

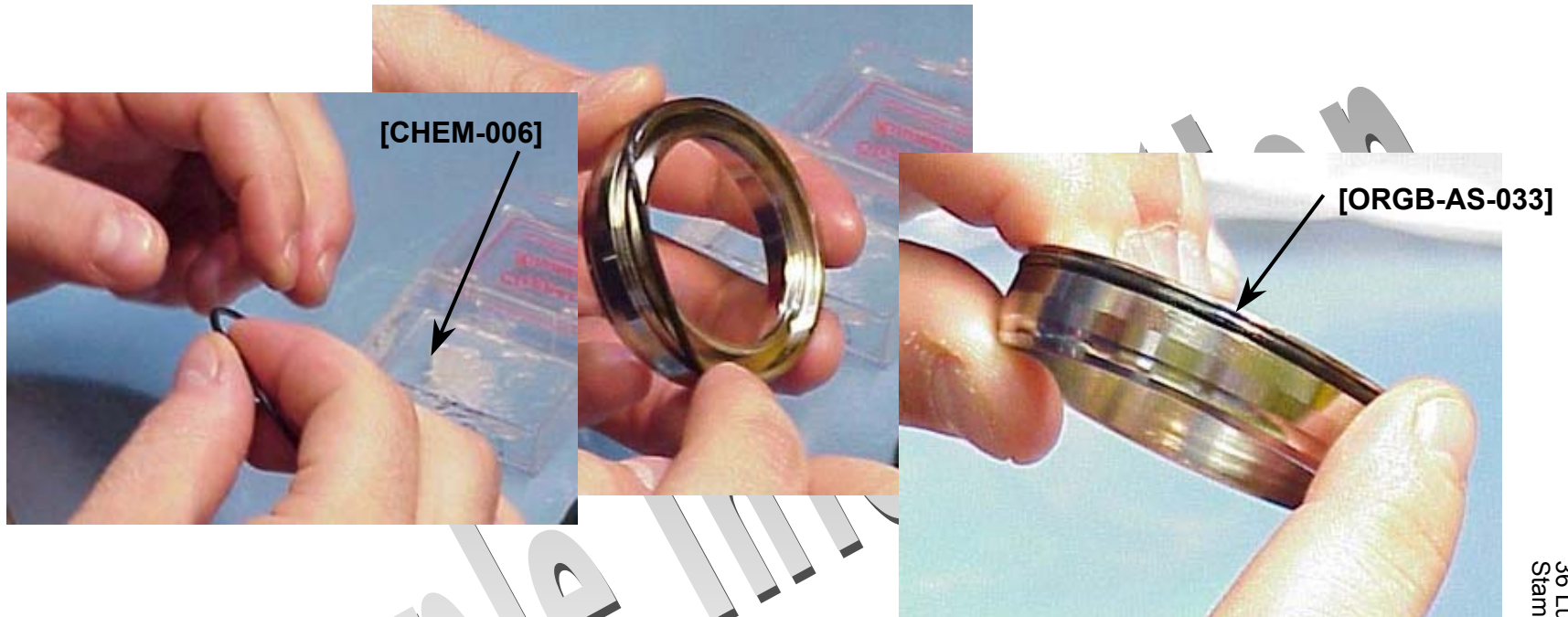
Sample Assembly Procedure

Following is an excerpt from a typical assembly procedure. Similar procedures are created for all items we assemble to ensure that the job is performed correctly and consistently regardless of the technician. Procedures are available for review by the customer.

Sample Information

New Horizon Machine Co., Inc.
36 Ludlow St.
Stamford, CT 06902

Install the Outer Piston O-Ring



- Thoroughly lubricate the o-ring [ORGB-AS-033] with a suitable Teflon® grease [CHEM-006]. Ensure the grease and your fingers are clear to avoid getting debris into the piston cavity.
- Lubricate the piston groove also. Do not pack excessive grease into the groove.
- Gently stretch the o-ring around the piston as shown.
- Verify it is seated in the groove for the entire diameter by running your finger around the seal surface.

SAMPLE INFORMATION

Proprietary Information

203-316-9355 www.newhorizonmachine.com

01/01/00 SAMPLE PART #

New Horizon Machine Co., Inc.
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Stamford, CT 06902

Install the Inner Piston O-Ring



- Thoroughly lubricate the o-ring [ORGB-AS-031] with a suitable Teflon® grease [CHEM-006]. Ensure the grease and your fingers are clean to avoid getting debris into the piston cavity.
- Lubricate the piston groove also. Do not pack excessive grease into the groove.
- Gently install the o-ring around the piston as shown.
- Verify it is seated in the groove for the entire diameter by running your finger around the seal surface. Avoid twisting the seal as you install it.

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Install the Center Module Seal



- Thoroughly lubricate the o-ring [ORGB-70-1.545] with a suitable Teflon® grease [CHEM-006]. Ensure the grease and your fingers are clean to avoid getting debris into the piston cavity.
- Lubricate the piston groove also. Do not pack excessive grease into the groove.
- Gently install the o-ring around the center module as shown.
- Verify it is seated in the groove for the entire diameter by running your finger around the seal surface. Avoid twisting the seal as you install it.

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Install the Center Module Top Seal



- Thoroughly lubricate the o-ring [ORGB-39-1.437] with a suitable Teflon® grease [CHEM-006]. Ensure the grease and your fingers are clean to avoid getting debris into the piston cavity.
- Lubricate the top edge also. Do not pack excessive grease into the edge.
- Gently install the o-ring around the center module as shown.
- Verify it is seated in the groove for the entire diameter by running your finger around the seal surface. For now, the grease will hold the seal in place.

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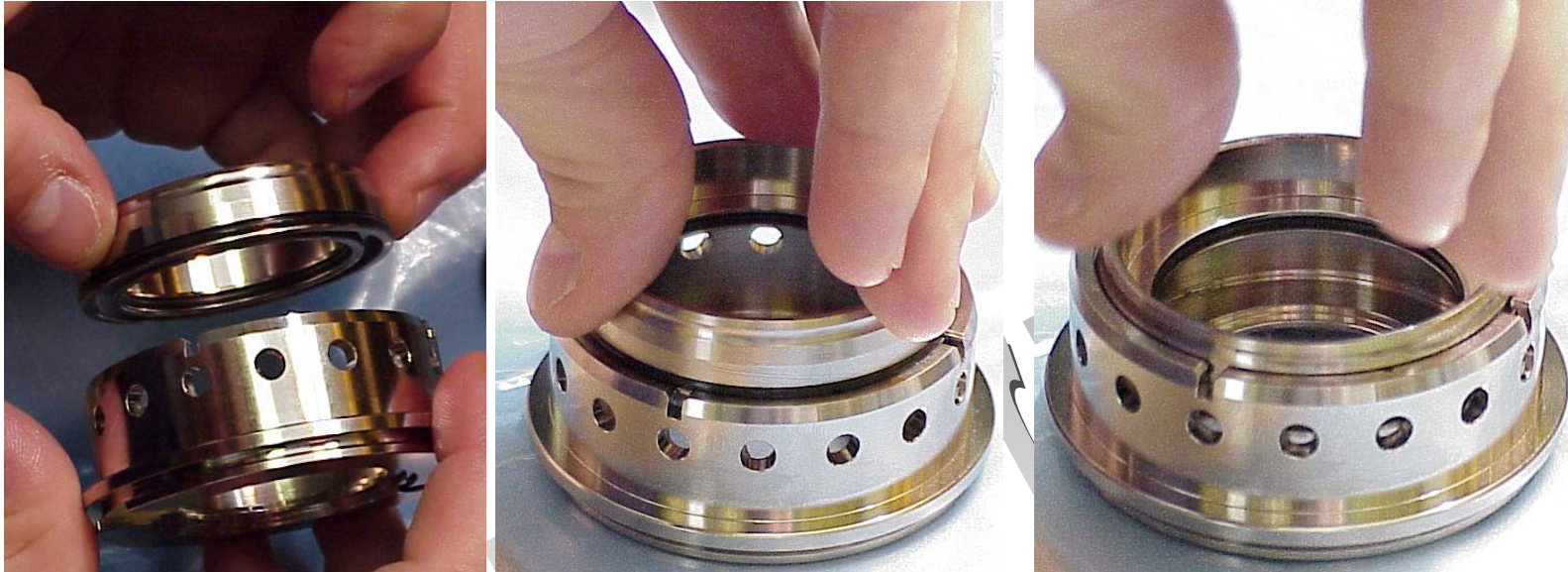
01/01/00 SAMPLE PART #

Lubricate the Inside of the Ball Retainer



- Thoroughly lubricate the inside of the ball retainer using a Teflon® based grease [CHEM-006] as shown.

Install the Piston



- Install the piston as shown. Ensure it is going in straight and not cocking.
- As the outer seal passes the ball holes be cautious to push slowly and with consistent force to avoid catching the o-ring.
- Push the piston in fully until it bottoms.

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