

# INSTRUCTION SHEET

INCLUDING: OPERATION, INSTALLATION & MAINTENANCE

RELEASED: 7-92  
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(REV. C)

## BUSHING INSTALLATION (FOR 38 and 39 SERIES CYLINDERS)

**⚠ CAUTION** BE SURE TO FOLLOW ASSEMBLY INSTRUCTIONS CAREFULLY. IMPROPER ASSEMBLY MAY CAUSE CYLINDER TO MALFUNCTION AND / OR CYLINDER ROD TO DISENGAGE WHICH COULD RESULT IN PROPERTY DAMAGE AND / OR PERSONAL INJURY.

- A. Apply Loctite 222 in two equally spaced 1/16 wide radial beads on the outside threads of the bushing.
- B. Torque bushing to 2 - 3 ft lbs (2.7 - 4.1 Nm).

NOTE: DO NOT PRE-ASSEMBLE BUSHINGS TO HEADS. Install bushings in head just prior to assembly of each unit. Bushing can be backed up 1/2 turn maximum within 3 minutes of installing bushing in head to free rod binding.

- C. Allow assembled components to cure for 10 minutes before handling or further assembly. Full cure will be complete within 24 hours.

NOTE: Avoid contact with fluids and do not apply load until fully cured.

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