

## AQ70 63/40\*300 (Hainzl) Water Hydraulic Cylinder

### Disassembly

1. Fix the bottom end of the cylinder in a vice.
2. Untighten the counter nut (A) of the adjustable rod eye (B) and unscrew the eye piece and nut.
3. To unscrew the stuffing box, use a hammer mandrel (C) with a 1/4" BSP end which fits into the cylinder connection port (D). The mandrel must fit tightly towards the port land.
4. With a hammer strike the mandrel anti-clockwise (seen from the rod end) to loosen the stuffing box.
5. Unscrew and remove the stuffing box (E) from the the cylinder tube and pull the piston rod out of the tube.
6. Remove the locking clip (F) and the scraper from the stuffing box by means of an adequate tool.
7. Fix the stuffing box in a vice. Remove the nylon bushing, using a mandrel. Now push the rod seal out.
8. Fix the piston (G) (with the piston rod) in a three-jaw chuck (H) or similar. The piston is locked with Loctite.

To loosen the piston, heat it to approximately 120 °C and unscrew the piston rod (anti-clockwise) by means of a spanner (use spanner on across-flats at the threaded end of the rod).

Disassemble the piston and remove the seals.



### Reassembly

9. Fit the piston, the seals and the O-ring on the piston rod. Degrease the piston and the piston rod threads and then apply Loctite 2701 on the rod thread and screw the piston on.
10. Fit the new scraper and rod seal as described in points 7 and 6 above.
11. Using a split lead bushing (I) to introduce the piston and rod into the cylinder tube - and observe that the guide-ring (J) is placed correctly in the groove of the piston.
12. Slide the stuffing box onto the rod and apply Anti-Block Grease on the outside thread of the stuffing box and oil on the inside thread of the cylinder tube ().
14. Screw the stuffing box into the tube clockwise. Tighten it by using the hammer mandrel in inlet port on the stuffing box – and strike the mandrel with a hammer.



Manufacturer

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