DX Repair Manual

1: Disassemble and wash all parts in a solvent tank.

2: Inspect Piston rod for and Low pressure piston for wear

3: Lay seals out on a clean rag or paper towel and grease them

4: Install O ring seals onto main body, air cylinder head, and divider. The inside of the air piston also has 2 o ring grooves, and 2 cup seals go on the outside of the air piston.

Note: “cup” side of the seal faces the outside of the cylinder.

5: Install the black seal spacer onto the high pressure piston, followed by the yellow seal. Use blue loc-tite on the piston cap to secure the seals into place. Note the seal position (spring faces the cap)

6: Press the orange seal into the main body. Spring on the seal faces the threaded side of the main body.

Install the seal cover, then the o ring seal. Flat seal goes in last

7: Lay out the seals, seal retainer and snap ring required for the main bearing assembly

8: Install O-ring on the body of the bearing

9: Install wiper seals in the following order: Plastic wiper, rubber seal, plastic wiper, then the retainer and the snap ring

10: Grease the cylinder bore and seal and push the high pressure piston assembly into the high pressure cylinder.

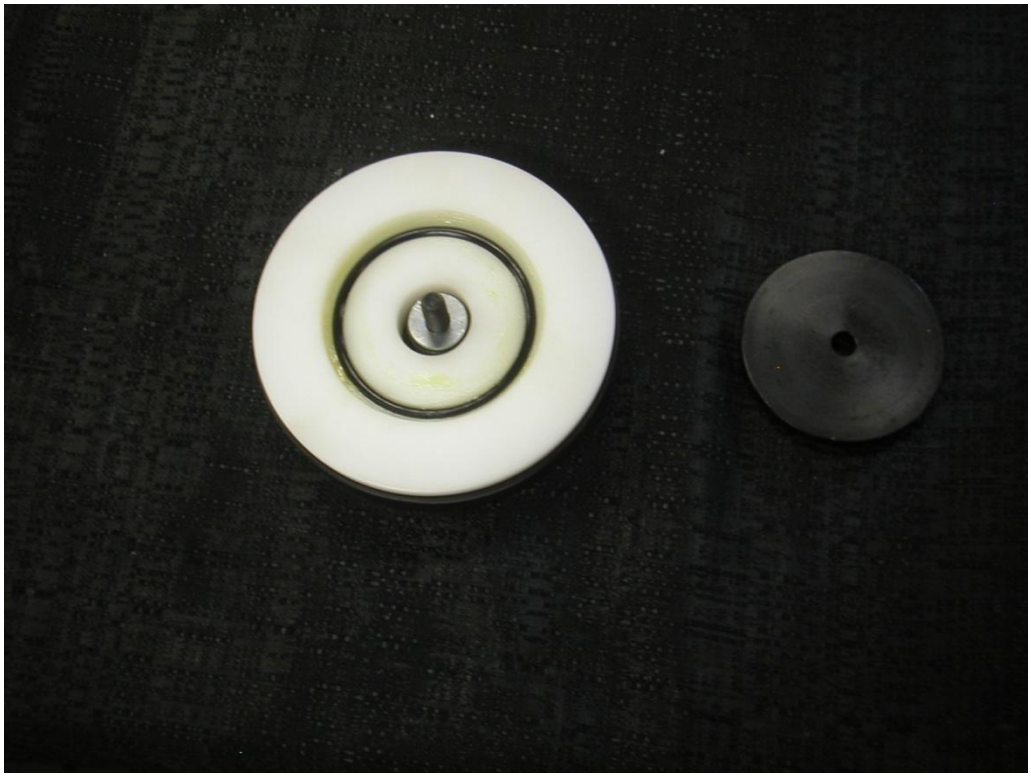
11: Push the oil cylinder tube onto the main body and tighten the main body onto the high pressure cylinder assembly.

OIL LEVEL

12: Insert the Main bearing assembly

13: Push divider onto the assembly. The side with the hole is to be facing up.

14: Assemble the air piston assembly as shown, ensure all seals are greased. Both sides of the piston have the same seals.



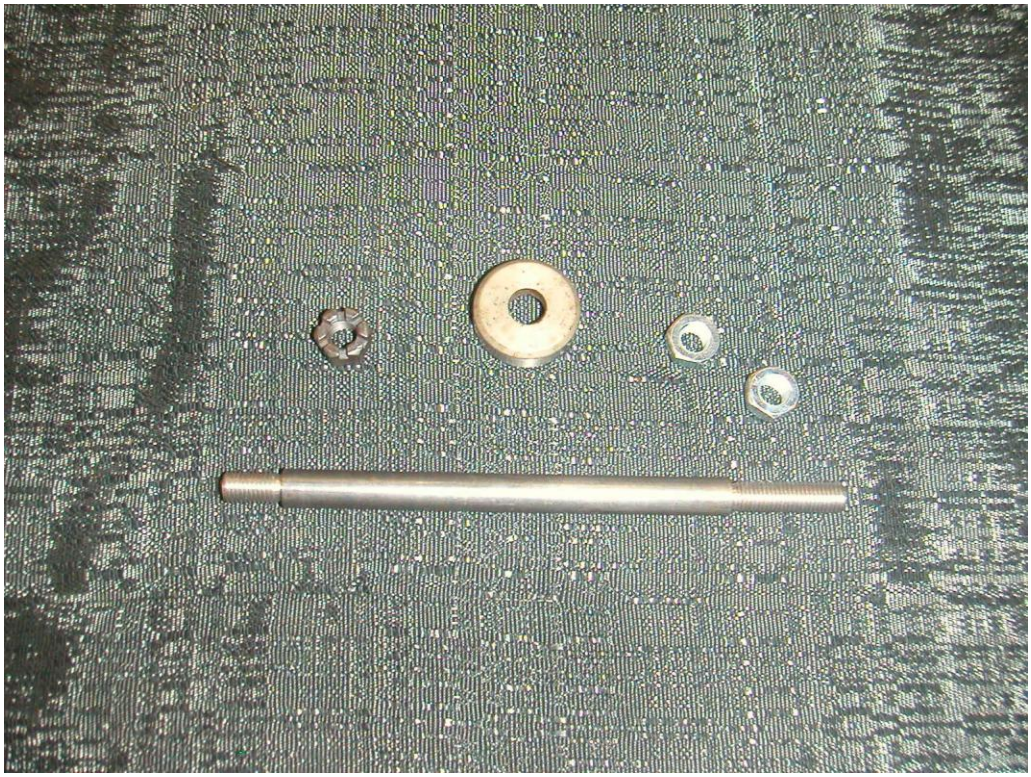
Place the piston disc on the bottom of the piston and tighten to the rod assembly using red loc-tite. The piston rod has 2 ends. One is rounded, the other is flat. The flat side goes towards the piston. Note the seal positions

15: Insert the piston rod/air piston assembly into the cylinder assembly as shown

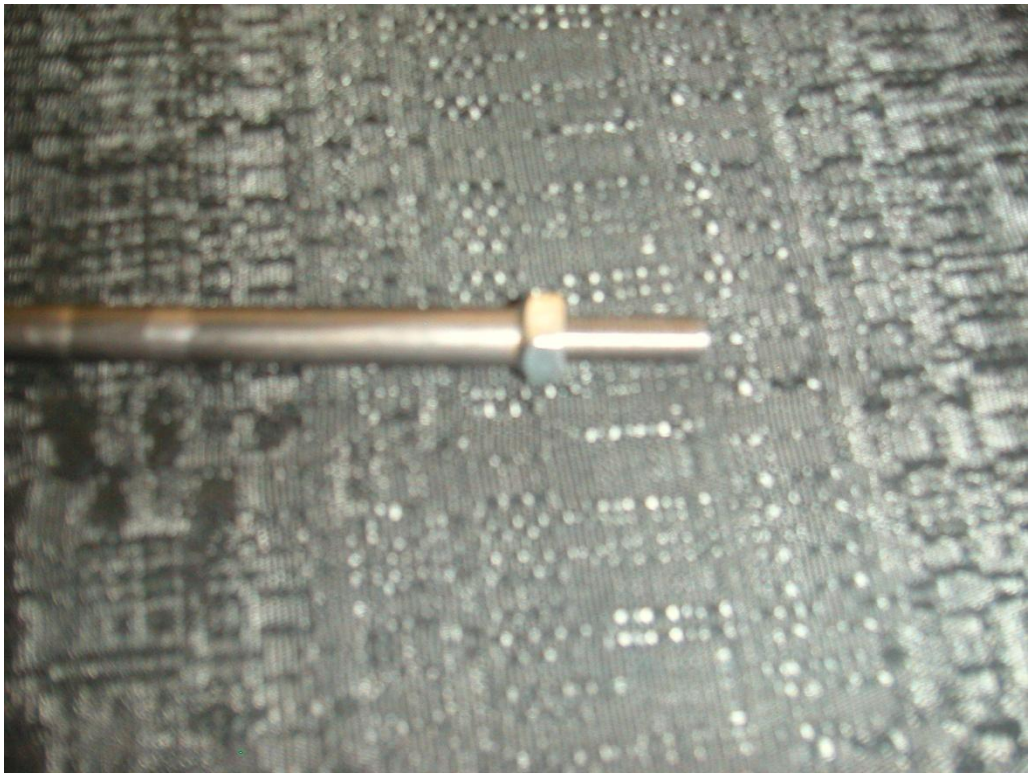
MULTICYL
CAUTION
DO NOT OVER TIGHTEN
OIL FILLER SCREW
MOUNT THIS WAY
UP FOR HORIZONTAL
OPERATION
OIL LEVEL

16: Place the cylinder assembly horizontally

17: Low pressure piston/stud assembly

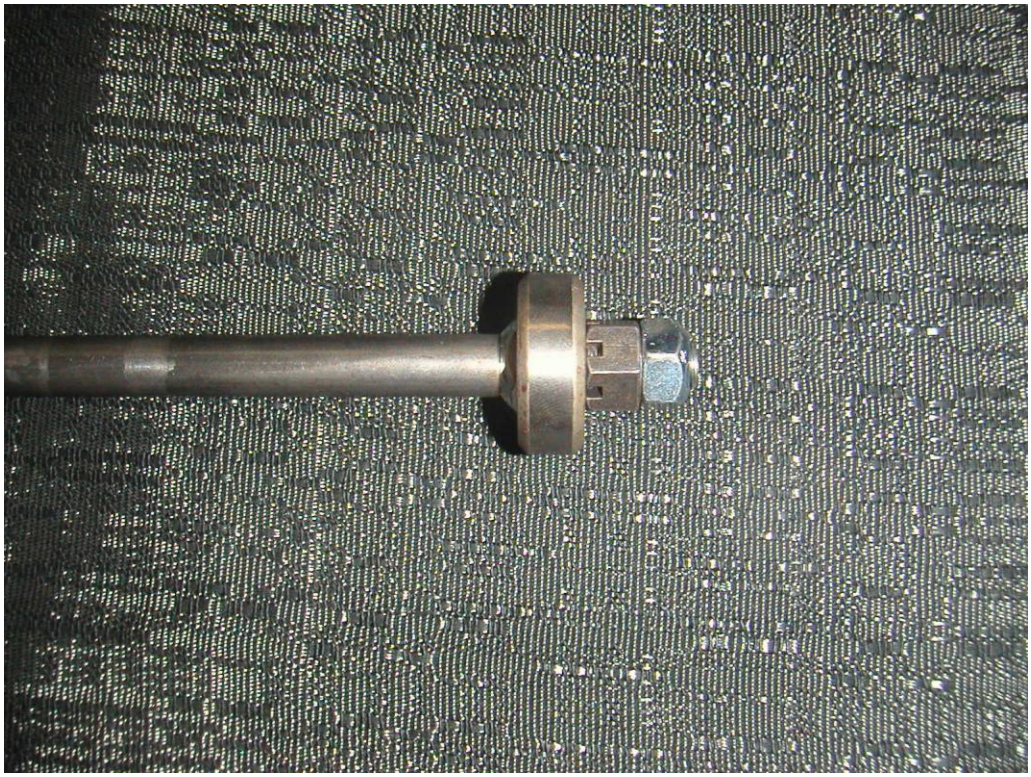


Install one of the locknuts BACKWARDS (flat side towards the thread) on the longer of the two threads.

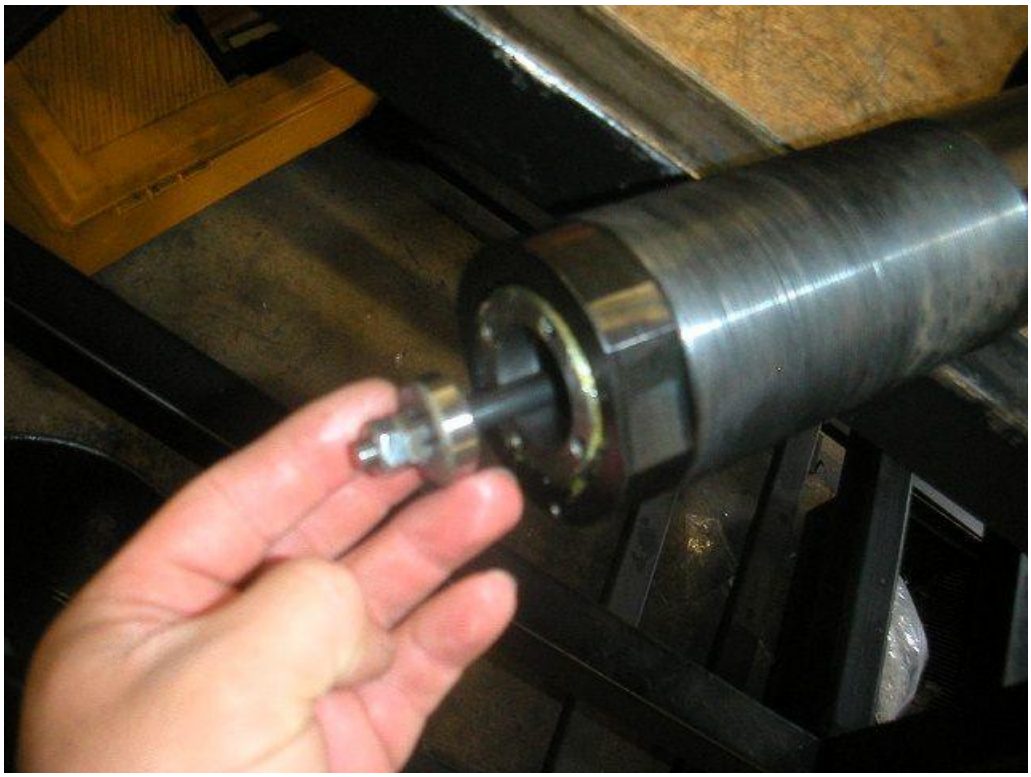


Slip low pressure piston onto the rod, recessed side towards the lock nut. Install the castellated nut, prongs towards the piston. Leave a .020” to .025” gap between the castellated nut and the piston.

Thread on the last lock nut to lock the castle nut into place



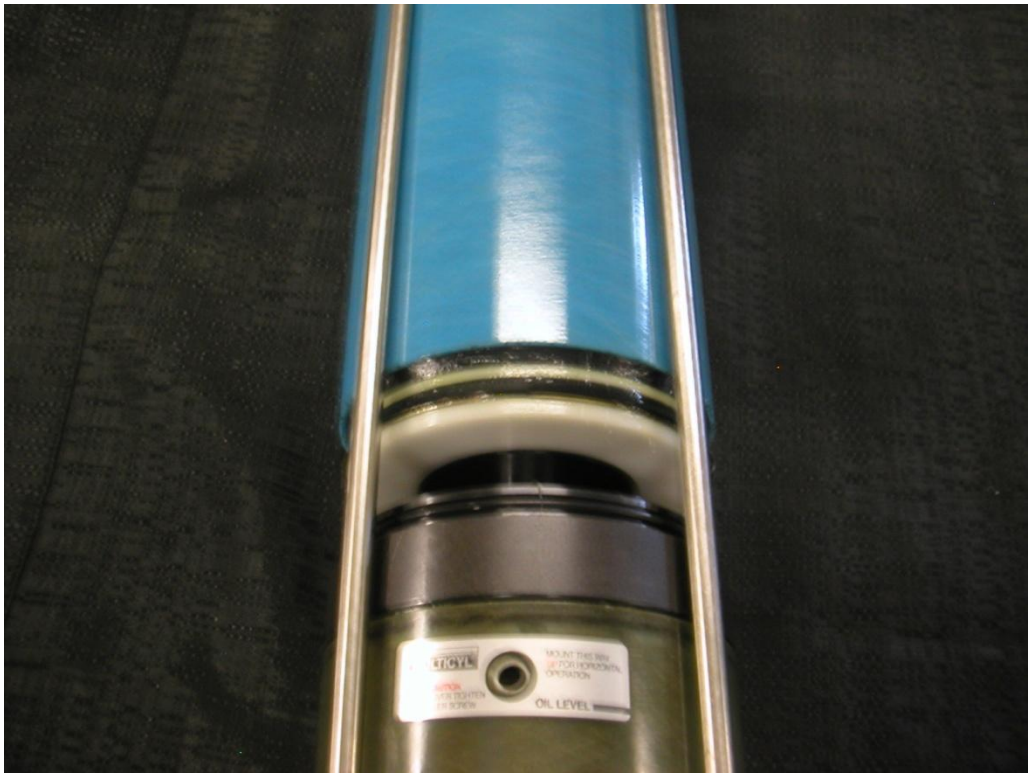
18: Thread in and tighten the low pressure stud/piston assembly using red loc-tite into the piston rod, through the bottom of the cylinder



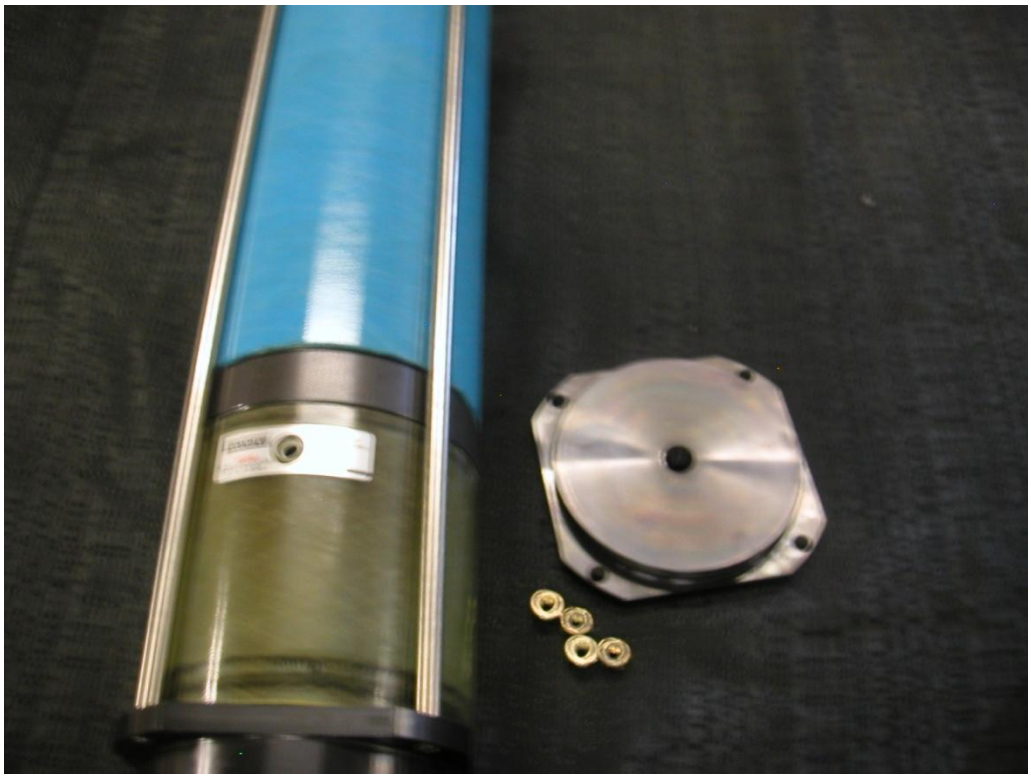
BAKERLUBE
Seals
LOCTITE
242

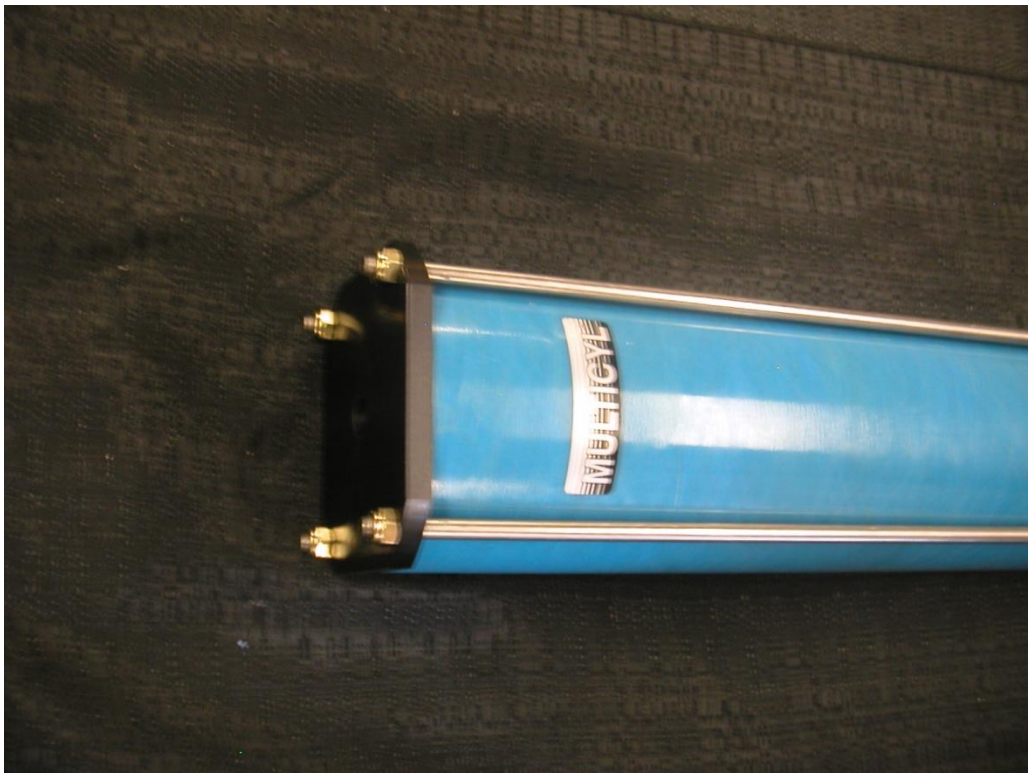
19: Install remaining o ring onto the female connector, flat seal goes on top of the o ring (towards the inside of the cylinder). Using blue loc-tite tighten the female connector onto the cylinder

20: stand cylinder up and install the air cylinder tube. Push the air piston cup seals in by and taking care not to pinch the seals or fold them backwards.



Top off assembly with the air cylinder head and tighten the 4 nylok nuts





21: fill oil reservoir with oil. Take short strokes with the cylinder to bleed the air out the bottom chamber. Oil in reservoir should be getting lower. Top up oil as necessary.