
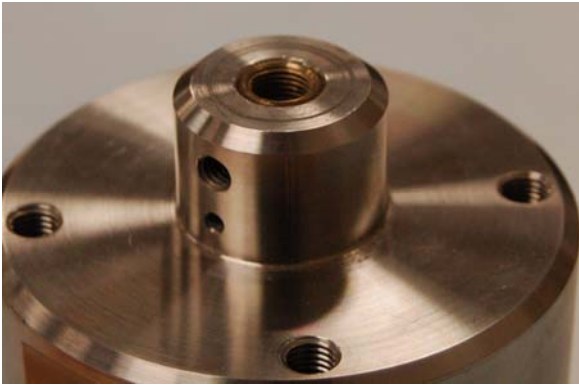
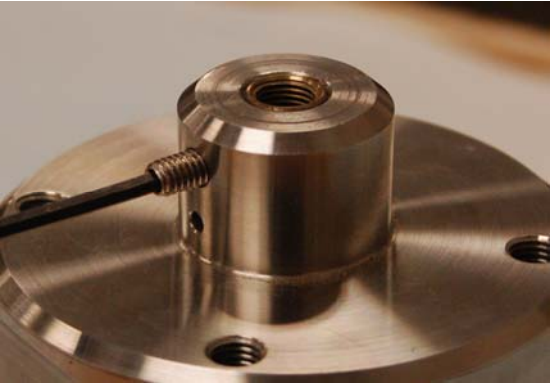




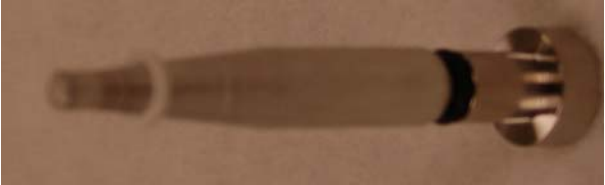



# Step by Step Assembly Instruction




## SF15000 B

	<p>Step 1</p> <p>Apply Red Loctite 27131 to threads of Bushing, P/N 20222.</p>
	<p>Step 2</p> <p>Install Brass Bushing, P/N 20222 in Body, P/N 20719.</p>
	<p>Step 3</p> <p>Install SHSC M6 X 8, P/N 71002101 in Body, P/N 20719</p> <p>Tighten Firmly</p>
	<p><b>Seat and Seat Holder</b></p>

# Step by Step Assembly Instruction

	<p>Step 4</p> <p>Install Seat in Seat Holder</p> <p><b>ORIENTATION : Small Hole faces out.</b></p>
	<p><b>Seat Properly Installed</b></p>
	<p>Step 5</p> <p>Install Seat Holder Seal "O" Ring on Seat Holder.</p> <p>Use "O" Ring Installation Tool, P/N 10210 to prevent damage to "O" Ring</p>
	<p>Step 6</p> <p>Install Seat Holder Seal BU Ring on Seat Holder.</p> <p>Use "O" Ring Installation Tool, P/N 10210 to prevent damage to BU Ring</p>
	<p>Step 7</p> <p>Install ATM "O" Ring on Seat Holder.</p> <p>Use "O" Ring Installation Tool, P/N 10118 to prevent damage to "O" Ring</p>

# Step by Step Assembly Instruction

	<p>Step 8</p> <p>Install ATM BU Ring on Seat Holder.</p> <p>Use "O" Ring Installation Tool, P/M 10118 to prevent damage to BU Ring</p>
	<p><b>Proper Placement of "O" Rings and BU Rings Shown.</b></p>
	<p>Step 9</p> <p>Apply Parker Lube to "O" Rings prior to installing Seat Holder</p>
	<p>Step 10</p> <p>Install Seat Holder Assy in Body, P/N 20719</p>

## Step by Step Assembly Instruction



### Step 11

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



**Seat Holder Properly installed.**



### Step 12

Install Spring Set (2 ea. Light 2 ea. Heavy) in Body, P/N 20719.

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

# Step by Step Assembly Instruction

	<p>Step 13</p> <p>Lightly tap a chisel at the point where the Pin Holder and Orifice flow path meet.</p> <p>This is to prevent a hydraulic lock condition from occurring with the Pin.</p>
	<p><b>Piston, P/N 20100</b> <b>Pin, P/N 20006</b> <b>Pin Spring, P/N 71002068</b> <b>Pin Holder, P/N 20101</b></p>
	<p>Step 14</p> <p>Install Pin Spring, P/N 71002068 in Piston, P/N 20100.</p>
	<p>Step 15</p> <p>Install Pin, P/N 20006 in Pin Holder, P/N 20101.</p>

## Step by Step Assembly Instruction



Step 16

Place Pin Holder & Pin in  
Piston.



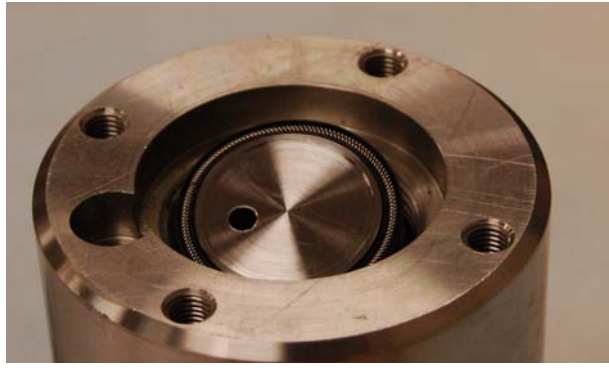
**Secure Piston in Collett Chuck to tighten  
Pin Holder.**



Step 17

Tighten Pin Holder to Piston

# Step by Step Assembly Instruction

 A photograph showing a piston assembly on the left and a black cup seal on the right. The piston assembly consists of a cylindrical body with a central piston pin and a top ring. The cup seal is a black, toroidal ring with a textured inner surface.	<p>Step 18</p> <p>Install Cup Seal, P/N 71001872 on Piston.</p>
 A close-up photograph of the piston assembly with the black cup seal properly seated on its outer edge.	<p><b>Cup Seal Properly Installed.</b></p>
 A photograph showing a person's hands holding the piston assembly. A grey applicator tool is being used to apply a substance to the inner surface of the cup seal.	<p>Step 19</p> <p>Apply Parker Lube to Cup Seal</p>
 A photograph showing the piston assembly inserted into a larger, cylindrical metal body. The cup seal is visible at the interface between the two parts.	<p>Step 20</p> <p>Place Piston Assembly in Body .</p>

## Step by Step Assembly Instruction



### Step 21

Use Piston Install Tool, P/N 20085 to push Piston Assembly into Body, P/N 20719.



**Piston Assembly properly installed in Body.**



## Step by Step Assembly Instruction



Step 22

Install BU Ring on Base Cap, P/N 20653



Step 23

Install "O" Ring on Base Cap, P/N 20653



Step 24

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

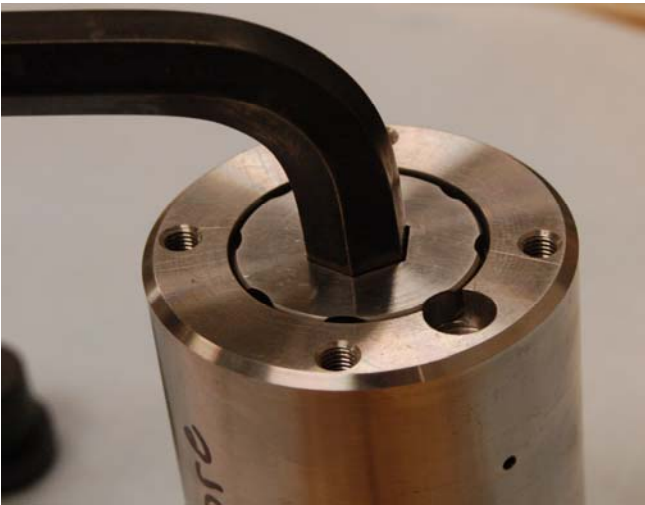
Apply SynLube to threads of Base Cap.

## Step by Step Assembly Instruction



Step 25

Install Base Cap in Body. P/N 20719



Step 26

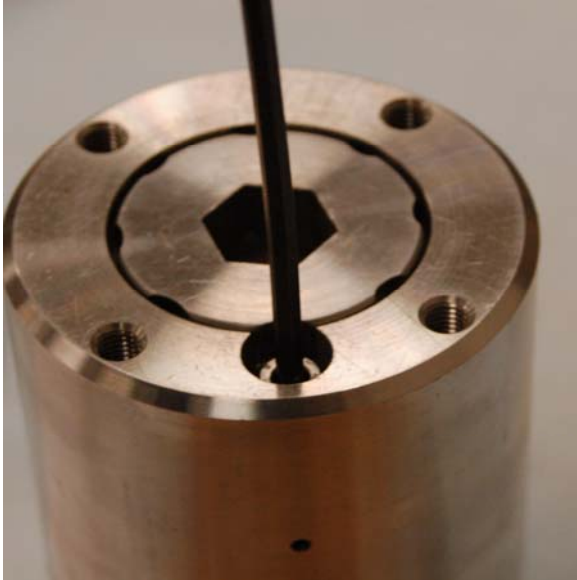


Align Base Cap Notch with  
Lock Bolt Hole



Step 27

Apply SynLube to Base Cap Lock Bolt  
P/N 71002872

# Step by Step Assembly Instruction

	<p>Step 28</p> <p>Install Base Cap Lock Bolt Bolt, P/N 71002872</p>
	<p>Step 29</p> <p>Apply SynLube to threads on Handle Assembly</p>
	<p>Step 30</p> <p>Install Handle Assembly in Body.</p>
<p><b>COMPLETED UNIT READY FOR TESTING</b></p>	