

sliding base.

(4) Remove the rotary table.

(5) Remove the bolts (9), lockwashers (10), gib pins (7), and table anchor plates (11).

NOTE

Do not separate the gib pins (7) and anchor chains (8)

unless replacement of one of the parts is necessary.

(6) Remove the rotary table slide bases (12 and 13).

(7) Remove the bolts (4), lockwashers (5), top guide rails (6), base guide strips (14), and shims (15).

b. Cleaning, Inspection, and Repair

(1) Clean all parts in an approved solvent and dry with compressed air.

(2) Inspect all parts for damage or excessive wear.

(3) Replace unserviceable parts as necessary.

c. Reassembly. Reassemble the rotary table sliding base by reversing disassembly procedures.

3-28. ROTARY TABLE TRANSFER CYLINDER (Figure 3-34).

a. Removal

(1) Disconnect hydraulic lines from the cylinder barrel (23).

(2) Remove spring pin (1), anchor pin (2), spring pin (21), anchor pin (22), and remove the transfer cylinder assembly.

b. Disassembly

(1) Remove the setscrew (7), plug (8) and unscrew the cap (9) from the cylinder barrel (23).

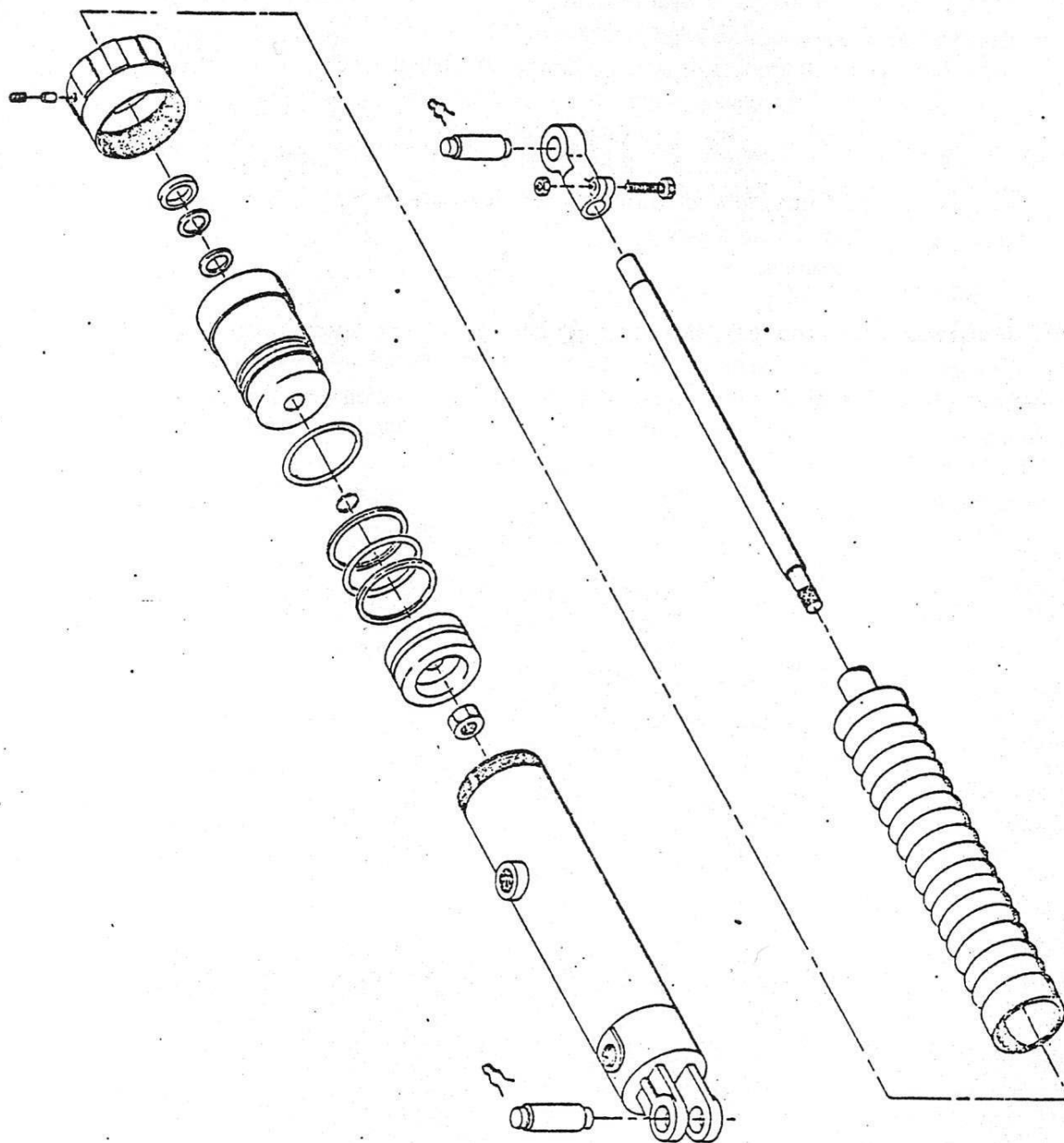
(2) Pull the rod (6) with all attached components out of the barrel (23).

(3) Remove the nut (3), bolt (4), lug (5), and protector (15).

(4) Remove the cap (9), seal (10), ring (11), o-ring (12), and head (13).

(5) Remove the nut (20) from the rod (6).

(6) Remove the piston (19), and o-rings (14, 16, 17 and 18).



1. SPRING PIN
2. ANCHOR PIN
3. NUT
4. BOLT
5. LUG
6. ROD
7. SETSCREW
8. PLUG
9. CAP
10. SEAL
11. RING
12. O-RING
13. HEAD
14. O-RING
15. O-RING
16. O-RING
17. O-RING
18. O-RING
19. PISTON
20. NUT
21. SPRING PIN
22. ANCHOR PIN
23. BARREL

Figure 3-34. Rotary Table Transfer Cylinder

c. Cleaning, Inspection, and Repair

- (1) Clean all parts, except seals, o-rings, and the protector, in an approved solvent.
- (2) Inspect the interior of the barrel. The interior surface must be smooth.
- (3) Inspect all parts for excessive wear or damage.
- (4) Thoroughly clean all grooves in which o-rings are installed.

CAUTION

Do not use a wire brush or abrasive material for
cleaning.

- (5) Replace all o-rings and seals, and any other parts considered unserviceable.

c. Reassembly. Reassembly the transfer cylinders by reversing disassembly procedures.

d. Installation. Reinstall the transfer cylinders by reversing disassembly procedures.