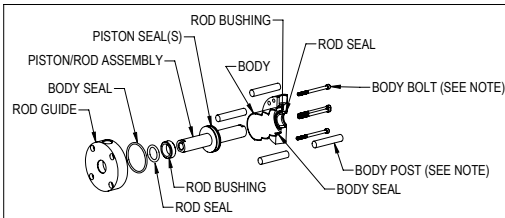




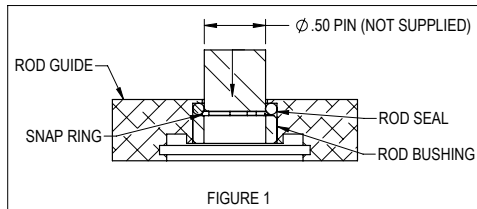
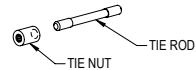
Flat-1 and Flat Square Double End Rod General Repair Instructions K-B-FOD-□, K-B-FSD-□

Disassembly

- 1) Using the appropriate allen wrench, remove the 4 (8 for long stroke versions) body bolts from the endcap(s).
- 2) Remove the body posts from the assembly.
- 3) Remove the rod guide and rear head from the body.
- 4) For cylinders with Viton option, please skip to step 6.
- 5) Install provided snap ring into the rod guide and press out the bushing as shown in Figure 1.
- 6) Remove the rod seal from the rod guide. (For cylinders with Viton option, a pick may be needed.)
- 7) Repeat steps 4-6 for rear head, then proceed to step 8.
- 8) Remove the body seals from rod guide and rear head.
- 9) Remove the piston seal(s) from the piston/rod assembly.



NOTE: FS MODELS WILL HAVE BODY POSTS REPLACED BY TIE RODS AND BODY BOLTS REPLACED BY TIE NUTS AS SHOWN BELOW:



(see reverse side for reassembly instructions)

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 rev. 1: EC-37791

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Flat-1 and Flat Square Double End Rod General Repair Instructions K-B-FOD-□, K-B-FSD-□

Reassembly

- 1) Lightly lubricate all of the new seals.
- 2) Install the new rod seal into the rod guide. (For cylinders with Viton option, please skip to step 4.)
- 3) Press in the new bushing into the rod guide as shown in Figure 2.
- 4) Repeat steps 2-4 for rear head, then proceed to step 5.
- 5) Install the new piston seal(s) onto the piston/rod assembly.
- 6) Install the new body seals into the rod guide and rear head.
- 7) Carefully install the rod guide assembly onto the rod/piston assembly.
- 8) Install the body into the rod guide. (Be careful not to damage the body seal.)
- 9) Install the rear head onto the body. (Be careful not to damage the body seal.)
- 10) Install the 4 posts back in between the rod guide and rear head.
- 11) Install the 4 (8 for long stroke versions) body bolts back into the rod guide and rear head.
- 12) Torque the bolts to the applicable values in Table 1. (See Table 2 for FSD models.)

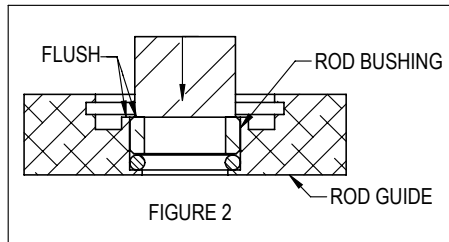


Table 1: Flat-1 Torque Specification

Bore Size	Screw Size	Torque: in-lb (ft-lb)	
		Standard	"S" Option
9/16", 3/4", 1-1/16"	#4-40	7 (.58)	3.5 (.29)
1-1/2", 2"	#10-24	35 (2.9)	19 (1.6)
2-1/2", 3"	1/4-20	90 (7.5)	41 (3.4)
4"	5/16-18	150 (12.5)	87 (7.2)

Table 2: Flat Square Torque Specification

Bore Size	Screw Size	Torque: in-lb (ft-lb)
3/4", 1-1/16"	#5-40	10 (.83)
1-1/2", 2"	.185-24	30 (2.5)
2-1/2"	1/4-28	35 (2.9)
3"	5/16-24	90 (7.5)
4"	3/8-24	150 (12.5)

(see reverse side for disassembly instructions)

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