

### Shifter Housing Assembly (Air Shifted)



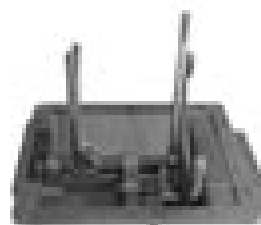
1. Inspect and replace all damaged or worn O-rings before assembly of the cover.



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 or 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.

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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 or 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.

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# Link Belt Hc 238h Manual

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