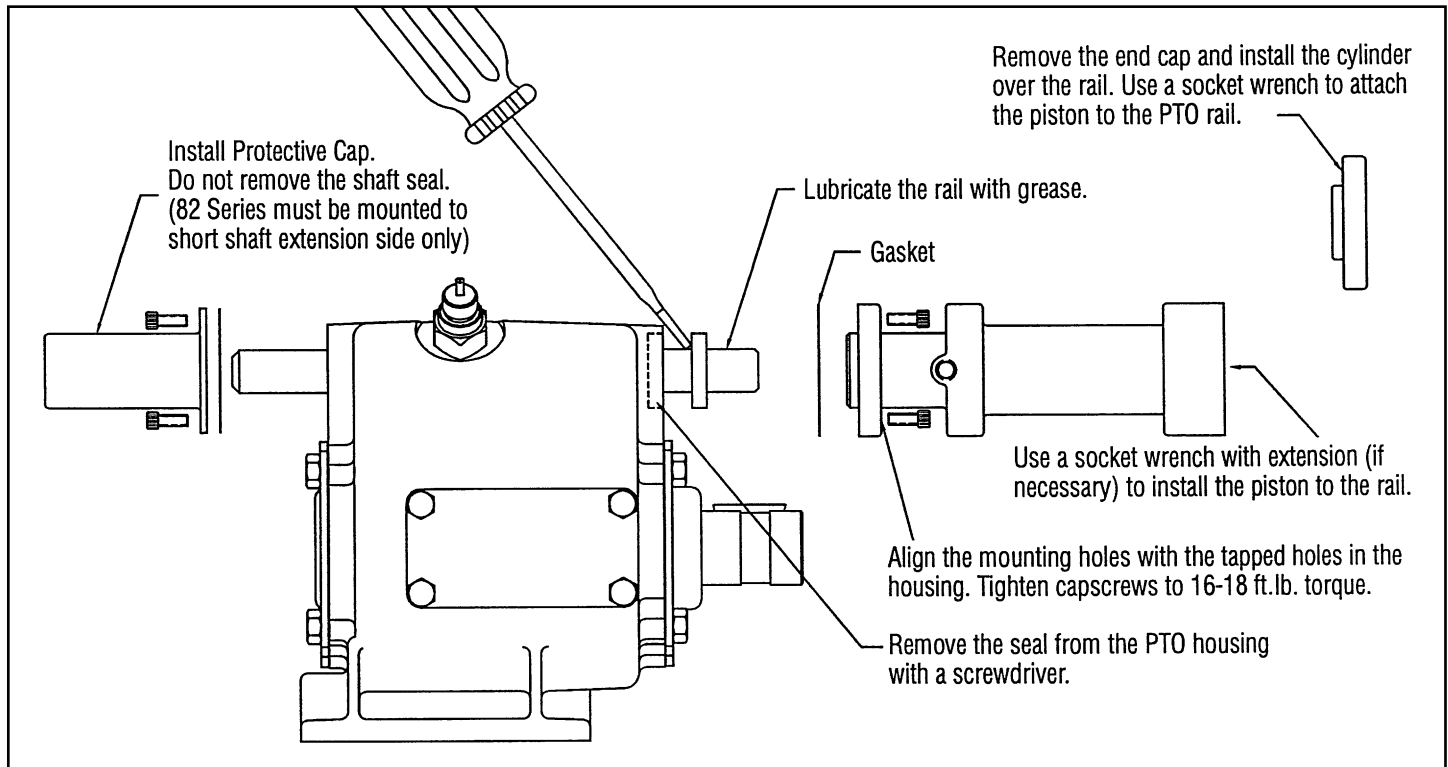


AIR SHIFT CYLINDER INSTALLATION



PROCEDURE:

1. Remove the eyebolt from the shifter rail. Determine which side of the PTO the air cylinder will be mounted. On reversible units the air cylinder (as received) may be mounted on either side of the PTO. The 82 series cylinder is normally supplied to mount to the output shaft side of the PTO, but it may be reassembled to fit the other side. Remove the shifter rail oil seal from this side of the PTO. This can be done by prying the seal from the housing with a flat tipped screwdriver. Insert the screwdriver under the O.D. of the seal and pry loose. The seal will not be reused and can be discarded.
2. Remove the end cap of the air cylinder.
3. Lubricate the PTO shift rail lightly with grease or oil.
4. Place the cylinder gasket on the nose of the cylinder housing.
5. Slide the cylinder over the rail until it stops.
6. Using a $\frac{9}{16}$ " socket and ratchet with an extension, screw the piston assembly onto the shift rail. Torque to 20 ft.lbs.
7. Align the cylinder mounting holes with the PTO holes and mount using the two $\frac{3}{4}$ " long sockethead cap screws. Torque to 8 ft.lbs.
8. Place the end cap on the cylinder housing using the two hexhead cap screws. Torque to 8 ft.lbs.
9. Install the protective cap to exposed rail end.
10. Remove the detent ball and spring from poppet retainer in housing and re-install retainer.
11. Finish the installation by following the installation diagrams found in the PTO owner's manual for the PTO you are installing.
12. Test shift the unit before placing into service.



Member of the Interpump Group

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