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Installation Instructions for C-3894-DM Cylinders

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Note: Cylinder should not have to be disassembled to install.

1. Insure that Valve Spool and Valve Face are free of foreign particles.
2. Clean Valve Face.
3. Remove Pipe Plug from rear port of Cylinder using 3/16" Hex Wrench.
4. Apply a drop of removable grade LocTite to threaded portion of Valve Spool.
5. Place Spacer end of Cylinder against Valve Body.
6. Attach Cylinder to Valve Spool by using 3/16" Hex Wrench engaged in Piston hex pocket (accessed through 1/8" NPT fitting port in back of Cylinder assembly). Hold opposite end of Valve Spool and tighten to 30-40 in-lbs.
7. Seat Cylinder assembly against Valve Face and orient to match bolt pattern.
8. Thread Cap Screws into Valve Body using M4 Hex Wrench and tighten to 60-90 in-lbs.
9. Test for proper alignment by turning Valve Spool using 3/16" Hex Wrench through rear port of Cylinder assembly. Valve Spool should rotate freely.
10. Replace Pipe Plug in rear port using 3/16" Hex Wrench. **Apply thread sealant to all fittings.**
11. Install DOT approved fittings and tubing as required.

