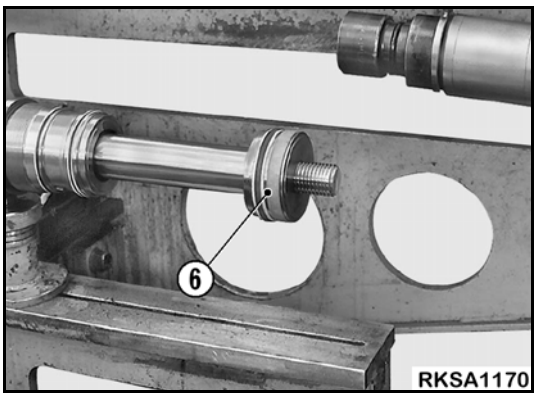
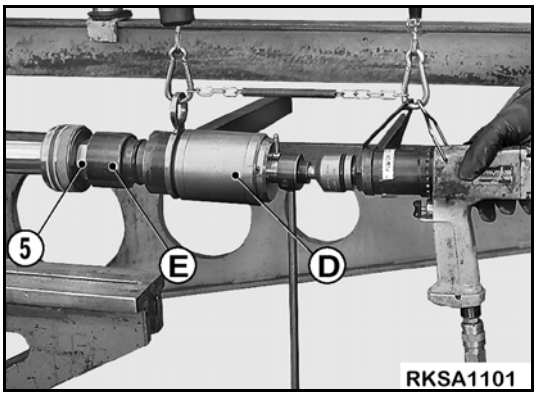
F. Mount the complete piston (6).



G. Mount the nut (5) that secures the piston and tighten it with the socket wrench **E** and the dynamometric tool with a multiplier **D**.

Nut: Loctite 262

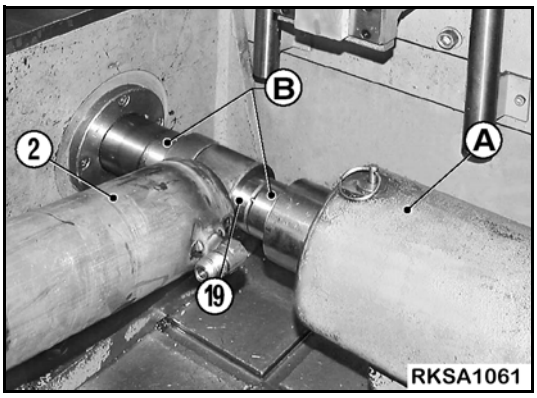
Nut:
Raising cylinder: 422 ±42 N•m (311 ±30.9 lbf ft)
Bucket cylinder: 343 ±34 N•m (253 ±25.0 lbf ft)



4. Cylinder assembly.

A. Mount the tools **A** onto the apparatus **B**.

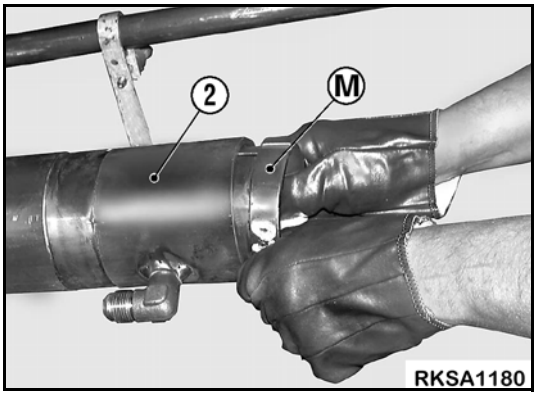
B. Position the bushing (20) and mount it onto the cylinder (2).
★ Leave the cylinder in position, ready for the next assembly operation.



C. Lubricate the threading and the first part of the cylinder (2).

Cylinder: Litio EP NLGI 2

D. Mount the two halves of the tool **M**, adapted to the diameter, onto the mouthpiece of the cylinder (2).



E. Mount the piston rod group (4) onto the tool **A** and raise the mobile part up to the end of its stroke.

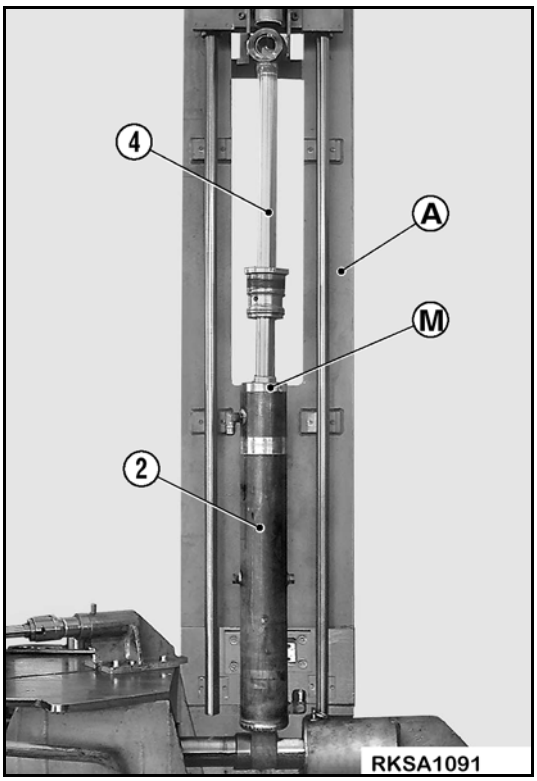
F. Put the cylinder (2) into a vertical position and guide the piston into the tool **M**.

G. Lower the apparatus supporting the piston rod (4) in order to insert the piston into the cylinder liner (2).

H. Remove the tool **M** from the cylinder and then lower the apparatus **A** even further, until the head (3) and the piston rod approach the cylinder.

I. Place the cylinder (2) in position for screwing in the head (3).

J. Insert the head into the cylinder and screw it in by hand for a few turns.



K. Attach the special wrench **C** to the dynamometric tool **D** and screw the head (3) fully home.

Head:
Raising cylinder: 430 ±43 N•m (317 ±31.7 lbf ft)
Bucket cylinder: 441 ±44 N•m (325 ±32.4 lbf ft)

L. Mount the guard rings (1) on both sides of the cylinder and the piston rod.