

## **INSTRUCTION# 6478**

### **INSTALLATION OF GTP-9657 AIR CYLINDER ASSEMBLY SERVICE KIT.**

**NOVEMBER 12, 2021**

**NOTE: FOR BEST PERFORMANCE, ALL ITEMS WITHIN THIS SERVICE KIT MUST BE USED.**

**TOOLS REQUIRED: 1. PICK 2. 5/32" HEX KEY 3. GTP-9424 THREAD SEALANT (SUPPLIED)**

#### **DISASSEMBLY**

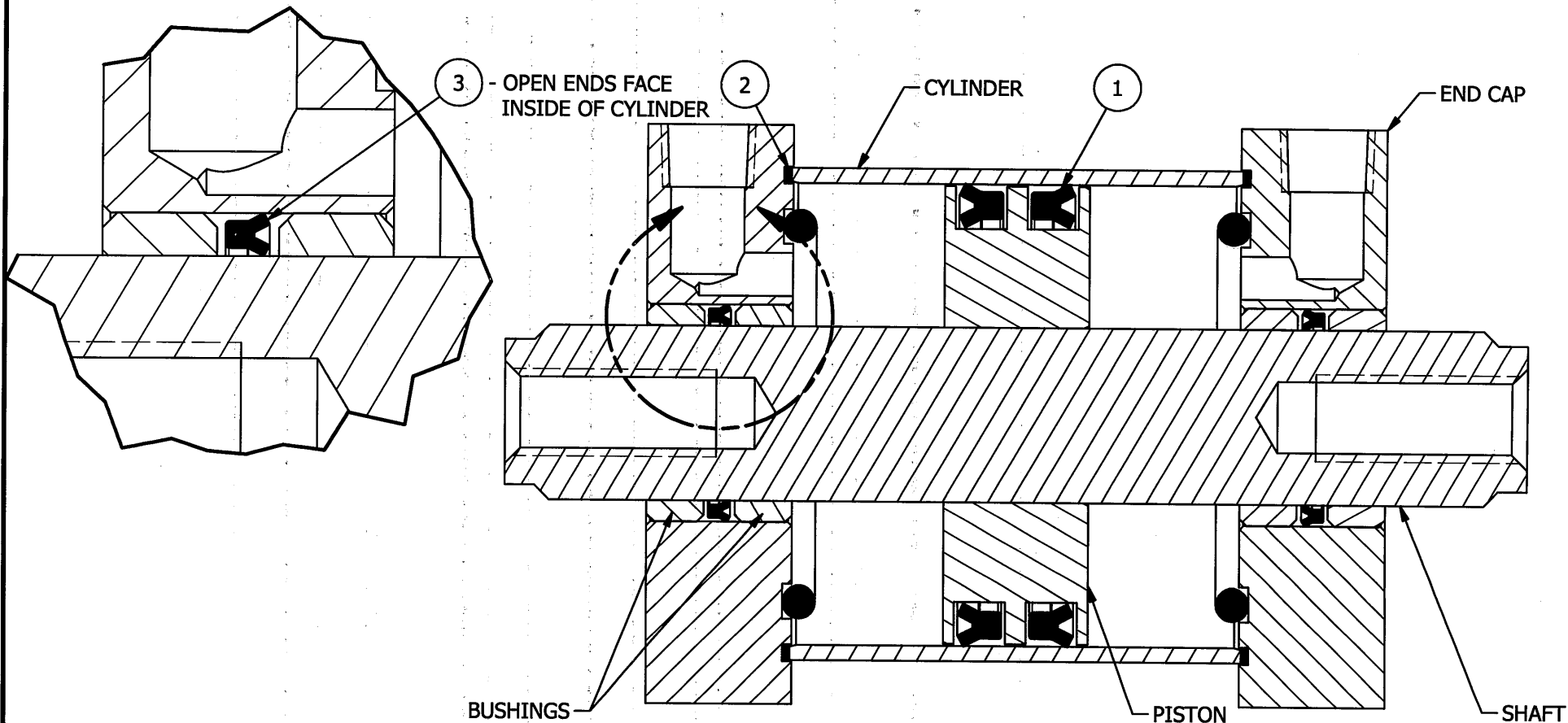
- 1. REVIEW THE DRAWING ON THE NEXT PAGE.**
- 2. WITH A PERMANENT MARKER, MARK THE END OF THE SHAFT ON THE SIDE OF THE CYLINDER WITH THE CAP ETCHED GTP-9657.**
- 3. CAREFULLY REMOVE THE FOUR BOLTS WITH THE 5/32" HEX KEY. DISPOSE OF THEM.**
- 4. WHILE HOLDING THE CYLINDER, GENTLY REMOVE ONE END CAP FROM THE ASSEMBLY.**
- 5. REMOVE THE CYLINDER FROM THE OTHER END CAP.**
- 6. REMOVE THE PISTON AND SHAFT ASSEMBLY FROM THE CYLINDER.**
- 7. REMOVE THE TWO SEALS FROM THE PISTON. USE THE PICK TO ASSIST WITH THIS IF NEEDED.**
- 8. USING THE PICK, REMOVE THE SEAL THAT IS BETWEEN THE TWO BUSHINGS IN EACH END CAP.  
BE CAREFUL TO NOT GOUGE THE BUSHINGS.**
- 9. REMOVE THE VEGETABLE FIBER GASKETS IN THE OUTER GROOVE OF EACH END CAP.**

#### **INSTALLATION**

- 1. INSTALLATION IS REVERSE OF ABOVE.**
- 2. ENSURE THE PISTON AND ROD SEALS ARE PLACED IN THE DIRECTION AS INDICATED ON THE DRAWING IN THE NEXT PAGE.**
- 3. LIGHTLY LUBRICATE ALL MOVING PARTS WITH VASELINE PRIOR TO ASSEMBLY.**
- 4. THE MARKED END OF PISTON SHAFT ASSEMBLY MUST BE INSTALLED IN THE END CAP ETCHED GTP-9657.**
- 5. PLACE A FEW DROPS OF GTP-9424 THREAD SEALANT ON EACH OF THE THREADS OF THE FOUR BOLTS PRIOR TO ASSEMBLY.**
- 6. AFTER ASSEMBLY IS TOGETHER, TIGHTEN EACH OF THE FOUR BOLTS IN A CRISS-CROSS PATTERN UNTIL THEY REACH 40 IN/LBS.**
- 7. ENSURE THE SHAFT CAN MOVE BACK AND FORTH WITH VERY LITTLE EFFORT.**

# PARTS LIST

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	GTP-9657-16	PISTON SEAL
2	2	GTP-9657-17G	GASKET
3	2	GTP-9657-18	ROD SEAL



UNLESS OTHERWISE SPECIFIED:  
BREAK ALL SHARP EDGES  
DIMENSIONS ARE IN INCHES  
TOLERANCES:

FRACTIONAL:  $\pm 1/32$   
DECIMAL:  $X.X \pm .05$   
 $X.XX \pm .01$   
 $X.XXX \pm .005$

ANGULAR:  $\pm 1^\circ$   
FINISH: 125 Ra

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FOR GTP-9657 AIR CYLINDER

SIZE	CAGE CODE	DWG NO	REV
A	32218	GTP-9657-INSTRUCTIONS	0

DRAWN	10/27/2021	SCALE	1:1	MATERIAL	SHEET 1 OF 1
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