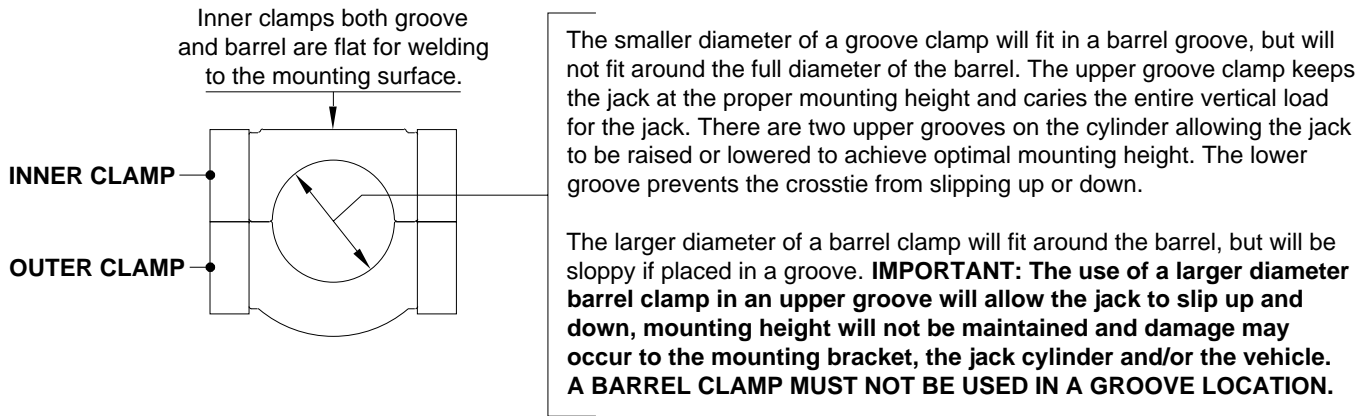


MOUNTING OF CYLINDER WITH CLAMP STYLE BRACKETS

For each capacity of jacks there are four different clamps, Inner and Outer Groove clamps and Inner and Outer Barrel clamps.



The clamps are designed to allow slight clearance when fully tightened. Any "squeeze" on the cylinder could affect the operation of the jack. Check the jack grooves and the clamps for any debris that could cause a "squeeze" when the clamps are tightened.

If a bracket with pre-mounted clamps is being used, be sure to orient the bracket so the smaller diameter clamp (groove clamp) is at the top and that the larger diameter clamp (barrel clamp) is at the bottom. See diameter info above.

If the clamps need to be mounted, follow the welding instructions below. The clamps can be put on the jack and then the assembly positioned for tack welding the clamps.

After tacking and before welding, remove the cylinder. Welding with the cylinder in place can damage the jack seals.

Gussets (NOT included) can be used to help position and keep the top inner clamp from "pulling" while welding the clamp. The gussets must be on the bottom of the clamp so they do not interfere with the spring bracket at the top of the jack.

