Use a tape measure to measure the distance from the top of the workpench to the top of the gauge pin, and record the dimension.



- Install the appropriate straight gauge pin in the fulle and bore.
  - Inspect the internal tions of the future eye. If it is damaged, it may be officiall to mated the gauge pin anothe can result in an incolurate measurement. Report the tions before installing the gauge pin.
  - Insert the straight gauge pin in the subservolume.

#### MOTICE

Do not force the gauge pin into the tone, because damage to the pin and/or not eye can occur. Damage may also cause the pin not to be perpendicular to the cylinder, resulting in an inaccurate inassurances.

 Rotate the gauge pin until the roll pin is orderted opposite the cylinder tube.

- d. Side the straight gauge pin into the tube end bore until the top-of the gauge pin is the same distance from the tip of the bench as the abspect gauge pin at the culticion rod end. Other to the massurement recorded in Siles 4.3
- In order to limity hold the gauge pin in the center of the habe bore, expand the gauge pin by holding the skilled head. both with a large intrevolver and lightering the nut.

NOTE: Do not over lighten the nut. Only slight pressure is necessary to securely hold the pin.

#### Measuring the Cylinder

#### & WARNING



Potential pinch point. Keep hands clear, and use caution when retracting the cylinder red.

- Connect a portable hydraulic pump, a hand-operated hydraulic pump, or a source of compressed air to the cylinder's hydraulic ports. This will enable manual extraction and enteracio of the cylinder loot.
- Completely retract the cylinder and into the cylinder. Complete retraction of the cylinder and is critical for accurate measurements.



 Use two technicians to measure the retracted arright. Each technician should use the fit Tape to measure the distance three times.

NOTE: Road the Pi Tago in the teme manner as senior colors. For more information on now to read the Pi Tago, refer to "Reading the Pi Tago" later in this stockhort.  Position the PI Topo around the top of the two gauge pins, between the etop on the gauge pins and the roll pins in the to-of the gauge pins. Pull the IN Topo until it is fortic.



- Record his measurement.
- Repeat to obtain three readings from each technician.
- Determine the two obsect measurements. Add these two readings and divide by two to determine an average measurement.

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# **Tool Operating Manualjustanswer**

Jorge Valenzuela Jiménez, Adrián González Sánchez

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