



**SERVICE INSTRUCTIONS FOR SEAL  
REPLACEMENT OF  
POWER GEAR HYDRAULIC  
LEVELING LEGS**

82-L0352

REV 8 4-27-2011

# **WARNING!**

**HYDRAULIC COMPONENTS CAN CAUSE SERIOUS INJURY OR DEATH IF PROPER SAFETY PRECAUTIONS ARE NOT FOLLOWED. ALL HYDRAULIC PRESSURE MUST BE RELEASED FROM THE SYSTEM, INCLUDING RAISING ALL JACKS AND REMOVING POWER FROM THE SYSTEM BEFORE REMOVAL OR DISASSEMBLY IS ATTEMPTED.**

**ALWAYS WEAR SAFETY EQUIPMENT. SAFETY GLASSES, GOGGLES AND/OR FACE SHIELDS CAN PREVENT SERIOUS INJURY AND SHOULD BE USED TO PREVENT EYE DAMAGE.**

**POWER GEAR WARRANTS THE SEALS AND COMPONENTS OF THESE KITS FOR 90 DAYS AGAINST DEFECTS IN MATERIALS AND WORKMANSHIP. NO GUARANTEE EXISTS ON THE ULTIMATE SUCCESS OR FAILURE OF THE JACK. THE SUCCESS OF THE RESEAL DEPENDS ON THE CARE TAKEN DURING INSPECTION, THE SKILL OF THE TECHNICIAN AND THE CLEANLINESS DURING THE RE-ASSEMBLY. ANY DEFECT ON THE SURFACE OF THE ROD WILL RESULT IN SEAL FAILURE OR REDUCE THE LIFE OF THE SEALS.**

**NOT ALL JACKS CAN BE DISASSEMBLED DUE TO VARIANCES IN ASSEMBLY TECHNIQUE, DISASSEMBLY TOOLS AVAILABLE OR DAMAGE DUE TO ENVIRONMENTAL CONDITIONS OR ABUSE. WHILE ONLY A VERY SMALL PERCENTAGE OF JACKS ARE IMPOSSIBLE TO DISASSEMBLE, JACKS SHOULD BE DISASSEMBLED BEFORE SEAL REPLACEMENT OR JACK REPLACEMENT COSTS ARE DETERMINED.**

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## TOOL REQUIREMENTS:

NOTE: Some tools may not be required for some jacks. This is a complete tool list to equip a technician for repairs to all types of Power Gear leveling cylinders.

- 1/4" punch
- 1/8" punch
- hammer
- strap wrench
- Small pick or screwdriver
- Grease gun
- Large spanner wrench
- Bench vise
- 15/16" socket
- 9/16" socket
- 7 mm socket
- Impact wrench
- Torque wrench
- Clean lint free shop towels
- Loctite® 243 or equivalent
- Wire brush
- Spray cleaning solvent
- Compressor
- Large pipe wrench or chain wrench
- Small propane torch

# POWER GEAR JACK ASSEMBLIES

## INTERNAL SPRING JACK ASSEMBLIES

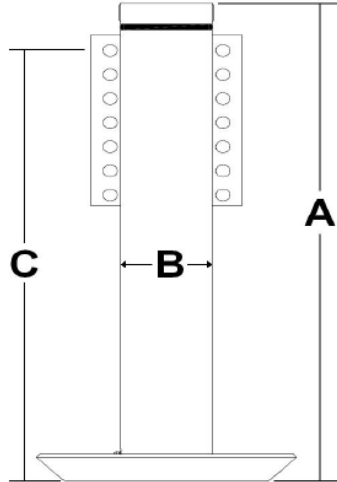
| Cap. | Leveling jack # | * Jack obsolete use # | Dimensions (in inches) |         |         | Seal kit # | Spring # | Notes  |
|------|-----------------|-----------------------|------------------------|---------|---------|------------|----------|--|
| 24K  | 500386T         |                       | A=22.37                | B=4.5   | C=20.09 | 800130S ** | N/A      |  |
| 24K  | 500620          |                       | A=22.375               | B=4.5   | C=22.37 | 800130S ** | N/A      | has mounting pad width of 7.25                                 |
| 16K  | 501136          |                       | A=22.37                | B=4.0   | C=13.25 | 800131S ** | N/A      | 4 bolt mounting pattern  |
| 16K  | 501137          |                       | A=22.37                | B=4.0   | C=18.94 | 800131S ** | N/A      | 4 bolt mounting pattern  |
| 24K  | 500386 *        | 500386T               | A=22.37                | B=4.5   | C=20.09 | 800130S ** | N/A      |  |
| 16k  | 501298          |                       | A=22.37                | B=4.0   | C=13.25 | 800131S ** | N/A      | 4 bolt mounting pattern/has 8" Shoe instead of the typical 10' |
| 16k  | 501299          |                       | A=22.37                | B=4.0   | C=18.94 | 800131S ** | N/A      | 4 bolt mounting pattern/has 8" Shoe instead of the typical 10' |
| 12K  | 500385TH        |                       | A=22.3                 | B=3.63  | C=20.11 | 800137S ** | N/A      |  |
| 12K  | 500385 *        | 500385TH              | A=22.25                | B=3.625 | C=20.11 | 800137S ** | N/A      |  |
| 16K  | 500070 *        | 500070TH              | A=22.25                | B=4.0   | C=21.42 | 800131S ** | N/A      |  |
| 16K  | 500070TH        |                       | A=22.37                | B=4.0   | C=20.09 | 800131S ** | N/A      |  |
| 16K  | 500145          |                       | A=22.25                | B=4.0   | C=21.42 | 800131S ** | N/A      |  |

N/A (Not Available) - Internal springs are not a service item

Measurements A and C are taken with jack completely retracted

Spring return jacks will only have one hydraulic hose attached to one of the two ports on top of jack

\*\* Information regarding seal kit replacement can be found in the seal kit manual number 82-L0353



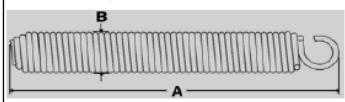
## EXTERNAL SPRING JACK ASSEMBLIES

| Cap. | Leveling jack # | * Jack obsolete use # | Dimensions (in inches) |         |         |         | Port Size | Seal kit # | Spring # | Notes   |
|------|-----------------|-----------------------|------------------------|---------|---------|---------|-----------|------------|----------|---|
| 6K   | 500384          | 501022                | A=21.25                | B=2.625 | C=17.61 | D=19.08 | #6        | No Kit     | 500590   | 501022 kit contains qty 1 500384HR jack and qty 2 hose adapter fittings |
| 6K   | 500384H*        | 501022                | A=21.25                | B=2.625 | C=17.61 | D=19.08 | #6        | 800132S ** | 500590   | 501022 kit contains qty 1 500384HR jack and qty 2 hose adapter fittings |
| 6K   | 500598*         | 501022                | A=21.25                | B=2.625 | C=18.17 | D=19.08 | #6        | 800132S ** | 500590   | 501022 kit contains qty 1 500384HR jack and qty 2 hose adapter fittings |
| 6K   | 500384HR        |                       | A=20.85                | B=2.625 | C=17.61 | D=19.59 | #4        | 800132S ** | 500590   |   |
| 9K   | 500082*         | 500146                | A=20.75                | B=3.25  | C=17.38 | D=18.71 | #6        | 800129S ** | 500094   | 500146 kit contains qty 1 500082HR jack and qty 2 hose adapter fitting  |
| 9K   | 500082H*        |                       | A=20.75                | B=3.25  | C=17.38 | D=18.71 | #6        | 800129S ** | 500094   |   |
| 9K   | 500082HR        |                       | A=20.75                | B=3.25  | C=17.38 | D=19.21 | #4        | 800129S ** | 500094   |   |
| 9K   | 500146          |                       | A=20.75                | B=3.25  | C=17.38 | D=19.21 | #4        | 800129S ** | 500094   | 500146 kit contains qty 1 500082HR jack and qty 2 hose adapter fitting  |
| 9K   | 500272*         | obsolete              | A=20.75                | B=3.25  | C=17.82 | D=18.83 | #6        | 800129S ** | 500094   |   |
| 9K   | 500759          |                       | A=20.40                | B=2.6   | C=17.6  | D=19.08 | #4        | 800138S ** | 500094   |   |
| 12K  | 501315          |                       | A=20.33                | B=3.25  | C=17.19 | D=19.33 | #6        | 800199S ** | 500094   |   |
| 12K  | 500800          |                       | A=19.2                 | B=3.25  | C=16.75 | D=19.21 | #4        | 800199S ** | 500094   |   |
| 9K   | 500235*         | 500235H               | A=18.25                | B=3.25  | C=17.38 | D=15.83 | #6        | 800129S ** | 500252   |   |
| 9K   | 500235H         |                       | A=18.19                | B=3.25  | C=17.38 | D=15.83 | #6        | 800129S ** | 500252   |   |
| 6K   | 500600*         | 500482H               | A=18.0                 | B=2.625 | C=15.63 | D=14.73 | #6        | 800132S ** | 500591   | Flat shoe   |
| 6K   | 500482*         | 500482H               | A=18.0                 | B=2.625 | C=15.38 | D=14.73 | #6        | 800132S ** | 500591   |   |
| 6K   | 500482H         |                       | A=18.0                 | B=2.625 | C=15.38 | D=14.73 | #6        | 800132S ** | 500591   |   |
| 9K   | 500498          | 500498H               | A=17.75                | B=3.25  | C=15.0  | D=15.83 | #6        | 800129S ** | 500252   |   |
| 9K   | 500498H         |                       | A=17.75                | B=3.25  | C=15.0  | D=15.83 | #6        | 800129S ** | 500252   |   |

### SPRING REPLACEMENT KITS

| Spring kit # | Meas. of Spring   |
|--------------|-------------------|
| 500094       | A=17" x B=2.5"    |
| 500252       | A=14.55" x B=2.5" |
| 500590       | A=17" x B=2.3"    |
| 500591       | A=14.55" x B=2.3" |

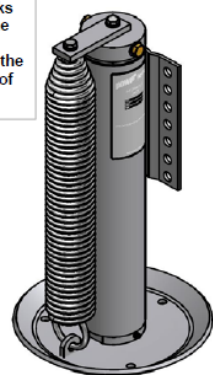
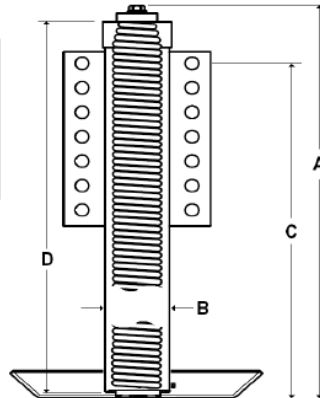
A is overall length and B is outer diameter



Measurements A and C are taken with jack completely retracted

Spring return jacks will only have one hydraulic hose attached to one of the two ports on top of jack

\*\* Information regarding seal kit replacement can be found in the seal kit manual number 82-L0353

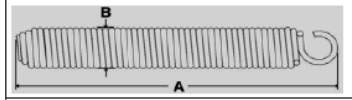


**POWER LEVEL (EXTERNAL SPRING) JACK ASSEMBLIES**

| Cap. | Leveling jack # | *Jack obsolete use # | Dimensions (in inches) |         |         |         |        | Seal kit #    | Spring # | Notes                       |
|------|-----------------|----------------------|------------------------|---------|---------|---------|--------|---------------|----------|-----------------------------|
|      |                 |                      | A                      | B       | C       | D       | E      |               |          |                             |
| 9K   | 500932          |                      | A=25.3                 | B=2.6   | C=24.4  | D=14.3  | E=5.0  | 800138S **    | 500094   |                             |
| 12K  | 501005          |                      | A=24.26                | B=3.25  | C=23.26 | D=16.0  | E=5.0  | 800199S **    | 500094   |                             |
| 9K   | 501004*         |                      | A=24.25                | B=2.625 | C=23.25 | D=16.0  | E=3.4  | 800138S **    | 500094   | No replacement is available |
| 6K   | 500832          |                      | A=23.25                | B=2.25  | C=22.3  | D=8.0   | E=5.0  | 800133S **    | 500591   |                             |
| 9K   | 500833          |                      | A=23.15                | B=2.6   | C=22.2  | D=14.3  | E=3.0  | 800138S **    | 500094   |                             |
| 12K  | 501106          |                      | A=22.20                | B=3.25  | C=21.70 | D=14.31 | E=3.0  | Not Available | 500094   |                             |
| 6K   | 501173          |                      | A=21.44                | B=2.25  | C=16.81 | D=12.3  | E=3.2  | 800133S **    | 500591   |                             |
| 9K   | 500843          |                      | A=21.15                | B=2.6   | C=20.2  | D=14.3  | E=1.0  | 800138S **    | 500094   |                             |
| 6K   | 500842          |                      | A=20.4                 | B=2.25  | C=19.5  | D=14.3  | E=2.5  | 800133S **    | 500591   |                             |
| 12K  | 3510000111      |                      | A=20.21                | B=19.27 | C=20.26 | D=14.31 | E=1.5  | 800199S **    | 500094   |                             |
| 6K   | 500933          |                      | A=19.75                | B=2.25  | C=17.75 | D=12.3  | E=1.5  | 800133S **    | 500591   |                             |
| 6K   | 500730          |                      | A=19.15                | B=2.25  | C=16.0  | D=8.0   | E=1.13 | 800133S **    | 500591   |                             |
| 6K   | 500876          |                      | A=18.94                | B=2.25  | C=17.0  | D=12.3  | E= 5   | 800133S **    | 500591   |                             |

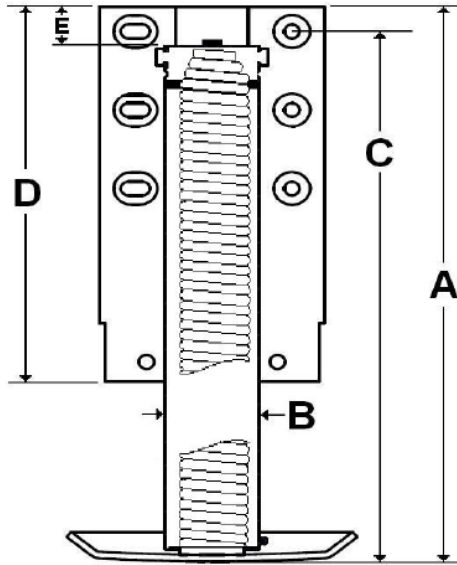
**SPRING REPLACEMENT KITS**

| Spring kit # | Meas. of Spring   |
|--------------|-------------------|
| 500094       | A=17" x B=2.5"    |
| 500252       | A=14.55" x B=2.5" |
| 500590       | A=17" x B=2.3"    |
| 500591       | A=14.55" x B=2.3" |

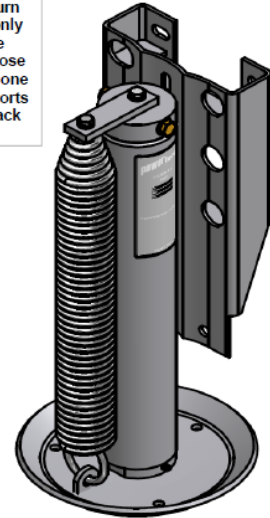


Measurements A, C, D, and E are taken with jack completely retracted

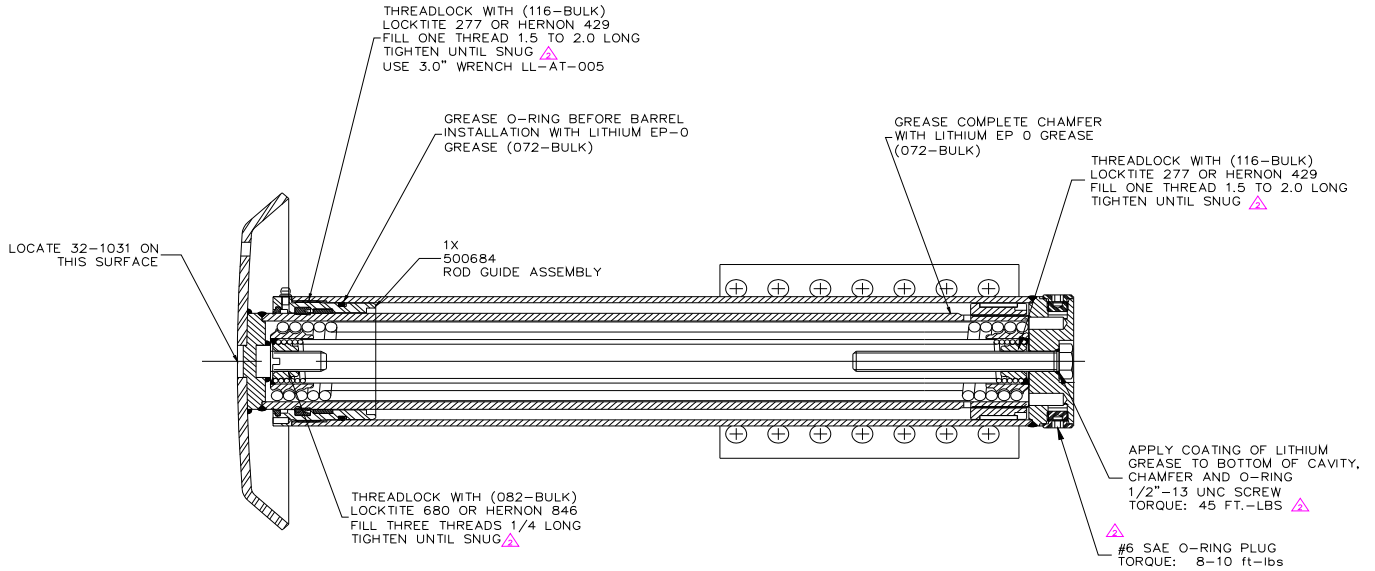
\*\* Information regarding seal kit replacement can be found in the seal kit manual number 82-L0353



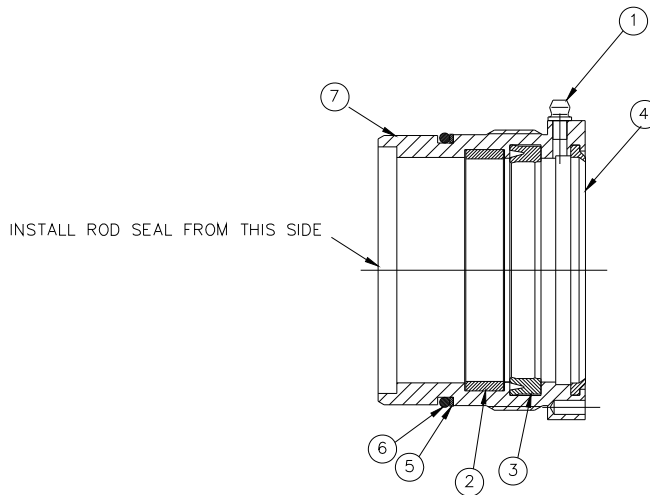
Spring return jacks will only have one hydraulic hose attached to one of the two ports on top of jack



# INTERNAL SPRING LEGS



**EXAMPLE OF A TYPICAL  
POWER GEAR HYDRAULIC LEG CROSS SECTION  
LEG PART NUMBERS - 500070-500145-500386-500620**

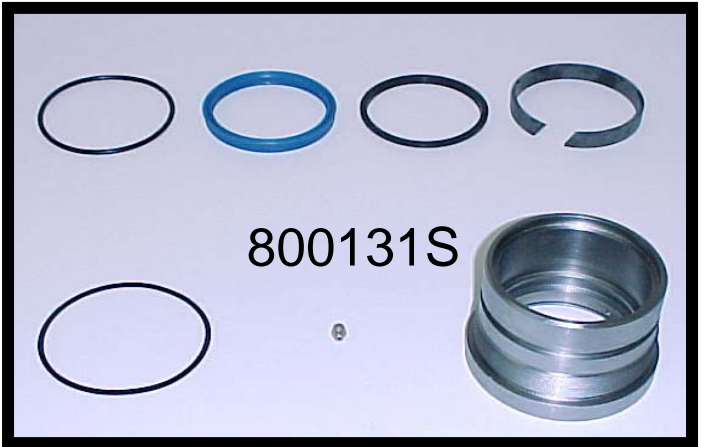
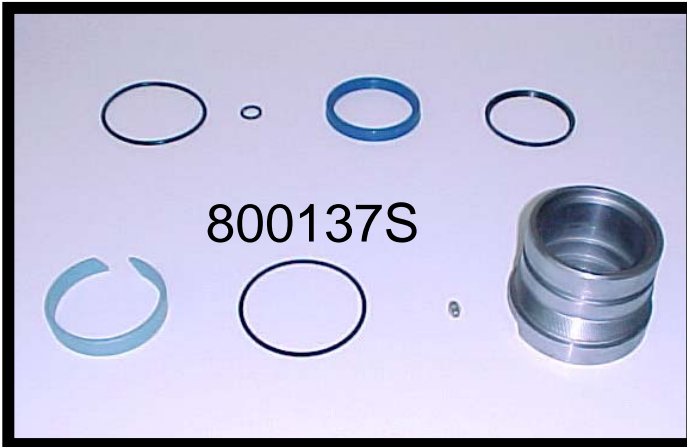


|      |                              |     |
|------|------------------------------|-----|
| 7    | GUIDE, ROD, 16K JACK         | 1   |
| 6    | RING, O, 16K JACK            | 1   |
| 5    | WASHER, BACK-UP, 16K JACK    | 1   |
| 4    | WIPER, ROD, 16K JACK         | 1   |
| 3    | SEAL, ROD, T, 3.00, 16K JACK | 1   |
| 2    | RING, WEAR, ROD, 16K JACK    | 1   |
| 1    | GREASE FITTING               | 1   |
| ITEM | DESCRIPTION                  | QTY |

**EXAMPLE OF A TYPICAL  
ROD GUIDE CROSS SECTION DETAIL AND ORDER OF ASSEMBLY  
LEG PART NUMBERS - 500070-500145-500386-500620**

**SEAL REPLACEMENT KIT PART NUMBER -**  
**800137S FOR 12000 LB. LEG - PART NUMBER**  
**500385**

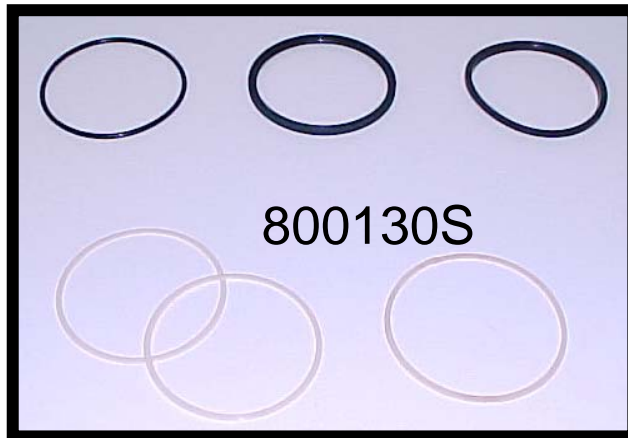
**SEAL REPLACEMENT KIT PART NUMBER**  
**800131S FOR 16000 LB. LEGS - PART**  
**NUMBERS 500070 & 500145**



| <u>QTY</u> | <u>PART #</u>                          | <u>DESCRIPTION</u>    |
|------------|--|-----------------------|
|            | * included within 800149 Elastomer pkg |                       |
| * 1        | 01-1077                                | O-RING                |
| * 1        | 01-1079                                | O-RING                |
| * 1        | 02-1034                                | SEAL                  |
| * 1        | 03-1009                                | WIPER                 |
| * 1        | 04-1023                                | WEAR RING             |
| * 1        | 05-1034                                | BACK-UP RING          |
| * 1        | 02-1030                                | BOLT SEAL (not shown) |
| 1          | 500680                                 | ROD GUIDE             |
| 1          | 10-1002                                | GREASE FITTING        |

| <u>QTY</u> | <u>PART #</u>                          | <u>DESCRIPTION</u>    |
|------------|--|-----------------------|
|            | * included within 800146 Elastomer pkg |                       |
| * 1        | 01-1067                                | O-RING                |
| * 1        | 02-1035                                | ROD GUIDE SEAL        |
| * 1        | 03-1015                                | 16K ROD WIPER         |
| * 1        | 04-1019                                | ROD WEAR RING         |
| * 1        | 05-1024                                | BACK-UP WASHER        |
| 1          | 10-1002                                | GREASE FITTING        |
| 1          | 500681                                 | ROD GUIDE             |
| * 1        | 02-1030                                | BOLT SEAL (not shown) |

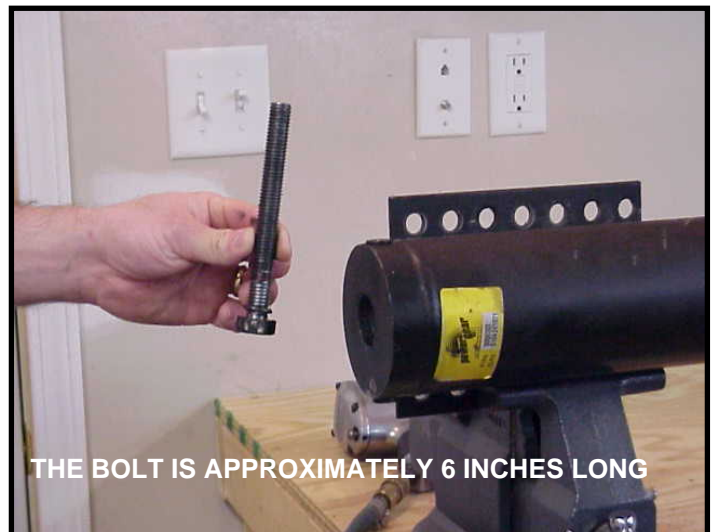
**SEAL REPLACEMENT KIT PART NUMBER**  
**800130S FOR 24000 LB. LEGS - PART**  
**NUMBERS 500386 & 500620**



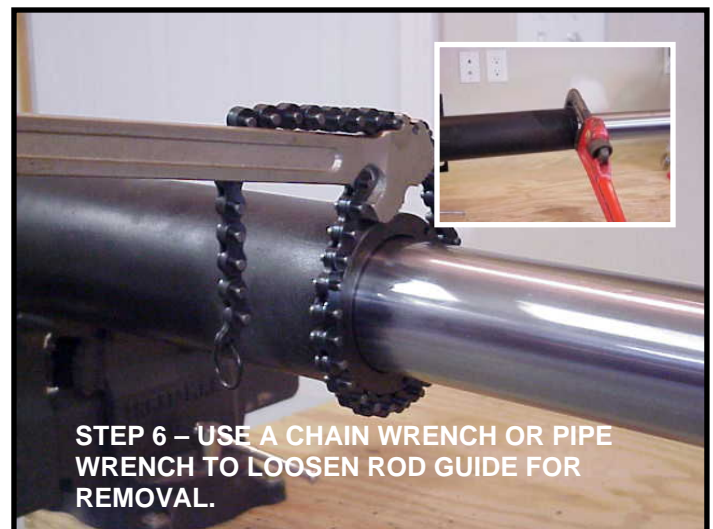
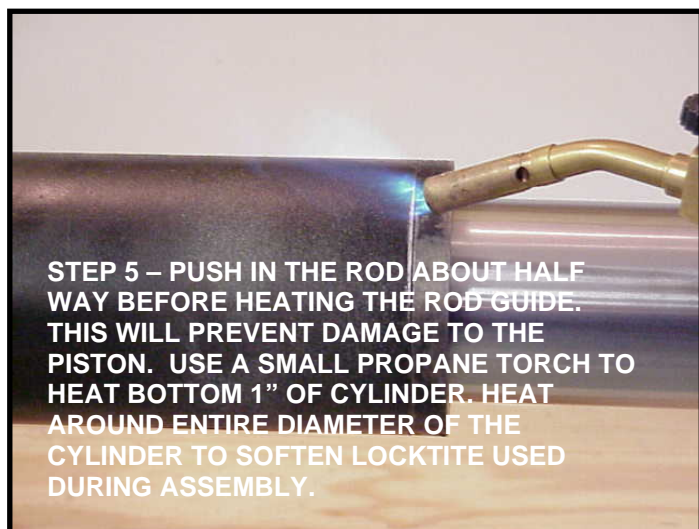
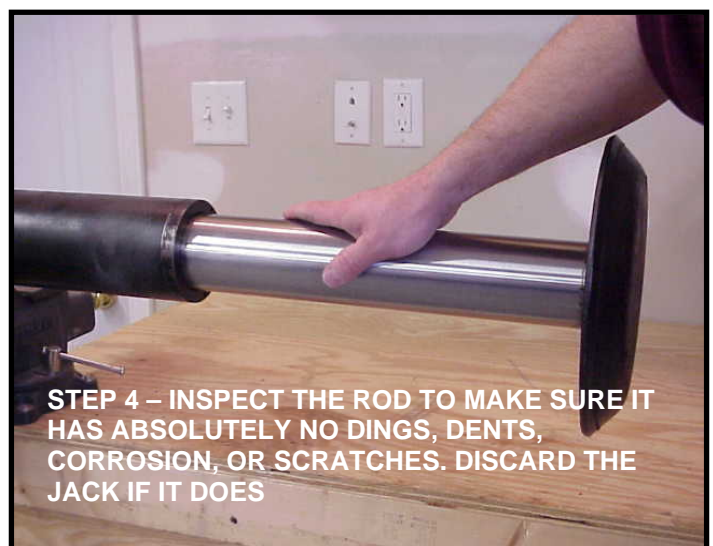
| <u>QTY</u> | <u>PART #</u>                          | <u>DESCRIPTION</u>         |
|------------|--|----------------------------|
|            | * included within 800157 Elastomer pkg |                            |
| * 1        | 01-1011                                | O-RING                     |
| * 1        | 02-1028                                | ROD GUIDE T-SEAL           |
| * 1        | 03-1010                                | 24K ROD WIPER              |
| * 2        | 05-1035                                | BACK-UP WASHER             |
| * 1        | 05-1036                                | BACK-UP WASHER             |
| * 1        | 02-1019                                | THREAD SEAL (NOT PICTURED) |



**NOTE - (NOT SHOWN) PRESSURE WASH THE EXTERIOR OF THE LEG TO PREVENT DIRT FROM CONTAMINATING INTERIOR OF THE LEG DURING THE RE-ASSEMBY PROCESS.**



**NOTE - IT MAY BE HELPFUL WHEN MOUNTING THIS JACK IN THE VISE TO ELEVATE THE FOOT END. THIS WILL PREVENT REMAINING OIL IN THE CYLINDER FROM DRAINING OUT WHEN THE ROD IS REMOVED.**



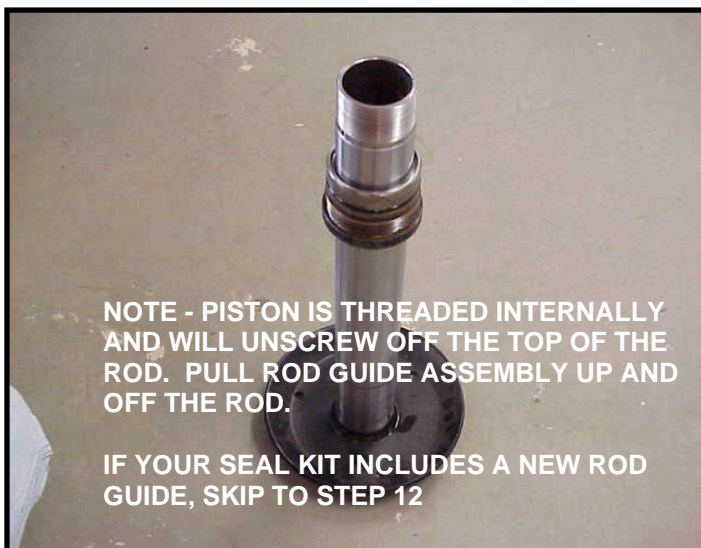




**STEP 7 - REMOVE ROD ASSEMBLY FROM CYLINDER.**



**STEP 8 - SET FOOTPAD ON THE FLOOR. WITH SPANNER WRENCH, REMOVE PISTON FROM ROD. NOTE: SOME MODELS WILL HAVE THE PISTON HELD IN PLACE WITH A LARGE SNAP RING. REMOVE WITH APPROPRIATE SIZE EXTERNAL SNAP RING PLIERS**



**NOTE - PISTON IS THREADED INTERNALLY AND WILL UNSCREW OFF THE TOP OF THE ROD. PULL ROD GUIDE ASSEMBLY UP AND OFF THE ROD.**

**IF YOUR SEAL KIT INCLUDES A NEW ROD GUIDE, SKIP TO STEP 12**



**STEP 9 - WITH PICK TOOL REMOVE EXTERNAL O-RING AND BACK-UP RING FROM ROD GUIDE.**



**STEP 10 - WITH PICK TOOL REMOVE SEALS AND ANY BACK-UP RINGS.**

**NOTE - SEAL MAY BE EITHER T-TYPE OR V-TYPE SEAL.**



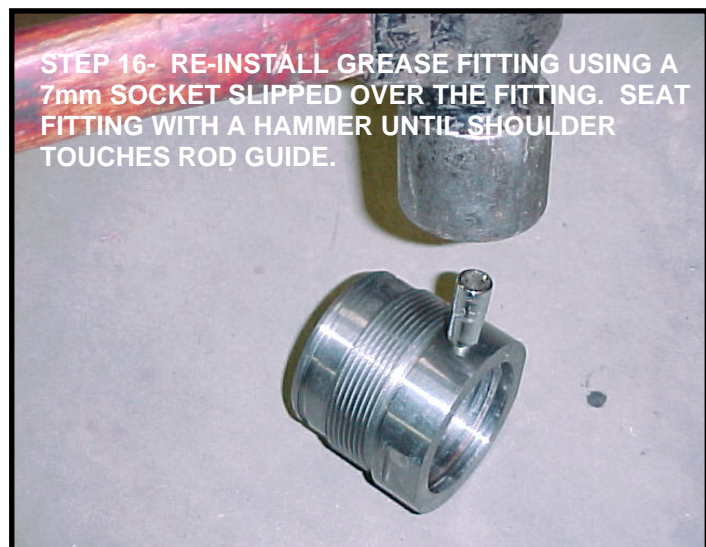
**STEP 11 - USING A WIRE BRUSH, CLEAN UP THE THREADS ON THE EXTERIOR OF THE ROD GUIDE. CLEAN THE LOWER INTERNAL PART OF THE ROD GUIDE IF NECESSARY.**

**NOTE - WIRE BRUSH DOES NOT NEED TO BE PNEUMATIC. ANY WIRE BRUSH CAN BE USED.**

**BE CAREFUL WHEN CLEANING THE INSIDE OF THE ROD GUIDE. THE SOFTER BEARING MATERIAL CAN BE DAMAGED.**



**NOTE:** STEP 13 SHOWS AN O-RING FOR THE BOLT. ON OLDER JACK LEGS, PART # 500385, A 1/2" BOLT SEAL WAS USED INSTEAD OF AN O-RING. NOTE THE PART #: IF THE PART # READS 500385, WITH NO LETTER SUFFIX, THE SEAL MUST BE USED INSTEAD OF THE O-RING. PLEASE CHECK THE BILL OF MATERIALS ON PAGE 6 FOR THE PART NUMBER OF THE SEAL. THE SEAL WILL BE INCLUDED IN ALL KITS WITH PART # 800137S.

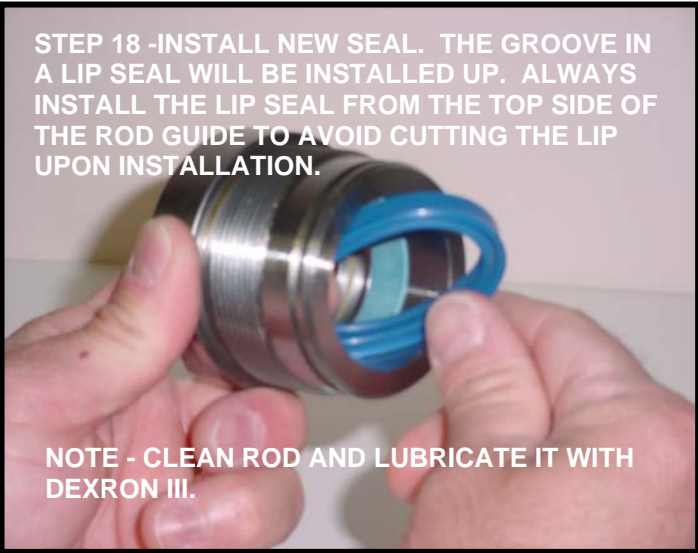


**NOTE - MAKE SURE SEALS ARE INSTALLED IN THE PROPER DIRECTION. SEALS INSTALLED INCORRECTLY WILL CAUSE THE LEG TO FAIL. PLEASE NOTE THE CROSS SECTIONAL DRAWING OF THE ROD GUIDE ON PAGE 6 TO NOTE THE PROPER INSTALLATION OF THE SEALS AND RINGS.**



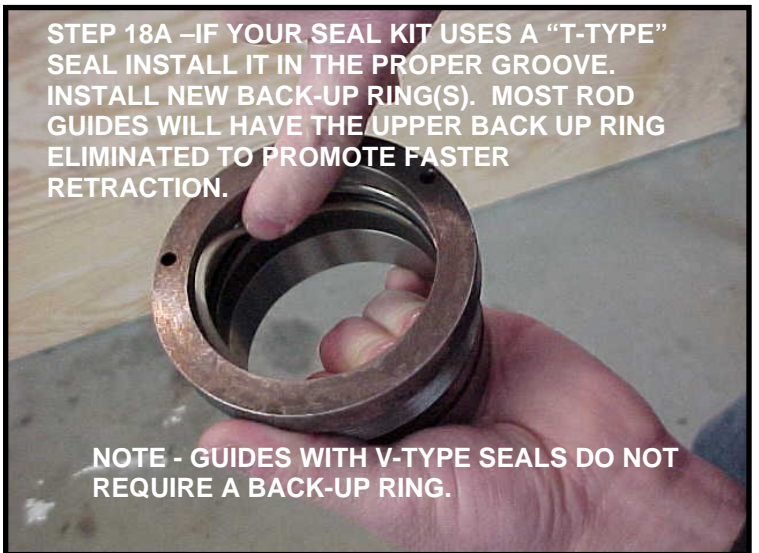
**NOTE - CHECK ORDER OF ASSEMBLY ON PAGE 6.**

STEP 18 -INSTALL NEW SEAL. THE GROOVE IN A LIP SEAL WILL BE INSTALLED UP. ALWAYS INSTALL THE LIP SEAL FROM THE TOP SIDE OF THE ROD GUIDE TO AVOID CUTTING THE LIP UPON INSTALLATION.



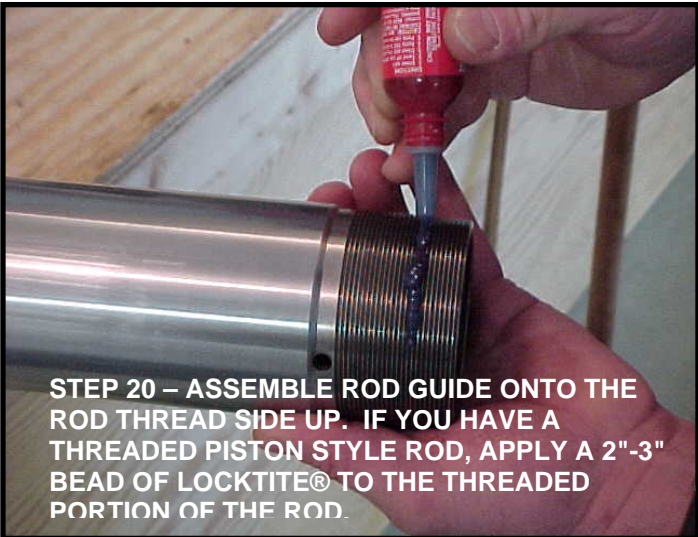
NOTE - CLEAN ROD AND LUBRICATE IT WITH DEXRON III.

STEP 18A -IF YOUR SEAL KIT USES A "T-TYPE" SEAL INSTALL IT IN THE PROPER GROOVE. INSTALL NEW BACK-UP RING(S). MOST ROD GUIDES WILL HAVE THE UPPER BACK UP RING ELIMINATED TO PROMOTE FASTER RETRACTION.

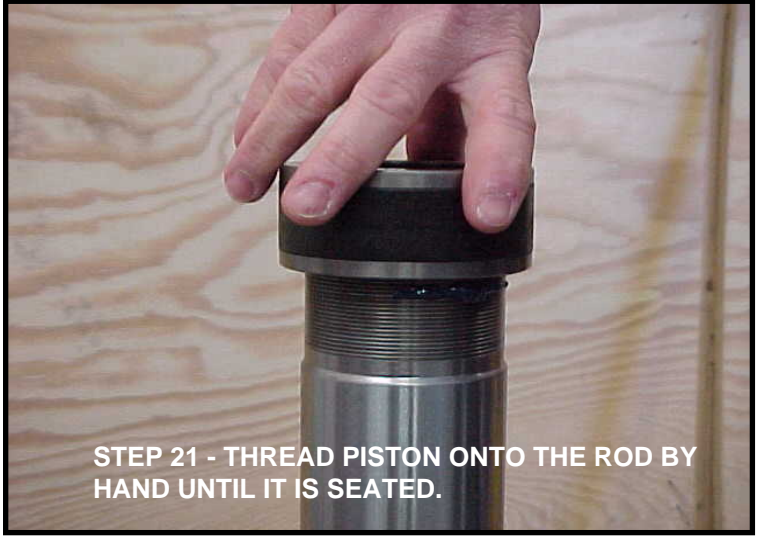


NOTE - GUIDES WITH V-TYPE SEALS DO NOT REQUIRE A BACK-UP RING.

STEP 20 - ASSEMBLE ROD GUIDE ONTO THE ROD THREAD SIDE UP. IF YOU HAVE A THREADED PISTON STYLE ROD, APPLY A 2"-3" BEAD OF LOCKTITE® TO THE THREADED PORTION OF THE ROD.



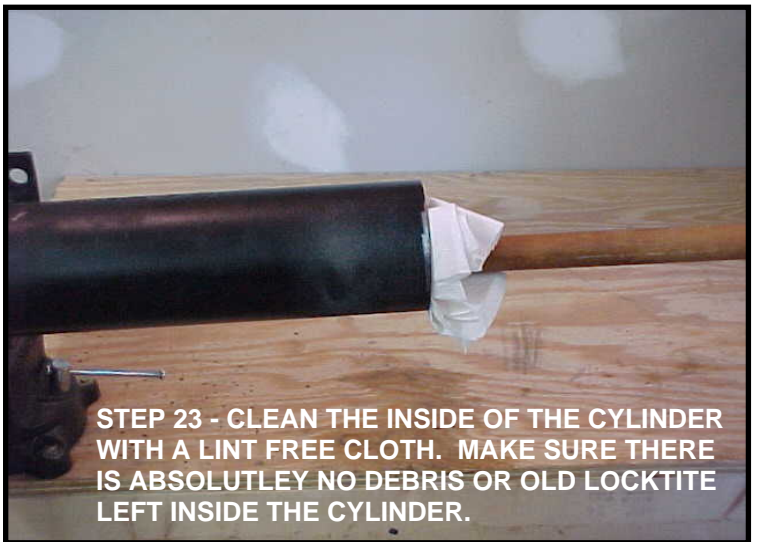
STEP 21 - THREAD PISTON ONTO THE ROD BY HAND UNTIL IT IS SEATED.

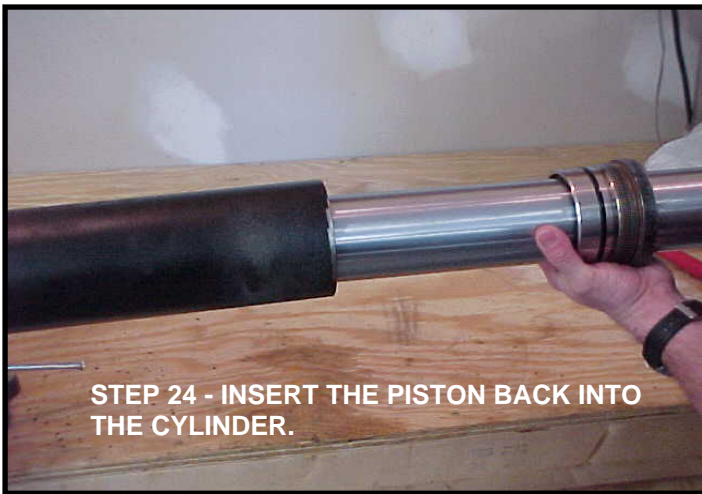


STEP 22 - USING A THE SPANNER WRENCH, TIGHTEN THE PISTON SNUGLY ON TO THE ROD. SNAP RING STYLE JACKS NEED THE SNAP RING INSTALLED AT THIS POINT.



STEP 23 - CLEAN THE INSIDE OF THE CYLINDER WITH A LINT FREE CLOTH. MAKE SURE THERE IS ABSOLUTLEY NO DEBRIS OR OLD LOCKTITE LEFT INSIDE THE CYLINDER.





STEP 24 - INSERT THE PISTON BACK INTO THE CYLINDER.



STEP 25 - PUSH ROD FULLY INTO THE CYLINDER. APPLY A 3" BEAD OF LOCKTITE TO THE EXTERNAL THREADS OF THE ROD GUIDE. START THREADING THE ROD GUIDE INTO THE CYLINDER.



STEP 26- USING THE CHAIN WRENCH, TIGHTEN ROD GUIDE INTO CYLINDER.

NOTE - NOTICE IN THE INSET PICTURE THAT THE ROD GUIDE IS SEATED SNUGLY TO THE CYLINDER.

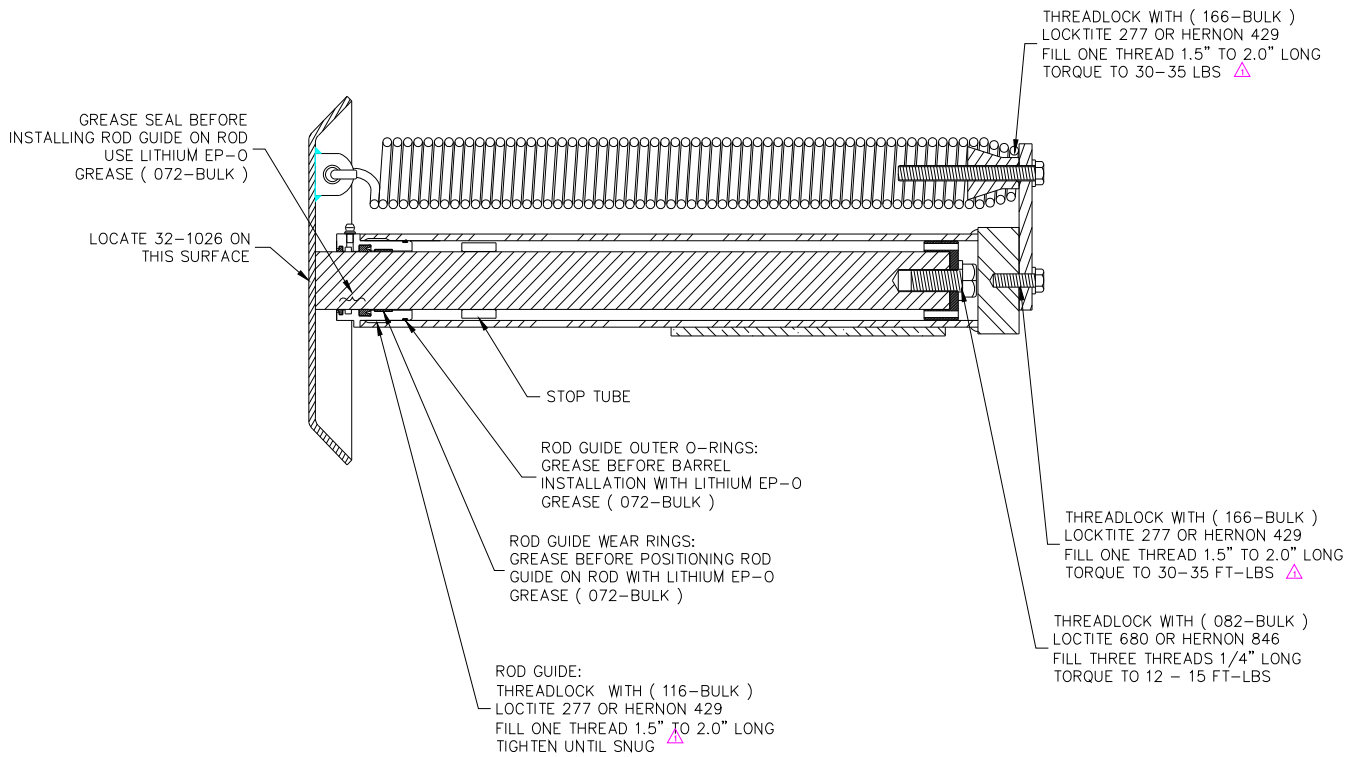


STEP 27 - APPLY 2" OF LOCKTITE TO THE THREADS IN THE MIDDLE OF THE 6" BOLT.

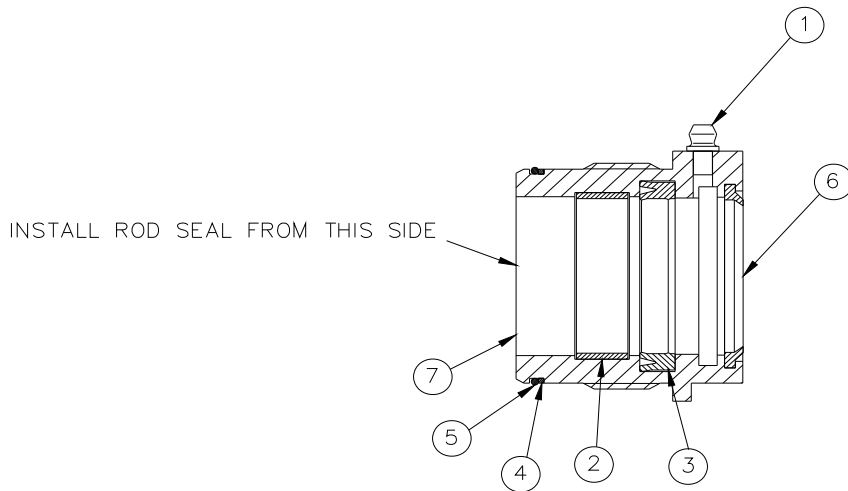
STEP 28- INSTALL THE BOLT AND TIGHTEN. TORQUE TO 45 FT/LB.

**NOTE – PAINT THE RODE GUIDE ONCE THE JACK IS COMPLETELY REASSEMBLED. GREASE THE ROD GUIDE. RE-INSTALL LEG ON THE COACH AND TEST TO OPERATE. FLUSH AND REFILL THE HYDRAULIC SYSTEM WITH FRESH FLUID (DEXTRON III). CYCLE EACH LEG 2-3 TIMES FROM FULL EXTENSION TO FULL RETRACTION AFTER FILLING RESERVOIR TO PURGE AIR FROM THE SYSTEM. BE SURE TO CHECK FLUID LEVEL AFTER EACH CYCLE OF THE LEGS.**

# EXTERNAL SPRING LEGS



EXAMPLE OF A TYPICAL ROD GUIDE CROSS SECTION DETAIL AND ORDER OF ASSEMBLY



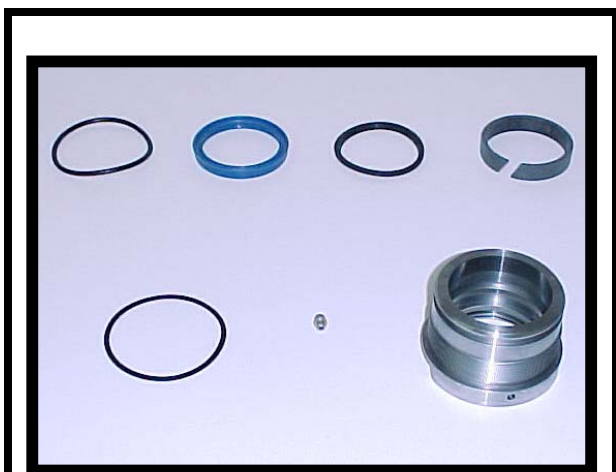
|      |                               |     |
|------|-------------------------------|-----|
| 7    | GUIDE, ROD, 6K JACK           | 1   |
| 6    | WIPER, ROD, 6K JACK           | 1   |
| 5    | RING, O, 2.25 O.D. 6K JACK    | 1   |
| 4    | WASHER, BACK-UP, 2.25 6K JACK | 1   |
| 3    | SEAL, ROD, 1.625, 6K JACK     | 1   |
| 2    | RING, WEAR, ROD, 6K JACK      | 1   |
| 1    | GREASE FITTING                | 1   |
| ITEM | DESCRIPTION                   | QTY |



**SEAL REPLACEMENT KIT PART NUMBER:**

**800129S**  
**FOR 9000 LBS. LEGS – PART NUMBERS**  
500082, 500082H, 500082HR, 500146,  
500235, 500272

**800132S**  
**FOR 6000 LBS. LEGS (2001 –PRESENT)**  
PART NUMBERS: 500384, 500384H,  
500384HR & 500482



**800129S CONTENTS**

\* included within 800145 Elastomer pkg

| QTY | PART #   | DESCRIPTION    |
|-----|----------|----------------|
| * 1 | 01-1071  | O-RING         |
| * 1 | 02-1032  | U-CUP SEAL     |
| * 1 | 03-1012  | ROD WIPER      |
| * 1 | 04-1017  | ROD WEAR RING  |
| * 1 | 040-1030 | ROD WEAR RING  |
| * 1 | 05-1027  | BACK UP WASHER |
| 1   | 500602   | ROD GUIDE      |
| 1   | 10-1002  | GREASE FITTING |
| * 1 | 030-1020 | O-RING         |
| * 1 | 050-1041 | BACK UP RING   |

The 800129S kit will include 2 similar looking rod guide wear rings. One is thicker than the other. If you are re-sealing an “HR” series jack, use the thicker wear ring



**800132S CONTENTS**

\*\* included within 800285 “HR” KIT

\* included with 800147 Elastomer pkg.

| QTY  | PART #   | DESCRIPTION    |
|------|----------|----------------|
| * 1  | 01-1078  | O-RING         |
| * 1  | 02-1033  | U-CUP SEAL     |
| * 1  | 03-1013  | ROD WIPER SEAL |
| * 1  | 04-1028  | ROD WEAR RING  |
| * 1  | 05-1037  | BACK UP WASHER |
| 1    | 10-1002  | GREASE FITTING |
| 1    | 500679   | ROD GUIDE      |
| 1    | 500497   | PISTON GUIDE   |
| ** 1 | 030-1019 | O-RING         |
| ** 1 | 050-1040 | BACK UP WASHER |
| ** 1 | 01-1078  | O-RING         |
| ** 1 | 05-1037  | O-RING         |
| ** 1 | 500752C  | ROD GUIDE      |
| ** 1 | 500756   | SEAL           |
| ** 1 | 500757   | ROD WIPER SEAL |
| ** 1 | 500758   | WEAR RING-ROD  |

The 800132S kit will have a separate kit within the box labeled 800285. Use components in this kit for HR style jacks.

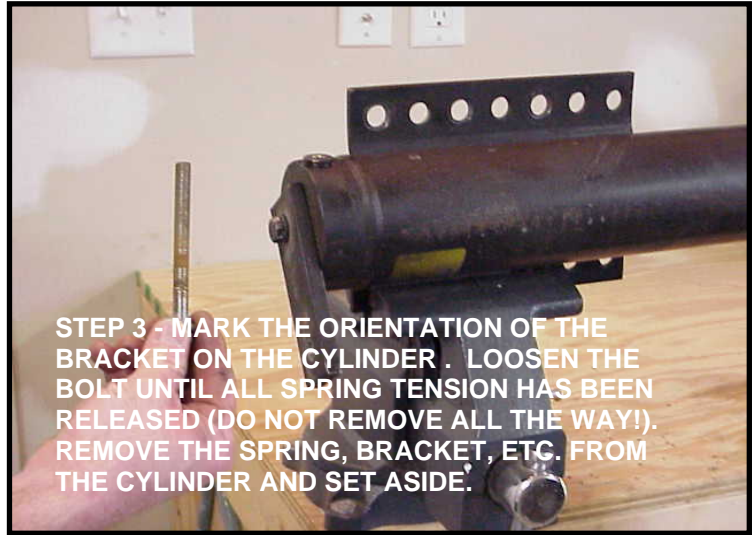


Kit numbers 800129S and 800132S include parts for two different style jacks. When re-assembling the jack you will need to determine which style you are working on. Use the following guidelines to choose the correct components: There are a few different ways to determine that you are working on an “HR” series jack.

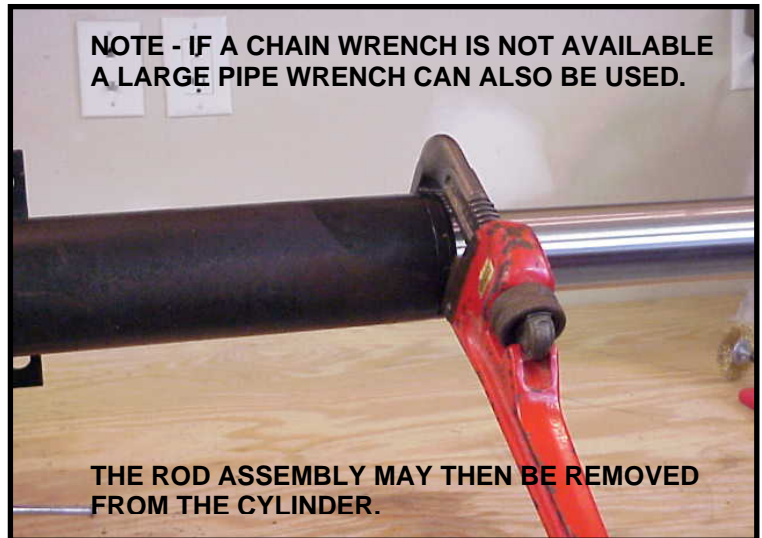
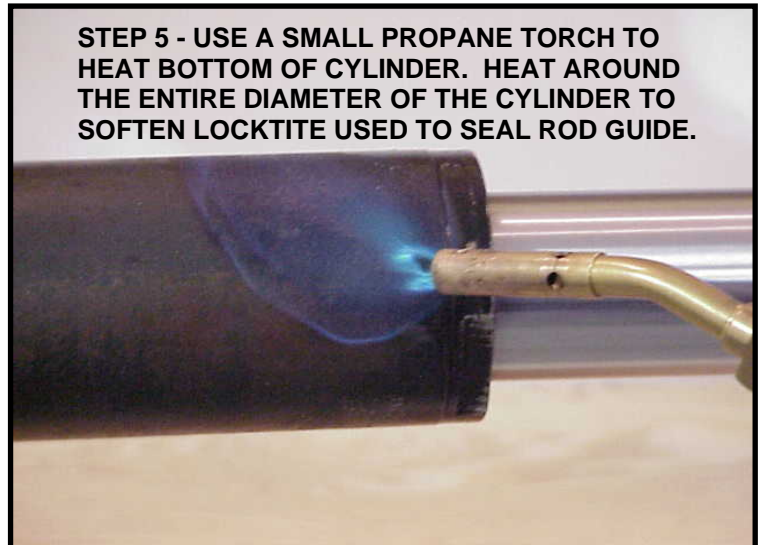
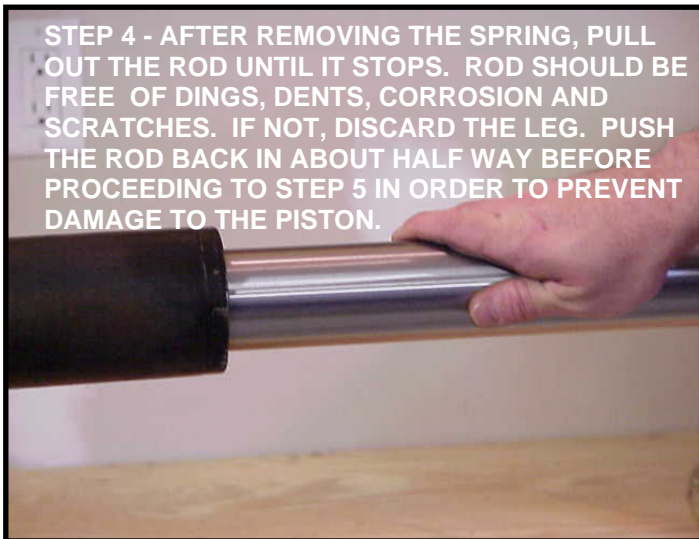
1. If the jack part number ends with the letters HR.
2. HR jacks have a #4 JIC hose fitting. Non “HR” jacks use a #6 JIC.
3. If the **piston** looks like the one pictured to the left, then it is an HR series jack.

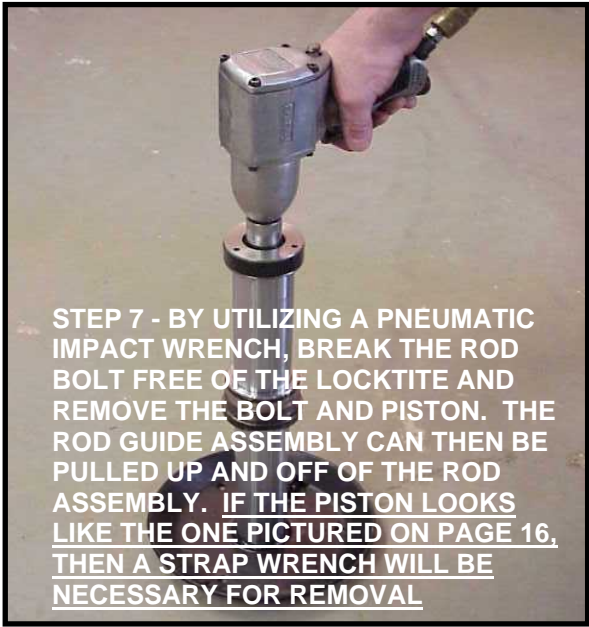


**STEP 1 - (NOT SHOWN) PRESSURE WASH THE EXTERIOR OF THE LEG TO PREVENT DIRT FROM CONTAMINATING INTERIOR OF THE LEG DURING THE REASSEMBLY PROCESS.**



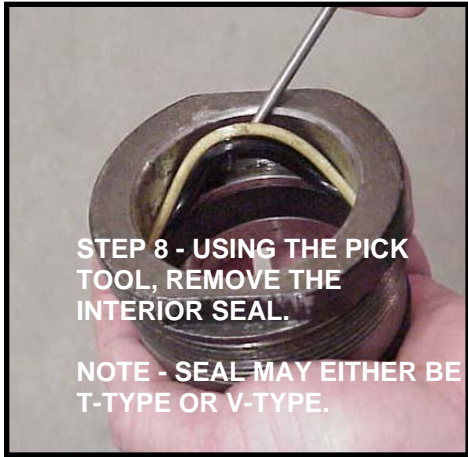
**NOTE - IT MAY BE HELPFUL WHEN MOUNTING THIS JACK IN THE VISE TO ELEVATE THE FOOT END. THIS WILL PREVENT REMAINING OIL IN THE CYLINDER FROM DRAINING OUT WHEN THE ROD IS REMOVED.**



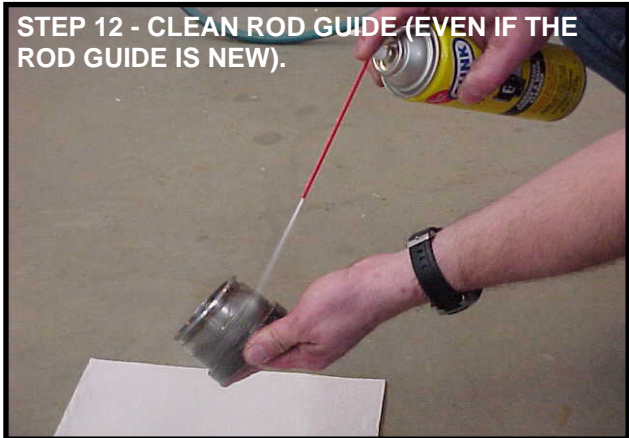


**STEP 7A- HR STYLE JACKS WILL USE A PISTON WHICH REQUIRES A STRAP WRENCH TO REMOVE**

**SKIP TO STEP 11 IF YOU ARE SUPPLIED WITH A NEW ROD GUIDE.**



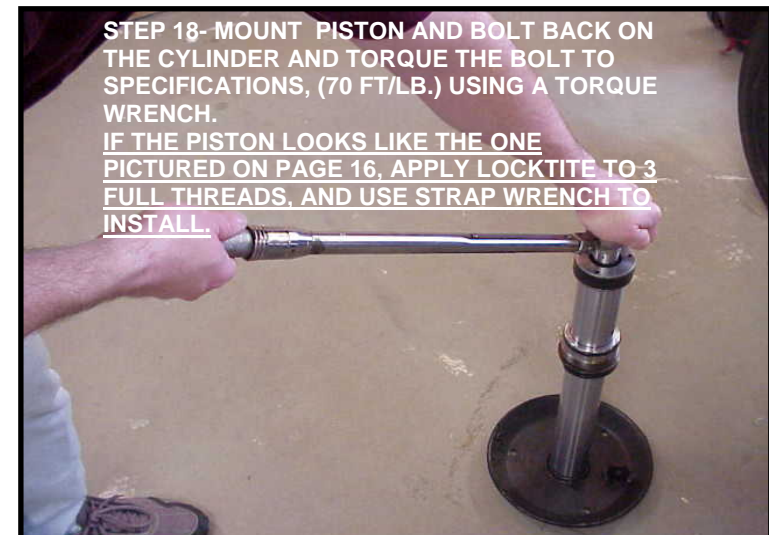
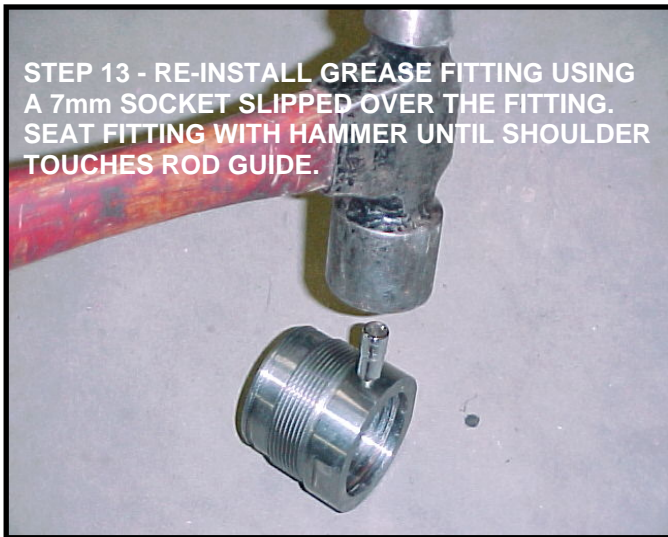
**NOTE - MAKE SURE SEALS ARE INSTALLED IN THE PROPER DIRECTION. SEALS INSTALLED INCORRECTLY WILL CAUSE THE LEG TO FAIL. PLEASE NOTE THE CROSS SECTIONAL DRAWING OF THE ROD GUIDE ON PAGES 14 AND 15 TO NOTE THE PROPER INSTALLATION OF THE SEALS AND RINGS.**



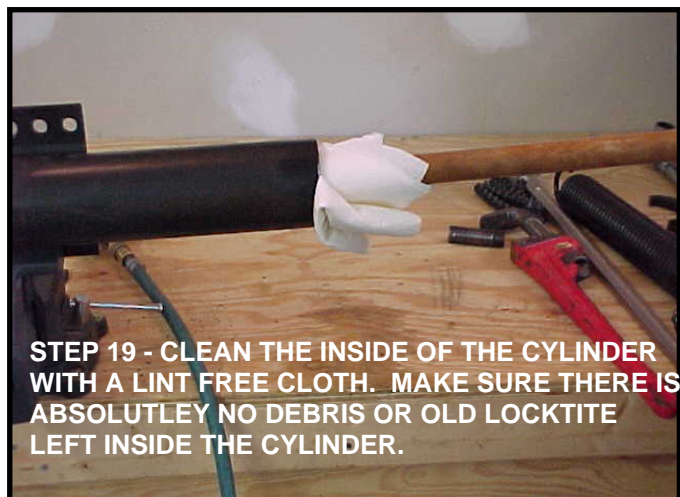
**NOTE - WIRE BRUSH DOES NOT NEED TO BE PNEUMATIC. ANY WIRE BRUSH CAN BE USED. BE CAREFUL NOT TO DAMAGE THE SOFT BEARING MATERIAL.**



**NOTE - CHECK ORDER OF ASSEMBLY ON PAGE 14.**







**STEP 19 - CLEAN THE INSIDE OF THE CYLINDER WITH A LINT FREE CLOTH. MAKE SURE THERE IS ABSOLUTLEY NO DEBRIS OR OLD LOCKTITE LEFT INSIDE THE CYLINDER.**



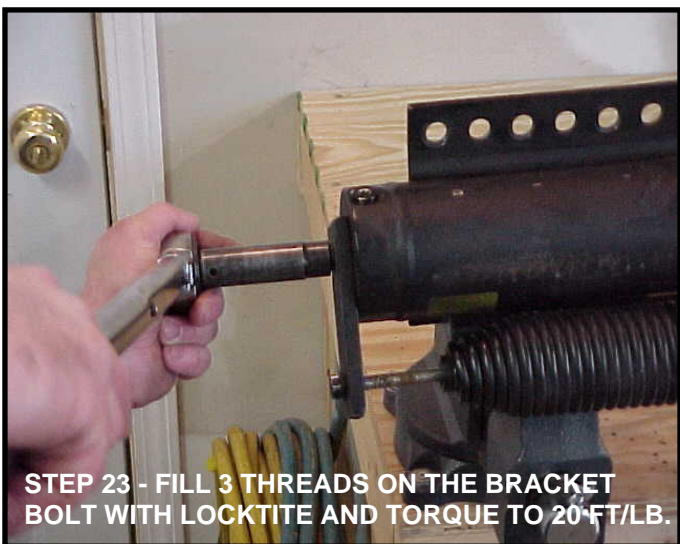
**STEP 20 - INSERT THE ROD ASSEMBLY BACK INTO THE CYLINDER.**



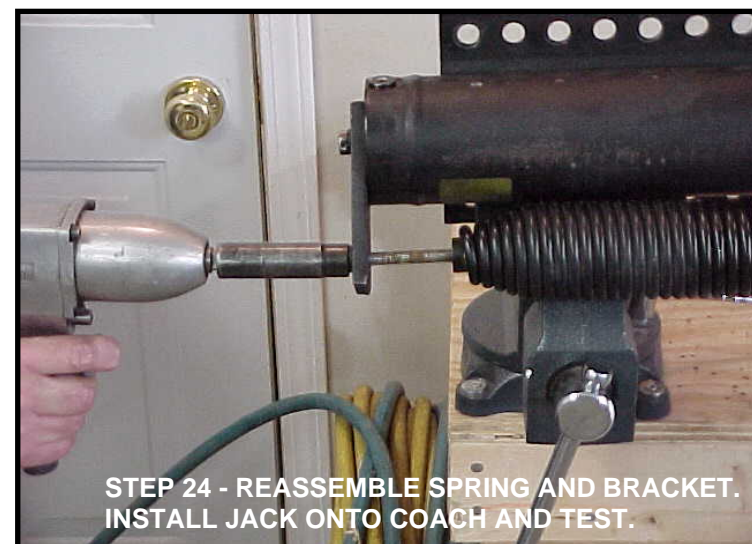
**STEP 21 - APPLY A 2" BEAD OF LOCKTITE TO THE ROD GUIDE THREADS.**



**STEP 22 - THREAD THE ROD GUIDE INTO THE CYLINDER AND TIGHTEN UNTIL SNUG.**



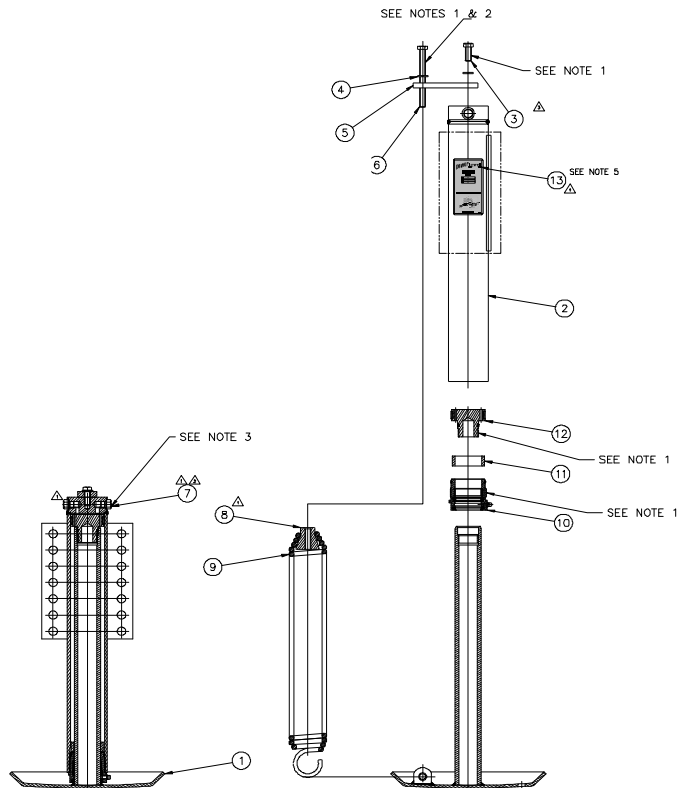
**STEP 23 - FILL 3 THREADS ON THE BRACKET BOLT WITH LOCKTITE AND TORQUE TO 20 FT/LB.**



**STEP 24 - REASSEMBLE SPRING AND BRACKET. INSTALL JACK ONTO COACH AND TEST.**

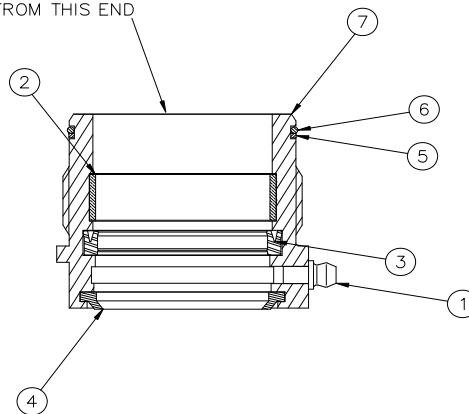
**NOTE - GREASE THE ROD GUIDE AND PAINT THE ROD GUIDE AREA ONCE THE JACK HAS BEEN FULLY ASSEMBLED. RE-INSTALL LEG ON THE COACH AND TEST TO OPERATE. FLUSH AND REFILL THE HYDRAULIC SYSTEM WITH FRESH FLUID (DEXTRON III). CYCLE EACH LEG 2-3 TIMES FROM FULL EXTENSION TO FULL RETRACTION TO PURGE AIR FROM THE SYSTEM. BE SURE TO CHECK FLUID LEVEL AFTER EACH CYCLE OF THE LEGS.**

# POWER LEVEL HYDRAULIC LEGS



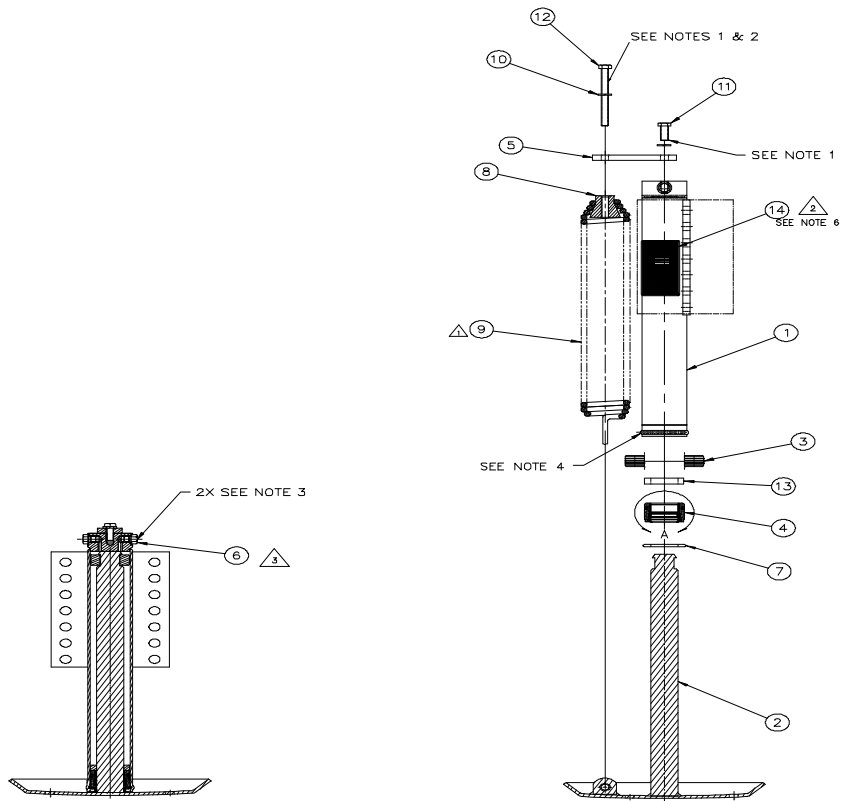
**EXAMPLE OF A TYPICAL  
POWER GEAR POWER LEVEL HYDRAULIC LEG CROSS SECTION DETAIL  
LEG PART NUMBERS - 500759-500833-500843**

INSTALL SEAL 605 FROM THIS END

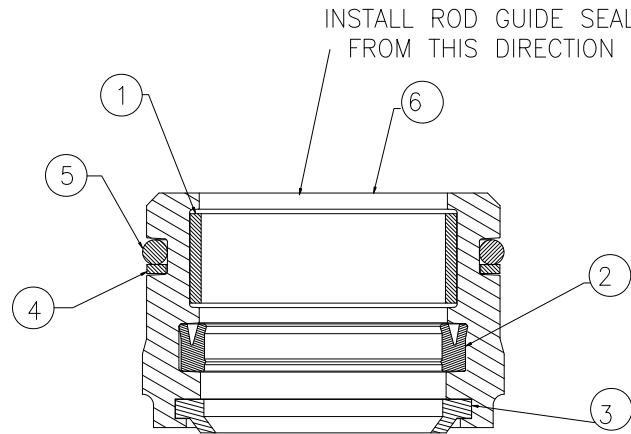


|      |                                  |     |
|------|----------------------------------|-----|
| 7    | ROD GUIDE 1.75 ROD HOLLOW        | 1   |
| 6    | O-RING 2.25 O.D. 9K-LW JACK      | 1   |
| 5    | BACK-UP WASHER 2.25 9K LW JACK   | 1   |
| 4    | WIPER, ROD, 9K-LW JACK 1.75 DIA. | 1   |
| 3    | SEAL 605 1.75                    | 1   |
| 2    | WEAR RING 1.75 DIA. ROD          | 1   |
| 1    | GREASE FITTING                   | 1   |
| ITEM | DESCRIPTION                      | QTY |

**EXAMPLE OF A TYPICAL  
ROD GUIDE CROSS SECTION DETAIL AND ORDER OF ASSEMBLY  
LEG PART NUMBERS - 500759-500833-500843**



**EXAMPLE OF A TYPICAL  
POWER GEAR POWER LEVEL HYDRAULIC LEG CROSS SECTION DETAIL  
LEG PART NUMBERS - 500730-500832-500842**

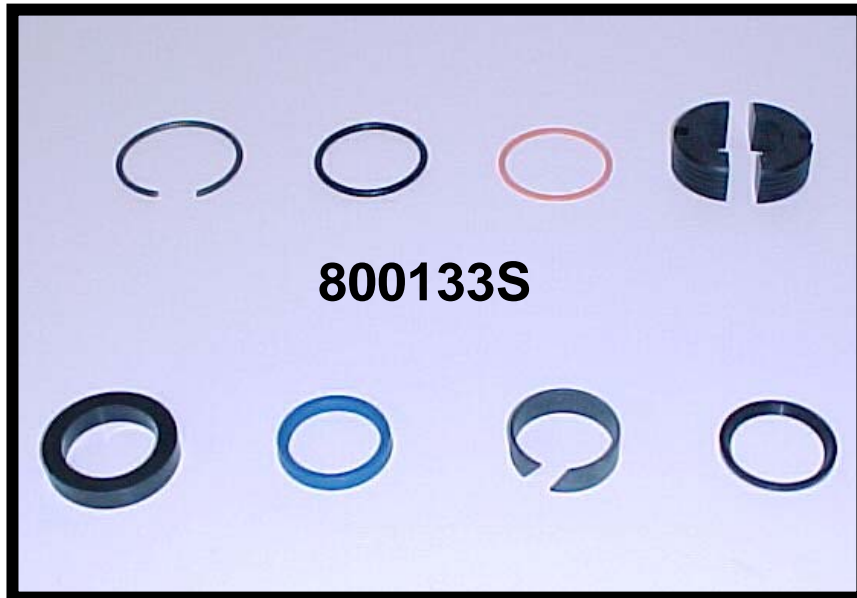


|       |                 |     |
|-------|-----------------|-----|
| 6     | 6K ROD GUIDE    | 1   |
| 5     | O-RING          | 1   |
| 4     | BACK-UP WASHER  | 1   |
| 3     | ROD WIPER 1.375 | 1   |
| 2     | ROD GUIDE SEAL  | 1   |
| 1     | WEAR RING 1.375 | 1   |
| ITEM# | DESCRIPTION     | QTY |

**EXAMPLE OF A TYPICAL 6K JACK ROD GUIDE  
CROSS SECTION DETAIL AND ASSEMBLY ORDER  
LEG PART NUMBERS - 500730-500832-500842**

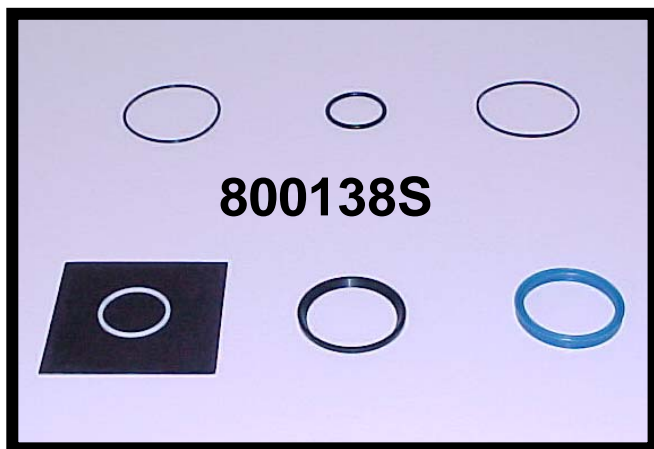


**SEAL REPLACEMENT KIT PART NUMBER – 800133S  
FOR 6000 LBS. POWER LEVEL LEGS – PART NUMBERS – 500730, 500832, 500842, 500933**



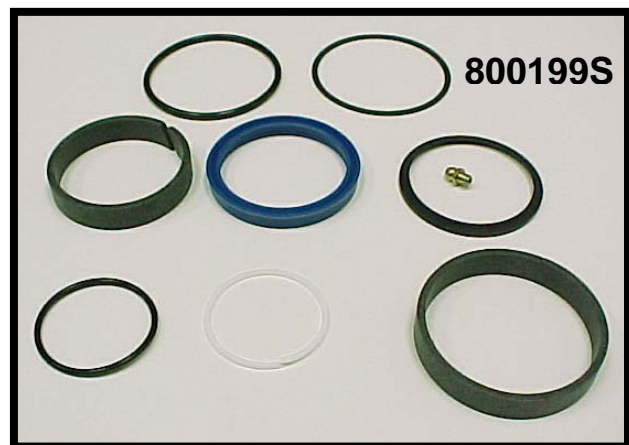
\* included within 800148 Elastomer pkg

| QTY | PART #   | DESCRIPTION    |
|-----|----------|----------------|
| 1   | A8121049 | RETAINING RING |
| * 1 | 01-1009  | O-RING         |
| * 1 | 05-1020  | BACK-UP WASHER |
| 2   | 500734   | PISTON         |
| 1   | 500739   | NYLON STOP     |
| * 1 | 500746   | ROD GUIDE SEAL |
| * 1 | 500747   | WEAR RING      |
| * 1 | 500748   | ROD WIPER      |



\* included within 800150 Elastomer pkg

| QTY | PART #   | DESCRIPTION         |
|-----|----------|---------------------|
| * 1 | 01-1078  | O-RING              |
| * 1 | 030-1019 | O-RING              |
| * 1 | 050-1040 | TEFLON BACK-UP RING |
| * 1 | 05-1037  | BACK-UP RING        |
| * 1 | 500756   | ROD GUIDE SEAL      |
| * 1 | 500757   | ROD WIPER           |
| 1   | 10-1002  | GREASE FITTING      |



\* included within 800200 Elastomer pkg

| QTY | PART #   | DESCRIPTION      |
|-----|----------|------------------|
| * 1 | 01-1071  | O-RING           |
| * 1 | 02-1032  | U-CUP SEAL       |
| * 1 | 03-1012  | ROD WIPER        |
| * 1 | 030-1020 | O-RING           |
| * 1 | 040-1029 | PISTON WEAR RING |
| * 1 | 040-1030 | ROD WEAR RING    |
| * 1 | 05-1027  | BACK UP WASHER   |
| * 1 | 050-1041 | BACK UP RING     |
| 1   | 10-1002  | GREASE FITTING   |

**NOTE -THE FOLLOWING DISASSEMBLY PROCEDURE IS FOR 6K LEGS. 9 AND 12K LEGS WILL USE THE SAME REBUILD PROCEDURE AS ON EXTERNAL SPRING STYLE LEGS. (NOT SHOWN) PRESSURE-WASH THE EXTERIOR OF THE LEG TO PREVENT DIRT FROM CONTAMINATING INTERIOR OF THE LEG DURING THE RE-ASSEMBLY PROCESS.**



**NOTE - IT MAY BE HELPFUL WHEN MOUNTING THIS JACK IN THE VISE TO ELEVATE THE FOOT END. THIS WILL PREVENT REMAINING OIL IN THE CYLINDER FROM DRAINING OUT WHEN THE ROD IS REMOVED.**



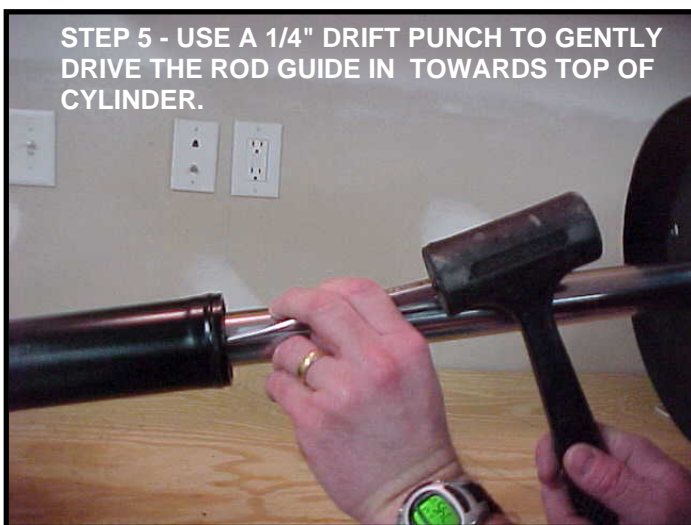
**STEP 2 - USING AN IMPACT WRENCH, LOOSEN SPRING TENSION BOLT UNTIL ALL SPRING TENSION HAS BEEN RELEASED (DO NOT REMOVE ALL THE WAY!), THEN REMOVE THE CYLINDER BRACKET BOLT TO REMOVE THE BRACKET BOLT SPRING**



**NOTE - WHEN SPRING TENSION AND BRACKET BOLT HAVE BEEN REMOVED, THE ENTIRE SPRING/BRACKET ASSEMBLY CAN BE REMOVED.**



**STEP 4 - AFTER REMOVING THE SPRING, PULL OUT THE ROD UNTIL IT STOPS. ROD SHOULD BE FREE OF DINGS, DENTS, CORROSION AND SCRATCHES. IF NOT, DISCARD THE LEG.**

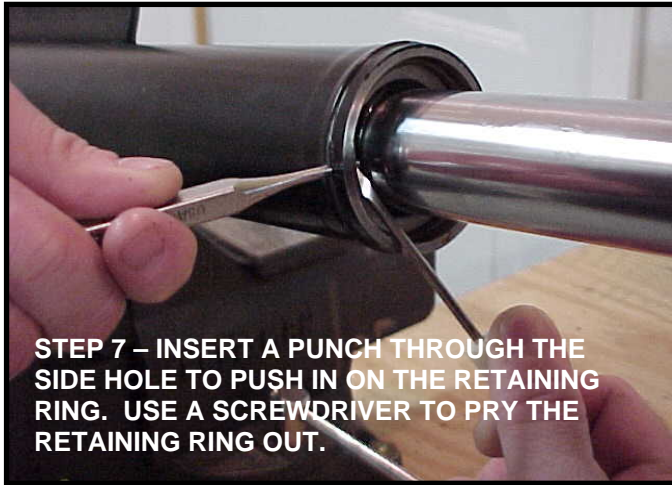


**STEP 5 - USE A 1/4" DRIFT PUNCH TO GENTLY DRIVE THE ROD GUIDE IN TOWARDS TOP OF CYLINDER.**

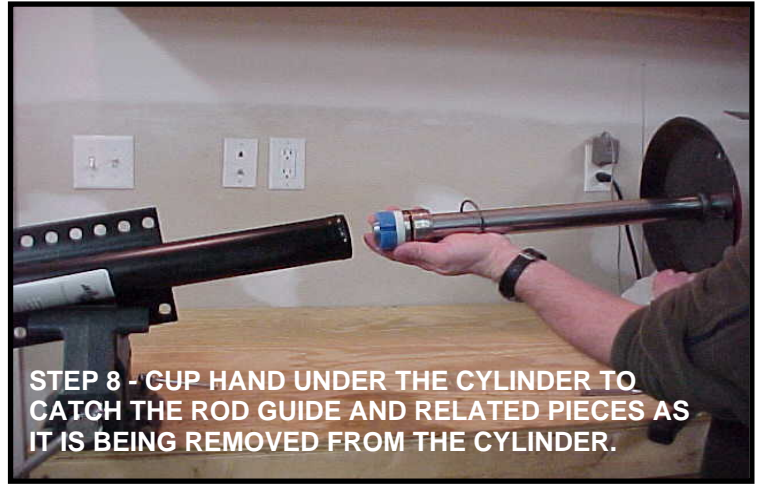


**STEP 6 - USE A 1/8" OR SMALLER DRIFT PIN PUNCH TO LOOSEN THE RETAINING RING.**





**STEP 7 – INSERT A PUNCH THROUGH THE SIDE HOLE TO PUSH IN ON THE RETAINING RING. USE A SCREWDRIVER TO PRY THE RETAINING RING OUT.**



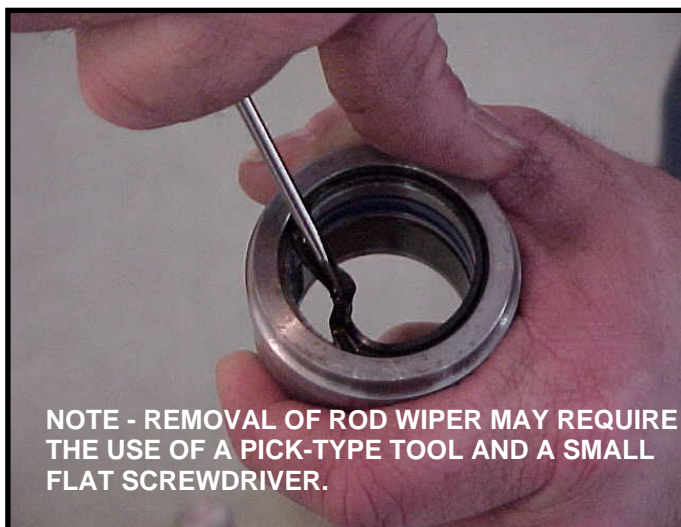
**STEP 8 - GUP HAND UNDER THE CYLINDER TO CATCH THE ROD GUIDE AND RELATED PIECES AS IT IS BEING REMOVED FROM THE CYLINDER.**



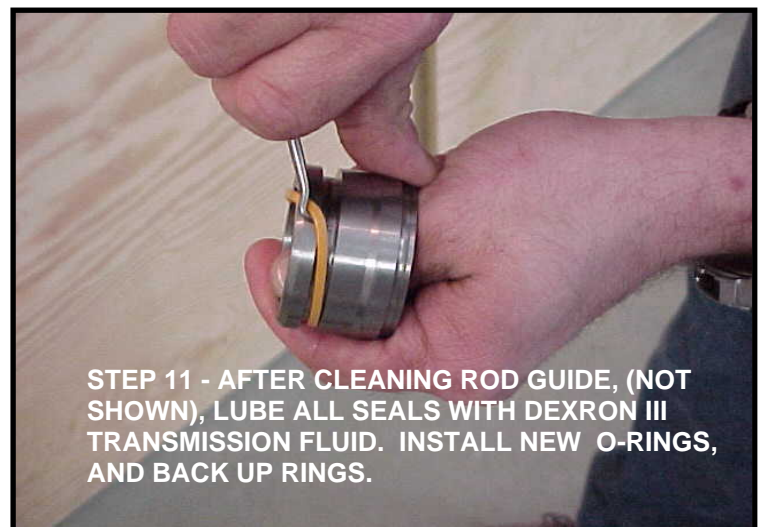
**STEP 9 - REMOVE PLASTIC PISTON FROM END OF ROD. PISTON WILL COME OFF IN TWO PIECES.**



**STEP 10 - USE A SUITABLE TOOL TO REMOVE BOTH SEALS FROM THE ROD GUIDE.**



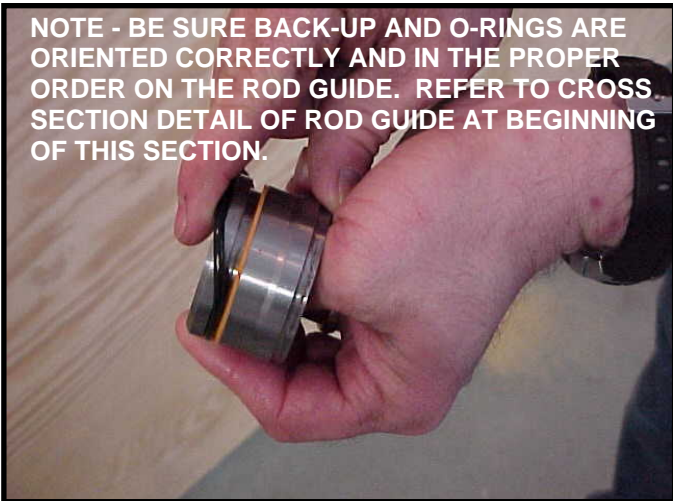
**NOTE - REMOVAL OF ROD WIPER MAY REQUIRE THE USE OF A PICK-TYPE TOOL AND A SMALL FLAT SCREWDRIVER.**



**STEP 11 - AFTER CLEANING ROD GUIDE, (NOT SHOWN), LUBE ALL SEALS WITH DEXRON III TRANSMISSION FLUID. INSTALL NEW O-RINGS, AND BACK UP RINGS.**

**NOTE - MAKE SURE SEALS ARE INSTALLED IN THE PROPER DIRECTION. SEALS INSTALLED INCORRECTLY WILL CAUSE THE LEG TO FAIL. PLEASE NOTE THE CROSS SECTIONAL DRAWING OF THE ROD GUIDE ON PAGES 21 AND 22 TO NOTE THE PROPER INSTALLATION OF THE SEALS AND RINGS.**

**NOTE - BE SURE BACK-UP AND O-RINGS ARE ORIENTED CORRECTLY AND IN THE PROPER ORDER ON THE ROD GUIDE. REFER TO CROSS SECTION DETAIL OF ROD GUIDE AT BEGINNING OF THIS SECTION.**



**STEP 12-INSTALL THE NEW WEAR RING BY COMPRESSING IT UNTIL THE ENDS OVERLAP. INSTALL NEW LIP SEAL WITH THE GROOVE POINTED UP. INSTALL FROM THE TOP SIDE TO PREVENT DAMAGE TO THE SEAL EDGES.**



**STEP 13 - INSTALL WIPER SEAL. MAKE SURE SEAL IS ORIENTED PROPERLY. FAILURE TO DO SO WILL CAUSE THE LEG TO FAIL.**



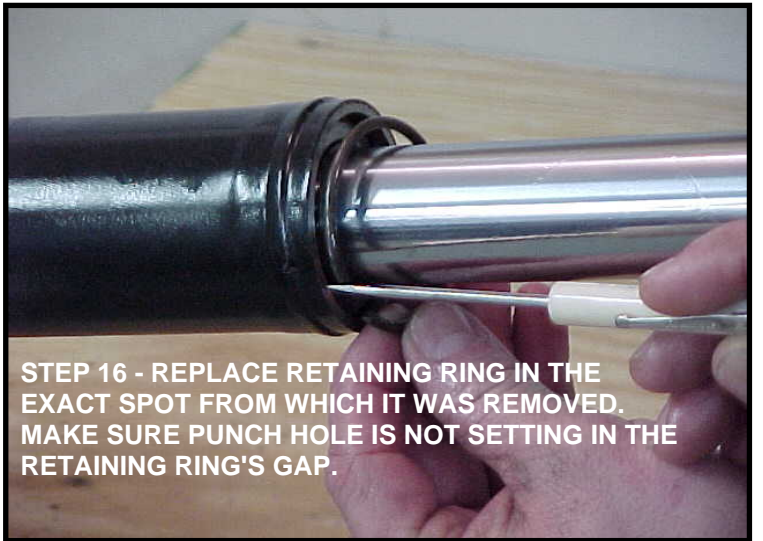
**STEP 14 - CLEAN INTERIOR OF LEG CYLINDER. USE A DUSTLESS CLOTH OR SHOP RAG. BE SURE TO REMOVE ALL DEBRIS.**



**STEP 15 - REPLACE ROD GUIDE ON TO ROD. REPLACE BOTH PIECES OF THE PISTON AND CUP THE REASSEMBLED ROD GUIDE IN YOUR HAND. INSERT THE ROD ASSEMBLY BACK INTO THE CYLINDER.**

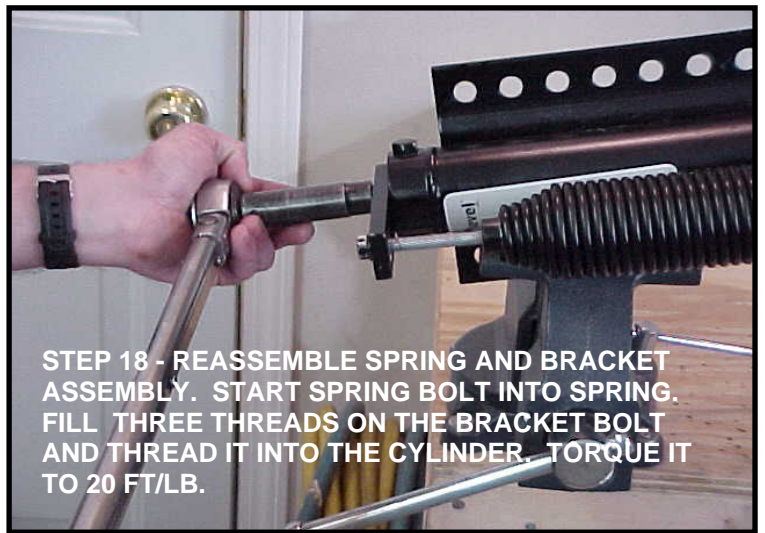
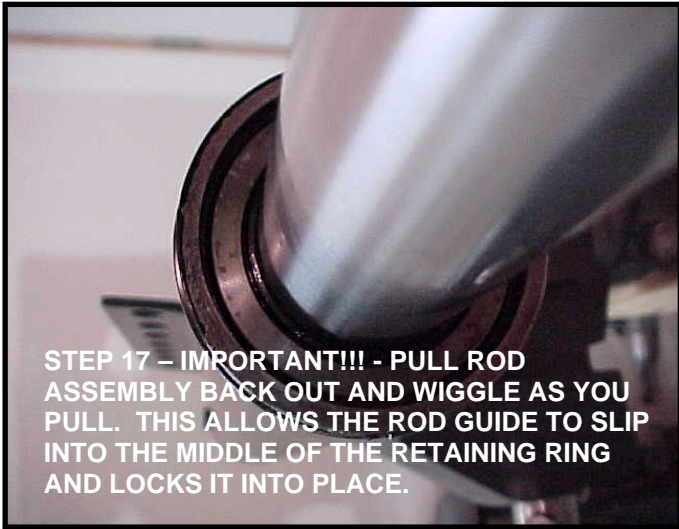


**STEP 16 - REPLACE RETAINING RING IN THE EXACT SPOT FROM WHICH IT WAS REMOVED. MAKE SURE PUNCH HOLE IS NOT SETTING IN THE RETAINING RING'S GAP.**



**NOTE - MAKE SURE SEALS ARE INSTALLED IN THE PROPER DIRECTION. SEALS INSTALLED INCORRECTLY WILL CAUSE THE LEG TO FAIL. PLEASE NOTE THE CROSS SECTIONAL DRAWING OF THE ROD GUIDE ON PAGES 20 AND 21 TO NOTE THE PROPER INSTALLATION OF THE SEALS AND RINGS.**





**NOTE - RE-INSTALL LEG ON THE COACH AND TEST TO OPERATE. FLUSH AND REFILL THE HYDRAULIC SYSTEM WITH FRESH FLUID (DEXTRON III). CYCLE EACH LEG 2-3 TIMES AFTER FILLING RESERVOIR TO PURGE AIR FROM THE SYSTEM AND PUSH THE FLUID THROUGH THE LINES. BE SURE TO CHECK FLUID LEVEL AFTER EACH CYCLE OF THE LEGS.**