



**SL JACK LEG  
ASSEMBLIES REPLACEMENT  
INSTRUCTIONS**

**EQS-RPI-FOOT-2001 R1**



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## **SL JACK LEG ASSEMBLIES REPLACEMENT INSTRUCTIONS**

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### **SL 24, SL 18, SL 16 and SL 15 Leg Assemblies**

This assembly utilizes the 3/4" Flat Head Allen Bolt, 3/4" X 1 1/4" FHSCS - Equalizer part # 1383.

#### **Required for installation:**

- Brush and solvent to clean threads
- Blue Loctite
- 1/2" drive impact gun
- 1/2" drive X 1/2" Allen Hex socket
- Compressed air source and air blow gun

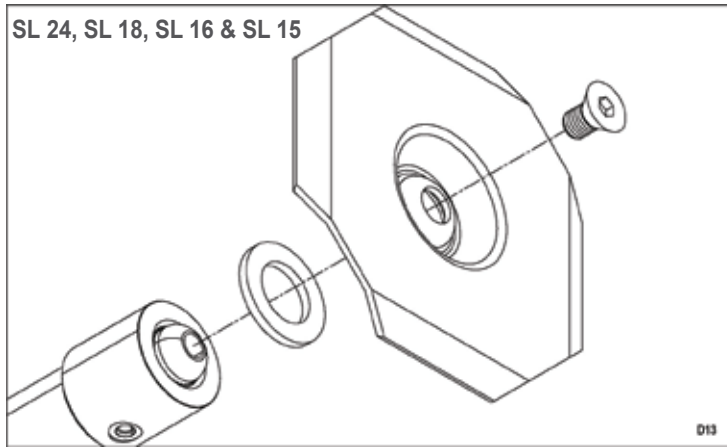
#### **Process**

1. Using solvent and brush, clean out the threaded hole in cylinder rod end (there may be grease in this threaded hole for corrosion protection during storage/shipping. This grease or corrosion protection must be cleaned out prior to installing the foot). Use compressed air to dry.
2. Apply liberally, blue Loctite to threads of cylinder rod or bolt (part # 1383).
3. Hold foot pad in place at end of cylinder rod with the cupped end to the cylinder rod.
4. Insert the bolt (part # 1383) through the hole in the center of the foot pad into the threaded end of the rod. Turn clockwise by hand to start (you may use the 1/2" Allen bit to help). Be sure that the bolt starts in straight and is not cross threaded.
5. Using the 1/2" Allen drive bit and 1/2" impact wrench/gun, tighten the bolt into the rod. Allow the impact wrench to impact/drive the bolt totally to full depth. Note that the cylinder rod will/may rotate as you do this.

#### **Notes**

When completed the foot is not intended to be tight. It is designed to pivot slightly and will be free to rotate when the cylinder is slightly extended.

- There may be a "foam" cushion or damping ring that is attached to the bottom of the cylinder body with adhesive. Its only purpose is to keep the foot from rattling when fully retracted. If it comes loose/falls it may be glued back up to the bottom of the cylinder or it may even be removed. Replacement part number for this ring on SL 15 and SL 16 is part # 1800. Replacement part number for the ring on SL 18 is part # 1799.
- Some cylinder rods may have a rubber ring around them that may stick to the rod as it is extended. This is a protection ring that is used in production to keep paint from the rod and lower seal area. It may be ignored or removed; it has no other use. Its presence, or lack of, is not a defective component.



## SL 13 Leg Assembly

This assembly uses the 3/4"-16 nylock jam nut.

Required for installation:

- 1/2" drive Impact wrench/gun
- 1/2" drive X 1 1/16" socket (6 point preferred)

## Process

1. Check/verify that the threads on the end of the cylinder rod are clean and not damaged. Use the nylock nut to check that it will thread (start) on the end of the rod. Do not fully install or tighten at this time. Remove the nut.
2. Position the hole in the middle of the foot pad over the threaded end of the rod. Start the nylock nut onto the threads by hand.
3. Using the impact wrench/gun and the 1 1/16" socket, tighten the nut onto the rod. Note that the rod may rotate as you are doing this. Tighten the nut until between 1 and 3 threads are visible past the end of the nylock nut.

## Notes

- When properly installed, if the cylinder is extended slightly, the foot should pivot slightly and will be free to rotate.

