“H” Lip Seal Maintenance & Repair Instructions

When H408 SEALS are replaced, the following procedure should be followed:  (see figs below)

a) Place GLAND NUT H406 and GLAND WASHER H409 on PISTON ASSEMBLY H423.

b) First insert the LIP SEAL INSTALLATION TOOL on Piston. (See chart for part number)

c) Form Lip of LIP SEAL around TOOL by gently placing one LIP SEAL, Lip Side last, on to TOOL, while carefully rotating the SEAL to avoid damage to the Lip. Then Remove seal from TOOL, reverse Lip Seal direction and reinstall seal, Lip side first, on to piston.

d) Gently place the next two LIP SEALS H408, one at a time, on the TOOL, Lip Side Last; while carefully rotating the Seals on the TOOL to avoid damage to the Lip.

e) Slide the TOOL off of the Piston Assembly.

f) Insert Piston with seals into CYLINDER Assembly H422 and tighten GLAND NUT H406 to a torque of 22 ± 10% inch·Lbs. (2.49 N·m ± 10%)

ROTA TE PISTON BY HAND AFTER REASSEMBLY TO ASSURE FREE MOVEMENT IN CYLINDER.

**CAUTION NEVER WITHDRAW THE PISTON MORE THAN 3/4”(19 mm) OTHERWISE SEALS COULD BE DAMAGED BY FLAT OF THE PISTON. **

YOUR EXACT SEAL CONFIGURATION MAY VARY, BUT THE PROCEDURE IS THE SAME.

<table>
<thead>
<tr>
<th>PISTON SIZE</th>
<th>INSTALLATION TOOL</th>
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<tbody>
<tr>
<td>1/8&quot;</td>
<td>500074</td>
</tr>
<tr>
<td>3/16&quot;</td>
<td>500072</td>
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<tr>
<td>1/4&quot;</td>
<td>500071</td>
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