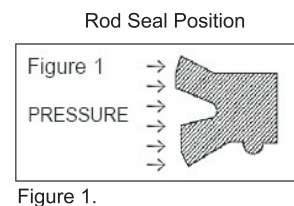
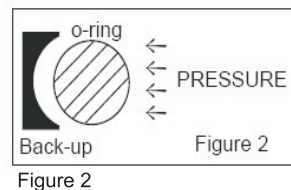
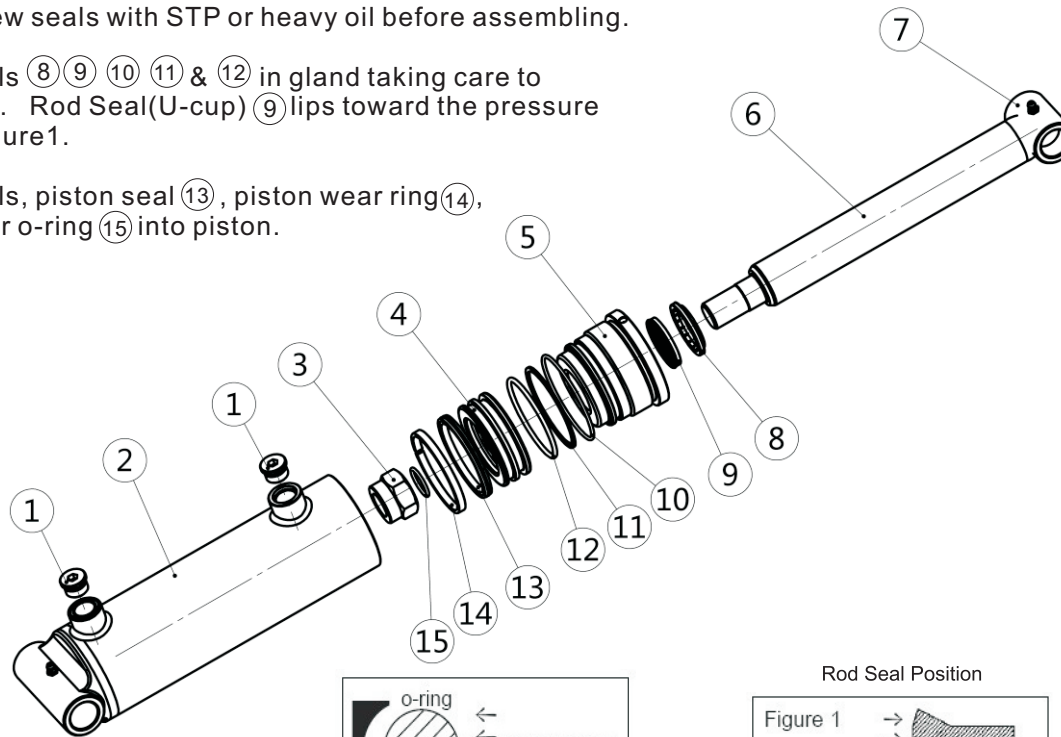


Guide for WEN (Model_WT) Cross Tube Hydraulic Cylinder Seals Replacement

1. Remove all ports plugs (1) and make sure all oil has been drained from ports.
2. Clamp rod end tube (7) in vise and fully extend cylinder. Protect rod surface while moving.
3. Clamp and hold the tube base tube. Un-thread the gland and slip the gland (5) and the piston (4) off tube (2).
4. Remove piston nut (3) and slip piston and gland off rod (6).
5. Remove old seals from gland and piston.
6. Wash and check all parts for excessive wear or obvious defect which might interfere with operation.
7. Lubricate all new seals with STP or heavy oil before assembling.
8. Install new seals (8) (9) (10) (11) & (12) in gland taking care to position the I.D. Rod Seal (U-cup) (9) lips toward the pressure as shown in Figure 1.
9. Install new seals, piston seal (13), piston wear ring (14), and piston inner o-ring (15) into piston.

10. With a twisting motion push gland onto rod from the piston end.
11. Torque piston nut (3) according to Table#1. Lube gland & piston seals.
12. Slide tube over piston and onto gland. Making sure parts are properly aligned to avoid cutting o-rings.
13. Thread gland into tube. and punch tightly.
14. Hand stroke cylinder to check for binding.
15. Your cylinder is now ready for operation.



Part No.	Description	Qty
1	Port Plug	2
2	Cylinder Tube	1
3	Piston Lock Nut	1
4	Piston	1
5	Gland	1
6	Piston Rod	1
7	Rod End Tube	1
8	Rod Wiper	1
9	Rod Seal	1
10	Gland Outer O-ring	1
11	Tube Back-up Ring	1
12	Tube Seal O-ring	1
13	Piston Seal	1
14	Piston Wear Ring	1
15	Piston Inner O-ring	1

TABLE#1 (Torque Guide)		
Bore Dia.	Tie-Rod Nut Torque LBS-FT (N-M)	Piston Nut Torque LBS-FT (N-M)
2.0"	40 (55)	150 (200)
2.5"	40 (55)	150 (200)
3.0"	75 (100)	265 (350)
3.5"	100 (130)	265 (350)
4.0"	120 (160)	550 (730)