**BAYSTAR™****SEAL KIT # HP4600**for use with BayStar Compact Cylinders:
HC4645H, HC4647H, HC4648H & HC4658H**NOTICE**

Discard Old Socket Screws. New screws are provided in this seal kit. DO NOT USE OLD SCREWS.

CAUTION

After removing cap screws there will be a small amount of debris on the screws. Ensure that any loose debris is removed from inside and the face of the cylinder barrel.

NOTICE

The bleed nipple assembly can be located on either side of the tee fitting if required.

1. To prevent as much fluid loss as possible, turn your steering wheel to hard over on the gland side that you are working on, i.e. Port side gland, turn steering wheel to port side.
2. Mark and remove steering lines and remove fittings from end gland. Clean threads of fitting.
3. Loosen the two socket cap screws securing the gland to the cylinder barrel (Item 1) using a 5/32" Allen Driver. DO NOT remove the screws at this time. Use a 5/8" box-end wrench to hold the cylinder rod nut that is on the same end as the gland that is being removed.
4. Remove the piston rod nut (item 3) and washer (item 4), and the support rod nut (item 6). Use a wrench on the opposite side piston nut to keep the rod from rotating.
5. Remove the two socket cap screws (item 1) securing the gland to the cylinder.
6. Slide the gland off of the piston rod. A small amount of fluid will leak out at this time.
7. Place Gland seal guide (item 5) onto the cylinder rod as shown in figure A, and lubricate with oil or grease.
8. Slide new gland over the seal guide and push into the cylinder barrel, taking care NOT to damage the new O'rings.
9. Install new socket cap screws (item 1) and hand tighten ONLY.
10. Reconnect the support rod, washers, and nuts.
11. Tighten the support rod nut (item 6) and piston rod nut (item 3).
12. Tighten the two NEW gland cap screws and torque to 60 in lb.
13. Apply a liquid, Teflon based pipe sealant onto the tee fitting threads being installed into the cylinder end glands. Tighten fitting **HAND-TIGHT**. Using a wrench tighten an additional 1.5 turns. Continue to tighten until desired orientation is achieved. (See 2nd Notice.)
14. Repeat steps 1 – 13 for the opposite side gland.
15. Bleed Hydraulic system as per your bleeding instructions in the BayStar Steering Installation Manual number 22, part # 946410.

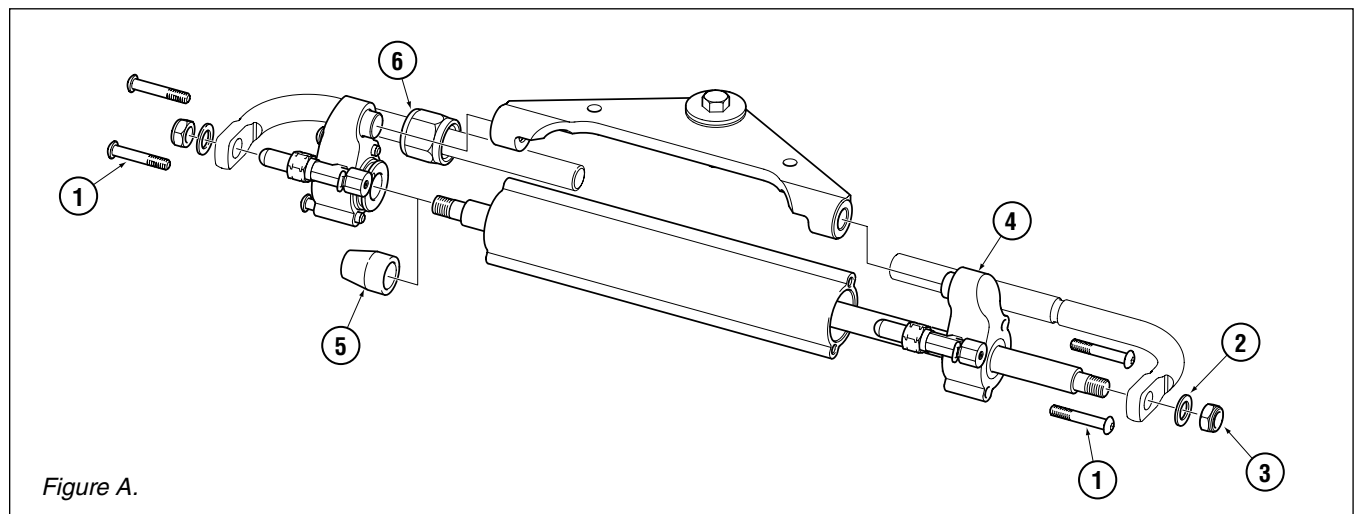


Figure A.