GENUINE GRACO PARTS & ACCESSORIES 918110 Repair Kit



for Unidrum Ram Assembly

GRACO INFORMATION ENCLOSED

GRACO INC. / P.O. BOX 1441 / MINNEAPOLIS, MN 55440-1441 406507 Rev B April 2001. Revised 11/2007

⚠ WARNING

For detailed instructions and warnings, see manual 309169.

Piston Rod Seal Service

WARNING

To reduce the risk of serious injury, whenever you are instructed to relieve pressure, always follow the Pressure Relief Procedure (see manual 309169).

- 1. Relieve the air pressure.
- 2. Remove the four nuts and lockwashers holding the tie bar to the rods. Remove the tie bar.
- Remove the guide sleeve retaining ring by gripping the ring tab with a pair of pliers and rotating the ring out of its groove.
- 4. Remove the guide sleeve by sliding it off of the rod. Four 1/4"–20 holes are provided to ease removal of the guide sleeve.

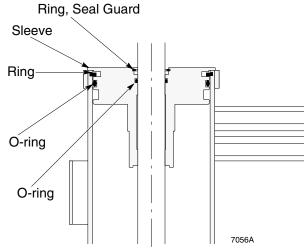
⚠ WARNING

Do not use pressurized air to remove the guide sleeve or piston. Failure to follow this instruction may result in personal injury.

Inspect the parts for wear or damage. Replace as necessary. 6. Install new O-rings and seal guard. Lubricate the packings with O-ring lubricant.

NOTE: Unmarked models and those marked Series A, B, or C use thinner (0.139) o-ring C20242. All models marked Series D or later use thicker (0.210) o-ring 121306.

- 7. Slide the guide sleeve onto the rod and push it into the cylinder. Replace the retaining ring by feeding it around the guide sleeve groove.
- 8. Reinstall the tie bar using the nuts and lockwashers. Torque to 40 ft-lb (54 N•m).





Ram Piston Service

₩ WARNING

To reduce the risk of serious injury, whenever you are instructed to relieve pressure, always follow the Pressure Relief Procedure (see manual 309169).

- 1. Relieve the air pressure.
- Remove the tie bar as explained under Piston Rod Seal Service.
- 3. Remove the guide sleeve and slide it off of the piston rod.

⚠ WARNING

Do not use pressurized air to remove the guide sleeve or piston. Failure to follow this instruction may result in personal injury.

- Carefully pull the piston rod straight up out of the cylinder. If the rod is cocked to one side, the piston or inside surfaces of the cylinder could be damaged.
- Carefully lay the piston and rod down so the rod will not be damaged or bent. Remove the lower piston retaining ring. Slide the piston off the piston rod.

- Install new O-ring seals on the piston rod and the piston. Lubricate the piston and seals. Reinstall the piston and retaining ring.
- Carefully insert the piston into the cylinder and push the rod **straight** down into the cylinder.
 Add 3 ounces of lubricant to each cylinder after inserting the piston.
- Slide the guide sleeve onto the piston rod. Reinstall the retaining ring and tie bar, as explained under **Piston Rod Seal Service**.

