

## Disassembly

Remove four tie-rods (1) and separate cylinder components.  
 Remove and discard the piston wear strip (2), piston seals (3), tube seals (4), rod seal (5) and rod wiper (6).

## Torque Guidelines

Part Number	Bore Size	Torque
<i>D24 T-M</i>	1½"	10 ft/lbs.
<i>D32 T-M</i>	2"	15 ft/lbs.
<i>D40 T-M</i>	2½"	15 ft/lbs.
<i>D52 T-M</i>	3-1/4"	25 ft/lbs
<i>D64 T-M</i>	4"	25 ft/lbs

## Assembly

Install replacement rod seal (5), rod wiper (6), and piston seals (3) in the orientation shown below.

Install replacement tube seals (4) in the grooves on each cylinder head.

Install replacement wear strip (2) in the shallow groove on the piston.

Apply a thin coat of petroleum-based oil to the newly-installed seals to prevent damage while reassembling the cylinder.

Reassemble the cylinder taking care to avoid damaging the seals.

Alternate tightening tie-rods to evenly torque to the provided torque guidelines.

