



HYDRAULIC SETTING TOOL ASSEMBLY INSTRUCTIONS



Product - Hydraulic Setting Tool

REV - 01

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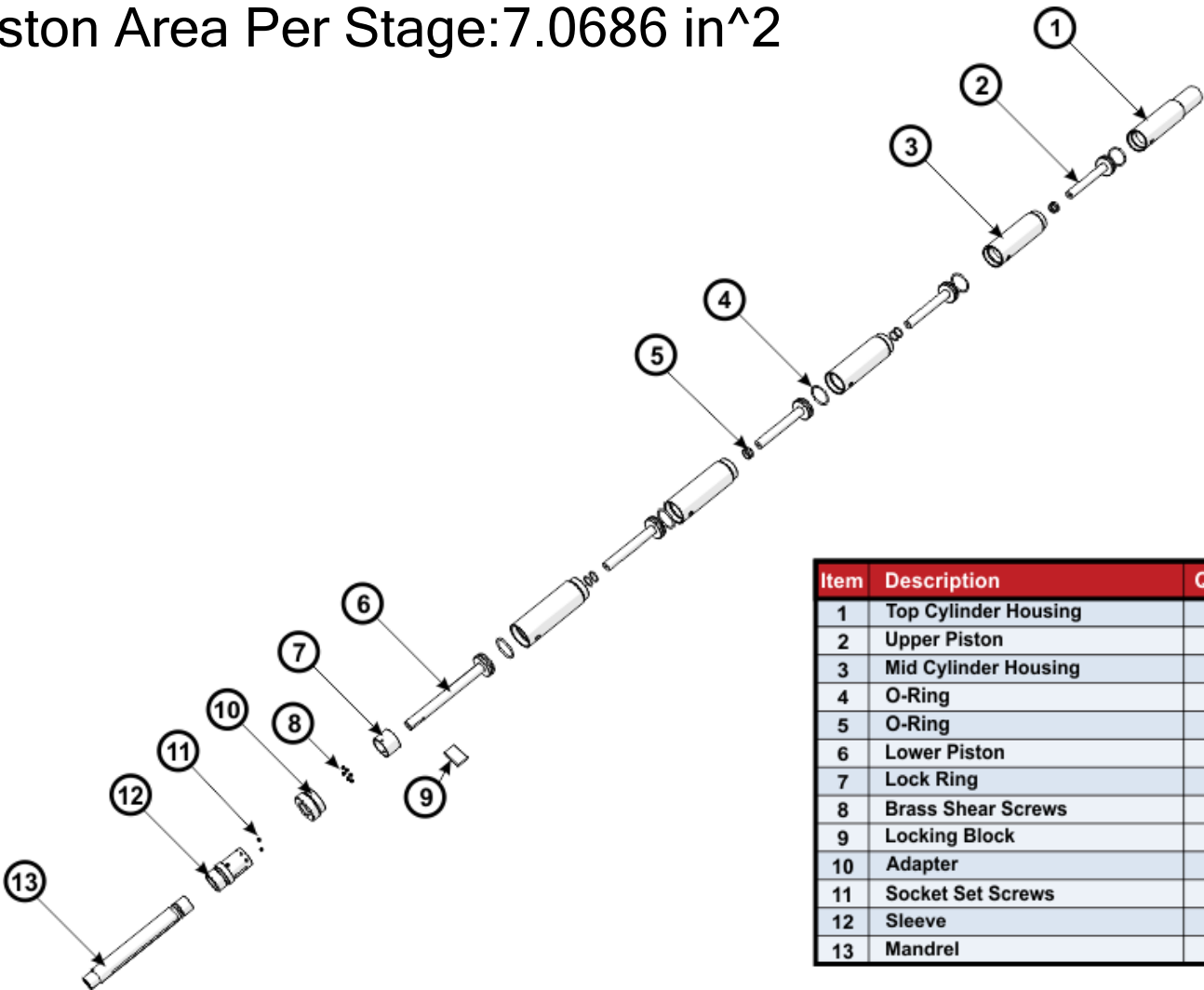
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ASSEMBLY INSTRUCTIONS



Hydraulic Setting Tool Exploded View

Piston Area Per Stage:7.0686 in^2



Item	Description	QTY
1	Top Cylinder Housing	1
2	Upper Piston	4
3	Mid Cylinder Housing	4
4	O-Ring	5
5	O-Ring	8
6	Lower Piston	1
7	Lock Ring	1
8	Brass Shear Screws	6
9	Locking Block	6
10	Adapter	1
11	Socket Set Screws	2
12	Sleeve	1
13	Mandrel	1

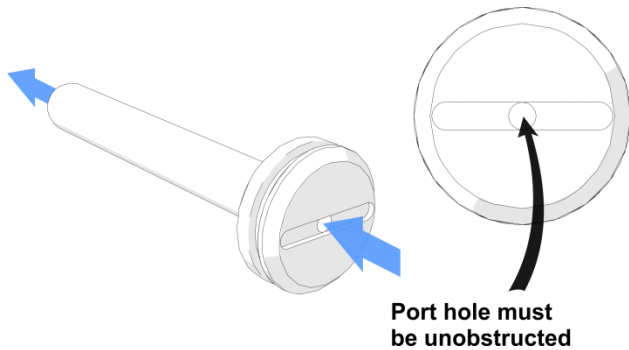
NOTE - The illustration above is intended as a guide only.

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Installation/ Setting Procedure

Note

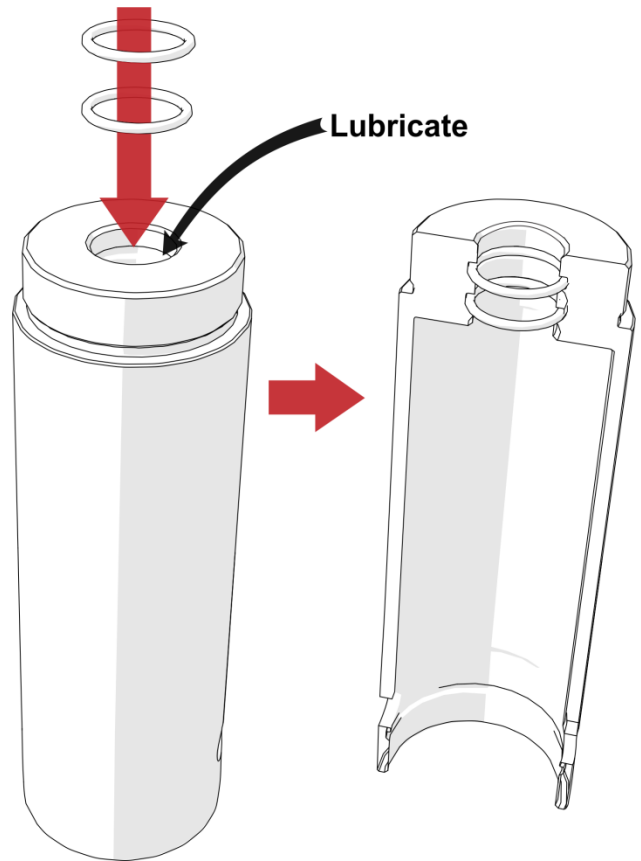
Inspect all O-Rings and replace Shear Screws on the Hydraulic Setting Tool after each run to ensure effective operation.



Note

Inspect Pistons prior to tool assembly and ensure there is no blockage of the port holes.

1 Apply grease and install two (2) O-Rings into each Cylinder sections.



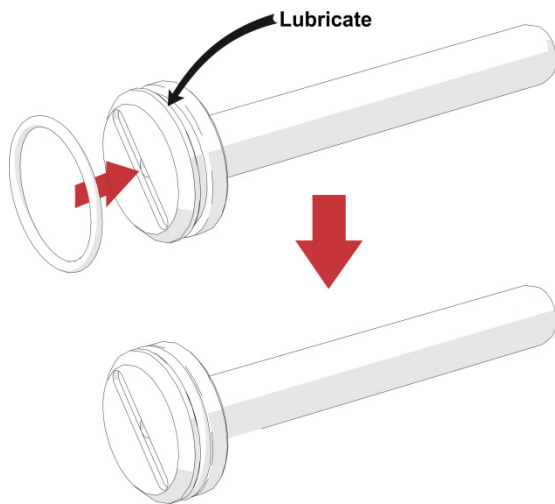
Note

Inspect all O-Ring grooves during installation and clean as required.

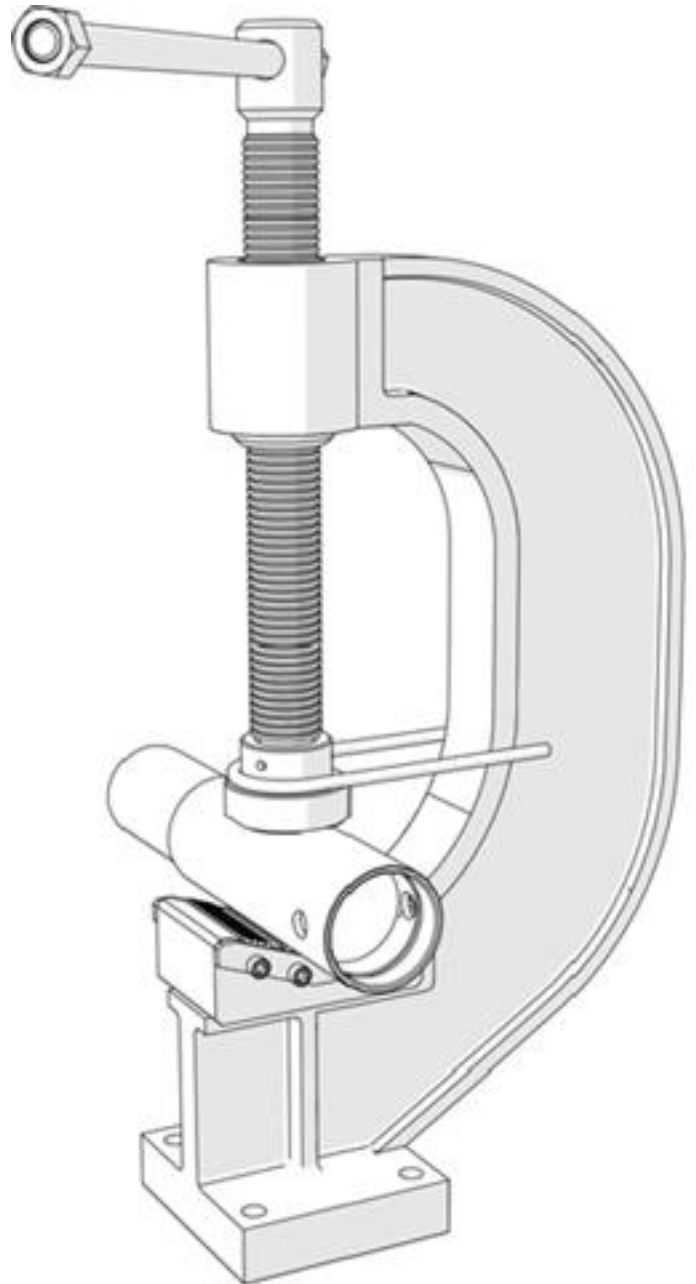
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2 Apply grease and install O-Rings onto Pistons.

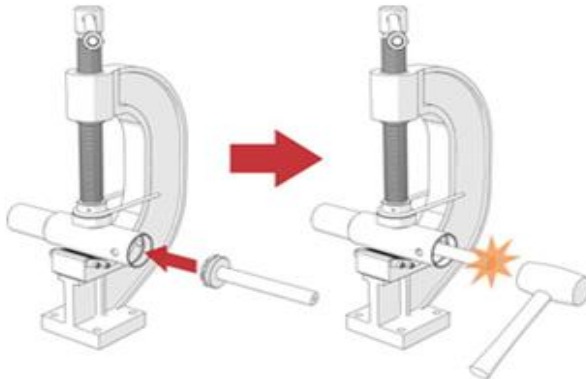


3 Place Top Cylinder Housing in vise.

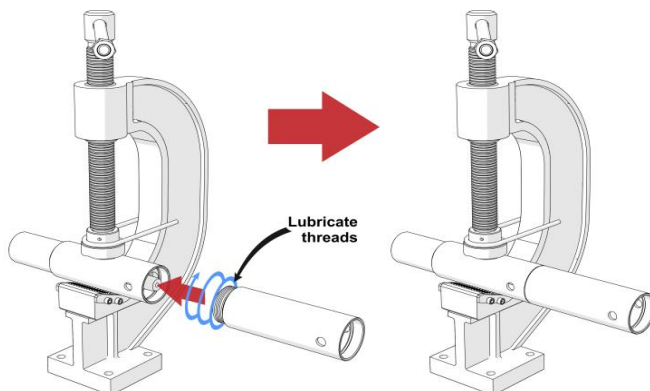


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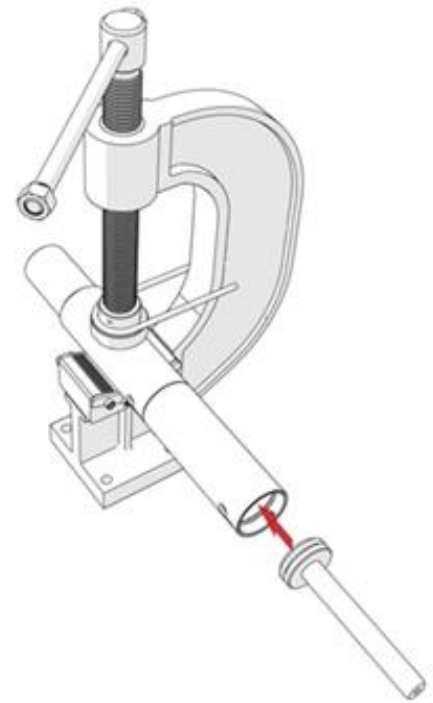
4 Insert the first Piston into the Top Cylinder Housing. If necessary, tap the piston in all the way with a rubber mallet.



5 Grease threads and turn on Mid Cylinder Housing to the Top Cylinder Housing. Assembly should be completed Hand Tight Only.



6 Insert the next Piston and tap into place with rubber mallet.



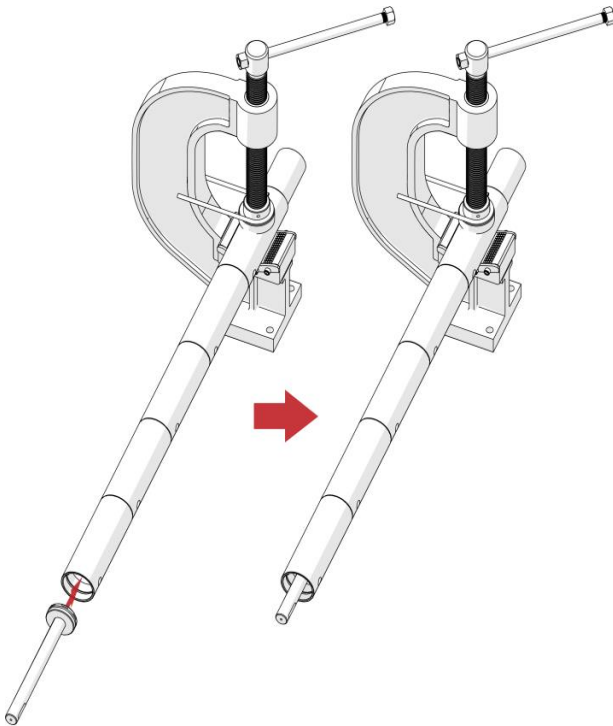
7 Keep adding Cylinders and Pistons as in steps 4-6 until the tool is made up to your application requirements.

Note

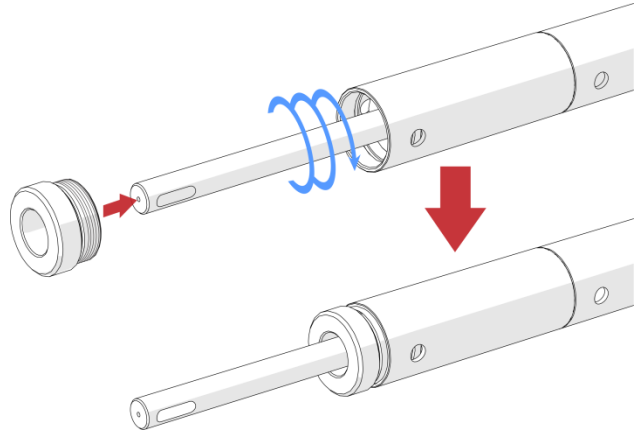
Use a tool support as the sections are added.

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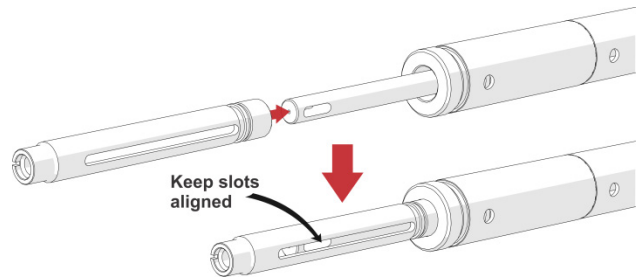
8 Insert Lower Piston partially into the last Cylinder. The Lower Piston is easy to identify: it has a slot at the bottom and no port holes.



9 Grease threads on Adapter and slide over Lower Piston. Screw Adapter onto bottom Cylinder.



10 Slide Mandrel over the Piston, with the notched end pointing out the bottom of the tool and into the Adapter.



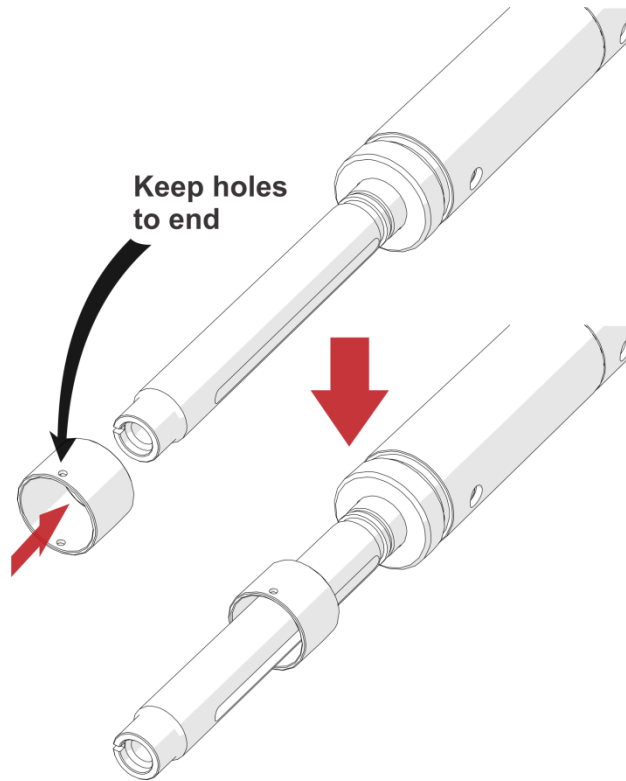
Note

Keep the slots on the Mandrel and Piston aligned during this procedure.

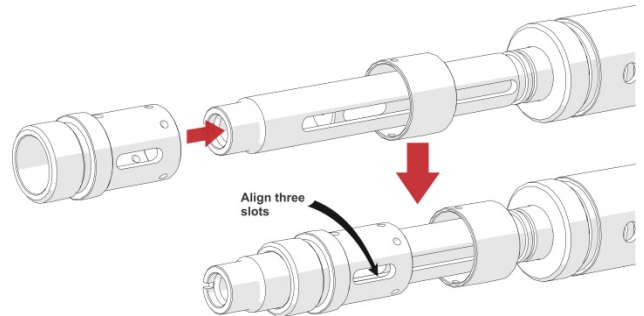
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11 Slide the Lock Ring over the Mandrel with the screw hole end toward the bottom of the tool.



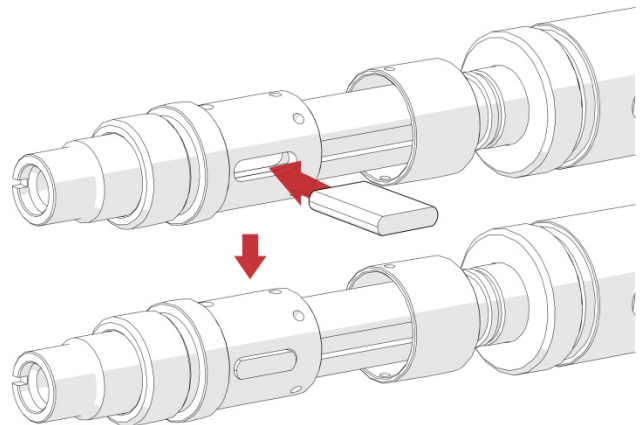
12 Slide the Sleeve over the Mandrel with the screw holes pointing in to the tool.



Note

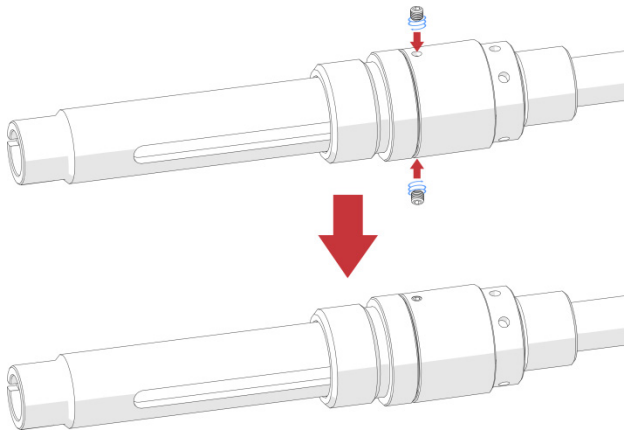
Keep the slots on the Mandrel, Piston and Sleeve aligned during this procedure.

13 Insert the Locking Block into the slots of the Sleeve, Mandrel and Lower Piston.

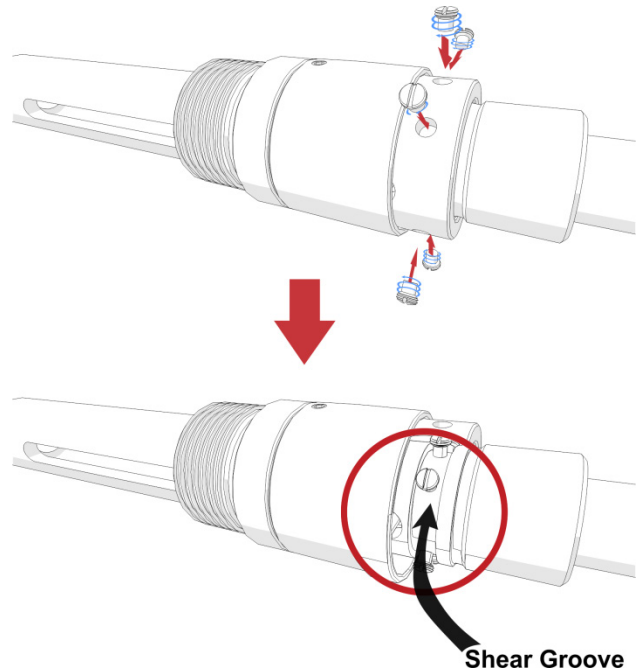


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14 Secure the Locking Block with the Locking Ring. Screw in the Socket Set Screws into the Locking Ring.



15 Slide the Sleeve assembly back so that the Shear Screw holes align with the Shear Groove, and insert the Shear Screws.



16 Double-check connections, and proceed to attach the setting sleeve and other tools to be used with the Hydraulic Setting Tool.