

ANY QUESTIONS

Call - John 419.787.9585

There are two sets of hydraulic components. Each assembly is made up of three tubes. Each tube has a #1 or a #2 stamped into it, #1 is used for the left assembly, #2 is used for the right assembly.

The tubes must be kept as an assembly, tubes are NOT interchangeable.

Strut Tube	1 or 2 stamped on top of tube
Guide tube	1 or 2 stamped on top of tube, fits inside foot tube
Foot tube	1 or 2 stamped on Foot of tube, fits inside strut tube, foot at bottom

Perform the following work, refer to the attached drawings;

- 1) Hone the inside of the strut tube, particularly at the location where the welding took place.

This inside surface must be a smooth quality as it makes up a high pressure O-Ring surface.

- 2) REVIEW THE ATTACHED DRAWINGS:

On the Guide Tube, Machine the weld fillet to provide a flat surface were the foot tube will rest on when its installed.

Measure and record how far down the new surface is compared to the old surface.

Its acceptable that the #1 and #2 guide tubes are different measurements.

Machine the minimum amount (remove the minimum amount of the fillet). However, the new flat surface cannot be greater than $\frac{1}{4}$ inch from the original surface. Otherwise, when the foot tube is cut, it will be weaker near its roller bearing holes.

- 3) On the Guide tube, clean up the O-ring groove. There was some over-spray while blasting the weld fillet, and this needs to be cleaned up.
- 4) Cut / remove from the top of the Foot tube, the amount measured in step 2 – PLUS 0.125 inches. The foot tube will now be shorter by the amount measured in step 2.

THIS IS VERY IMPORTANT - By doing this, when the foot tube and the guide tube are assembled, they should be exactly $\frac{1}{8}$ inch shorter then the original. (+/- .005)

