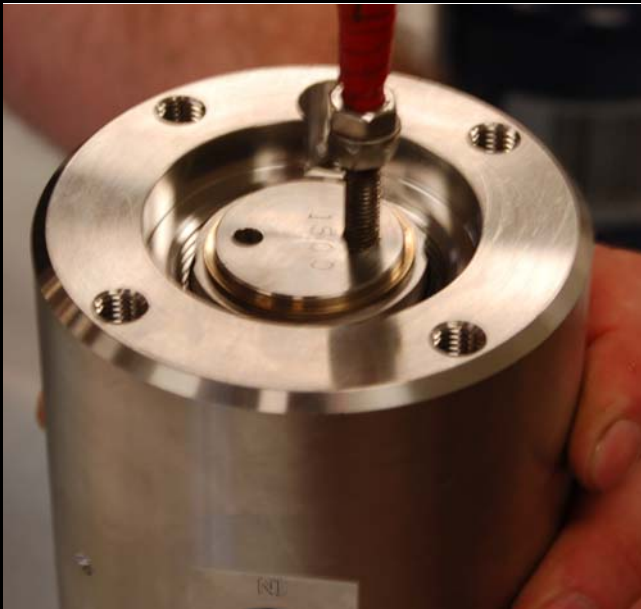
Step 26

Apply Parker Lube to Piston Cup Seal



Step 27

Attach Piston Assembly to Piston Install Tool



Step 28

Install Piston Assembly into Body

# Step by Step Assembly Instruction

	<p>Piston Assembly properly installed.</p>
	<p>Step 29</p> <p>Install Base Cap Seal BU Ring on Base Cap, P/N 20847</p>
	<p>Step 30</p> <p>Install Base Cap Seal ("O" Ring) on Base Cap, P/N 20847</p>

## Step by Step Assembly Instruction



Step 31

Apply Parker to Base Cap "O" Ring

Apply SynLube to Base Cap threads



Step 32

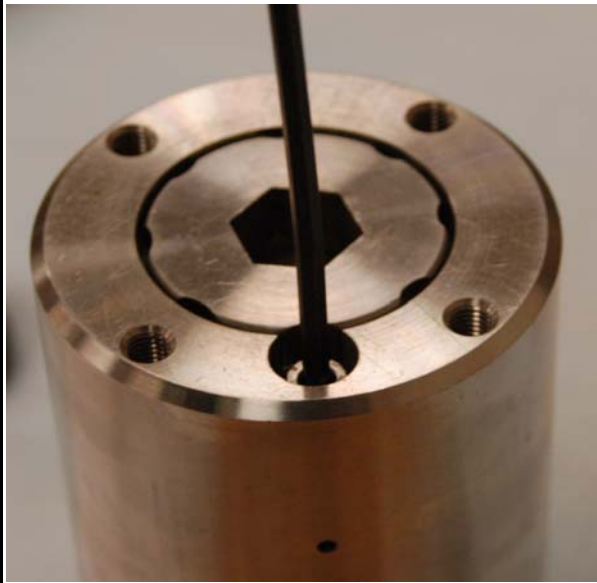
Install Base Cap Assembly in Body



Step 33

Align Base Cap notch with Lock Bolt hole.

## Step by Step Assembly Instruction



Step 34

Install Lock Bolt, P/N 71002091.



Step 35

Apply SynLube to threads and  
Install Handle Assembly.

**COMPLETED UNIT READY FOR TESTING**