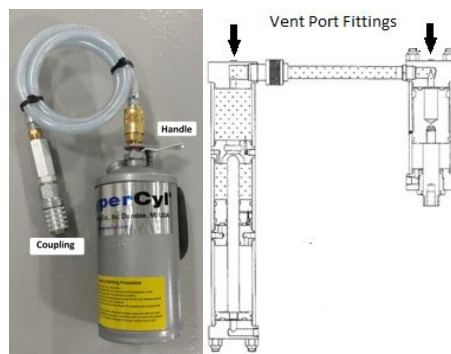




HPS/HPX SERIES FILL AND VENT PROCEDURE – HFP-2

1. Fill the HFP-2 fill unit with ISO 32 oil or equivalent.
2. Retract the cylinder rod (energize B1) and block in retracted position.
3. Remove the black rubber dust cover from the cylinder fill coupling.
4. Depress the inner ring on the fill unit coupling to allow oil to flow. Repeatedly depress the handle until all air has been vented from the fill unit tubing, close coupling.
5. Connect fill unit to fill coupling on cylinder.
6. Repeatedly depress the fill unit handle until the handle becomes difficult to depress. Do not allow the fill unit can to get completely empty. Refill as necessary.
7. Slowly loosen the vent port fitting on the cap of whichever unit is lower. **DO NOT REMOVE PLUG.** Once all air has been vented from the vent port fitting (free from bubbles) tighten vent port fitting. Repeat process on whichever unit is higher, working the hydraulic hose to ensure all air is allowed to travel to the highest vent port.
8. Disconnect the fill unit from the cylinder.
9. Repeat steps 4 thru 8 until no air is noticed when purging the cylinder.



Note: Air pressure must be applied to port “B2” to extend or retract cylinder rod. Always remember that air will travel to the highest point in any system. Any coil in the hydraulic hose will trap air. This fill and vent procedure will not remove air trapped in a coil of the hydraulic hose.