



#### To Protect Your Warranty, Use Only ENERPAC Hydraulic Oil.

Enerpac recommends that all kit components be installed to insure optimum performance of the repaired product.

**SERVICE INSTRUCTIONS:** These Service Instructions are intended to be used by qualified personnel at Authorized Enerpac Service Centers. Users of Enerpac equipment should see the cylinder Instruction Sheet for installation, operation, and maintenance information.

#### YOU MAY NEED:

- cylinder repair kit
- drill
- spanner wrench
- press capable of withstanding cylinder tonnage
- hand pump with hose
- solvent
- Enerpac hydraulic oil

#### DISASSEMBLY

Use the complete model number and date code when ordering repair parts.

1. Make sure the plunger is fully retracted.
2. Remove the coupler, inspect for damage to the threads and seals.
3. Detach the saddle from the plunger.

**IMPORTANT:** If stake marks are present, drill out the stake mark between the stop-ring threads and the cylinder internal threads. Use an appropriate sized drill. Drill only deep enough to remove stake mark. If stake marks are not present, Loctite may have been applied during production. A light application of heat to the Loctite coating may be required to loosen the stop-ring.



#### WARNING

Use extreme caution when removing the stop-ring from the cylinder base. The return spring is compressed under the stop-ring and will push the stop-ring out rapidly unless held down during disassembly.

5. Provide a downward force on top of the stop-ring to prevent the spring from forcing the stop-ring out of the cylinder base. For 60 and 100 ton cylinders, use a press to contain return spring force. While downward force is holding stop-ring, slowly unscrew the stop-ring until the threads disengage.
6. Remove the spring and plunger from the cylinder base.

**NOTE:** it may be necessary to use a hand pump to hydraulically push the plunger out of the base, especially if there is any corrosion present.

7. On recent models the tube assembly or plunger guide is removable. Remove the retaining ring and slide the tube assembly/plunger guide away from the base.
8. Remove all seals from the plunger and base. Use caution to avoid scratching any sealing surfaces.
9. Inspect the cylinder bore and plunger surfaces for deep gouges or nicks and replace if necessary.  
**NOTE:** Honing of the cylinder is not recommended because removing metal from the bore will destroy sealing capabilities. It is permissible to polish slight gouges by hand in the local area only.
10. Inspect the saddle for damage or cracks. Replace all damaged saddles.

#### ASSEMBLY

1. Use a suitable solvent to clean all parts prior to assembly.
2. Compare the new parts from the repair kit with the old parts to make sure they match.
3. Install new seals and parts provided in the repair parts kit. Refer to the repair parts sheet for the correct location of each part.
4. Lubricate the seals and the sealing surfaces with Enerpac hydraulic oil.
5. Slide the tube assembly/plunger guide into place and install the retaining ring.
6. Insert the plunger into the base.
7. Insert the spring into the base, placing it over the outside of the plunger.  
**NOTE:** If Loctite is to be used on the stop-ring apply 1 or 2 drops of a mild 200 series Loctite to the upper 3 to 4 threads.
8. Place the stop-ring on the spring while exerting a downward force on top of the stop-ring to compress the spring into the

base. Use a press for 60 and 100 ton cylinders Thread the stop-ring completely into place.

9. Install the saddle and coupler.
10. Perform the test procedure as described below before proceeding to steps 11 and 12.
11. After testing is complete, and the cylinder is determined to be in proper working order, stake the cylinder between the stop-ring and the base internal threads, if Loctite was not used.
12. Remove any illegible or damaged decals and replace.

## TEST PROCEDURE

1. Place the cylinder in a press capable of withstanding the tonnage of the cylinder being tested.
2. Advance the cylinder to 80% of its stroke and pressurize to 10,000 psi.
3. Maintain pressure and inspect for leakage.
4. Retract the cylinder, making sure the plunger retracts completely.
5. See steps 11 and 12 in ASSEMBLY section.

### Enerpac Worldwide Locations

#### Africa

ENERPAC Middle East FZE  
P.O. Box 18004  
Jebel Ali, Dubai  
United Arab Emirates  
Tel: +971 (0)4 8872686  
Fax: +971 (0)4 8872687

#### Australia

ENERPAC, Actuant Australia Ltd.  
Block V Unit 3, Regents Park Estate  
391 Park Road, Regents Park NSW 2143  
(P.O. Box 261) Australia  
Tel: +61 297 438 988  
Fax: +61 297 438 648

#### Brazil

Power Packer do Brasil Ltda.  
Rua dos Inocentes, 587  
04764-050 - Sao Paulo (SP)  
Tel: +55 11 5687 2211  
Fax: +55 11 5686 5583  
**Toll Free in Brazil:**  
Tel: 0800 891 5770  
vendabrasil@enerpac.com

#### Canada

Actuant Canada Corporation  
6615 Ordan Drive, Unit 14-15  
Mississauga, Ontario L5T 1X2  
Tel: +1 905 564 5749  
Fax: +1 905 564 0305

#### Toll Free:

Tel: +1 800 268 4987  
Fax: +1 800 461 2456

#### Technical Inquiries:

techservices@enerpac.com

#### China

Actuant China Ltd.  
1F, 269 Fute N. Road  
Waigaoqiao Free Trade Zone  
Pudong New District  
Shanghai, 200 131 China  
Tel: +86 21 5866 9099  
Fax: +86 21 5866 7156

◆ e-mail: [info@enerpac.com](mailto:info@enerpac.com)

Actuant China Ltd. (Beijing)  
709A Xin No. 2  
Diyang Building  
Dong San Huan North Rd.  
Beijing City, 100028 China  
Tel: +86 10 845 36166  
Fax: +86 10 845 36220

#### Central and Eastern Europe

ENERPAC B.V.  
Galvanistraat 115  
P.O. Box 8097, 6710 AB Ede  
The Netherlands  
Tel: +31 318 535 936  
Fax: +31 318 535 951

#### France

ENERPAC  
Une division de ACTUANT France s.a.  
B.P. 200  
Parc d'Activités  
du Moulin de Massy  
F-91882 Massy CEDEX France  
Tel: +33 1 601 368 68  
Fax: +33 1 692 037 50

#### Germany, Austria, Switzerland, Russia, Greece and CIS (excl. Caspian Sea Countries)

ENERPAC Applied Power GmbH  
P.O. Box 300113  
D-40401 Düsseldorf  
Germany  
Tel: +49 211 471 490  
Fax: +49 211 471 49 28

#### India

ENERPAC Hydraulics (India) Pvt. Ltd.  
Office No. 9,10 & 11,  
Plot No. 56, Monarch Plaza,  
Sector 11, C.B.D. Belapur  
Navi Mumbai 400614, India  
Tel: +91 22 2756 6090  
Tel: +91 22 2756 6091  
Fax: +91 22 2756 6095

#### Italy

ENERPAC S.p.A.  
Via Canova 4  
20094 Corsico (Milano)  
Tel: +39 02 4861 111  
Fax: +39 02 4860 1288

#### Japan

Applied Power Japan Ltd.  
1-1-11, Shimomae  
Toda-shi  
Saitama Pref.  
Japan 335-0016  
Tel: +81 484 30 1055  
Fax: +81 484 30 1066

#### The Netherlands, Belgium, Luxembourg, Sweden, Denmark, Norway, Finland, Baltic States

ENERPAC B.V.  
Galvanistraat 115  
P.O. Box 8097, 6710 AB Ede  
The Netherlands  
Tel: +31 318 535 911  
Fax: +31 318 525 613  
+31 318 535 848

#### Technical Inquiries Europe:

techsupport.europe@enerpac.com

#### Singapore

Enerpac Asia Pte. Ltd.  
25 Serangoon North Ave. 5  
#03-01 Keppel Digihub  
Singapore 554914  
Thomson Road  
P.O. Box 114  
Singapore 915704  
Tel: +65 64 84 5108, +65 64 84 3737  
1800 363 7722  
Fax: +65 64 84 5669

#### Technical Inquiries:

sales@enerpac.com.sg

#### South Korea

Actuant Korea Ltd.  
3Ba 717, Shihwa Industrial Complex,  
Jungwang-Dong, Shihung-Shi, Kyunggi-Do  
Republic of Korea 429-450  
Tel: +82 31 434 4506  
Fax: +82 31 434 4507

◆ internet: [www.enerpac.com](http://www.enerpac.com)

#### Spain, Portugal

ENERPAC  
C/San José Artesano 8  
Pol. Ind.  
28108 Alcobendas  
(Madrid) Spain  
Tel: +34 91 661 11 25  
Fax: +34 91 661 47 89

#### Middle East, Turkey, Caspian Sea

ENERPAC Middle East FZE  
P.O. Box 18004  
Jebel Ali, Dubai  
United Arab Emirates  
Tel: +971 (0)4 8872686  
Fax: +971 (0)4 8872687

#### United Kingdom, Ireland

ENERPAC Ltd., P.O. Box 33  
New Romney, TN28 8QF  
United Kingdom  
Tel: +44 1527 598 900  
Fax: +44 1527 585 500

#### USA, Latin America and Caribbean

ENERPAC  
P.O. Box 3241  
6100 N. Baker Road  
Milwaukee, WI 53209 USA  
Tel: +1 262 781 6600  
Fax: +1 262 783 9562

#### User inquiries:

+1 800 433 2766

#### Distributor inquiries/orders:

+1 800 558 0530

#### Technical Inquiries:

techservices@enerpac.com

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For your nearest authorized Enerpac Service Center, visit us at [www.enerpac.com](http://www.enerpac.com)