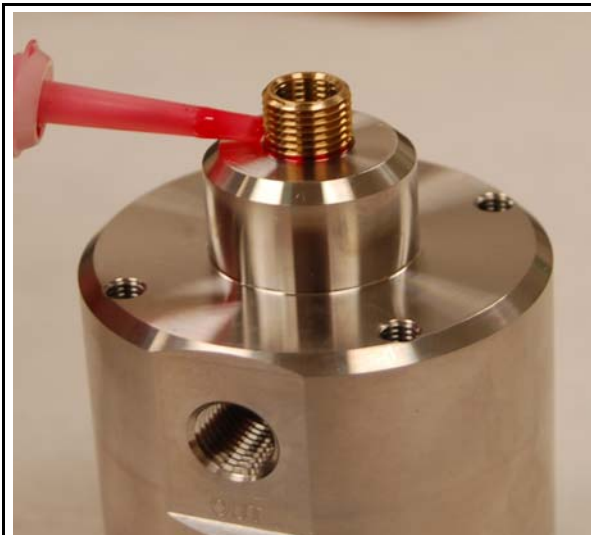


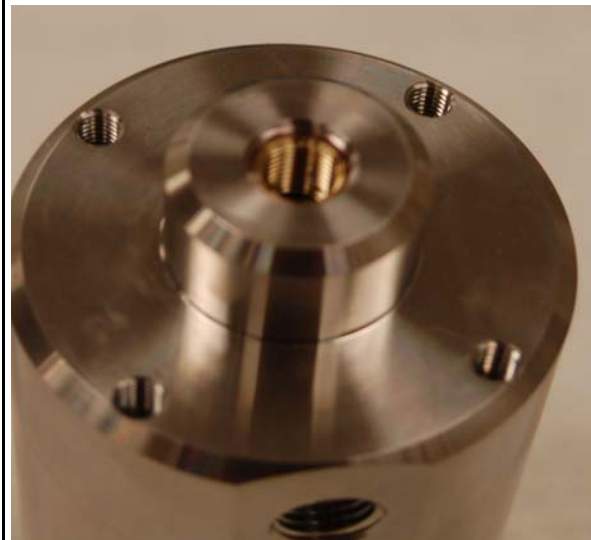
# Step by Step Assembly Instruction

SF5000C



Step 1

Apply Red LocTite 27131 to threads of Bushing, P/N 20096.



Step 2



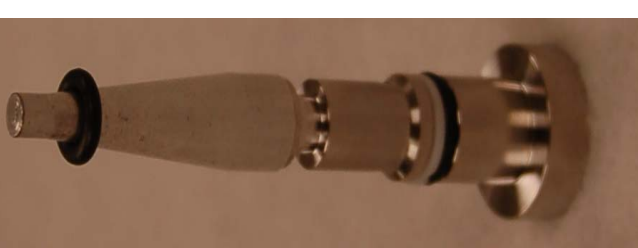
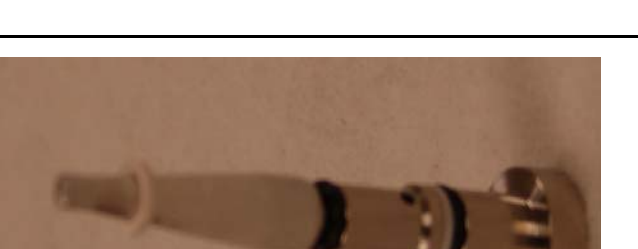
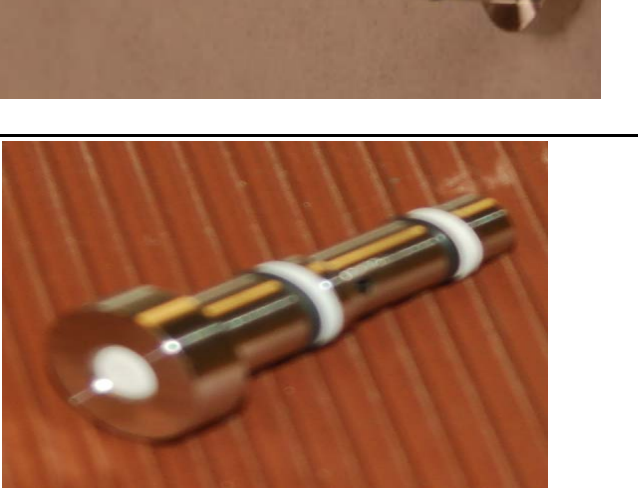
Install Brass Bushing, P/N 20096 in Body, P/N 20093



**SEAT HOLDER w/ SEAT**

**(Item # 5 with # 6 & # 21)**

# Step by Step Assembly Instruction

	<p>Step 3</p> <p>Install Seat Holder Seal "O" Ring (Item # 12) on Seat Holder.</p> <p>Use "O" Ring Installation Tool to prevent damage to "O" Ring (Tool Kit, P/N 20755)</p>
	<p>Step 4</p> <p>Install Seat Holder Seal BU Ring (Item # 18) on Seat Holder.</p> <p>Use "O" Ring Installation Tool to prevent damage to BU Ring</p>
	<p>Step 5</p> <p>Install ATM "O" Ring (Item # 11) on Seat Holder.</p> <p>Use "O" Ring Installation Tool to prevent damage to "O" Ring</p>
	<p>Step 6</p> <p>Install ATM BU Ring (Item # 17) on Seat Holder.</p> <p>Use "O" Ring Installation Tool to prevent damage to BU Ring</p>
	<p><b>Proper Placement of "O" Rings and BU Rings Shown.</b></p>

## Step by Step Assembly Instruction



### Step 7

Apply Parker Lube to "O" Rings prior to installing Seat Holder



### Step 8

Install Seat Holder Assy in Body



**Seat Holder Properly installed.**

## Step by Step Assembly Instruction



### Step 9

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 10

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



### Step 11

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

## Step by Step Assembly Instruction



Step 12

Place Pin Holder & Pin in  
Piston.



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





Step 13

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 cap. The cup seal is a black, ring-shaped component with a textured inner surface.	<p>Step 14</p> <p>Install Cup Seal, P/N 71001872 (Item # 13) on Piston.</p>
 A close-up photograph of the piston assembly with the black cup seal properly installed around the top edge of the piston body.	<p><b>Cup Seal Properly Installed.</b></p>
 A photograph showing a person's hand holding the piston assembly. A thin, grey tube is being used to apply Parker Lube to the inner surface of the cup seal.	<p>Step 15</p> <p>Apply Parker Lube to Cup Seal</p>
 A photograph showing the piston assembly inserted into the top of a larger cylindrical body. The cup seal is visible around the top edge of the piston.	<p>Step 16</p> <p>Place Piston Assembly in Body .</p>

## Step by Step Assembly Instruction

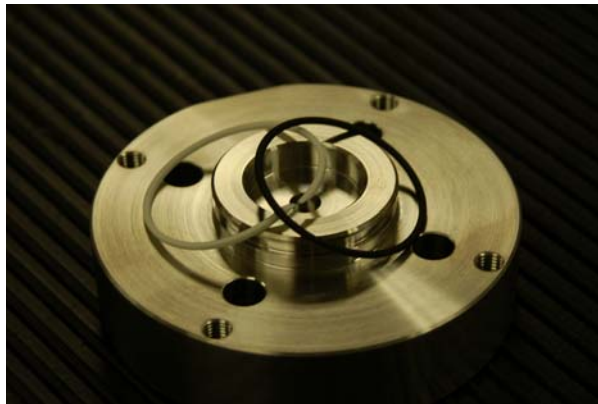


### Step 17

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

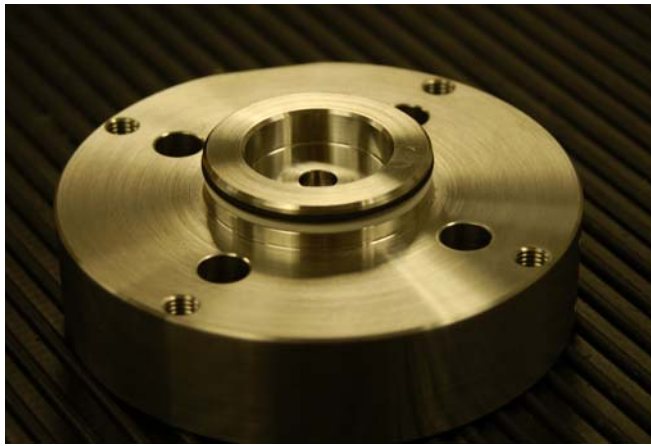


**Piston Assembly properly installed in Body.**



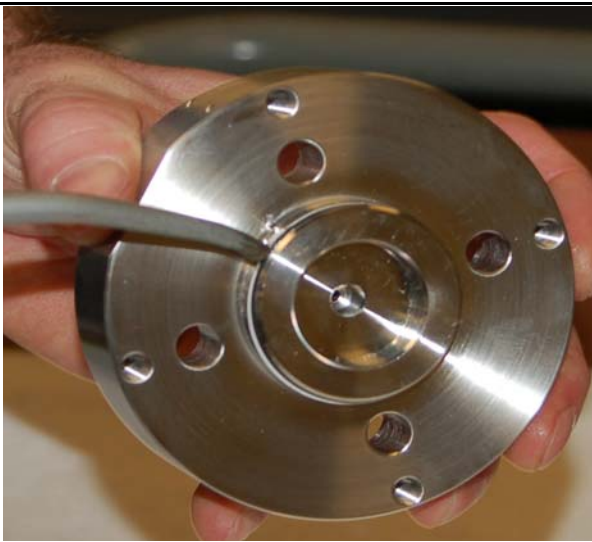
**Base Cap, P/N 20092  
Base Cap "O" Ring (Item # 16)  
Base Cap BU Ring (Item # 19)**

## Step by Step Assembly Instruction



Step 18

Install "O" Ring and BU Ring on Base Cap



Step 19

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

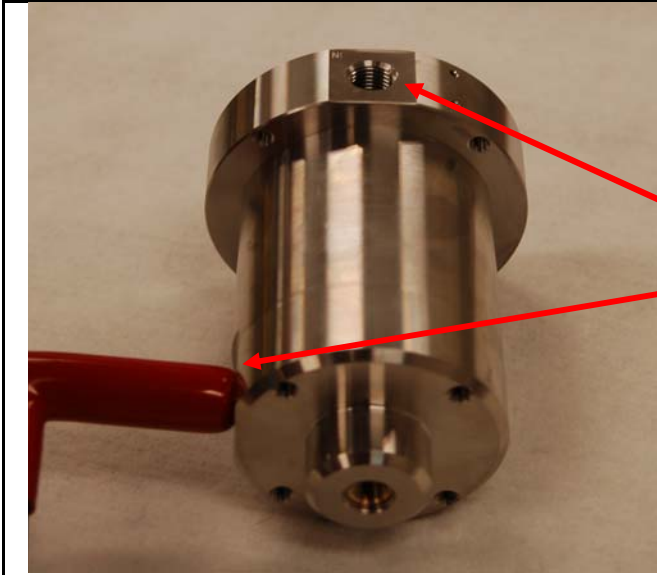


Step 20

Install Base Cap on Body



# Step by Step Assembly Instruction



ORIENTATION :

Inlet

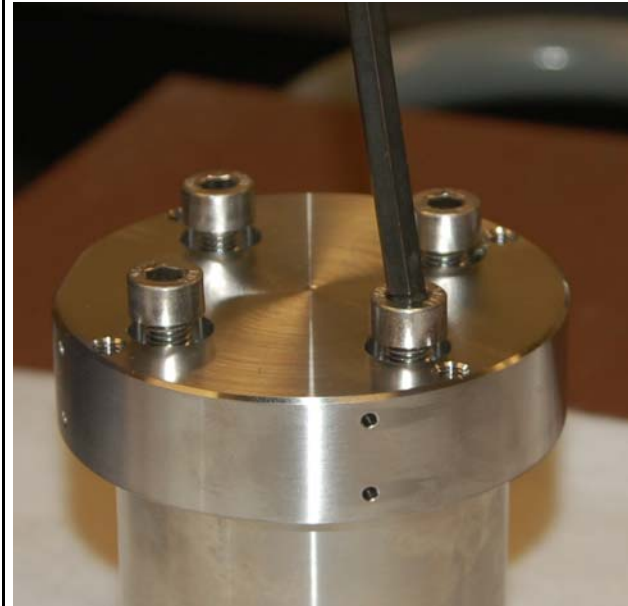
Outlet

Should be 90° as shown



Step 21

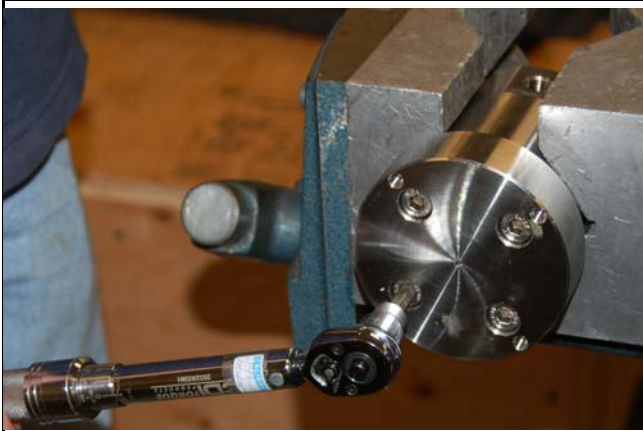
Apply SynLube to Base Cap Bolts



Step 22

Install Base Cap Bolts

# Step by Step Assembly Instruction



Step 23

Torque Base Cap Bolts to 10 Ft Lbs



Step 24

Apply SynLube to threads on Handle Assembly



Step 25

Install Handle Assembly in Body.

**COMPLETED UNIT READY FOR TESTING**