

INSTRUCTION SHEET NO. 362

September, 2017

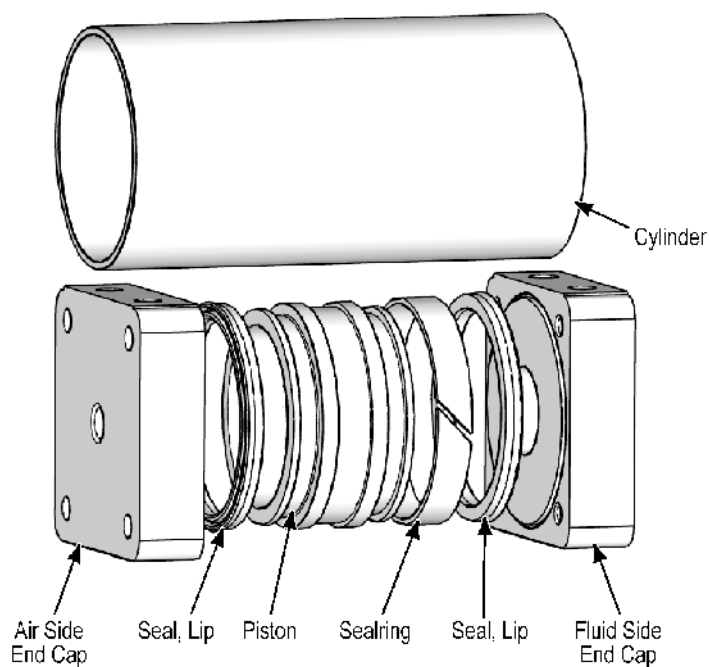
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SUBJECT: Retarder Air Accumulator-Installation of Piston and Seals

MODELS AFFECTED: All 3000/4000 Series Product Families

Accumulator Seal Kit-P/N 29535973

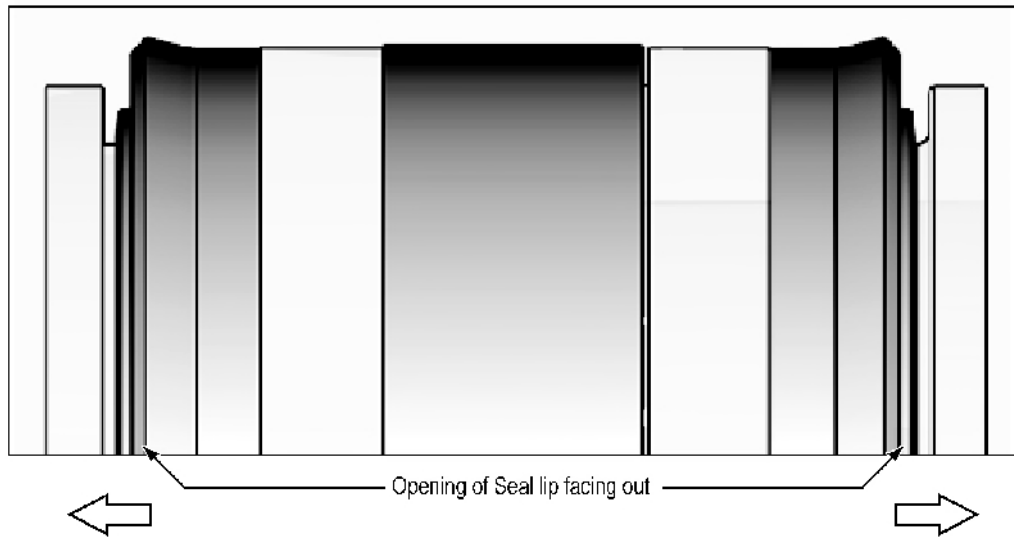
Part Number	Description	Quantity
29527008	Seal, Lip, WT	2
29527009	Ring, SLYD	1
29527010	Seal, End, WT	2
29534489	Seal End, Cap	2



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Figure 1. Parts Used to Assemble Cylinder

1. Install the piston into the cylinder bore.
2. Install the seal (taper facing inward, refer to Figure 2) on the piston (refer to Figure 3).



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Figure 2.

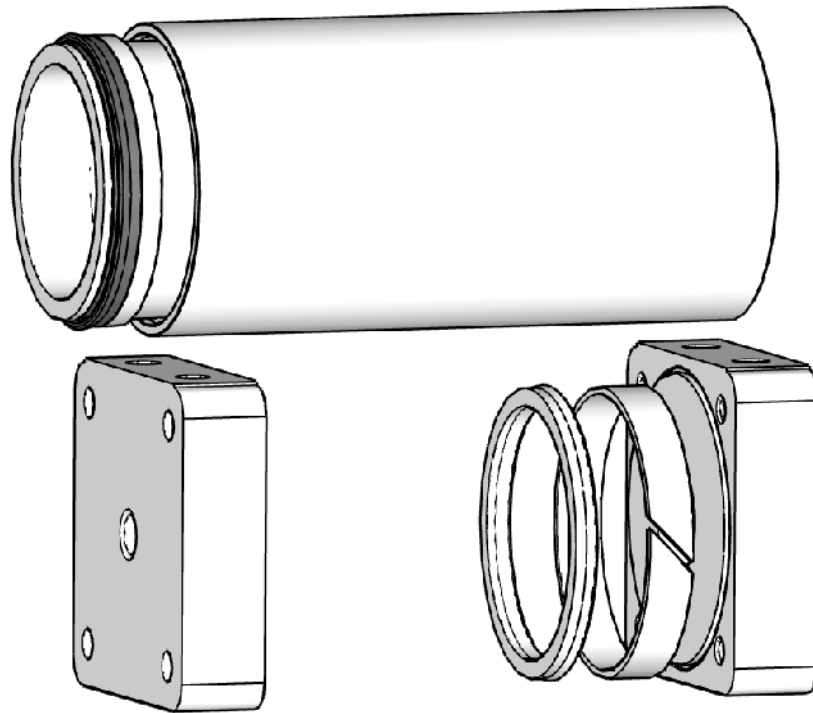


Figure 3.

3. Press the piston and seal through the bore, exposing the piston at the opposite end while leaving the first seal inside the cylinder bore. Install the second seal (taper facing inward) and seal ring (refer to Figure 4).



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Figure 4.

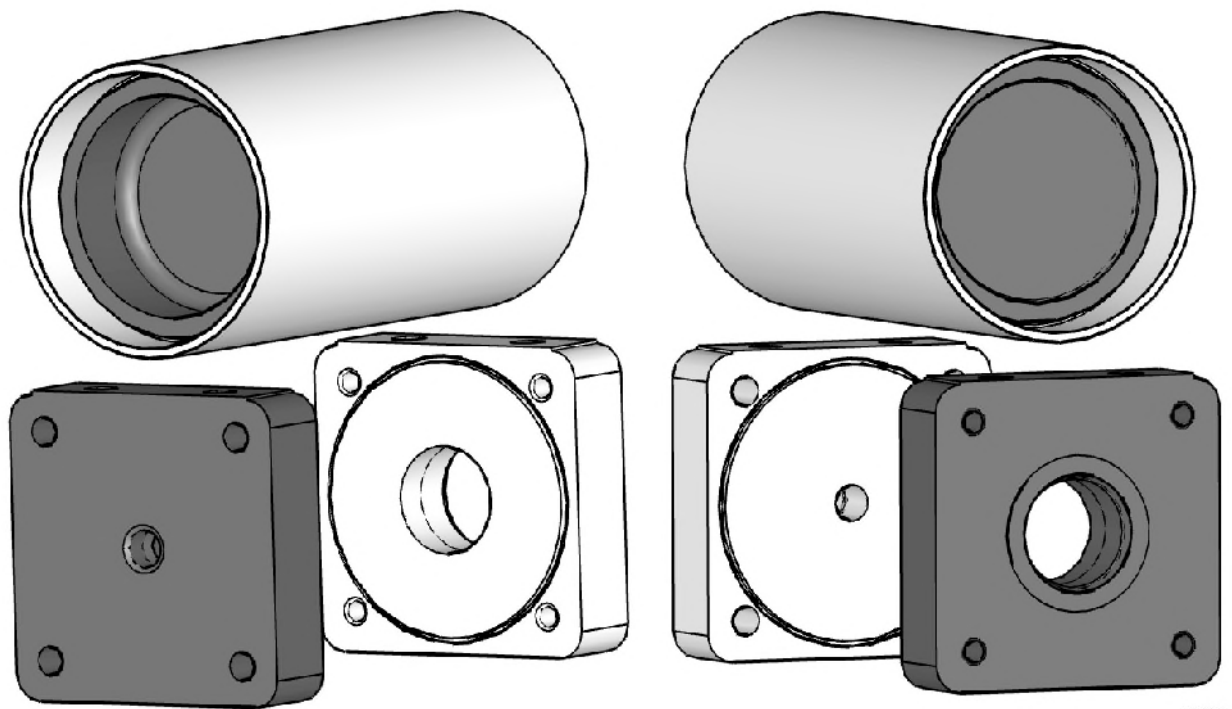
4. Press the piston assembly back into bore.



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Figure 5.

5. Install the O-ring seal inside the air side end cap. Install the air side end cap on the concave side of the piston (refer to Figure 6).



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Figure 6.

6. Install the O-ring seal inside the fluid side end cap. Install the fluid side end cap on the flat side of the piston (refer to Figure 6). Install the 4 bolts and torque the bolts to 32-36 N·m (24-27 ft-lb).