

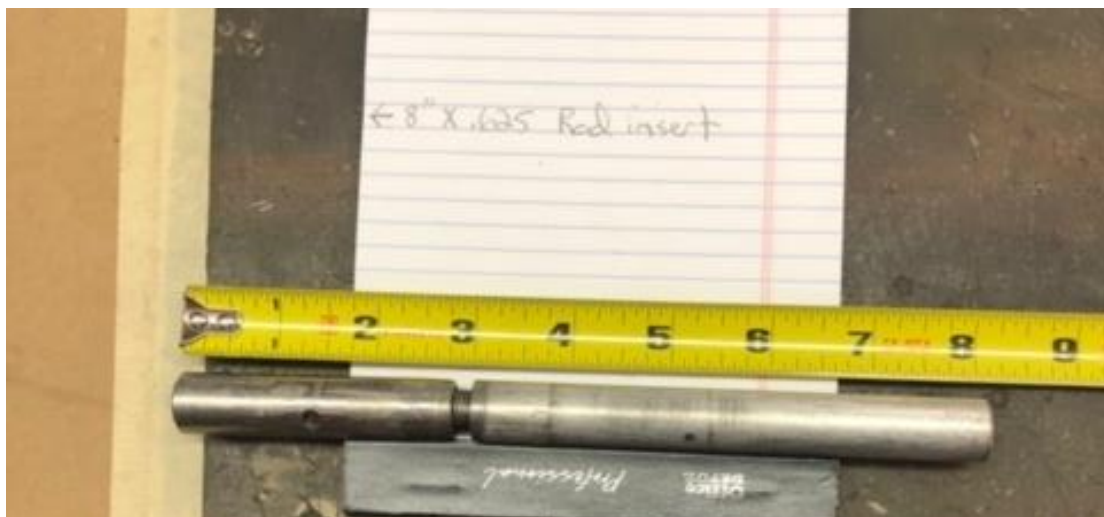
# SPRING CYLINDER REMOVAL OF SPRING PROCEDURE

## TOOLS REQUIRED:

1.6875" SPANNER WRENCH  
WITH .875 HOLE, 3/16" PINS



.625 x 8" SOLID METAL ROD

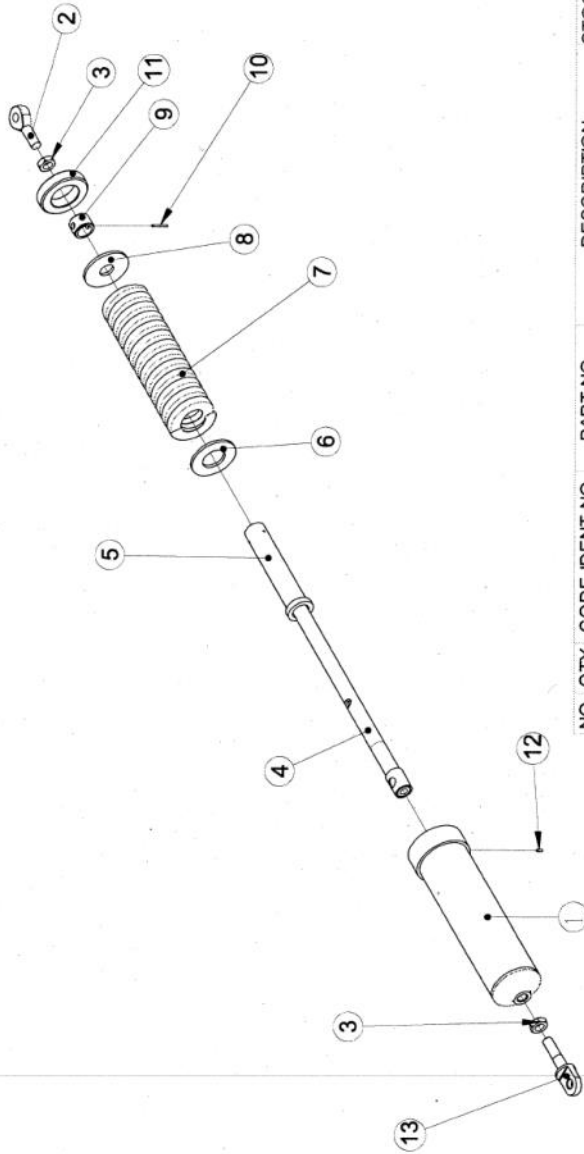


## TOOLS REQUIRED CONT.):

.625 x 5.5" SOLID METAL ROD, WITH ONE  
END THREADED 1/2" FOR 7/16-20



REV	ECN	DESCRIPTION	APP'D BY	DATE
A	1100-12	PART MARKING	WKL	7-Nov-03
B	1100-54	CHANGED NOTES	WKL	8-Jan-04
C	1100-77	New Length, Eyebolt & Drawing Name	WKL	11-Oct-05



NO.	QTY	CODE-IDENT-NO	PART NO.	DESCRIPTION	STOCK SIZE	MATERIAL	MATERIAL SPEC.	WEIGHT-LBS	FINISH	ZONE
1	1	17564	L20500-15A	TUBE ASSEMBLY						
2	1		HMX-6G	ROD END						
3	2		AN316-7R	HEX NUT						
4	1	17564	L20500A-15-3	TUBE ASSEMBLY						
5	1	17564	L20500-15-2	TUBE ASSEMBLY						
6	1	17564	L20500-15-5	WASHER						
7	1		L20500-15-R68	SPRING						
8	1	17564	L20500-15-6	WASHER						
9	1	17564	L20500-15-7	TUBE						
10	1		MS171652	SPRING PIN						
11	1	17564	L20500-15-9	NUT						
12	1		MS171522	SPRING PIN						
13	1	17564	L20500A-23A	EYE BOLT, SPL						

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES EXCEPT AS NOTED

DECIMALS X 1  
XX 1  
XXX 1  
INCHES X 1

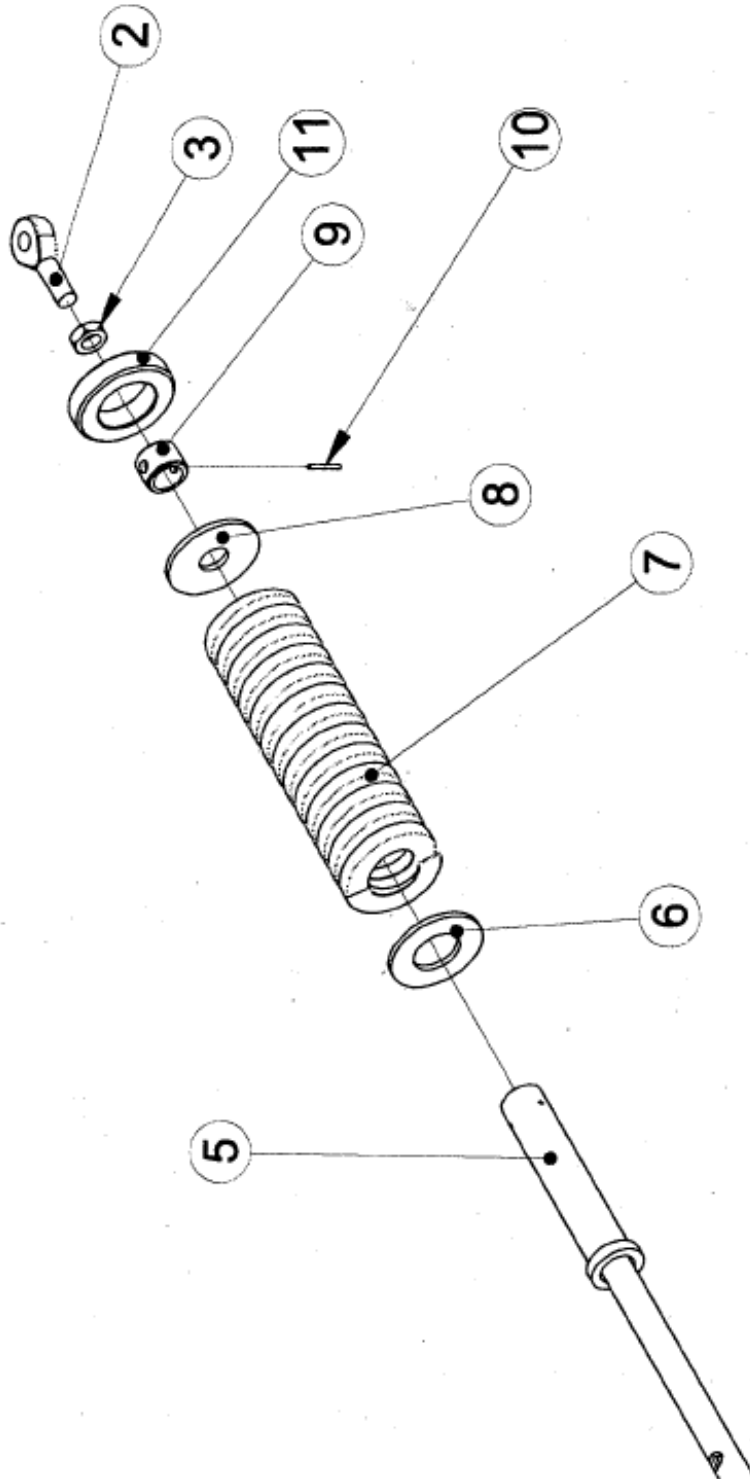
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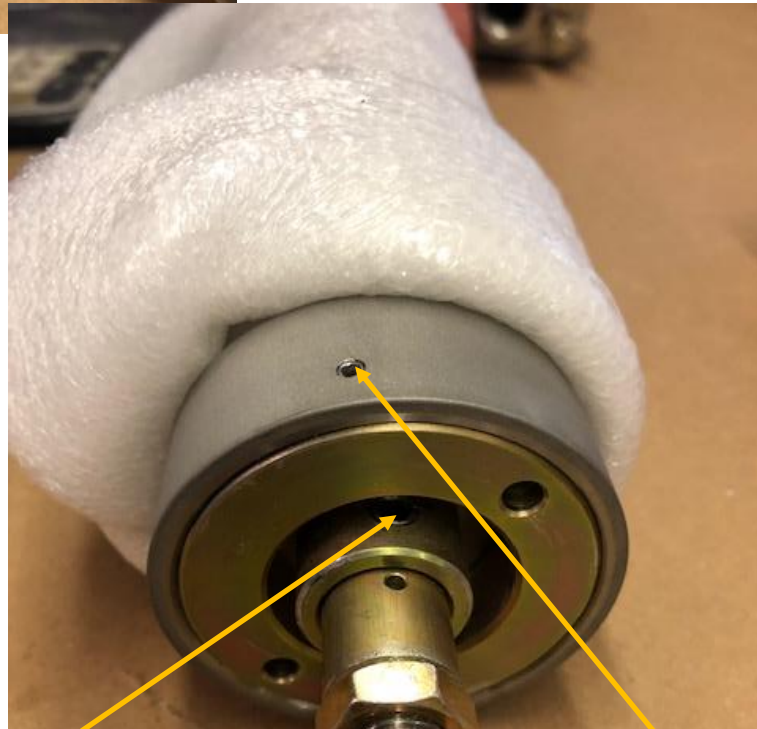
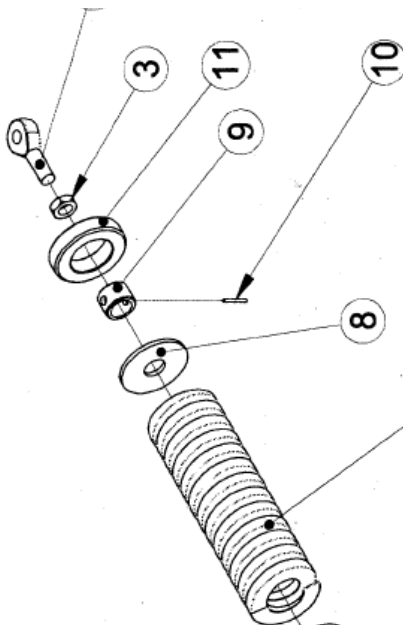
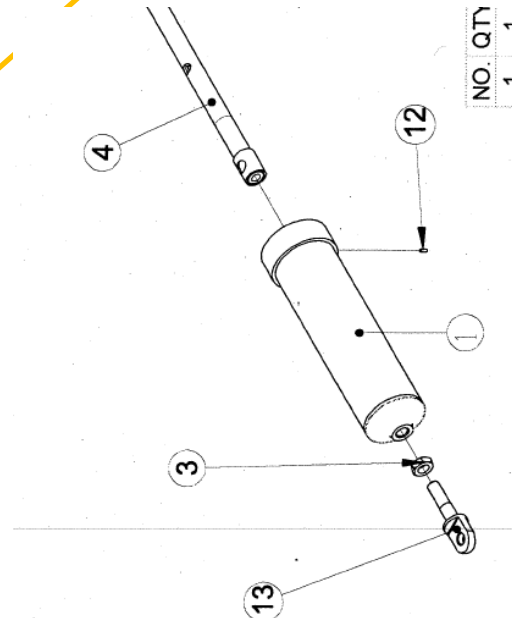
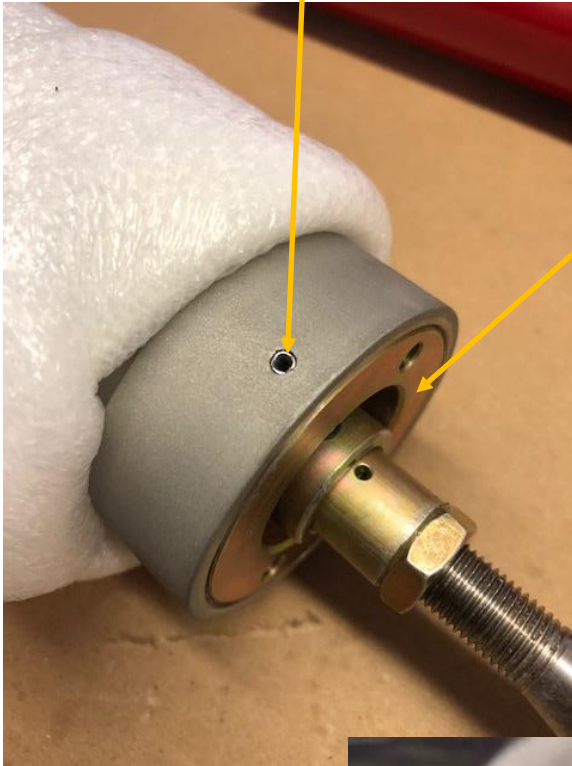
## SPRING CYLINDER, TAIL SKI

Approved by : WKL	Size	Code Ident.No.	REV
Checked by : GL	B	17564	L20500A-15A
Drawn by :PCSI			C
Date :SEPTEMBER 22,2003	Scale 1:4	Sheet 2 OF 2	

REMOVE #2 ROD END & 3 HEX NUT FROM  
END OF SPRING CYLINDER.



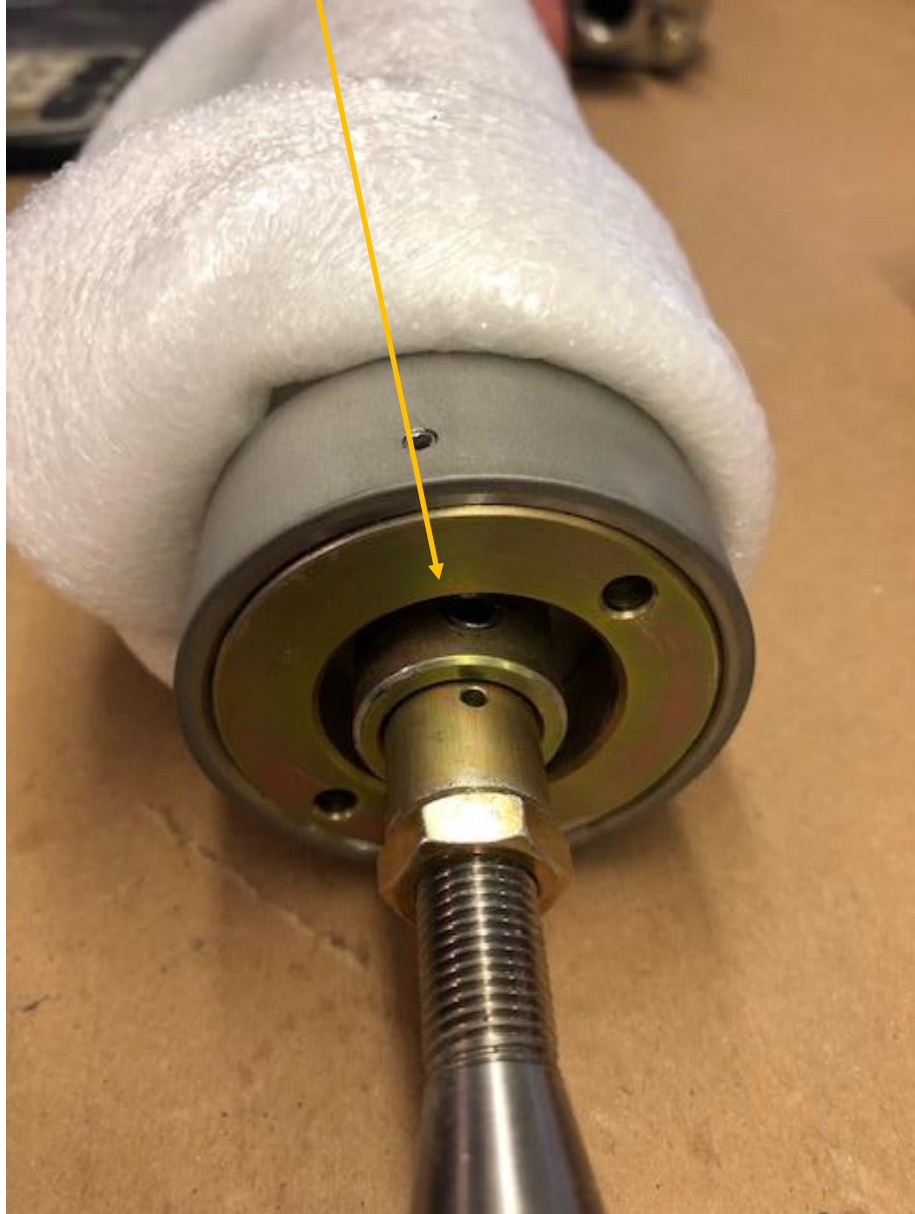
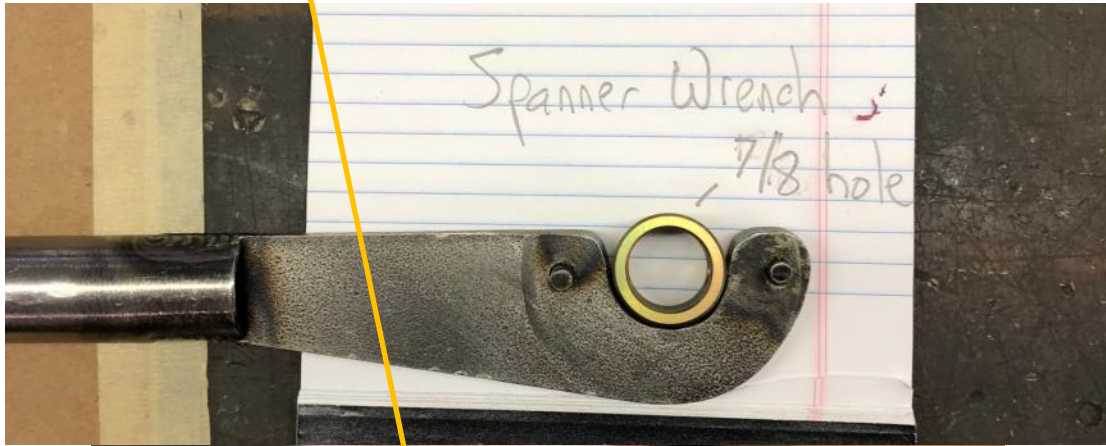
REMOVE #12 SPRING PIN SECURING #11  
NUT ON CYLINDER. USE A 1/8" PUNCH



NOTE: IT IS RECOMMENDED THAT YOU  
ALIGN #9 TUBE ROLL PIN HOLE WITH #12  
SPRING PIN. TO ALLOW #12 PIN TO DROP  
OUT EASILY.



USE SPANNER WRENCH TO REMOVE #11 NUT  
(THREADED COLLER).



AFTER REMOVING #11 NUT, THE SPRING ASSEMBLY IS REMOVED FROM THE #1 TUBE ASSEMBLY.





**INSERT 8" X .625 ROD INTO  
BASE OF SPRING ASSEMBLY**

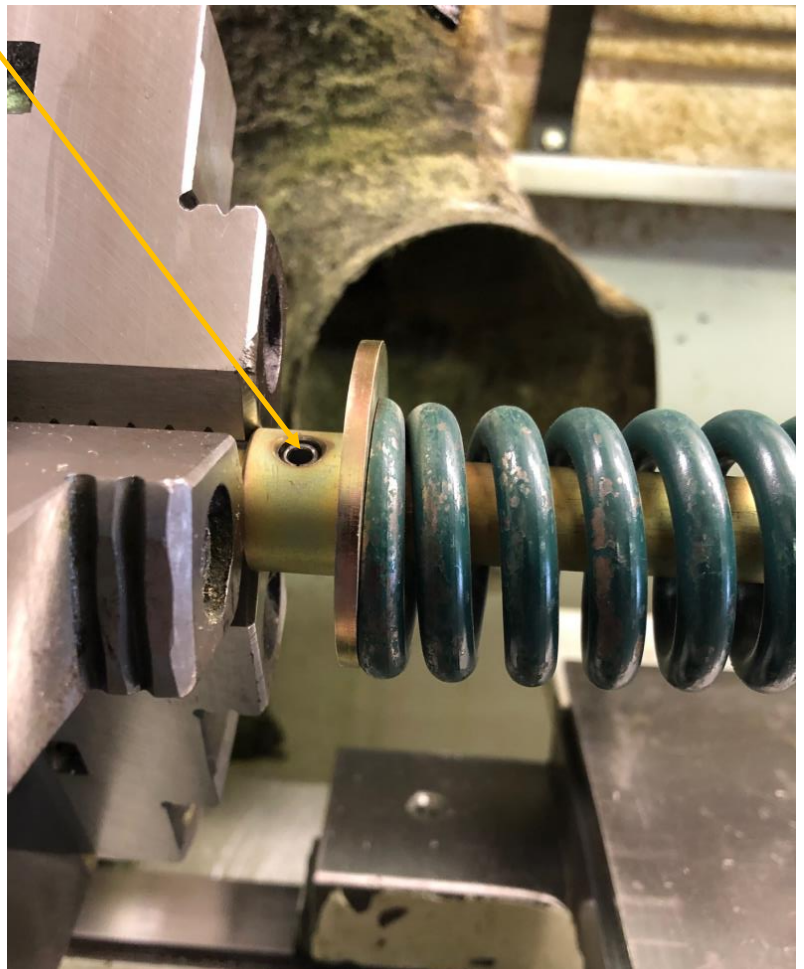




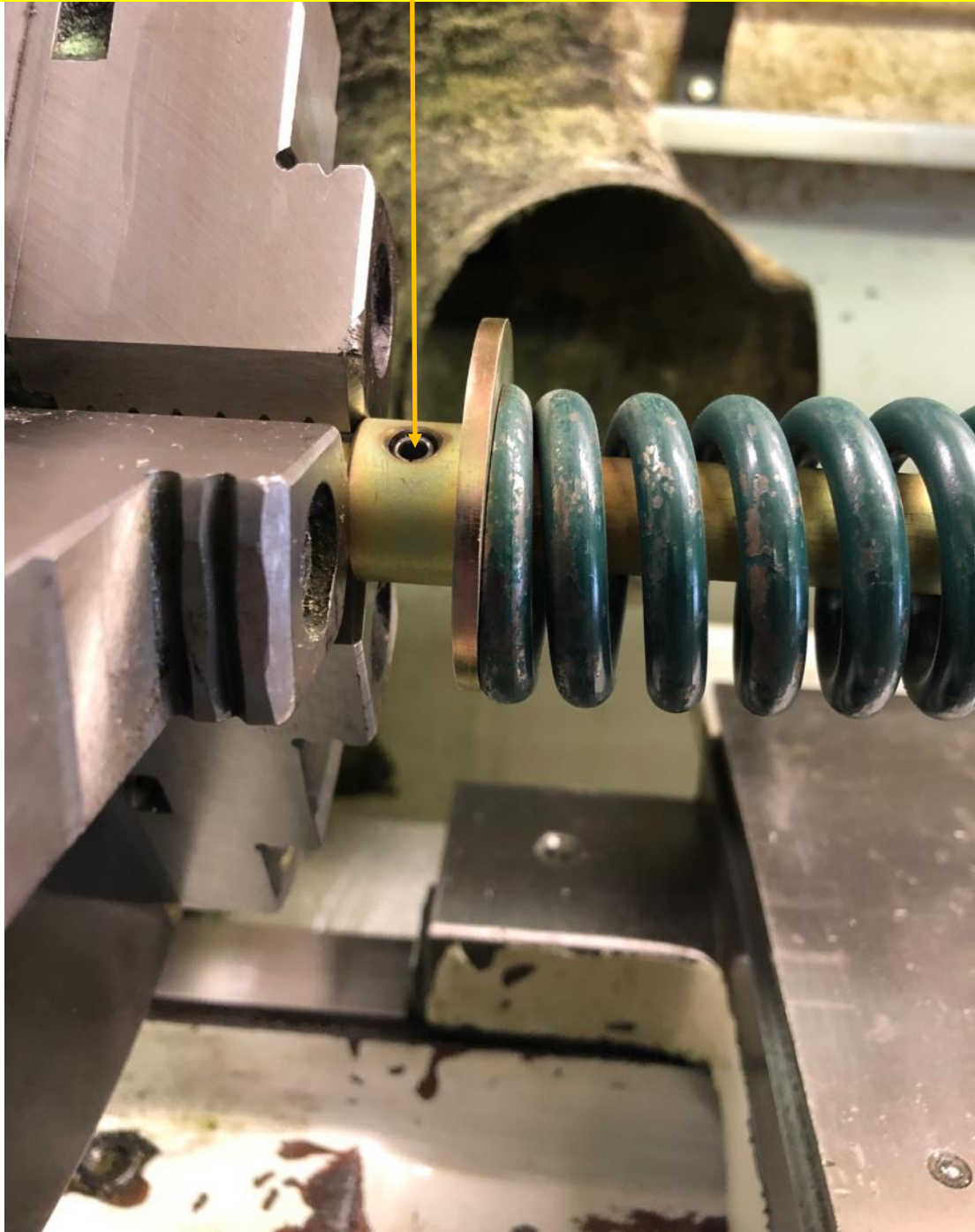
**LOOSELY INSERT SPRING ASSEMBLY  
TOP END INTO LATHE CHUCK. THERE  
SHOULD BE ADEQUATE GAP FOR TUBE  
ASSEMBLY #4 TO SLIDE IN AND OUT OF  
CHUCK. EASILY.**



INSERT SPRING CYLINDER ASSEMBLY AND APPLY LIGHT PRESSURE WITH TAILSTOCK. THE SPRING IS UNDER LOAD. DRIVE OUT #12 WITH 3/16" ROLL PIN PUNCH. USE TAILSTOCK ADJUSTMENT TO RELEASE PRESSURE AFTER #10 SPRING PIN IS REMOVED



DRIVE OUT #12 WITH 3/16" ROLL PIN PUNCH.  
USE TAILSTOCK ADJUSTMENT TO RELEASE  
PRESSURE AFTER #10 SPRING PIN IS REMOVED

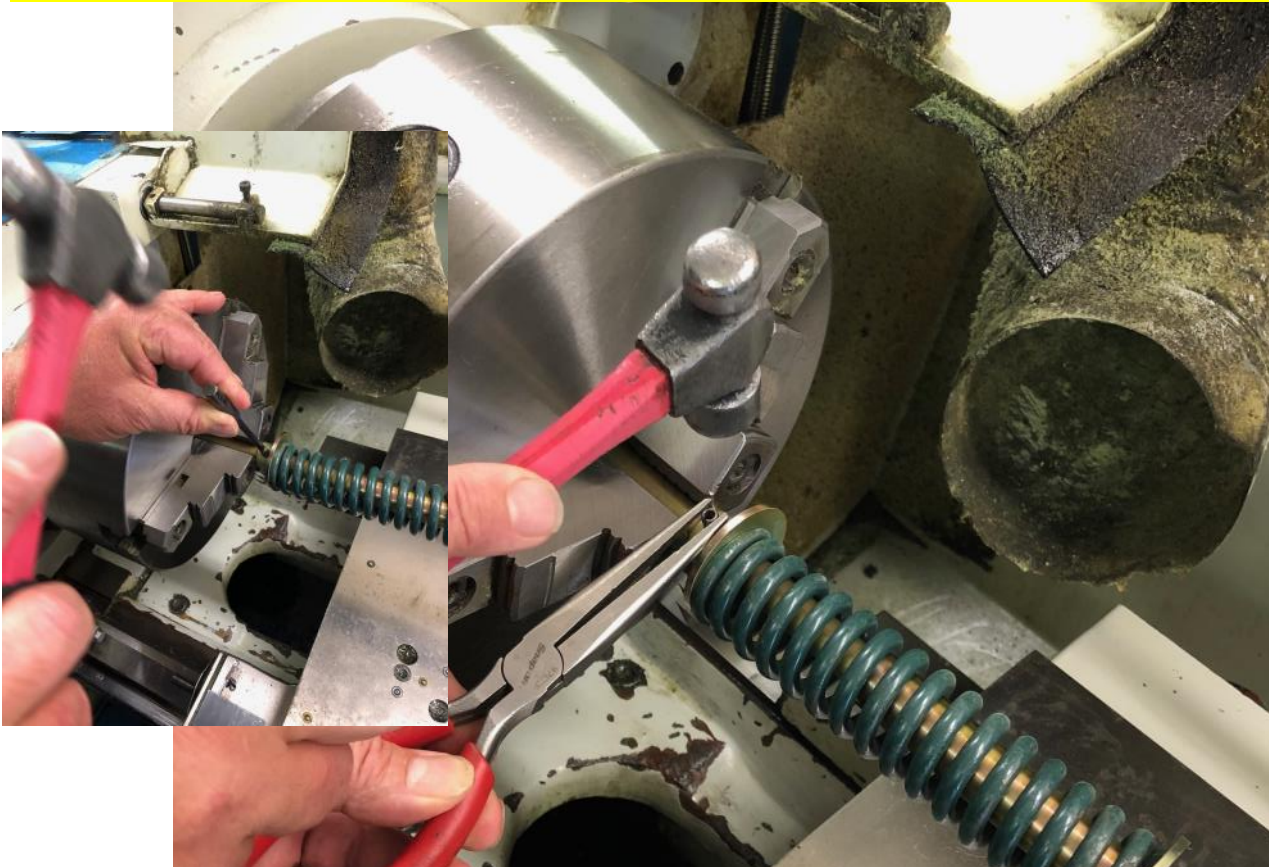




INSTALL SPRING CYLINDER IN LATHE AS DONE IN REMOVAL. LOCK DOWN THE TAILSTOCK. USE THE TAILSTOCK ADJUSTMENT TO APPLY PRESSURE TO SPRING UNTIL HOLE IN #4 IS LINED UP ON #9.



TAP SPRING PIN #10 INTO #9 HOLE, USING PLIERS AND A HAMMER. ONCE PIN IS STARTED, USE A 3/16" ROLL PIN PUNCH TO SET THE #10 SPRING PIN FLUSH WITH THE OUTSIDE OF #9 TUBE.



SET THE #10 SPRING PIN FLUSH WITH THE OUTSIDE OF #9 TUBE









- LUBRICATE THE SPRING WITH SUPER LUBE (OUR SUIT-ABLE SUB). APPLY WITH A BRUSH BETWEEN SPRING GAPS.
- INSERT SPRING ASSEMBLY INTO #1 TUBE ASSEMBLY.
- REINSTALL #11 NUT INTO #1 TUBE ASSEMBLY AND TIGHTEN WITH SPANNER WRENCH.
- TORQUE SHOULD BE ADEQUATE TO PREVENT A GAP BETWEEN THE #11 NUT AND SPRING ASSEMBLY.  
(CHECK FOR MOVEMENT)



IT IS LIKELY THAT YOU WILL NEED TO DRILL A NEW HOLE IN THE #11 NUT.

USE THE SAME HOLE IN #1, AND DRILL THRU THE #11 NUT WITH A #31 DRILL BIT.

DRIVE A NEW #12 SPRING PIN FLUSH WITH THE OUTSIDE OF THE #1 TUBE ASSEMBLY.

AVOID DRILLING INTO THE SPANNER HOLES IN THE #11 NUT. ADJUST #11 TO AVOID THIS.

