

To Replace O-ring and Back-up Ring

- Step 1: Place a rag under the hydraulic hose fitting on the flow control valve mounted on top of the pump. Now, loosen the hydraulic hose fitting. You do not need to remove the hose, just loosen it to break the air lock. After the new O-ring is installed and the piston is placed back in the cylinder, **DO NOT OVERTIGHTEN THIS FITTING**. Tighten it and then run the machine. Retighten it until it stops leaking.
- Step 2: Lift the bottom platen and piston **STRAIGHT OUT** of the cylinder. If you don't keep it level, it will be very hard to get out. Turn the platen upside down, piston side up and lay it on a soft towel or rag.
- Step 3: Wipe the inside of the cylinder out with a clean rag. Look down inside the cylinder, you will see a groove cut in the side of the cylinder. With a small blade screwdriver, carefully remove the white back-up ring and black o-ring. Take a clean rag and clean out the o-ring groove.
- Take the new o-ring and back-up ring and stretch them over the piston to shape them. Leave them there for 4 or 5 minutes. Now, push the new black o-ring in place **BELOW** the white back-up ring in the same groove. Wipe the top half of the cylinder and o-ring on the inside with clean ATF oil.
- Step 4: Inspect the piston for scratches. If there are any you can buff them off with extra fine emery paper. Wipe the piston off to remove all dirt. Coat the end of the piston with ATF oil. Center it over the cylinder opening and keeping it level, re-install it into the cylinder. If you don't keep the piston level, it will be very hard to get it back inside the cylinder.
- Step 5: Retighten fitting on flow control valve. Run machine and check for leaks.
- Step 6: Call Test Mark with any questions or problems.