

SEAL KIT# HP4600 for use with BayStar Compact Cylinders: HC4645H, HC4647H, HC4648H & HC4658H

Installation Instructions

NOTICE

Discard Old Socket Screws. New screws are provided in this seal kit. **DO NOT USE OLD SCREWS**

CAUTION

After removing cap screws there will be a small amount of debris on the screws. Ensure that any loose debris is removed from inside and the face of the cylinder barrel.

- 1 To prevent as much fluid loss as possible, turn your steering wheel to hard over on the gland side that you are working on, i.e. Port side gland, turn steering wheel to port side.
- 2 Disconnect tubing from cylinder fitting and remove fittings from end gland.
- 3 Loosen the two socket cap screws securing the gland to the cylinder barrel (Item 1) using a 5/32" Allen Driver. **DO NOT** remove the screws at this time. Use a 5/8" box-end wrench to hold the cylinder rod nut that is on the same end as the gland that is being removed.
- 4 Remove the piston rod nut (item 3) and washer (item 4), and the support rod nut (item 6). Use a wrench on the opposite side piston nut to keep the rod from rotating.
- 5 Remove the two socket cap screws (item 1) securing the gland to the cylinder.
- 6 Slide the gland off of the piston rod. A small amount of fluid will leak out at this time.
- 7 Place Gland seal guide (item 5) onto the cylinder rod as shown in figure A, and lubricate with oil or grease.
- 8 Slide new gland over the seal guide and push into the cylinder barrel, taking care **NOT** to damage the new O'rings.
- 9 Install new socket cap screws (item 1) and hand tighten **ONLY**.
- 10 Reconnect the support rod, washers, and nuts.
- 11 Tighten the support rod nut (item 6) and piston rod nut (item 3)
- 12 Tighten the two NEW gland cap screws and torque to 60 in lb.
- 13 Apply a Teflon based pipe sealant to the fitting threads that will be screwed into the gland. **DO NOT** use Teflon tape. Tighten fitting to 7 ft. lb, then tighten the fitting to your desired orientation.
- 14 Repeat steps 1 – 13 for the opposite side gland.
- 15 Bleed Hydraulic system as per your bleeding instructions in the BayStar Steering Installation Manual number 19.

