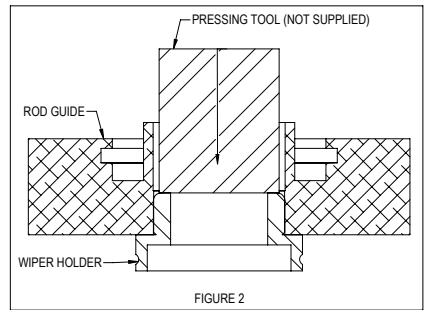
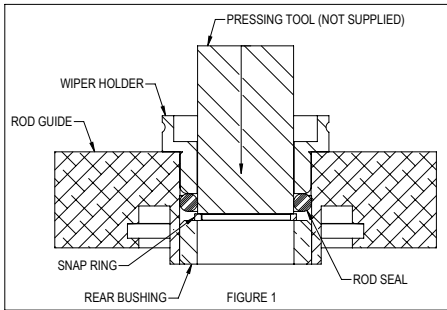
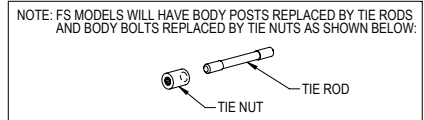
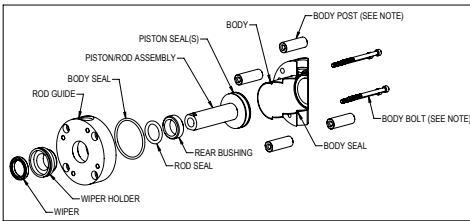




Flat-1 and Flat Square Wiper Option General Repair Instructions K-B-FO-W-□, K-B-FS-W-□

Disassembly

- 1) Using the appropriate allen wrench, remove the 4 (8 for long stroke versions) body bolts from the end cap(s). (Use extreme caution, single acting models contain springs so contents may be pressurized.)
- 2) Remove the body post from the assembly.
- 3) Remove the rod guide and rear head from the body. (Please take note of placement of spring, if applicable.)
- 4) Install provided snap ring into the rod guide (rod wiper is facing up as shown in Figure 1).
- 5) Press out bushings from rod guide and remove rod seal.
- 6) Press out wiper holder (as shown in Figure 2).
- 7) Remove body seals from rod guide and rear head.
- 8) Remove the piston seal(s) from piston/rod assembly.



(see reverse side for reassembly instructions)

Bimba Manufacturing Company
Monee, IL 60449-0068
Telephone: 708.534.8544
Fax: 708.235.2014
Email: cs@bimba.com
www.bimba.com

Form FOFSW-612
rev. 1

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Flat-1 and Flat Square Wiper Option General Repair Instructions K-B-FO-W-□, K-B-FS-W-□

Reassembly

- 1) Lightly lubricate all of the new seals.
- 2) Press new rod wiper holder into rod guide as shown in Figure 3.
- 3) Install new rod seal and press in new bushing into place as shown in Figure 4.
- 4) Press wiper into holder.
- 5) Install new piston seal(s) onto piston/rod assembly.
- 6) For spring retract models, install the spring onto the piston/rod assembly.
- 7) Install new body seal in rod guide and rear head.
- 8) Carefully install the rod guide assembly into the piston/rod assembly. (Use extreme caution, single acting models contain springs so contents may be pressurized.)
- 9) For spring extend models, install the spring back onto the piston end of the piston/rod assembly.
- 10) Install the body into the rod guide assembly. (Be careful not to damage the body seal.)
- 11) Install the rear head onto the body. (Be careful not to damage the body seal.)
- 12) For single acting models, the sub-assembly may need to be compressed with an arbor press.
- 13) Install the 4 posts back between the rod guide and the rear head.
- 14) Install the 4 (8 for long stroke versions) body bolts back into the rod guide and rear head.
- 15) Torque the bolts to the applicable values in Table 1. (See Table 2 for FS models.)

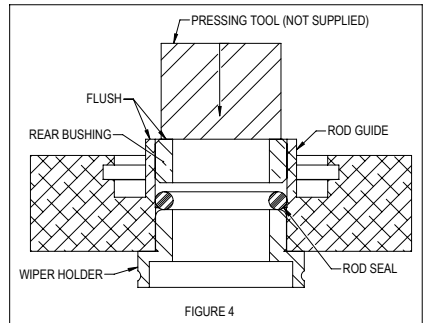
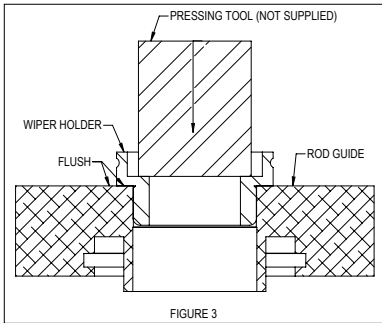


Table 1: Flat-1 Torque Specification

Bore Size	Screw Size	Torque: in-lb (ft-lb)	
		Standard	"S" Option
9/16", 3/4", 1-1/16"	#4-40	7 (.58)	3.5 (.29)
1-1/2", 2"	#10-24	35 (2.9)	19 (1.6)
2-1/2", 3"	1/4-20	90 (7.5)	41 (3.4)
4"	5/16-18	150 (12.5)	87 (7.2)

Table 2: Flat Square Torque Specification

Bore Size	Screw Size	Torque: in-lb (ft-lb)
3/4", 1-1/16"	#5-40	10 (.83)
1-1/2", 2"	.185-24	30 (2.5)
2-1/2"	1/4-28	35 (2.9)
3"	5/16-24	90 (7.5)
4"	3/8-24	150 (12.5)

(see reverse side for disassembly instructions)

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