

Repair Manual for all threaded Unic cylinders

1. Start by heating the front end of the pipe (ex. by gas burner)
2. The front end must be loosened by screwing a piston rod into the air connection in both cylinder ends (by removal, make sure that the cylinder is heated sufficiently in order to avoid damaging of the thread in the pipe and the cap).
3. Remove the piston rod with the piston.
4. Heat the rear end and place the pipe in a screw vice carefully. Remove the rear end using same process as removing the front end.
5. Remove all seals, press out the bushing in the front end using a mandrel or similar tool.
6. All parts must be cleaned. No glue is allowed on the threads of the front- and rear end. The cylinder pipe must be totally clean without perceptible scratches or other kind of damage.
7. Press the new bushing into the front end by using a mandrel or similar tool.
8. Grease the front and rear end (Nulon) before mounting the seals and mount the brake seals without using any tools. Multipurpose Grease from Würth (NSF) or similar can be used.
9. Mount the sealing ring and the wiper seal in the front end. When mounting the seals of PUR and Viton do not use any tools. By PTFE seals use a mandrel or similar tool and suitable squeezing tools.
10. Mount the large O-rings on the front- and rear end and the small O-rings on the brake screws.
11. Grease the cylinder inside.
12. Mount the piston seals on the piston and grease carefully (Nulon).
13. Press the piston and the piston rod into the cylinder pipe carefully and remove any grease from the threads of the cylinder pipe.
14. Before assembling the cylinder put on a smooth layer of e.g. threadlocker, medium strength, from Würth (NSF) or Loctite 542 on the threads of the front- and rear end. Do not use excessive force when assembling the cylinder as the thread might be damaged.
15. The cylinder is now ready for testing.

