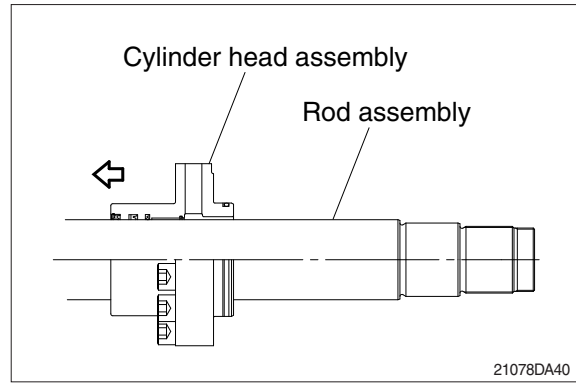
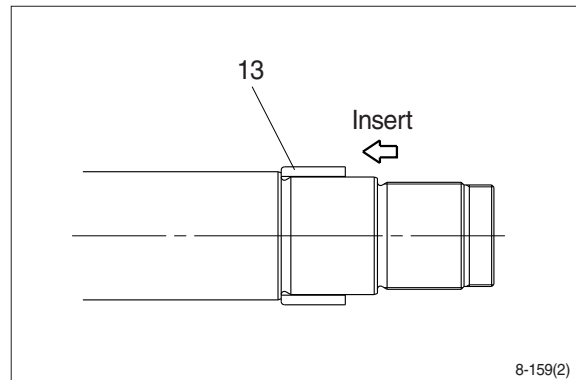


**(3) Install piston and cylinder head**

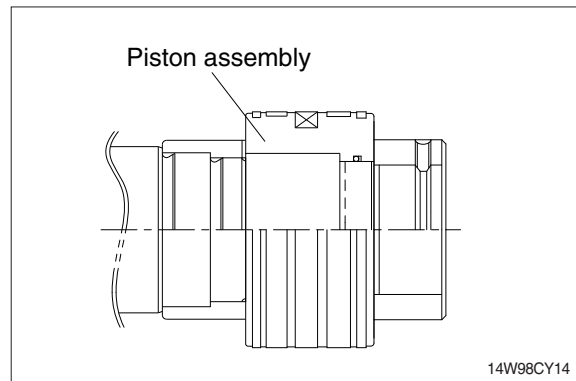
- ① Fix the rod assembly to the work bench.
- ② Apply hydraulic oil to the outer surface of rod assembly (2), the inner surface of piston and cylinder head.
- ③ Insert cylinder head assembly to rod assembly.



- ④ Insert cushion ring (13) to rod assembly.
- ※ Note that cushion ring (13) has a direction in which it should be fitted.

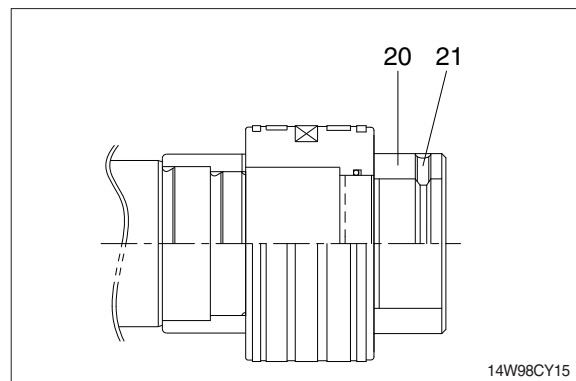


- ⑤ Fit piston assembly to rod assembly.
- Tightening torque :  $150 \pm 15 \text{ kgf} \cdot \text{m}$   
( $1085 \pm 108 \text{ lbf} \cdot \text{ft}$ )



- ⑥ Fit lock nut (20) and tighten the set screw (21).
- Tightening torque :

Item		kgf · m	lbf · ft
20	Bucket	$100 \pm 10$	$723 \pm 72.3$
	Boom		
	Arm		
21		$2.7 \pm 0.3$	$19.6 \pm 2.2$



### (3) Overall assemble

- ① Place a V-block on a rigid work bench.  
Mount the tube assembly (1) on it and fix the assembly by passing a bar through the clevis pin hole to lock the assembly.
- ② Insert the rod assembly in to the tube assembly, while lifting and moving the rod assembly with a crane.
  - ※ Be careful not to damage piston seal by thread of tube assembly.
- ③ Match the bolt holes in the cylinder head flange to the tapped holes in the tube assembly and tighten socket bolts to a specified torque.
  - ※ Refer to the table of tightening torque.

