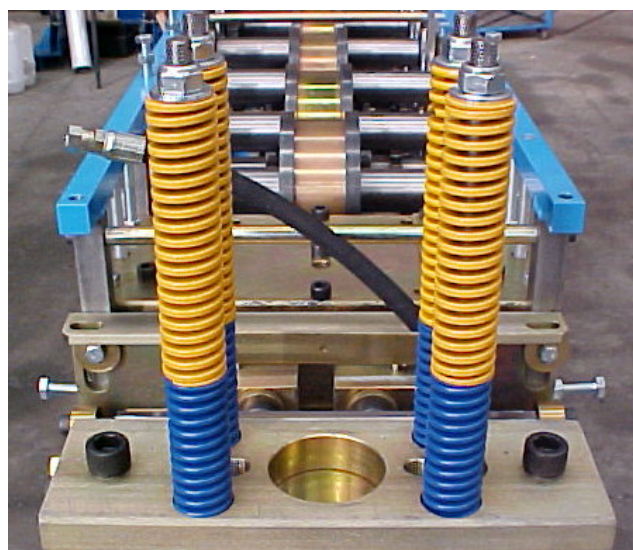
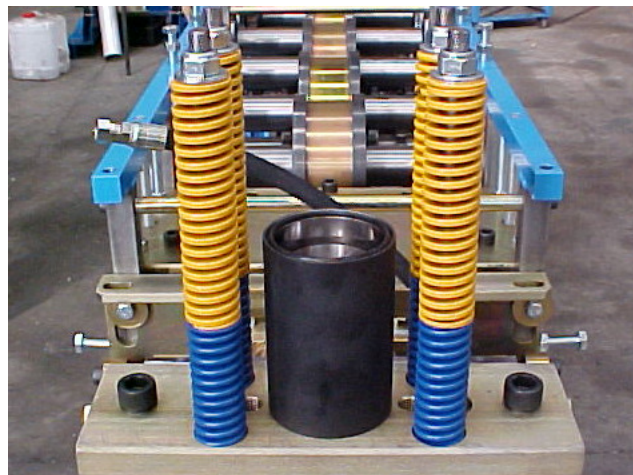


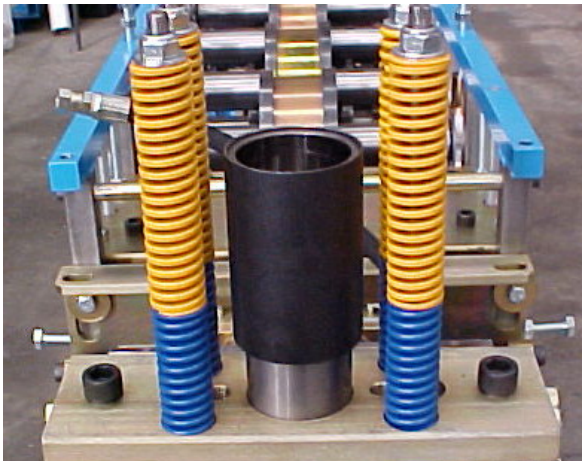
Changing Seals in Hydraulic Cylinders

The method is the same for all cylinders in the Howick Frame machine except for the ones in the lip roll unit.

1. Turn off machine and disconnect the power.
2. Undo the hydraulic fitting. *Note: oil will leak out.*
3. Undo the bolts.
4. Lift off the cylinder cap. *Note: the cylinder and piston may also lift out of the main block if it is a tight fit.*
5. Lift the cylinder and piston off the main plate.
6. Remove the O-ring from the top of the cylinder.



7. Push the piston out of the cylinder.
8. Remove the seal from the piston.
9. Push the new seal onto the piston over the chamfered edge with the lip of the seal facing upwards.
10. Push the piston back into the cylinder with the chamfered edge of the cylinder facing down and the chamfered edge of the piston facing up. *Note: Putting some oil on the piston will make it easier to push in.*



11. Put the cylinder back in place.
12. Put the O-ring on the cylinder cap.
13. Put the cylinder cap on top of the cylinder.
14. Put the cap screws back in, making sure to do them up evenly so that the cylinder cap is level.
15. Reattach the hydraulic hose.
16. Wipe up any excess oil.
17. The machine is ready to run.



The cylinder does not seal in the bottom section and therefore if there is any excess oil around the bottom of the cylinder it will be blown out by the air escaping as it is pressurized in the cylinder.

This is not a leak.



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117 Vincent St, Howick, Auckland, New Zealand
Phone 64 + 9 + 5345569 Fax 64 + 9 + 5370459
Email: info@howick.co.nz www.howick.co.nz