



1. Disassemble the Jaw Bar.
2. Clean and inspect the cylinder walls for wear, pitting and scoring. If surface is damaged, lightly hone the cylinder walls to restore the surface finish. In the event that the cylinder walls are badly damaged, consult your service representative for replacement or rebuild.
3. Remove the old polypak.
4. Check the piston for nicks and burrs and remove any present with a file. (A damaged piston will destroy a piston bar in a matter of hours. A very costly mistake.)
5. Install the polypak onto the piston as shown. The polypak will install easier if it is at 70-80 F. Start the polypak at one side and work it around the edge (like a tire) with some screw drivers. Be Careful not to damage the piston and remove any nicks or burrs.
6. Insert the Piston into the installation tool as shown and squeeze it into place compressing the sides of the polypak.
7. Install a bolt into the back side of the piston thru the hole provided in the installation tool.
8. Lubricate the cylinder bore with clean hydraulic oil.

9. Align the installation tool over the cylinder bore and **gently** tap the piston into the bore.
10. Remove the bolt and installation tool

Patience is the key to success

