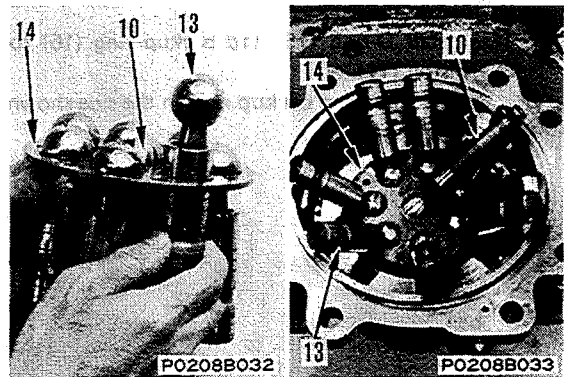




9. Piston, retainer

- 1) Set 7 pistons (13) and center shaft (10) in retainer (14).
- 2) Set piston and center shaft on shaft together with retainer.

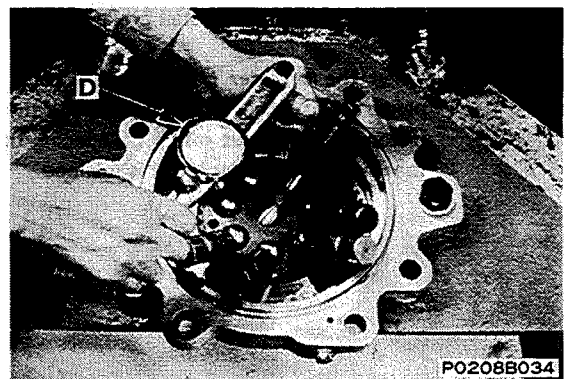


- 3) Using tool D, tighten 7 screws.

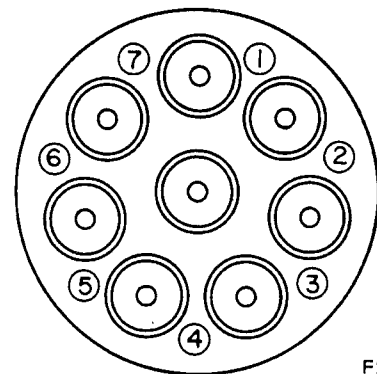
 Mounting screw: Adhesive (LT-2)

 Mounting screw:

1st time	0.4 — 0.6 kgm
2nd time	1.2 — 1.5 kgm
Target	1.35 kgm



- ★ Tighten in the order shown in the diagram. The screws can be tightened either clockwise or counterclockwise.
- ★ After tightening the screws, check that the piston moves smoothly and can fall under its own weight. If the movement is not smooth, loosen the screws and then tighten them again.

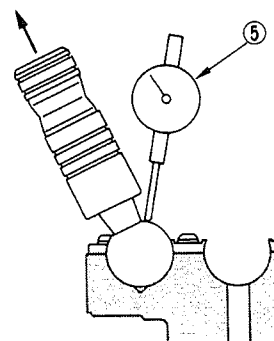


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- 4) After tightening screws, measure clearance at ball of piston.

- i) Set dial gauge ⑤ in position on ball.
- ii) Pull piston and measure clearance between ball and retainer.

★ Clearance at ball : Max. 0.35 mm

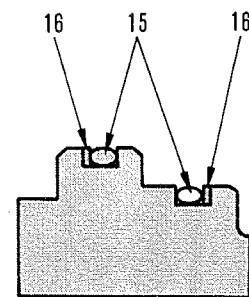
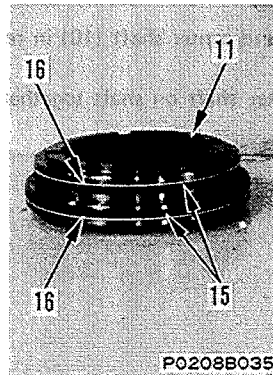


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10. Brake piston assembly

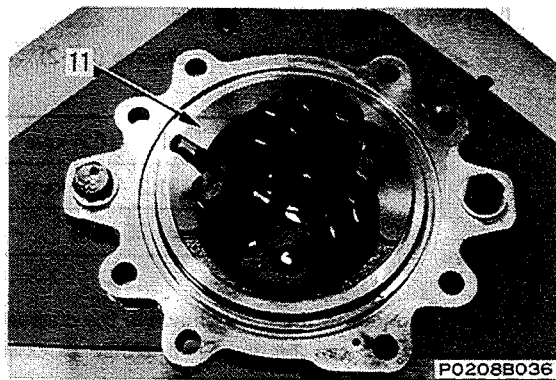
- 1) Install O-ring (15) and backup ring (16) to brake piston (11).

★ Install the backup ring on the side shown in the diagram.



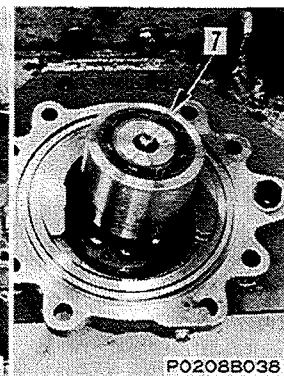
- 2) Align match marks, and install brake piston assembly (11).

★ When the cylinder block is assembled in the next step, it fits at an angle, so install the brake piston with the cut inside part facing the side to which the cylinder block is inclined.



11. Cylinder block

- 1) Install center ring (9) and spring (8) to center shaft (10).
- 2) Align with piston, and install cylinder block (7).



12. Spring

Align outside circumference (inside circumference opens) and install spring (6).

