



H&O Die Supply, Inc 1-800-222-5441 sales@hodie.com

Multicyl Inc

MC Cylinder Series Assembly



Step 1



Clean and dry all parts thoroughly in a solvent tank or equivalent,

Step 2



Lay out and **grease all seals from seal kit**. It is very important to grease the seals to avoid tearing during installation.





Step 3



- A) Install ram guide and seal on ram piston, install circlip.
- B) Install wiper seal into ram stop sleeve, place compression spring over ram piston.
- C) Compress whole assembly in an arbor press or equivalent and install retaining ring.

Step 4



Install piston ring onto low pressure piston, secure with circlip.



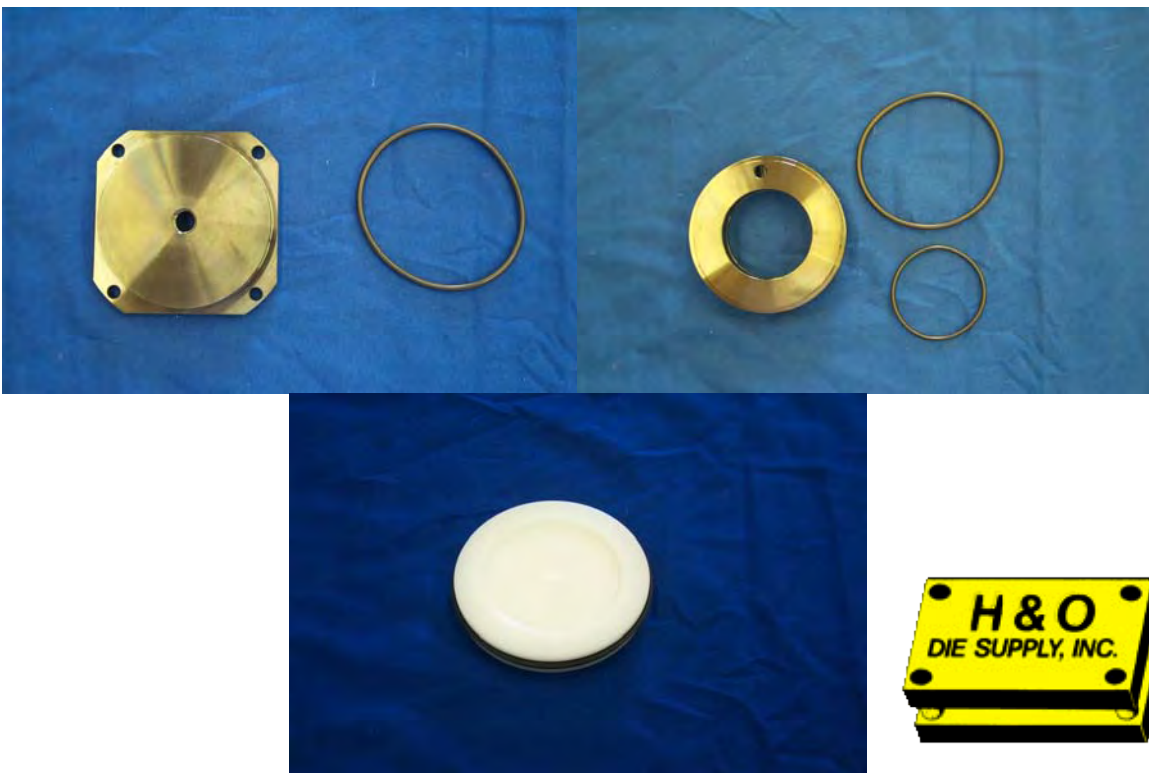
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Step 5



- a) Install O-ring seals onto main body
- b) Install orange seal into the bottom of the main body, followed by the third stage seal cover, and o-ring plus accompanying flat ring seal.
- c) Install wiper seals plus retaining washer and circlip into main bearing.

Step 6



- a) Install o-ring seal on air cylinder head



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- b) Install o-rings on divider plate
- c) Install seal on air piston (check seal breakdown included with seal kit to see orientation)

Step 7



- a) Install oil cylinder tube onto main body, taking care to position the filler hole 180 degrees from the oil pickup holes in the main body
- b) Install spacer tube
- c) Press divider plate onto assembly

Step 8





- a) Place air spring onto piston rod assembly
- b) Place piston rod and spring assembly onto the main body assembly
- c) Compress the spring assembly and place Low pressure piston over the piston rod stud, followed by washer and locknut
- d) Tighten lock nut and hold the piston rod assembly with a hex wrench.

Step 9



- a) Place air cylinder tube over main body assembly
- b) Press by hand the air piston (make sure seal is well greased) into air cylinder tube
- c) Tighten lock nuts

Step 10



- Grease bottom seal on ram assembly and tap using a soft mallet into the High pressure cylinder
- Tighten assembly into cylinder and replace the set screw (blue loctite recommended on setscrew)
- Re-attach ram cap.

Step 11



- Fill high pressure cylinder with **AW32 non-detergent oil**
- Hold high pressure cylinder assembly in a **SOFT** jawed vice (wood or aluminum) and thread and tighten main body assembly onto high pressure cylinder.
- Fill with AW32 non-detergent oil to the fill line.

