

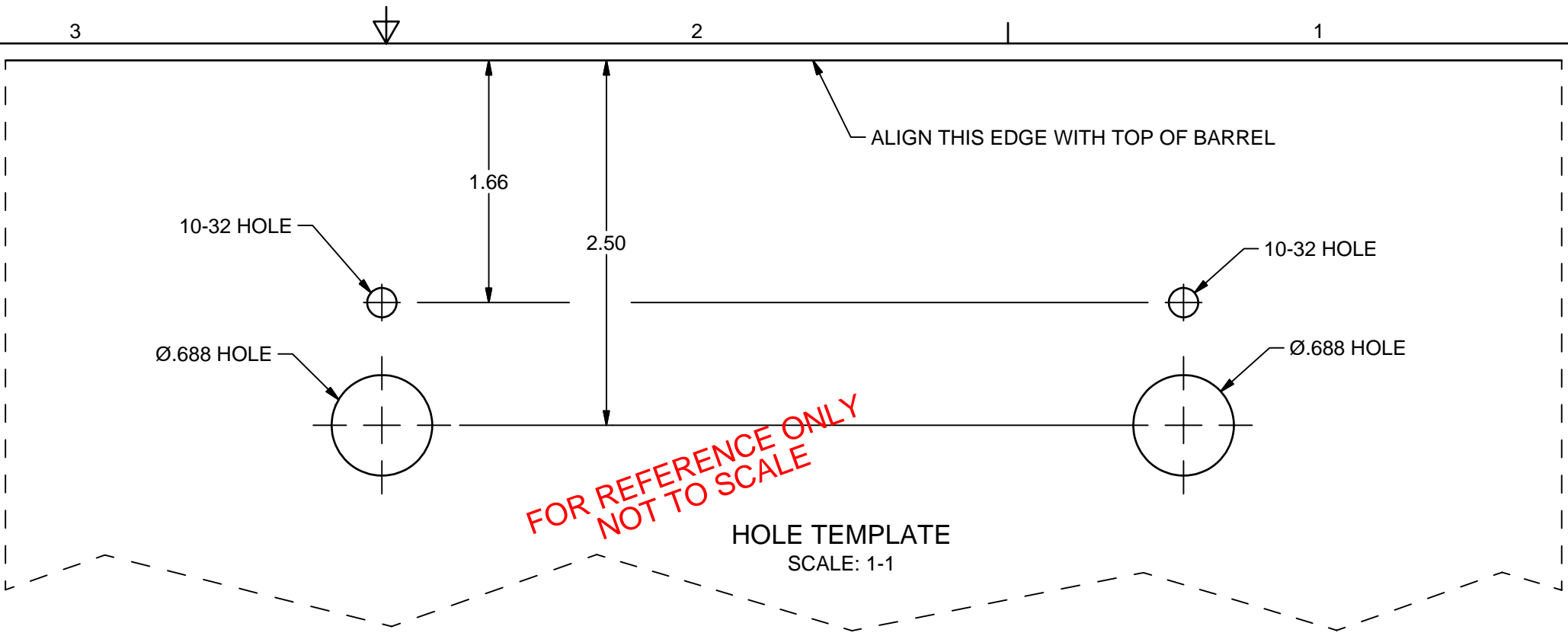
\*READ ALL INSTRUCTIONS BEFORE BEGINNING\*

**DISASSEMBLE STRUT:**

1. REMOVE PISTON/COLLAR ASSEMBLY FROM BARREL.
2. REMOVE T-HANDLES AND PINS w/LANYARDS. DO NOT DISCARD.
3. REMOVE RUBBER CUP AND WASHER ON THE BOTTOM OF PISTON BY REMOVING THE HEX BOLT. DO NOT DISCARD. INSPECT FOR ANY WEAR OR DAMAGE TO RUBBER. IT MAY BE NECESSARY TO USE A PUTTY KNIFE TO BREAK CUP AND WASHER LOOSE FROM PISTON.
4. SLIDE OLD COLLAR OFF OF PISTON.
5. CLEAN OUT BARREL AND WIPE DOWN.

**BARREL MODIFICATION INSTRUCTIONS:**

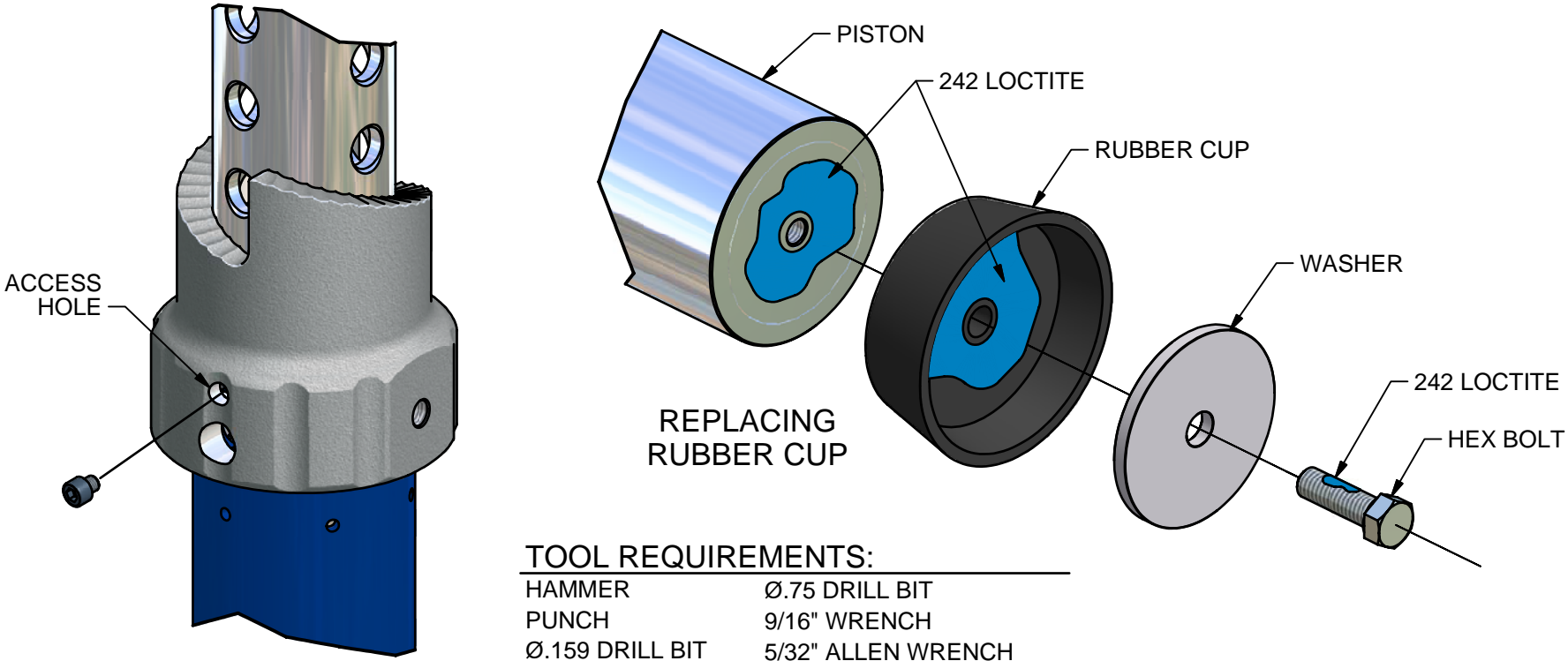
1. CUT OUT TEMPLATE, ALIGN WITH TOP OF BARREL AND MARK/PUNCH HOLES TO BE ADDED
2. DO NOT DRILL THRU BARREL TO MAKE BOTH SETS OF HOLES
3. TO MAKE THE 10-32 HOLES, DRILL THRU ONE WALL AT A TIME WITH A Ø.159 (21) DRILL BIT. TAP HOLES USING A 10-32 UNC-3B TAP. USE A Ø.25 DRILL BIT TO DEBURR/CHAMFER THE 10-32 HOLES. ONLY DRILL DEEP ENOUGH TO KNOCK OFF THE SHARP EDGES.
4. USE A Ø11/16" (.688) DRILL BIT TO MAKE THE TWO LARGER HOLES. DRILL THRU ONE SIDE AT A TIME. TO DEBURR/CHAMFER THE EDGES OF THESE HOLES USE A Ø3/4" (.75) DRILL BIT. ONLY DRILL DEEP ENOUGH TO KNOCK OFF THE SHARP EDGES.
5. CHECK THE ID OF ALL NEW HOLES FOR BURRS. USE SANDPAPER OR A FILE TO KNOCK OFF ANY BURRS. IF BURRS ARE NOT REMOVED THEY COULD DAMAGE THE RUBBER CUP.



THIS RETROFIT KIT IS  
**NOT** INTENDED FOR  
UPGRADING THE AA STRUT


**REASSEMBLE STRUT:**

1. REMOVE RUBBER CUP AND WASHER BY LOOSENING THE HEX BOLT. INSPECT RUBBER CUP FOR WEAR AND/OR DRY ROT. REPLACE IF NECESSARY. REMOVE ANY LOCTITE RESIDUE FROM ALL COMPONENTS. DO NOT USE ANY SOLVENTS.
2. SLIDE NEW E.C. COLLAR ONTO PISTON. MAKE SURE THE TEETH ARE FACING UP TOWARD THE TOP OF THE PISTON.
3. REPLACE RUBBER CUP, WASHER AND HEX BOLT. SEE ILLUSTRATION FOR MORE DETAILS. DO NOT OVER-TIGHTEN THE BOLT. WIPE AWAY ANY EXCESS LOCTITE. SPRAY RUBBER CUP WITH A NON-PETROLEUM BASED SILICONE (3M SILICONE LUBRICANT RECOMMENDED).
4. RE-ASSEMBLE PISTON INTO THE BARREL. COLLAR SHOULD REST ON TOP OF BARREL. APPLY A SMALL AMOUNT OF 242 LOCTITE TO THE THREADS OF THE 10-32 SHCS. USING THE SMALL ACCESS HOLE, FASTEN THE 10-32 SHC SCREWS (215A186) TO THE BARREL. ROTATE COLLAR TO ACCESS OTHER HOLE. COLLAR SHOULD SPIN FREELY ON TOP OF THE BARREL. ALLOW LOCTITE APPROXIMATELY FOUR HOURS TO SET BEFORE PRESSURIZING THE STRUT WITH AIR.
5. REPLACE T-HANDLES WITH PINS & LANYARDS.



**TOOL REQUIREMENTS:**

- |                  |                              |
|------------------|------------------------------|
| HAMMER           | Ø.75 DRILL BIT               |
| PUNCH            | 9/16" WRENCH                 |
| Ø.159 DRILL BIT  | 5/32" ALLEN WRENCH           |
| 10-32 UNC-2B TAP | LOCTITE 242 (BLUE)           |
| Ø.25 DRILL BIT   | NON-PETROLEUM SILICONE SPRAY |
| Ø.688 DRILL BIT  |                              |

PART NO:		MAT'L SPEC.		NOMINAL SIZE:		
REPORT ERRORS & CHANGES REMOVE ALL SHARP EDGES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCE ON: DECIMALS    ANGLES .XX ± .010       ± 1/2" .XXX± .005		 HURST JAWS OF LIFE®		HALE PRODUCTS, INC. A Unit of IDEX Corporation Shelby, NC 28150 USA		
				TITLE  E.C. COLLAR RETROFIT		
COPYRIGHT © NOT TO BE REPRODUCED OR USED TO MAKE OTHER DRAWINGS OR MACHINERY		SIZE            B		DWG NO:    159A185		
DATE:        5/22/2008						
DRAWN:       Tab		SCALE: varies		SHEET    1       OF       1		REV:    01