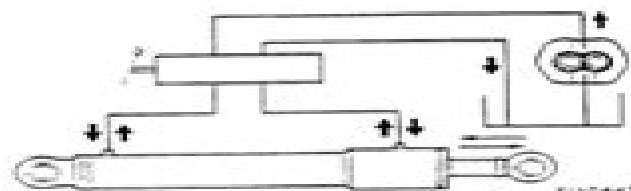


Inspection After Assembly**No Load Operation Test**

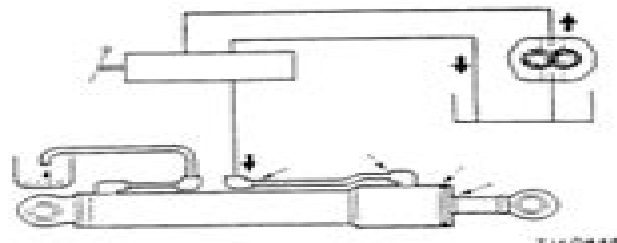
- (1) Place the cylinder in a horizontal position with no load.
- (2) Apply gentle pressure alternately to the ports at both sides, operating the piston rod 5 or 6 times.
- (3) Make sure there is no abnormality in the operating condition.

**Leak Test****• External Leakage**

- (1) Apply test pressure for 3 minutes each to the retraction side and the extension side.
- (2) Make sure there are no abnormalities such as external leakage or permanent deformation, etc. in the rod seal, the rod cover mount, or in any welded portion.

• Internal Leakage

- (1) Disconnect the extension side hose.
- (2) Apply test pressure to the retraction side for 3 minutes.
- (3) Measure the amount of oil that has leaked from the extension side.
 - The amount of leakage should be 1 cc / 3 min. or less.

**Bleeding Air from the Hydraulic Cylinder**

Bleed the air out of the cylinder when the cylinder is removed or when the hydraulic piping, etc. is disconnected.

1. Start the engine and let it idle for approximately 5 minutes.
2. With the engine running at slow speed, extend and retract the cylinder 4 or 5 times.
 - Move the piston rod to a position 100 mm before the end of the stroke, being careful not to apply any relief at all.
3. With the engine at top speed, repeat the operation in "2", then with the engine running at slow speed, move the piston rod to the stroke end and apply relief.

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