

Fig. 11A—Cross section of external steering cylinder. Refer to text.

1. Piston
2. Piston rod
3. Piston seal

4. Seal and
5. Piston rod
6. Piston seal

7. Seal
8. Piston rod
9. Seal

10. Seal and
11. Piston rod
12. Seal

13. Seal
14. Piston rod
15. Seal

16. Seal and
17. Piston rod
18. Seal

guide (7) into cylinder until snap ring (20) is accessible and remove snap ring. Pull rod assembly out of cylinder. Inspect components for excessive wear and damage. Tighten piston retaining nut to 100-125 ft.-lbs. Lubricate all seals and wiggle prior to rod assembly installation in cylinder.

ALL OTHER MODELS. Remove the steering cylinder as outlined in paragraph 17 and preserved as follows: Remove fitting (6)—Fig. 11A) and push the rod guide (22) into cylinder tube far enough to remove snap ring (7). Use piston and rod to bump guide (22) out of cylinder. Remove cap screw or nut (27) from end of rod and remove piston (20). Guide (22) can be withdrawn from rod after piston is removed.

Carefully inspect all parts for scoring or excessive wear. Install piston rod scraper (3) with sharp edge of seal out. Install back-up ring (2) with rough side toward inside of cylinder. Install "O" ring (5) in same groove on inner side of back-up ring. Install back-up ring (20) in outer groove of piston rod guide. Position "O" ring (13) in same groove between back-up ring and inner end of rod guide. Install "O" ring (15) in outer groove of piston (20). Position sealing ring (26) in outer groove over the "O" ring. On Model 200 install "O" ring (20) and back-up ring (20) side by side with "O" ring inner piston rod. Install the two split wear rings (14) in the two outer grooves in piston. Model 200 has only one wear ring on piston.

Lubricate piston rod (8) and slide rod guide (with seal) over the rod. Install piston (20) and tighten lock nut or cap screw (27). Lubricate the cylinder bore, piston and rod guide. Slide piston and rod guide into cylinder and push rod guide into cylinder far enough to install snap ring (7).

NOTE: Port in rod guide should be in line with hole in cylinder. Bump rod guide out against snap ring with piston and install fitting (6).

Internal (Dual) Cylinders

19. R&R AND OVERHAUL. The front support resting on all tri-tyre models and some adjustable axle models is used as the steering cylinder. To remove front support, refer to paragraph 10. Remove adjustable axle, or tri-tyre pedestal from front support. Remove plug (11)—Fig. 12), screw (18A), washer (20) and shim (8). Steering shaft (1) can be removed from the bottom. Remove cylinder plugs (20) and withdraw pistons (10).

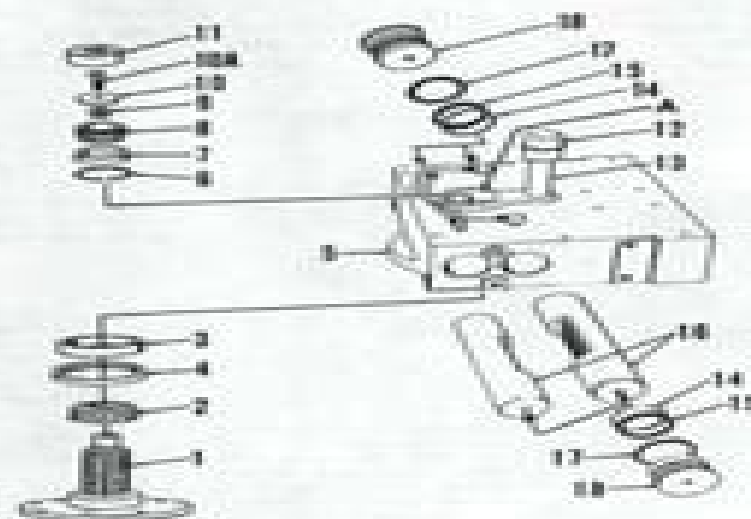
When reassembling, remove all seals. Install one back-up ring (14) and "O" ring (12) in cylinder, then insert piston (10) from opposite side of cylinder. Install a back-up ring (14) and "O" ring (12) on the other side of cylinder, then reinsert the piston.

NOTE: Make certain that nut-ways (steering portion of piston) is not pushed through new seals (12) or leakage may occur.

Install other piston and seals and align center bush of both pistons (10) with centerline of hole (1A). Install steering spindle (1) with index mark on flange returned at the rear. Steering shaft bearings (2 & 6) should be oil

Fig. 12—Exploded view of dual internal steering cylinder. Front support is used as steering cylinder.

1. Steering shaft
2. Front bearing
3. Shim
4. Washer
5. Plug
6. Rear bearing
7. Seal
8. Piston rod
9. Seal
10. Piston
11. Piston rod
12. Seal
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