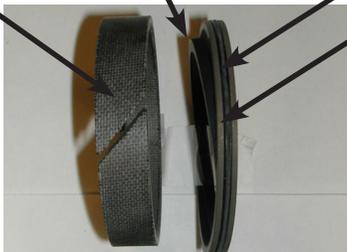
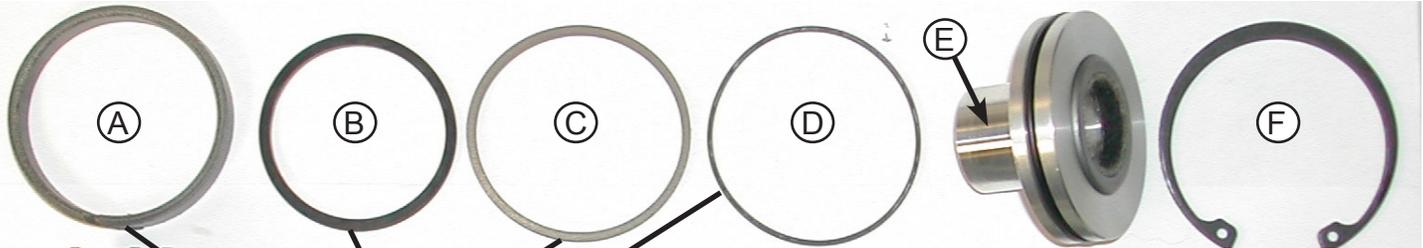


Lip Cylinder Rebuild Parts Breakdown & Instructions



Item	Description	Part Number
A	Ring, Wear, Lip Cylinder	
B,C,D	Seal, AQ, Lip Cylinder	
E	Cylinder Head Subassembly, Lip Cylinder	
F	Internal Retaining Ring, Lip Cylinder	
A-F	Lip Cylinder Rebuild Kit (pre-1992)	0525-0014
A-F	Lip Cylinder Rebuild Kit (1992-present)	0525-0059



Fig. 1

Rebuild Instructions

If cylinder is leaking hydraulic fluid from the breather, weep tube or yoke end of cylinder case, rebuilding is possible by replacing the worn seals, wear ring and cylinder head subassembly with the parts listed above.

! WARNING

Failure to observe proper removal, installation and repair instructions could result in equipment damage and/or personal injury or death.

1. See TSB#02-003 for lip cylinder removal/replacement instructions.
2. With cylinder removed from leveler, remove roll pin from yoke and remove yoke from cylinder shaft.
3. Compress cylinder head subassembly (**item E**) and remove internal retaining ring (**item F**).
4. Remove lip cylinder internal parts assembly from cylinder casing; note location of springs, spacer and washer (see **Fig. 1**).
5. Inspect inside wear surface of cylinder bore for nicks, pitting due to corrosion or other damage.*
***If damage is found, rebuilding may not be possible - Contact Systems, LLC Technical Services.**
6. If no damage is found, remove old seals and wear ring (**items A-D**) from lip cylinder assembly.
7. Replace wear ring and seals in reverse order of removal, making sure each is flat without twists or kinks.
8. Lubricate all seals and wear ring with lithium grease to prepare for installation in cylinder bore.
9. Lubricate inside wall of cylinder bore with coating of approved MIL-H-5606-G hydraulic fluid.
10. Install lip cylinder internal parts assembly in cylinder bore, carefully working rings/seals over internal ridge.
11. Lubricate and install included cylinder head subassembly (**item E**). Discard old subassembly.
12. Install retaining ring (**item F**), yoke and roll pin.
13. Install lip cylinder in dock leveler, operate leveler and check for leaks following instructions in TSB#02-003.