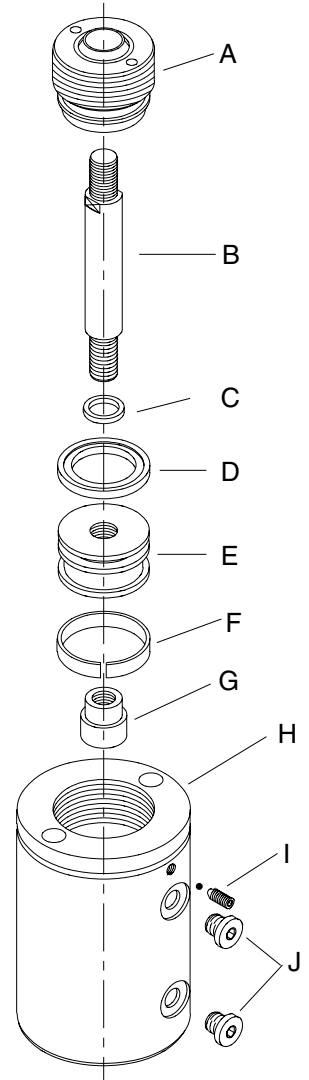




## DK Series Maintenance Instructions

Parts List			
Item	Description	Part No. ø40 mm	Part No. ø55 mm
A	Front Head Rod Cartridge	KE306571	KF306642
B	Piston Rod	KE15M.__*	KF15M.__*
C	Piston O-Ring	KE45V243	KF45V350
D	Piston Seal	KE48V238	KF48V345
E	Piston	KE256573	KF256641
F	Piston Rider	KE41V237	KF41V344
G	Piston Nut	KE856709	KF856791
H	Cylinder Body	KE05M.__*	KF05M.__*
I	Set ScREW	UMH05080008	UMH05080008
J	Flush Plugs	KE86V236	KF86V351
K	Rear Head Cartridge (not shown)	KE106595	KF106637

\* Must also specify stroke length when ordering these parts.  
 Repair Kits DK40-RK and DK55-RK include items A & D  
 Repair Kits DKD40-RK and DKD55-RK include items A, D & K



### Service Tools

Starter Tube  
ST-40  
ST-55

Used to avoid damaging the piston seal when installing the piston into the cylinder.



Spanner Wrench  
SW-40  
SW-55

Used to insert and remove the cartridge during cylinder repair.



## DISASSEMBLY



1



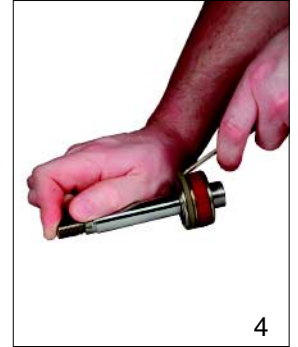
2a



2b



3



4

(1) Loosen the set screw(s) by turning counterclockwise 1-2 turns. (2a) Using a spanner wrench, unscrew the front head rod cartridge. (2b) For the double rod end model, unscrew and remove the rear head cartridge.

(3) Pull the entire rod assembly out of the cylinder. Once the assembly is removed, slide the rod cartridge off the rod and discard. (4) Remove the old piston seal. Take care not to scratch the finish on the piston rod.

*Note: It is not necessary to replace the wear ring unless there is visible damage.*

## REASSEMBLY



5



6



7



8

(5) Install the new piston seal. The soft o-ring seal should be installed first. The outer seal should then be installed with a small, flat blade screwdriver. Take care not to damage the seal. The outer seal may be made more pliable by heating in warm oil.

(6) Insert the starter tube into the cylinder. (7) Slide the piston rod assembly into the cylinder. (8) Using a soft mallet, tap the piston rod assembly until the piston reaches the bottom of the cylinder. Remove the starter tube.



9



10a



10b



11

(9) Grease the piston rod with a small amount of hydraulic fluid. Twist the new cartridge while sliding it onto the rod. (10a) Using a spanner wrench, turn the front cartridge until it rests flush with the top of the cylinder.

(10b) For the double rod end model, completely reinstall the front cartridge then repeat steps 9 and 10a for the rear head. (11) Retighten the set screw(s).