OIL REFILL AND AIR BLEEDING INSTRUCTIONS

For Hydro-Pneumatic Cylinders

Check oil level
With the power stroke fully extended, it must be possible to manually push the indicator pin (back of cylinder) into the cylinder until flush. This does require a bit of force. If the pin can be pushed to flush, oil level is ok.

Recommended oil types
Hydraulic Oil Type HL or HLP with a viscosity of 32mm^2/sek at 40°
BP-Energol HL32
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Mobile Nuto H32

IMPORTANT: DO NOT DEVIATE FROM THE FOLLOWING REFILLING ROCEDURES.
OVERFILLING WILL RESULT IN DAMAGE TO THE FEED PISTON AND THE MALFUNCTION OF THE CYLINDER.

Refill oil level
Use only the proper oil pump with the correct fitting. Part number 404886 Sold by SCHMIDT Technology.
Use only hydraulic oil as recommended above**.**

Piston rod pointing down
1.   Air pressure 30 – 70 psi is applied to cylinder. Ram / piston is retracted in its home position (do not energize any valves).
2.   Remove plate (size approximately 3" x 0.5") located on back of cylinder. The 0.6 mm / 0.025" hole should be visible.
3.   Connect oil pump to refill port and pump oil until it flows out of the hole without any air bubbles. Ensure that the pump has adequate amount of oil so no oil is pumped into the cylinder.
4.   Pump again after 30 minutes
5.   Place plate back on cylinder
      >> ready for operation

Piston rod horizontal
1.   Air pressure 30 – 70 psi is applied to cylinder. Ram / piston is retracted in its home position (do not energize any valves).
2.   Remove plate (size approximately 3" x 0.5") located on back of cylinder. The 0.6 mm / 0.025" hole should be visible.
3.   Remove knurled cap of the high-pressure control port. Press on center of fitting with a 2 mm diameter pin until oil flows out of the fitting without any air bubbles.
4.   Connect oil pump to refill port and pump oil until it flows out of the hole without any air bubbles. Ensure that the pump has adequate amount of oil so no oil is pumped into the cylinder.
5.   Pump again after 30 minutes
6.   Place plate back on cylinder
      >> ready for operation