

4. Measure distance from top of housing to top of cylinder, and note for future reference.
5. Locate short length (6"-8") of heavy gauge pipe having an inner diameter just slightly larger than the cylinder outer diameter. Slide this pipe over cylinder.
6. Wrap several layers of masking tape around top of cylinder to provide hand-hold.
7. Hold assembly so that housing is immersed in boiling water. Periodically pull assembly from water and shake in an up and down movement so that the pipe on the cylinder acts as a hammer to drive the housing from the cylinder.

SECTION III. REWORK OF HOUSING

After removing the housing from the cylinder according to Section II, preceding, rework the housing as follows:

1. Using file, milling machine, or other convenient method; cut into the forging to remove the crack and adjacent material. Cut a 1/2" radius slot to a depth as necessary, but not to exceed 7/16". All surfaces should have a gentle radius when cutting is finished. See sketch.
2. Clean the cut surfaces and check for continuation of the crack. If it is not possible to clean out cracked material without cutting below housing axle extension (7/16" max.) the housing must be replaced.

NOTE: If crack is not in the area as indicated in the sketch (forging part line) part must be replaced.

SECTION IV. RE-INSTALLATION OF HOUSING

To install reworked or new housing, proceed as follows:

1. Heat housing in boiling water, dry socket area.
2. If facilities are available chill cylinder.
3. Paint end of cylinder and housing socket with zinc chromate primer.
4. Before primer dries place cylinder 90° from old position in housing and press into position. Check cylinder length with dimension taken in step 4 of Section II, to check that cylinder is full in.