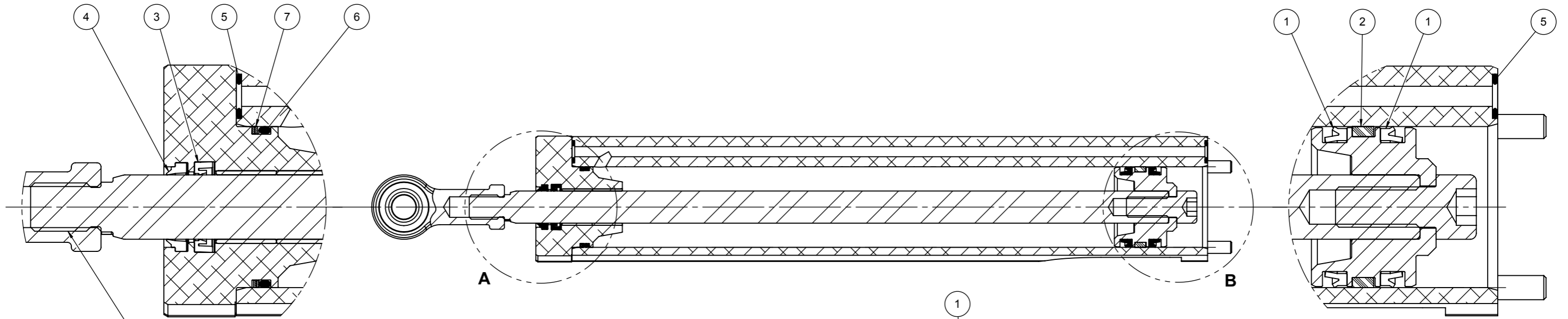


RELEASED DRAWING

PROVISIONAL ~ DRAWING FOR REVIEW ONLY NOT FOR MANUFACTURING PURPOSES
 PROTOTYPE ~ DRAWING FOR SMALL PROTOTYPE BATCHES
 RELEASED ~ DRAWING FOR PRODUCTION BATCHES

THIRD ANGLE PROJECTION **A3**



DETAIL A
SCALE 1 : 1

REASSEMBLY:
APPLY ADHESIVE HMS1008.01
(LOCTITE 222 / ORAPI 101)

DETAIL B
SCALE 1 : 1

REASSEMBLY TO MANIFOLD:
APPLY ADHESIVE HMS1008.01
(LOCTITE 222 / ORAPI 101)
TORQUE 12 Nm
4 x SCREWS

USE PROTECTIVE SHUTTLE
TO INSERT PISTON ROD
THROUGH THESE SEALS

REASSEMBLY:
APPLY ADHESIVE HMS1008.01 (LOCTITE 222 / ORAPI 101)
TORQUE 12 Nm
4 x SCREWS

SEE NOTE 3

NOTES

- 1) ONLY PARTS IDENTIFIED IN BALLOONS / BOM ARE INCLUDED WITH THE KIT
- 2) KIT SHALL INCLUDE A COPY OF THE SERVICING INSTRUCTIONS:
"K:\11 Product Documentation & Labels\Manuals & Enclosures\Customer Documentation\
Marine Service Instructions.pdf"
- 3) GUIDE STRIP SUPPLIED FLAT: WRAP AROUND PISTON GROOVE

ITEM NO.	DRG NO	PART NO	DESCRIPTION	STOCKCODE	QUANTITY
1	B1009	C2 4010 N3584	40mm PISTON SEAL (PARKER C2 4010 N3584 40x32x5.5)	000742	2
2	B1009	FR 3505 Q5029	GUIDE STRIP FOR 40mm DIA PISTON (PARKER FR 3505 Q5029)	000742	1
3	B1009	C1 1049 N3571	16mm ROD SEAL (PARKER C1 1049 N3571 16x22.5x4.5)	000742	1
4	B1009	A1 1016 N3587	16mm ROD WIPER SEAL (PARKER A1 1016 N3587 16x22x5)	000743	1
5		200-011-4490	O RING	V02530	2
6		202-672-4490	O RING	000739	1
7		BS 0356-24	SPIRAL BACK UP 40 x 1.4 x 36	000940	1

Hy-Pro
motion and control solutions

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TOLERANCES
UNLESS OTHERWISE STATED
DECIMAL None +/- 1 mm
DECIMAL 0.0 +/- 0.25mm
DECIMAL 0.00 +/- 0.10mm
ANGLES +/- 0.5°
REFER BS308 PARTS 1 TO 3
ALL DIMENSIONS IN mm

MATERIAL

TREATMENT
N/A

DESCRIPTION

MC+/ML+40 CYLINDER SUB ASSEMBLY SERVICE KIT

HYPRO MANUFACTURING QUALITY STANDARDS APPLY
DO NOT SCALE IF IN DOUBT ASK
HYDRAULIC PROJECTS LTD. 01626 863634
www.hypro.co.uk enquiries@hypro.co.uk

SHEET SCALE
1:2
APPROX. SCALE
WHEN PRINTED A3

STOCK CODE
NOT STOCKED

DRG NO
R4080-sk
Sheet1 of 2

ISSUE
02

