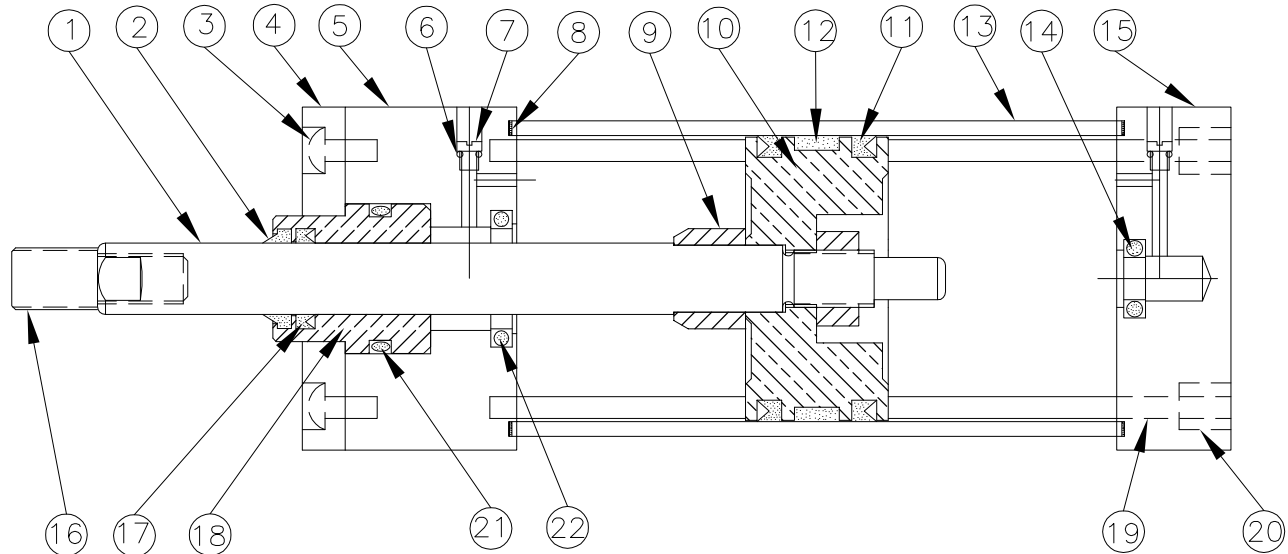


DURAMASTER CYLINDERS, INC.

5688 W. CRENSHAW ST.
TAMPA, FL. 33634-3013
PH. (813) 882-0040
FAX (813) 888-6688



BASIC CYLINDER

DESCRIPTION	PART #	QTY.	DWG.
1. ROD	2XX-40000	^ (1)	A
2. ROD WIPER	4XX-51609	@ (1)	.
3. RETAINER BHCS	3XX-5XXXX	(4)	.
4. BUSHING RETAINER	1XX-5021X	(1)	A
5. HEAD CAP	1XX-5020X	(1)	C
6. CUSHION O-RING	4XX-50300	& (2)	.
7. CUSHION SCREW	1XX-50400	(2)	A
8. TUBE SEAL	4XX-50501	& (2)	.
9. CUSHION SPUD	1XX-5060X	(1)	A
10. PISTON	1XX-50800	^ (1)	B
11. PISTON SEAL	4XX-51000	& (2)	.
12. WEARBAND	5XX-50900	&* (1)	.
12a. MAGNETIC STRIP	215-55000	(1)	.
13. TUBE	2XX-11000	(1)	.
14. END CAP CUSHION	4XX-5150X	& (1)	.
15. END CAP	1XX-50210	(1)	B
16. ROD STUD	1XX-506XX	~ (1)	A
17. ROD SEAL	4XX-51608	@ (1)	.
18. BUSHING	1XX-5161X	@ (1)	A
19. TIE ROD	2XX-35000	(4)	.
20. TIE ROD NUT	1XX-50100	(4)	A
21. BUSHING O-RING	4XX-51607	@ (1)	.
22. HEAD CAP CUSHION	4XX-5150X	& (1)	.
30. MAGNETIC PISTON/ROD ASSY.	# 30		
31. PISTON/ROD ASSY.	# 31		

NOTE:

IN ORDER TO ENSURE PROPER PARTS REPLACEMENT YOU MUST INCLUDE THE SERIAL NUMBER OF THE CYLINDER.

* WEARBAND IS REPLACED BY MAGNETIC STRIP IF MAGNETIC PISTON OPTION IS SPECIFIED

~ROD STUD OPTIONAL - FEMALE THREAD IS STANDARD

^ONLY SOLD IN #30, #31 ASSY.

SEAL KITS:

1. DBK KIT (@)
2. DSK KIT (&)
3. DRK KIT (CONTAINS ALL @ AND &)

TORQUE SPECIFICATIONS:

BORE SIZE	TIE ROD NUT
1 1/2"	20-24 IN. LBS.
2" & 2 1/2"	42-48 IN. LBS.
3 1/4" & 4"	120-132 IN. LBS.
5"	180-200 IN. LBS.
6"	250-275 IN. LBS.
8"	575-600 IN. LBS.

RE-ASSEMBLY OF CYLINDER AFTER MAINTENANCE:

1. SCRIBE MARK ON THE TIE ROD NEXT TO THE HEAD BEFORE DISASSEMBLY.
2. DISASSEMBLE THE CYLINDER AND PERFORM THE NECESSARY MAINTENANCE.
3. REASSEMBLE THE CYLINDER AND ADJUST THE TIE ROD NUTS TO THE TIE RODS SO THAT THE SCRIBE MARKS ALIGN THEMSELVES WITH THE HEADS.
4. TORQUE THE HEAD CAP NUTS TO SPECIFICATION SHOWN ABOVE.