

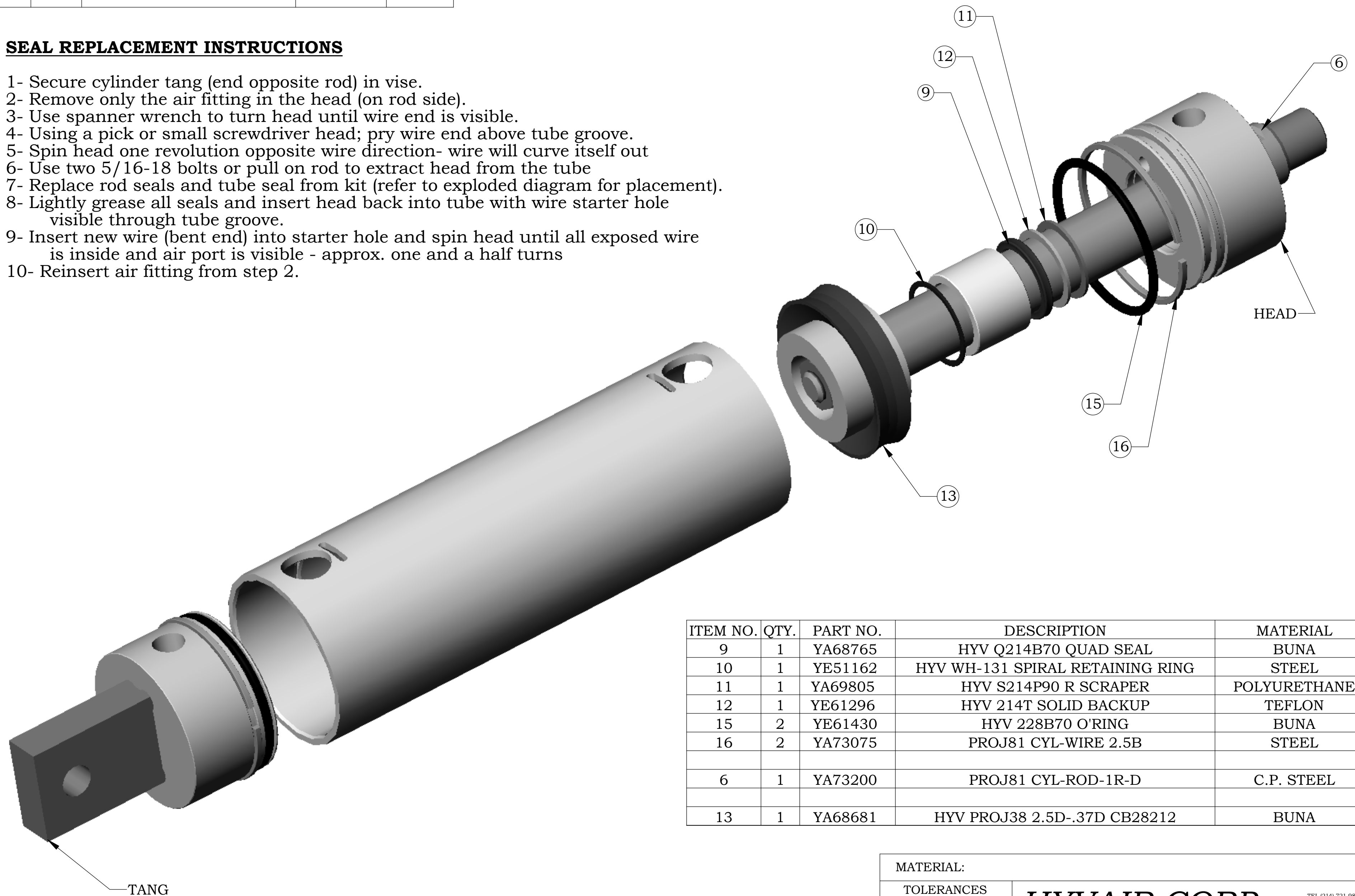
REVISION	DATE	REMARKS	DESIGN ORIGATION	CHECKED BY

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BREAK ALL EDGES 45° x .01" UNLESS OTHERWISE NOTED.

### SEAL REPLACEMENT INSTRUCTIONS

- 1- Secure cylinder tang (end opposite rod) in vise.
- 2- Remove only the air fitting in the head (on rod side).
- 3- Use spanner wrench to turn head until wire end is visible.
- 4- Using a pick or small screwdriver head; pry wire end above tube groove.
- 5- Spin head one revolution opposite wire direction- wire will curve itself out
- 6- Use two 5/16-18 bolts or pull on rod to extract head from the tube
- 7- Replace rod seals and tube seal from kit (refer to exploded diagram for placement).
- 8- Lightly grease all seals and insert head back into tube with wire starter hole visible through tube groove.
- 9- Insert new wire (bent end) into starter hole and spin head until all exposed wire is inside and air port is visible - approx. one and a half turns
- 10- Reinsert air fitting from step 2.



ITEM NO.	QTY.	PART NO.	DESCRIPTION	MATERIAL
9	1	YA68765	HYV Q214B70 QUAD SEAL	BUNA
10	1	YE51162	HYV WH-131 SPIRAL RETAINING RING	STEEL
11	1	YA69805	HYV S214P90 R SCRAPER	POLYURETHANE
12	1	YE61296	HYV 214T SOLID BACKUP	TEFLON
15	2	YE61430	HYV 228B70 O-RING	BUNA
16	2	YA73075	PROJ81 CYL-WIRE 2.5B	STEEL
6	1	YA73200	PROJ81 CYL-ROD-1R-D	C.P. STEEL
13	1	YA68681	HYV PROJ38 2.5D-.37D CB28212	BUNA

MATERIAL:

TOLERANCES (UNLESS NOTED OTHERWISE)	
DECIMAL:	
.0"	± .05"
.00"	± .01"
.000"	± .005"
.0000"	± .0025"
ANGULAR:	
± .05°	

**HYVAIR CORP.**

TEL.(214) 721-9877  
108 S. NURSERV RD.  
IRVING, TX. 75060

SCALE: 1=1	NEXT ASSY.	DRAWN BY: S. FLATT
DATE: 04/05/04	PAGE: 1 OF 1	REVISION:
DESCRIPTION: ALPINE 5918 EXPLODED		CATALOG NO. YC40540