replacement parts industries, inc.
"The Alternate Source"®
CALL 800-221-9723 or 818-882-8611 • FAX 818-882-7028
E-MAIL: techsupport@rpiparts.com • WEBSITE: www.rpiparts.com

# ADC178
# TILT CYLINDER KIT
# INSTALLATION INSTRUCTIONS

## REQUIRED TOOLS

- Slotted Screwdriver
- Pliers
- 1/2" & 9/16" Wrenches
- Hydraulic Fluid (RPI Part #RPF449)
- Paper Towels or Shop Towels

## TILT CYLINDER REMOVAL

**1.** With the chair back in the full down position, raise the toe board and secure using the tilt roller assembly (See Figure 1).

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

**2.** Disconnect the power to the chair.

**3.** Using the 9/16" wrench disconnect the high pressure hose from the right angle fitting of the cylinder. Use a towel to catch any residual hydraulic fluid.

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

**4.** Prop the chair to expose at least 3” of the cylinder rod (See Figure 2)

**5.** Disconnect and save the sleeve clamp that holds the clear plastic vent tube to the barb. Disconnect vent tube from barb.

**6.** Break the Loctite seal between clevis yoke and shaft. Remove shaft from clevis yoke using a 1/2" wrench, channel locks or vise grips.

**7.** Use the flat blade screwdriver to remove the retainer clip then remove the cylinder by sliding the right angle fitting through the opening. Save the retainer clip and washer.

## TILT CYLINDER INSTALLATION

**8.** Slide the cylinder washer over the right angle fItting.

**9.** Install the new cylinder by sliding the right angle fitting thru the upper structure hole and securing it with the retainer clip.

**10.** Apply Threadlocker (RPI Part #RPA032) to cylinder shaft threads and install the new Tilt Cylinder into the clevis yoke with a 1/2" wrench (see Figure 2). **DO NOT USE CHANNEL LOCKS, OR VISE GRIPS.**

**11.** Use the sleeve clamp to secure the clear vent tube to the cylinder barb.

**12.** Using a towel, cover the high pressure fItting and remove the support from the back of the chair allowing the cylinder rod to retract fully.

**13.** Using the 9/16" wrench, turn the cylinder so that the right angle fItting on the cylinder is pointing upward, then reconnect the high pressure hose. Firmly tighten the fitting on the high pressure hose ensuring that no leaks will occur.

**14.** Reconnect power to the chair and raise the back so that most of the cylinder rod is exposed. Using a small amount of RPI Hydraulic Fluid (RPI Part #RPF449) on a towel lubricate the exposed cylinder rod.

**15.** 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).

**FIGURE 1**

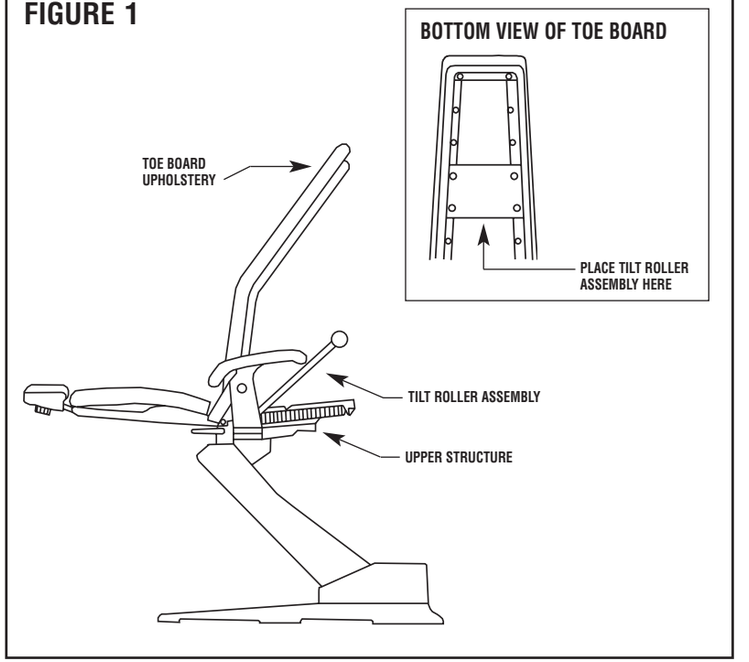


**FIGURE 2**