

### DISASSEMBLY, HEAD END

Remove any plumbing from cylinder ports; wrap barrel in heavy cloth to prevent damage to barrel. Place cap end of cylinder barrel in vise. As you rotate head counter-clockwise, use a screw driver to lift end of circumflex key clear of slot (Fig. 1).

Continue rotation of head, and circumflex key will feed out of slot (Fig. 2). Gripping rod, pull forward. Head, rod and piston will come out of barrel (Fig. 4). Screw head off rod threads for ease of clearing rod packing.

### CAP END

Slide head end back in barrel to support barrel and follow same procedure as above to remove circumflex key from cap end (Fig. 3). If cylinder has been used in wet or moist external conditions for a long period, circumflex key may be corroded. If this is the case, apply penetrating oil into the lock slots prior to disassembly.

### ASSEMBLY

Replace piston (if necessary), rod packings and wiper and all static seals. Clean I.D. of tube thoroughly. Lubricate rod packings and O.D. of piston prior to assembly. To reassemble cylinder, follow above procedure, except heads will be turned clockwise after circumflex key is engaged in tang hole in circumflex groove of head. Turn clockwise until circumflex is completely into groove and cylinder port in head is aligned with port hole in barrel. To get head end over rod threads without damaging packing and wiper, wrap rod threads with tape.

**NOTE:** Lock nut must be replaced when piston is replaced (Fig. 4). Do not use old lock nut. Complete packing kits and lubricants are available for all Flairline cylinders and can be ordered from your Flairline distributor.

