

Shifter Housing Assembly (Air Shifted)



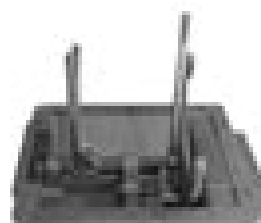
1. Inspect and replace all damaged or worn O-rings before assembly of the cover.



2. Place the 1st-2nd speed piston rod into the shifter housing. Place the 1st-2nd speed shift fork on the piston rod with the long hub toward the front. Place the brass internal piston rod bushing on the end of the rod. Check and make sure the interface is still in the cross hole between the rods.



3. Secure the shift fork to the piston rod with the retainer. Torque the retainer to 40-50 ft-lb (53-67Nm). Use a suitable driver to drive the piston rod bushing into the piston housing bore. Flange on bushing will seat against the bore inside the piston housing bore.



4. Repeat the same procedure for the adjacent piston rod fork. Place the rear outer piston O-ring into each piston housing bore.



5. Place the rear outer piston into each piston housing bore.



6. Assemble a snap ring into each piston housing bore.

25 of 30



7. Assemble the front outer piston O-ring into each piston housing bore.



8. Place the internal piston with the front outer piston assembled to it into the bore and onto the piston rod. Repeat the same procedure for the adjacent piston rod. Secure the internal pistons on the piston rods with the locknuts.



9. Assemble the snap ring to each piston housing bore.



10. Assemble the cylinder caps with O-ring and washer in each piston housing bore.



11. Place the snap ring at the front of each cylinder cap.



12. Place the snap pins and plugs in the top of the shifter housing. If removed, reinstall or fit to the front of the shifter.

26 of 30

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Table of Contents Link Belt Hc 238h Manual

1. Understanding the eBook Link Belt Hc 238h Manual
 - The Rise of Digital Reading Link Belt Hc 238h Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Link Belt Hc 238h Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Link Belt Hc 238h Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Link Belt Hc 238h Manual
 - Personalized Recommendations
 - Link Belt Hc 238h Manual User Reviews and Ratings
 - Link Belt Hc 238h Manual and Bestseller Lists
5. Accessing Link Belt Hc 238h Manual Free and Paid eBooks
 - Link Belt Hc 238h Manual Public Domain eBooks
 - Link Belt Hc 238h Manual eBook Subscription Services

- Link Belt Hc 238h Manual Budget-Friendly Options
- 6. Navigating Link Belt Hc 238h Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Link Belt Hc 238h Manual Compatibility with Devices
 - Link Belt Hc 238h Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Link Belt Hc 238h Manual
 - Highlighting and Note-Taking Link Belt Hc 238h Manual
 - Interactive Elements Link Belt Hc 238h Manual
- 8. Staying Engaged with Link Belt Hc 238h Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Link Belt Hc 238h Manual
- 9. Balancing eBooks and Physical Books Link Belt Hc 238h Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Link Belt Hc 238h Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Link Belt Hc 238h Manual
 - Setting Reading Goals Link Belt Hc 238h Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Link Belt Hc 238h Manual
 - Fact-Checking eBook Content of Link Belt Hc 238h Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends

-
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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