



Instruction

9515172 Cylinder repair guide

Revisions and changes

Rev:	Prepared by	Summary of changes
00	KKF	New document
01	OK	New template, Sparepart updated

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1 SCOPE

This instruction can be used for these toolkits / spare part repair kits:

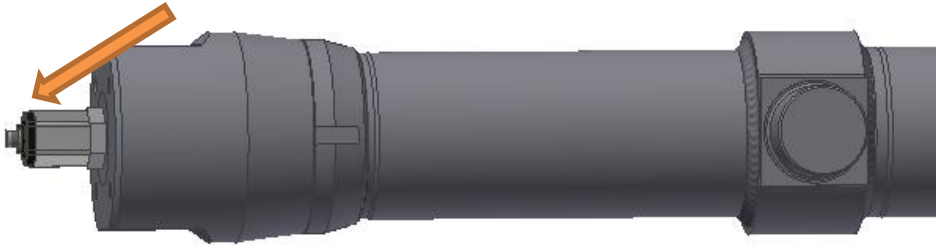
- 9515172 Toolkit 140/90 Glual & Flutechnik**
- 5272399H Repair kit Heavy sparepart sales 140/90
- 5272402H Repair kit Heavy sparepart sales 140/90

2 DISASSEMBLY

Before disassembly, the system must be in safe mode, pressureless and the cylinder drained for oil. Prepare for oil collection when dismantling valve block, pipes, and cylinder enclosure.

2.1 POSITIONS SENSOR

Unscrew and pull the position sensor out of the cylinder. Mount the oil drain hose 34762 for draining the oil.



2.2 BEARING HEAD

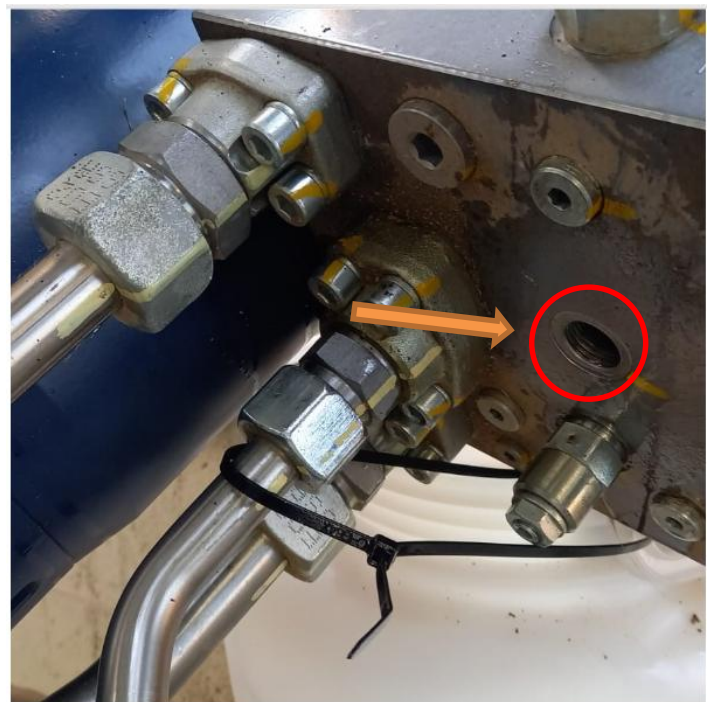
Measure the distance between the piston rod and bearing head.

Loosen all the bolts in the clamping bearing head.

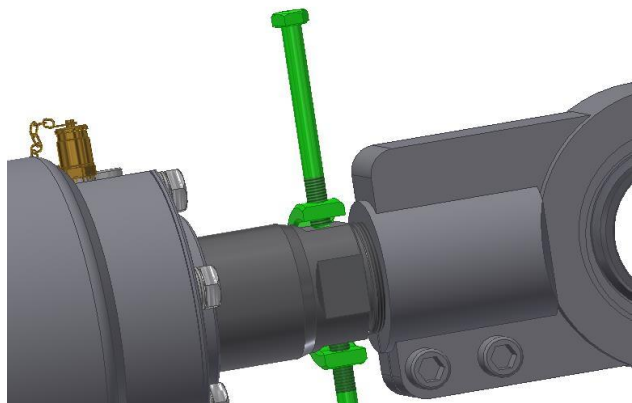
Widen out the clamping by mounting plate chisels in the slots on each side until the bearing head can be turned easy.



Remove plug on valve block to open for air to the front of cylinder. If plug is mounted, it is not possible to move the rod out and in by hand.

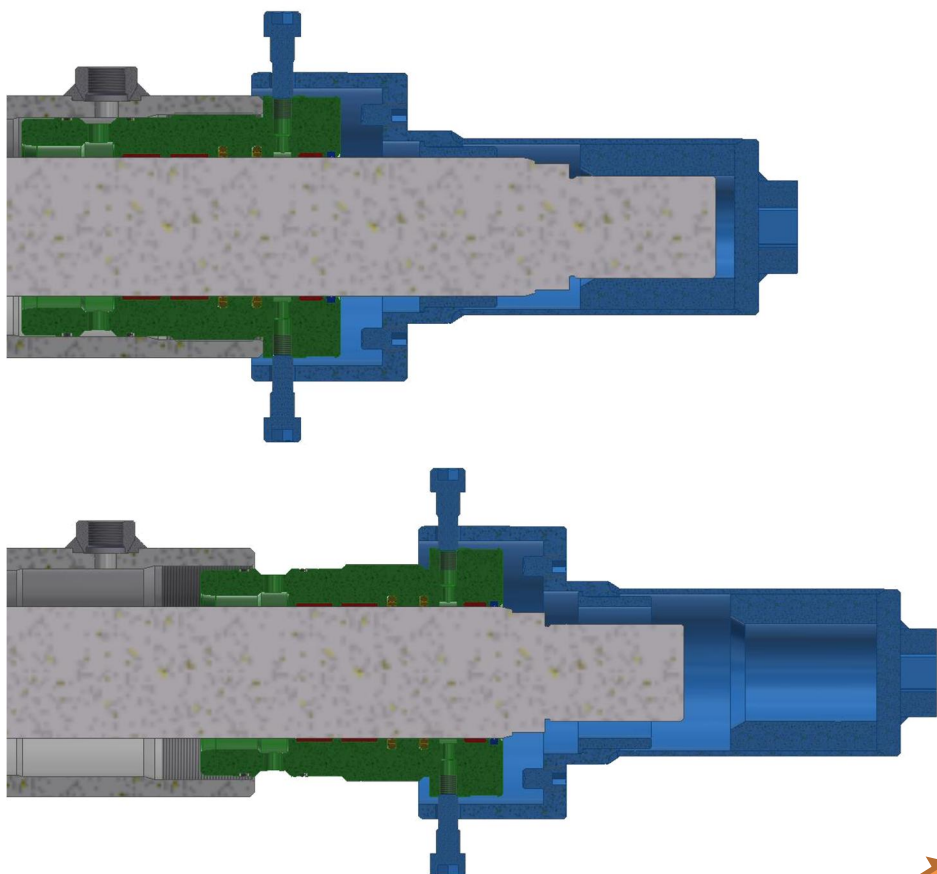


Unscrew rod from bearing head with the 9515171 and chisels still sitting in the slots.



2.3 GLAND

Remove the stopscrew (quill screw) between the gland and tube and remove the paint from the gap between the gland and tube. Use the special socket 5272412 to loosen and unscrew the gland, as shown below.



Use a torque multiplier for it: **1 : 3,3** x torque.

<https://www.batonordic.dk/dk/p-346/bato-gearnogle-3-4f-x-1m-2500nm>



2.4 PISTON

Pull the rod with piston out of the tube.

3 ASSEMBLY

Inspect and clean tube inside for damages. Replace cylinder if scratched or worn out.

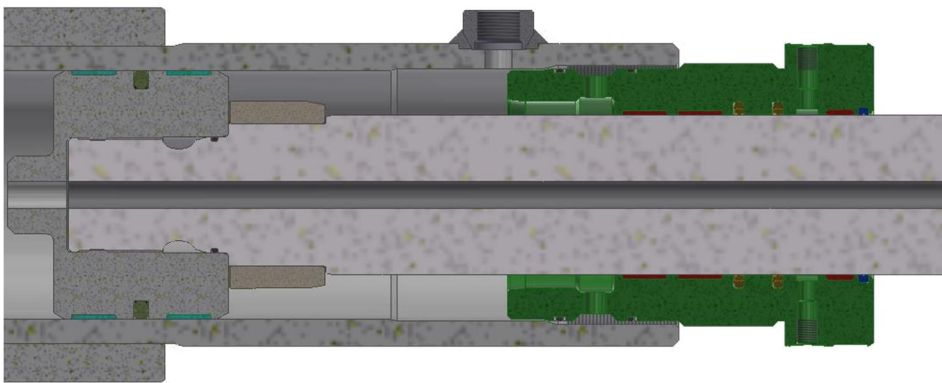
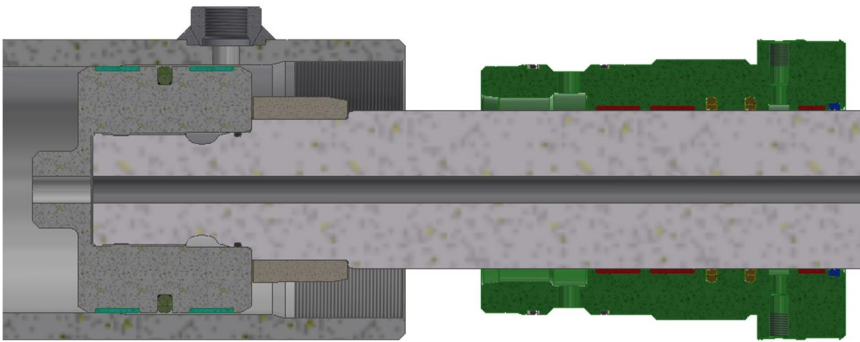
Oil/grease all seals/mating surfaces and threads before assembling.

Be careful with the cleanliness during assembly.

3.1 PISTON

Slide the piston rod and gland with pre-mounted seals into the tube.

Be carefully when the piston seal passes the tube threads and B-port.



Use the special socket 5272412 Tighten it with 1200 Nm.

[All as shown in section 2.3, just in reverse order.]

3,3 POSITIONS SENSOR Reinstall position sensor in cylinder. Tighten with 80 Nm.



3.4 BEARING HEAD

Grease on the thread before screw the bearing head on the rod end with the chisels still sitting in the slots. Use tools shown in section 2.2 Adjust it into position and remove the chisels.

Tighten all the clamping bolts.

3.5 END ASSEMBLY / INSPECTION

Mount , pipes, and all other disconnected parts.

Drive the cylinder full stroke 5 times between 5-85°without load, to bleed air out of the system. Test the cylinder under full pressure and check for tightness.

4 TOOL KIT NO. 9515172

Reservedelsliste - Spare Part List - Ersatzteilliste

Pos.	Stk. Pcs. Stück	Vare nr. Item. no. Warennr.	Beskrivelse	Description	Beschreibung
10	1	5272412	Montagetop Ø180x354;DC=Ø145	Mounting top Ø180x354;DC=Ø145	Montageoberteil Ø180x354;DC=Ø145
20	1	9515171	Montagenøgle for AF=82	Mounting key for AF=82	Montageschlüssel für AF=82
30	1	34762	Slangesæt for olietømning	Oil drain hose kit	Ölablassschlauch-Kit
40	2	63295	Mejsel 1	Chisel 1	Meißel 1
50	2	63065	Mejsel 2	Chisel 2	Meißel 2

