



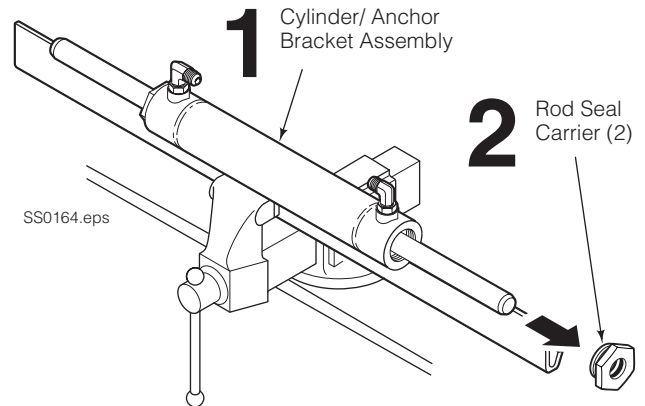
Installation Instructions

F-Series Sideshifter Cylinder Rod Seal Service Kits 219868 (55F & 66F) and 6091229 (100F)

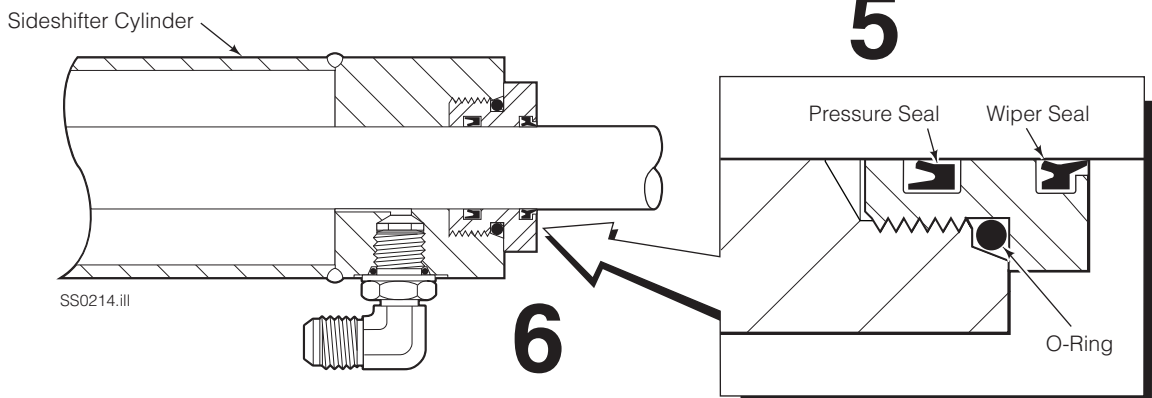
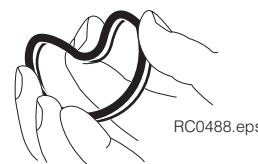
This sheet provides instructions to install new cylinder rod seals. **NOTE:** The Sideshifter must be removed from the truck, and the cylinder removed from the Sideshifter for this procedure. Refer to Service Manual 220526.

Rod Seal Replacement

- 1 Clamp the cylinder/anchor bracket in a soft-jawed vise. **CAUTION:** Do not clamp on the cylinder shell.
- 2 With the cylinder rod centered, unscrew the seal carriers from each of the cylinder retainers. Slide the seal carriers off the cylinder rod. **NOTE:** If installing new seal carriers loaded with seals, proceed to Step 6.
- 3 Remove the seals and O-ring by prying them out with a brass O-ring tool. **CAUTION:** Do not scratch the seal grooves.
- 4 Clean the seal carrier and cylinder rod with cleaning solvent. Lubricate the new seals and O-rings with petroleum jelly.
- 5 Install the seals into the seal carrier grooves. Seal install tool, Part No. 780146 is available for this procedure. If installing seals by hand, form seals into a 'kidney' shape to ease placement into the bore. **Pressure seals are installed with the lip toward the pressure side of the cylinder** (see illustration).
- 6 Apply petroleum jelly to the inside of the seal carriers and slide onto the cylinder rod. Screw the seal carriers hand tight into the cylinder retainer.
- 7 After the sideshifter is remounted on the truck, tighten the seal carriers to 120 ft.-lbs. (165 Nm).



Form seals into 'kidney' shape to install



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