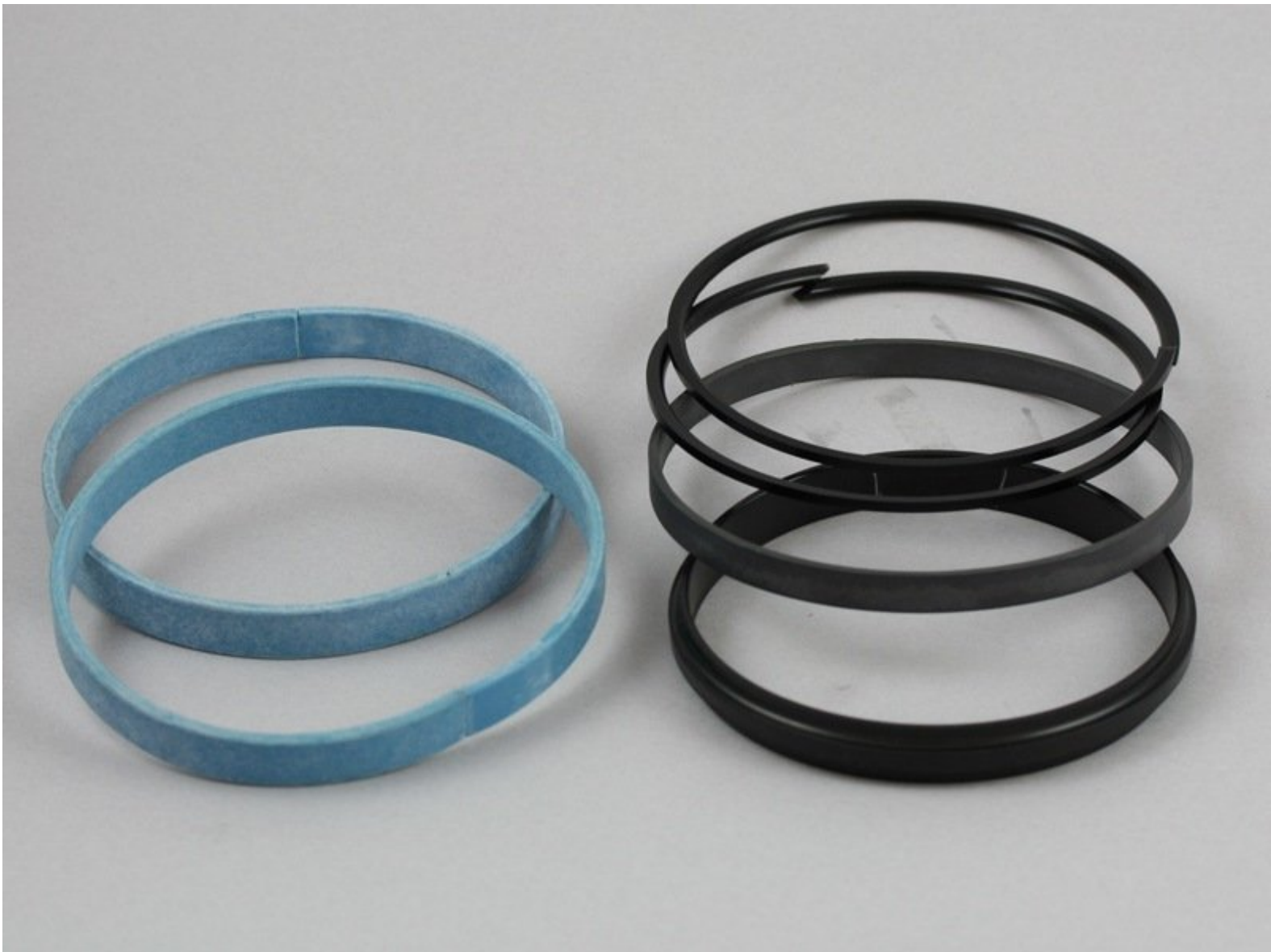




How to Repair a Flow Style Piston Seal Using Kit #12386

These instructions will demonstrate how to replace components of a Flow Style Piston Seal with kit #12386

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INTRODUCTION

Hypertherm is in no way affiliated with the above mentioned manufacturer



TOOLS:

- Piston Seal Installation Tool 4.0" Diameter #13706 (1)
- Pick (1)



PARTS:

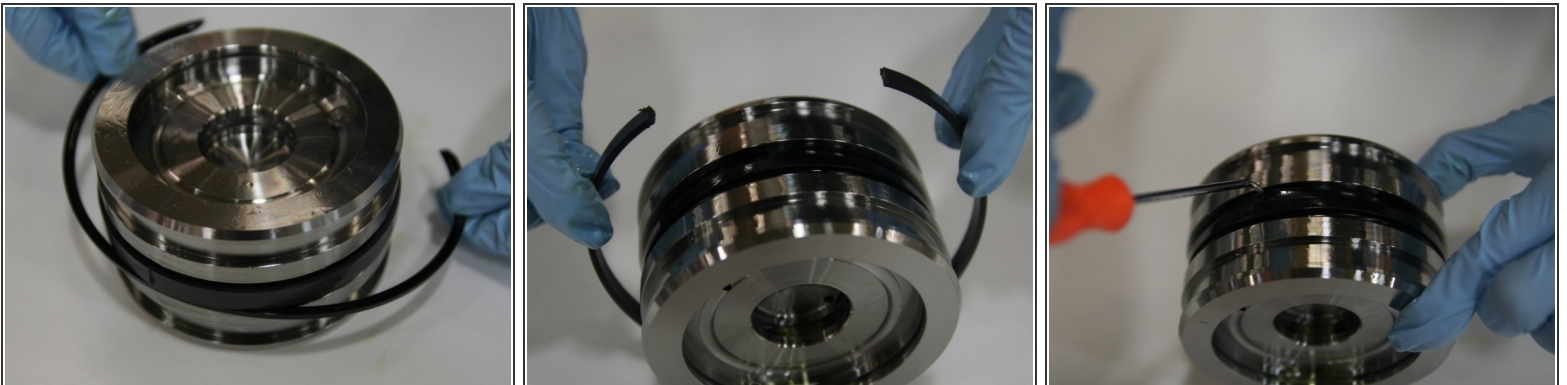
- Hydraulic Piston (New Style) #12349 (1)
- Piston Seal Kit #12386 (1)

Step 1 — How to Repair a Flow Style Piston Seal Using Kit #12386



- Remove the first wear ring from the piston.
- Remove the second wear ring from the piston.
- Remove the first split ring from the middle groove of the piston.

Step 2



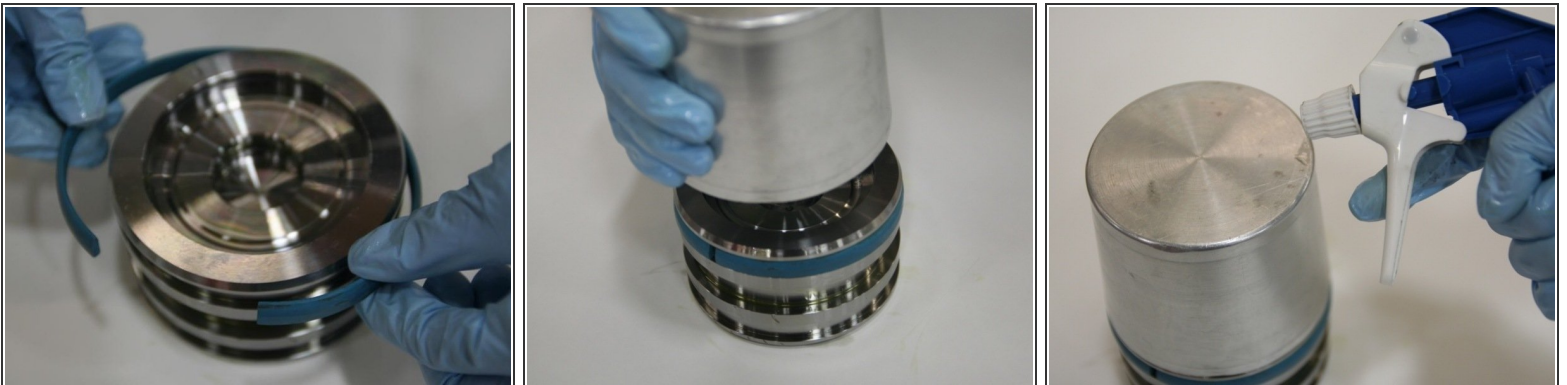
- Remove the second split ring from the middle groove of the piston.
- Cut the cap seal from the middle groove of the piston with a pen knife.
- Use a pick to remove the T-seal from the middle groove of the piston.

Step 3



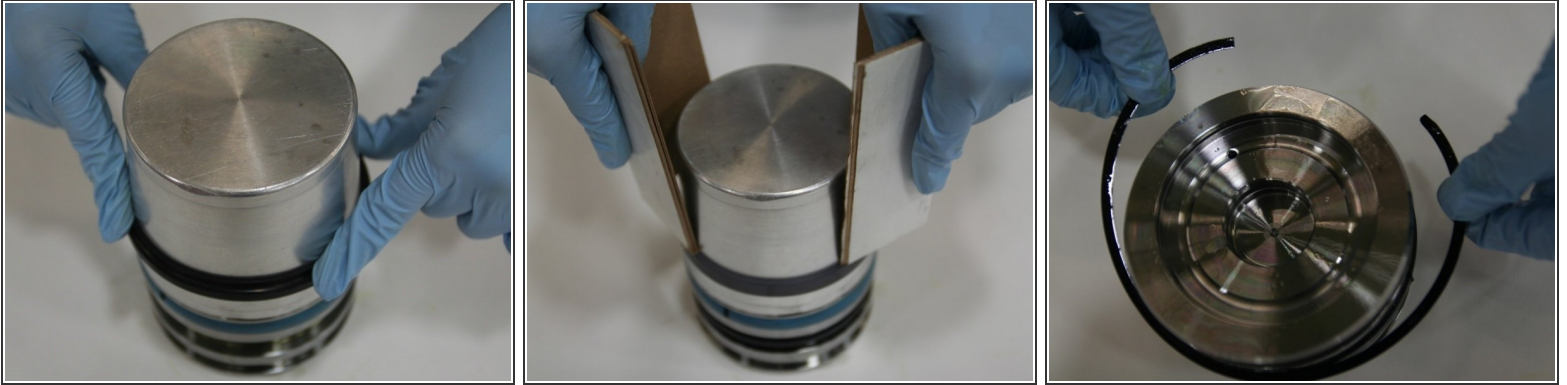
- Wipe down the piston with the towel to remove excess hydraulic fluid.
- Visually inspect the piston for any scratches or blemishes. If damaged, replace the piston.
- Reapply the hydraulic fluid to the piston with a spray bottle.

Step 4



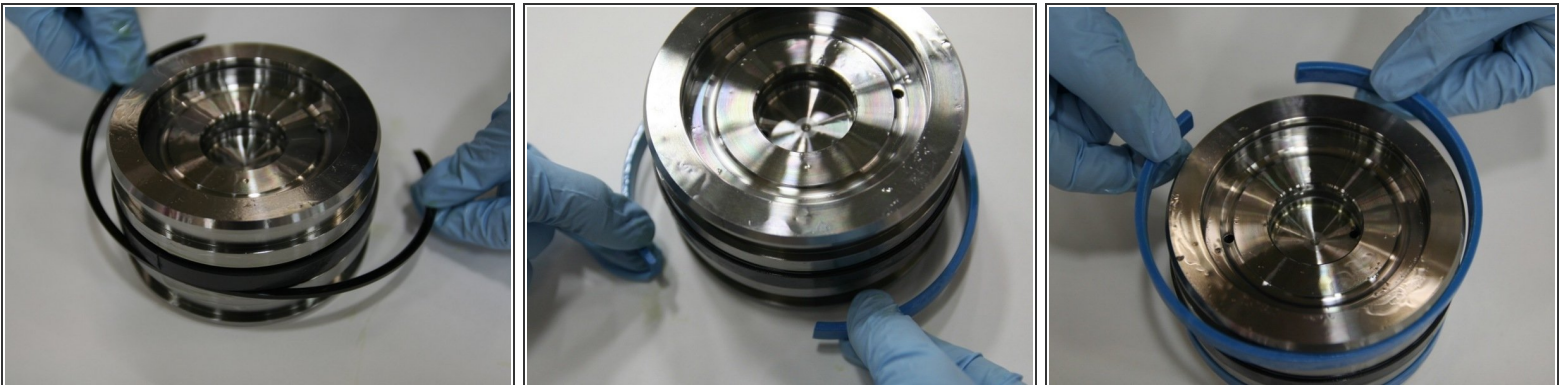
- Put the modified wear ring into the top groove of the piston.
 - ⓘ To create the modified wear ring, shave one edge of a new wear ring (not included in kit) with a belt sander and have the wear ring facing up so there is an easier placement of the cap seal.
- Put the piston assembly tool onto the piston to fit in the groove.
- Apply hydraulic fluid to the piston assembly tool.

Step 5



- Slide the T-seal around the piston assembly tool, past the modified wear ring, and into the middle groove of the piston.
- Slide the cap seal onto the piston assembly tool and push the cap seal down (using rigid cardboard) past the modified wear ring and over the T-seal to place in the middle groove.
- Put the first split ring onto the middle groove with the rounded side facing inward towards the T-seal.

Step 6



- Put the second split ring onto the middle groove with the rounded side facing inward towards the T-seal.
 - The break in the split ring should be on the opposite side of the first split ring.
- Put the first wear ring onto the bottom groove of the piston.
- Put the second wear ring onto the top groove of the piston.

Step 7



- Apply hydraulic fluid to the entire piston with a spray bottle.
- Proceed to the assembly of the intensifier.