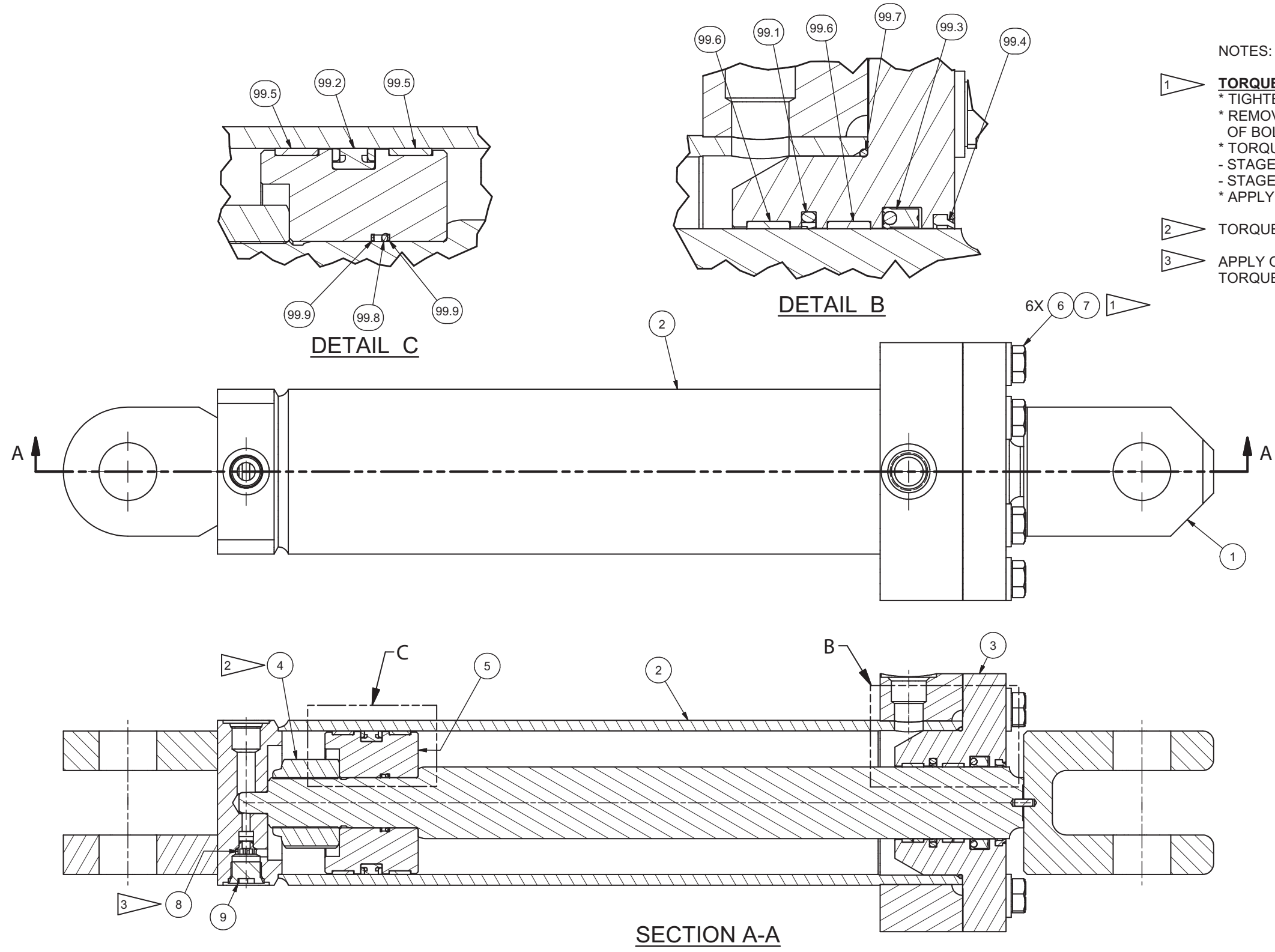


Cylinder Assembly, Steering



NOTES:

- 1 **TORQUE REQUIREMENT NOTE**
 * TIGHTEN BOLTS TO REQUIRED TORQUE VALUE (SEE 80-1057).
 * REMOVE DIRT, LOOSE SCALE, BURRS, AND PAINT FROM THE MATING SURFACES OF BOLTED JOINTS.
 * TORQUE BOLTS IN STAR PATTERN IN TWO STAGES:
 - STAGE 1 50-60% OF FULL TORQUE VALUE
 - STAGE 2 FINAL TORQUE VALUE
 * APPLY COPPER ANTI-SEIZE ASC P/N 244264 TO FASTENERS
- 2 TORQUE TO 1,400 FT-LBS WITH HYDRAULIC OIL AS LUBRICANT.
- 3 APPLY ONE DROP OF THREADLOCK PRIOR TO INSTALLATION
 TORQUE TO 1-2 FT-LBS USE 257709 INSTALLATION TOOL.

Item	Part No.	Qty	Description
603213 Cylinder Assembly, Steering			
1	603224	1	. Stem
2	603223	1	. Barrel
3	603214	1	. Gland, Cylinder
4	219929	1	. Nut
5	603227	1	. Piston
6	R13810974	6	. Capscrew
7	221777W	6	. Washer
8	257705	1	. Check Valve
9	224964	1	. Fitting
99	601114	1	. Kit, Packing
99.1	69768.0250	1	.. Seal, Buffer
99.2	69770.0500	1	.. Seal, Piston
99.3	251514	1	.. Seal
99.4	20545	1	.. Wiper Ring
99.5	70384.0500	2	.. Wear Ring, Piston
99.6	70385.0250	2	.. Wear Ring, Rod
99.7	233126	1	.. O-Ring
99.8	Y098629-224	1	.. O-Ring
99.9	227787	2	.. Backup Ring