

Number One In Fluitronic Elevator Components

Assembly Instructions for Multiple Piece Single Stage Jack



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Table of Contents

S4.1.4 PRE-ASSEMBLY OF JOINTED JACK.....	3
S4.1.5 ASSEMBLY OF JOINTED CYLINDER (Piston Diameter 70-110mm).....	4
S4.1.6 ASSEMBLY OF JOINTED CYLINDER (Piston Diameter 120-150mm)	5

This document is for information purposes only. We reserve the right to modify the reported specifications, in any parts, without notice. The printed drawings are informational only, and there might be differences with the actual product.

S4.1.4 PRE-ASSEMBLY OF JOINTED JACK

1. Carefully remove the piston from both the top and bottom cylinders. Make sure that all pistons, cylinders and components are kept from damage, loss or contamination.

ASSEMBLY OF JOINTED CYLINDER

1. The bottom section may have to be supported with a V block in order to tighten the two sections together. (See the following cylinder joint installation instructions. For Jacks with piston diameters of 70mm-110mm see data sheet S4.1.5. For piston diameters of 120mm-150mm see data sheet S4.1.6.)

ASSEMBLY OF JOINTED PISTON

1. Pick up pistons, remove o-ring and clean both male and female threads with a non-residual solvent. Examine both threads for damage.
2. Pick up bottom piston and lower into cylinder. Hold in position using a wood b v-block. Be careful not to damage the edge of the piston (joint end).
3. Refit the o-ring onto the male thread, apply Loctite and thread the top piston into the bottom piston until the painted lines marked on the piston joint match up.
4. Polish the joint smooth as required.
5. Support the piston, remove the v-block and lower into cylinder.
6. Fit gland seals and Flange.

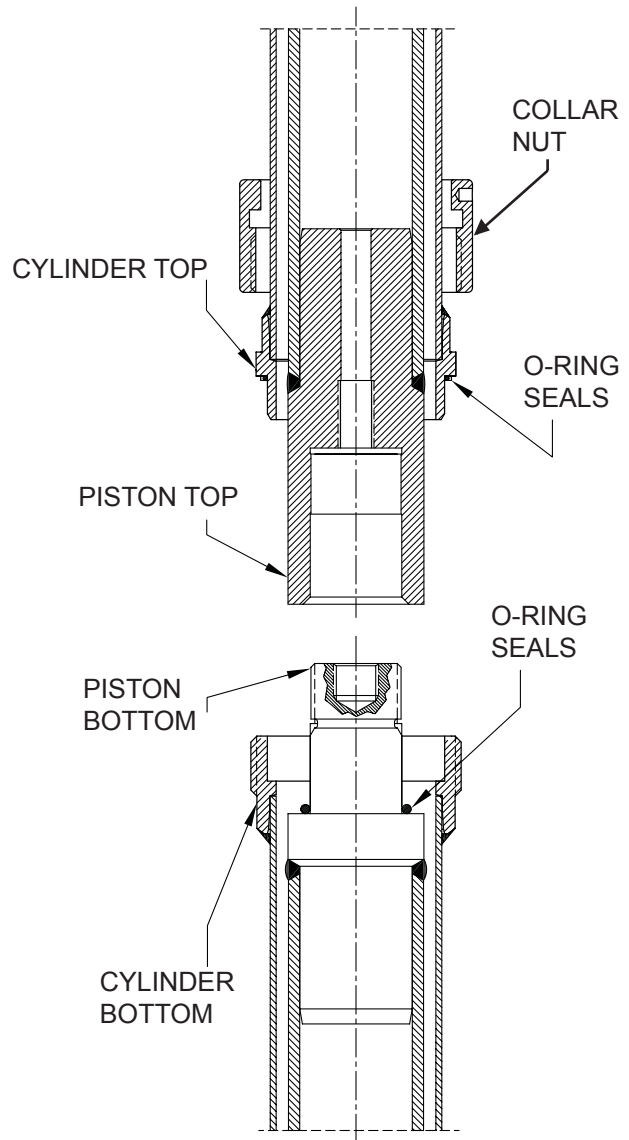
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S4.1.5 ASSEMBLY OF JOINTED CYLINDER (Piston Diameter 70mm-110mm)

INSTALLATION INSTRUCTIONS

NOTE: ALL THREADED JOINTS SUPPLIED BY OLS DO NOT REQUIRE WELDING.

1. Remove o-ring from male section.
2. Clean threads with non-residual solvent.
3. Re-fit O-ring.
4. Apply small amount of grease to O-ring only.
5. Slide male joint into female joint, making sure markings on cylinder are in line.
6. Apply loctite to male thread.
7. Screw collar nut down and tighten with spanner wrench (see table below). Make sure punch marks and markings on joints are in line.



SPANNER WRENCHES

PISTON \varnothing (mm/in.)	JOINT \varnothing (mm/in.)	WRENCH SIZE (mm/in.)
70/2.76	142/5.59	135-145/5.32-5.71
80/3.15	142/5.59	135-145/5.32-5.71
90/3.54	155/6.10	155-165/6.10-6.50
100/3.94	170/6.69	155-165/6.10-6.50
110/4.33	195/7.67	180-195/7.09-7.68

S4.1.6 ASSEMBLY OF JOINTED CYLINDER (Piston Diameter 120mm-150mm)

INSTALLATION INSTRUCTIONS

NOTE: ALL THREADED JOINTS SUPPLIED BY OLS DO NOT REQUIRE WELDING.

1. Remove o-ring from male section.
2. Clean threads with non-residual solvent.
3. Re-fit O-ring.
4. Apply small amount of grease to O-ring only.
5. Slide male joint into female joint.
6. Apply loctite to male thread.
7. Screw the two sections together using a strap wrench.

