



Double-Wall® Air Cylinder

General Repair Instructions

K-B-□, K-D-□, K-P-M-□

Disassembly

- 1) Remove 4 plate screws, retaining plate, rod wiper bushing assembly, plastic spacer, and rod seal from the front of the cylinder.
- 2) Using a screw driver, remove the front retaining ring and discard.
- 3) Pull rod out of assembly. This will also remove the rod guide and possibly the inner body.
- 4) For DWD versions; repeat steps 1-2 on the rear of the cylinder.
- 5) Using a screw driver, remove the rear retaining ring and discard.
- 6) Remove rear head. If the inner body was not removed in step 3, it will be removed now.
- 7) Remove O-rings from the rod guide(s) and/or rear head and discard.
- 8) Remove wave spring(s) from rod guide(s) and discard.
- 9) Remove piston seal(s), piston wear strip, and magnet (M options only) from the piston and discard.

Repair

- 1) Install piston seal(s) after they are lightly lubed, piston wear strip, and magnet (M options only) onto the piston.
- 2) Install wave spring(s) onto rod guide(s).
- 3) Install O-rings onto the rod guide(s) and/or rear head.
- 4) Install the rear head (or rear rod guide) into rear end of outer body with the body hole and port threads inline.
- 5) Install a new retaining ring back into the rear groove in the outer body.
- 6) Install the rod guide onto the inner body.
- 7) Insert the piston and rod assembly approximately midway into the inner body with the rod sticking through the rod guide.
- 8) Insert the rod guide and sub-assembly into the front of outer body with the body hole and port threads inline.
- 9) Press in rod guide to compress the wave spring, then install a new retaining ring back into the front groove in the outer body.
- 10) Install rod seal, rod wiper bushing assembly, plastic spacer, and retaining plate back onto front of cylinder.
- 11) Install 4 plate screws to finish the re-build.

