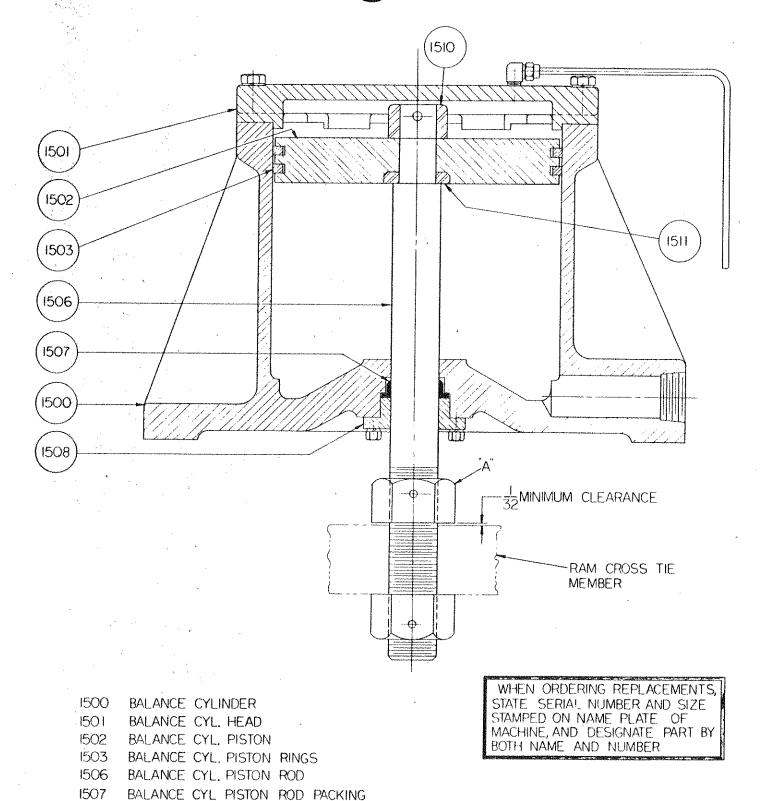
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INSTRUCTIONS FOR ASSEMBLY OF BALANCE CYLINDER

WITH THE RAM AT BOTTOM DEAD CENTER, ASSEMBLE THE BALANCE CYLINDER PISTON ROD-(1506) TO THE RAM CROSS TIE MEMBER. THE BALANCE CYLINDER PISTON-(1502) SHOULD BE POSITIONED WITH THE UPPER BALANCE CYLINDER PISTON ROD NUT AT "A" SO AS TO PROVIDE A 5/8 INCH CLEARANCE BELOW THE BALANCE CYLINDER PISTON-(1502).

WARNING:

PROVIDE A MINIMUM OF $\frac{1}{32}$ CLEARANCE BETWEEN THE BALANCE CYLINDER PISTON ROD UPPER NUT AND THE RAM CROSS TIE MEMBER.

BALANCE CYL PISTON ROD PACKING GLAND

BALANCE CYL PISTON THRUST WASHER

BALANCE CYL PISTON ROD NUT

1510