

Date: 2014-01-02

No. TC-1234

AMMCO

BADA

COATS

Brake Lathes (BL)

Tire Changers (TC)

Wh. Balancers (WB)

Accessories (AC)

Manuals (MA)

Tools (TO)

Other (OT)

SUBJECT: 4070 - 7 and 8 inch Cylinder Filling Process

On the Model 4070 Tire Changer, one side of both the 7 inch and 8 inch cylinders is filled with hydraulic oil. This oil is pushed from one cylinder to the other through a connecting hose by compressed air on the other side of each cylinder's piston. There must be no air left in either cylinder's oil filled side or the connecting hose for proper operation of the unit.

Since the fill plug for the cylinders is facing down when the cylinders are in their working position, the cylinders and connecting hose must be removed as an assembly from the unit for filling or refilling. *Always disconnect the air supply to the machine and depressurize the entire unit before attempting any service procedures.*

TO FILL COMPLETELY EMPTY CYLINDERS: (*SEE ILL. with p/n ON PAGE TWO*) (connecting hose, p/n 8108319, must be attached to the cylinders.)

1. Remove the fill plug, p/n 8120344, in the 7 inch "slave" cylinder, p/n 85608739.
2. Use compressed air through the plug opening, to force the piston in the slave cylinder all the way to opposite end cap.
3. With the plug still removed, force the piston shaft on the 8 inch cylinder, p/n 85608715, to full extension with compressed air through the elbow fitting, p/n 8184256.
4. Fill the slave cylinder with the hydraulic oil specified in the note below through the fill plug hole.
5. Install the fill plug and rotate the slave cylinder to put the elbow at the top. (This will force oil first into the 8 inch cylinder in the next step.)
6. Start with the elbow on the slave cylinder and cycle the cylinders back and forth with compressed air through the elbow fittings. (Finish with the slave piston at the cap opposite the fill plug by applying air pressure through the 8 inch cylinder elbow.)
7. Rotate the cylinder to bring the fill plug to the top and remove the fill plug.
8. Repeat steps 4, 5, 6, and 7 above until there is no air in the cylinders.

NOTE: The filled assembly requires about 1.25 gallons of high quality hydraulic oil such as COATS Hydraulic Oil (part #8101411) or an approved alternate choice (Empak 4061, or Shell Tellus 21). *It usually takes three cycles to fill*

completely empty cylinders; first using about 0.60 gallons, then about another 0.60 gallons and finally about 0.05 gallons.

Cylinders out of machine with pistons in starting positions for complete filling.

