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CALL 800-221-9723 or 818-882-8611 • FAX 818-882-7028  
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## ADC174 TILT CYLINDER KIT INSTALLATION INSTRUCTIONS

### REQUIRED TOOLS

- Large Flat Blade Screwdriver
- 1/2" Thin Profile Wrench
- 3/16" Hex Key
- RPF449 Hydraulic Fluid
- 5/8" & 9/16" Wrenches
- Paper Towels or Shop Towels

### TILT CYLINDER REMOVAL

1. Position the chair with the base in the fully up position and the back in the fully down position. Raise the toe board and secure with the elastic safety cord that is found under the chair (see Figure 1). Remove the upper structure cover from the chair.

#### WARNING

**CHAIR BACK MUST BE SUPPORTED SO THAT IT  
WILL NOT FALL WHEN TILT CYLINDER IS DISCONNECTED**

2. To bypass the limit switches raise the roller link and press the back down switch (see Figure 2). Lower the back until the tilt cylinder is completely compressed. NOW DISCONNECT THE POWER TO THE CHAIR.

#### WARNING

**DO NOT PRESS THE "BACK UP" POWER BUTTON IF THE  
ROLLER LINK IS LIFTED. IT MAY CAUSE DAMAGE TO THE CHAIR.**

3. Detach the plug from the vent tube (see Figure 2). Remove the clear breather tube by detaching and saving the sleeve clamp, and remove from cylinder barb (see Figure 3).
4. Break the "Loctite" seal between the clevis link and shaft. Remove shaft from clevis link using a 1/2" thin profile wrench, channel locks, or vise grips.
5. With a 3/16" hex key wrench remove the two socket head cap screws that hold the bottom of the cylinder to the upper structure (see Figure 2).
6. Position paper towels or shop towels under the tilt cylinder to catch oil. Use a 9/16" wrench to hold the fitting on the high pressure hose. With a 5/8" wrench, loosen the connection and disconnect the high pressure hose from the elbow (see Figure 3). Remove the tilt cylinder from the chair.

### TILT CYLINDER INSTALLATION

7. Apply Threadlocker (RPI Part #RPA032) to cylinder shaft threads and install the new Tilt Cylinder into the clevis link with a 1/2" thin profile wrench (see Figure 2). **DO NOT USE CHANNEL LOCKS, OR VISE GRIPS.**
8. Apply Threadlocker (RPI Part #RPA032) to each one of the **new** socket head cap screws. Use the cap screws to attach the cylinder to the upper structure. Fully tighten the cap screws and back off 1/4 turn (see Figure 2).
9. Attach the clear breather tube to the barb on the cylinder and reinstall the sleeve clamp. Use the 9/16" and 5/8" wrenches to install the high pressure hose to the elbow fitting on the cylinder (see Figure 3). Firmly tighten the fitting on the high pressure hose ensuring that no leaks will occur. **DO NOT TURN OR LOOSEN THE ELBOW FITTING ON THE CYLINDER.**
10. Be sure roller link is in its fully down position. Connect power to the chair. Raise the back of the chair all the way up exposing most of the cylinder shaft. Lightly coat the shaft of the cylinder with Hydraulic Fluid (RPI Part #RPF449).
11. Actuate the chair base up and back several times to purge any air in the lines. If the chair jerks or is noisy it may need Hydraulic Fluid (RPI Part #RPF449).
12. Verify proper operation of the chair. Clean any residual oil that may have spilled. Connect the vent plug (see Figure 2) and check for leaks. Attach all covers.

FIGURE 1

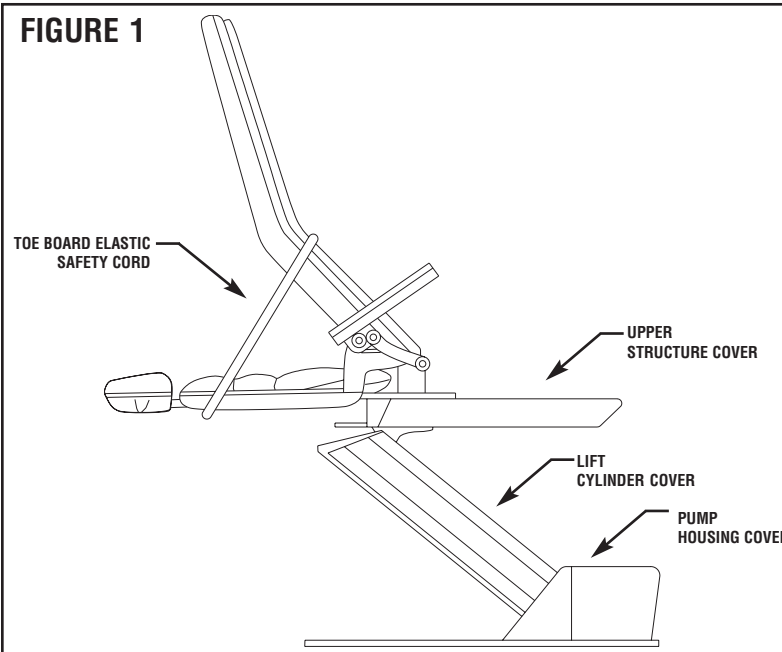


FIGURE 2

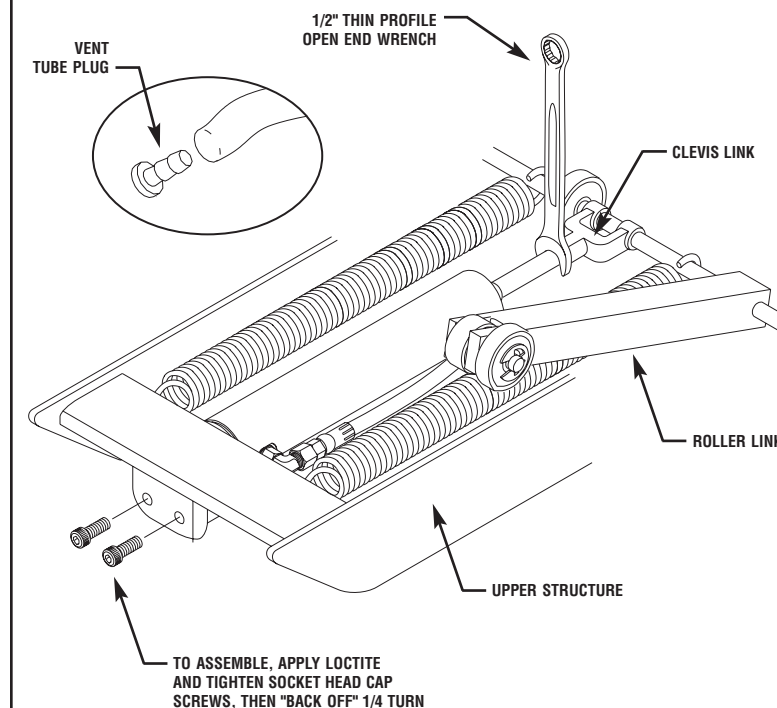


FIGURE 3

