

RESEALING THE BOTTOM PISTON BAR

- 1) The first thing you will want to do is remove the inbound and out bound table. To do this raise the top jaw up as far as it will go and turn off the machine. Remove the clevis pins from the bottom of the hydraulic cylinders on the bottom of the out bound table. Next remove the two pivot bolts located at the end of the in-bound table. This is where the inbound table pivots up and down. Now the table assembly is disconnected from the cutter and using a forklift and some chains the entire table can be lifted through the cutter and set out of the way.
- 2) Turn the cutter back on and extend the teeth but do **not** lock them. Turn the machine back off. If a power washer is available then wash the bottom jaw area. Blow off to dry.
- 3) Remove the 3/4-10 socket head cap screws that secure the bottom tooth bar to the bottom piston bar. You should not have to remove the teeth. These bolts are tight and a large breaker bar may be required.
- 4) Once all of the bolts are removed use a forklift and some nylon straps to lift the tooth bar off of the piston bar and out of the way. (Hint: If you have two 1/2 in diameter rods that are about 1ft long you can remove the bolts from two teeth that are equidistant from the center of the bar and hook the nylon strap on the bars and lift it off.
- 5) Screw a long 1/2" course threaded bolt into the end of the piston and remove it. Be certain not to get any dirt in the piston bar. Follow the attached instructions to remove the poly-pak and install a new one on the piston.
- 6) Inspect the piston for any gouges or rough area and sand smooth or replace the piston. Also inspect the bore to be certain that it is smooth. If the bore looks worn, tapered, or oval in shape it may need special pistons to seal properly. Call Cee-Jay with further instructions on how to handle this.
- 7) When the new seal is installed the piston can be reinstalled into the piston bar. This is done by gently pressing the piston into the bore. **DO NOT COCK THE PISTON!! DO NOT USE A HAMMER.** This will damage the piston bar and result in leaks. Be certain the piston stays straight and that the lip on the seal is protected. A small amount of grease may be helpful.
- 8) When all of the pistons are back in place, inspect the tooth bar to be certain that the teeth move freely back and forth. This may be a good opportunity to remove any sticking teeth and clean them, replace any dirt wipers and repair any damaged teeth. Wipe both bars clean and replace the tooth bar. Apply anti-seize to bolts and torque to 250 foot-pounds.
- 9) Replace inbound table being certain that the table springs are back in their seats and reconnect the cylinders.

Call 800-350-9313 with any questions that you might have.

RESEALING THE TOP PISTON BAR

You do not have to remove the tables when resealing the top piston bar.

- 1) Turn the cutter back on and extend the teeth and using a wooden board, shove the teeth back into the jaw, but **DO NOT LOCK THEM. TURN OFF MACHINE.**
- 2) Remove all the $\frac{3}{4}$ -10 Socket Head Cap Screws EXCEPT FOR ONE IN THE MIDDLE, which secure the top tooth bar to the top piston bar. You should not have to remove the teeth. These bolts are tight and a large breaker bar may be required.
- 3) Set four 4 x 4 pieces about 3' – 4' long from the outbound table to the inbound table for the top tooth bar to rest on, two on each side. These will hold the top tooth bar.
- 4) Lower the top jaw until the tooth bar rests on the 4 x 4's. Take out the last $\frac{3}{4}$ -10 socket head cap screw, and raise the top jaw again.
- 5) Follow instructions 5 through 8 in the instructions above on the bottom piston bar.
- 6) When done with the piston bar, reverse the procedures above to reattach the top tooth bar. The socket head cap screws are torqued to 220 ft/lbs.