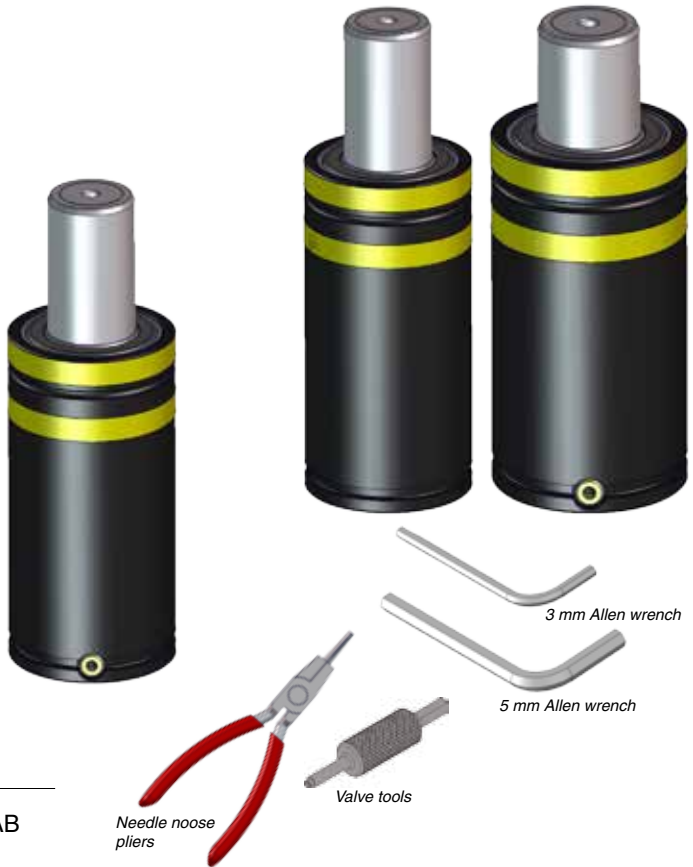


Service port – Die Separation (DS) gas spring

DS 3000

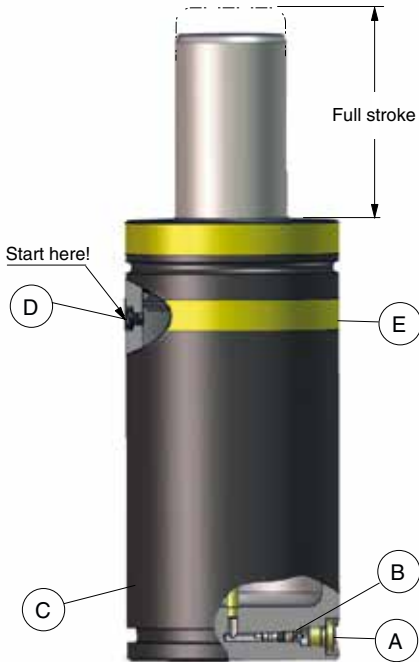
DS 5000

DS 7500



DISCHARGING INSTRUCTIONS

This procedure must be followed whenever a DS gas spring is not reaching its maximum stroke length. When maximum stroke length is not reached, the gas spring is to be considered faulty.



- A) G 1/8" Cover screw
- B) Valve
- C) Tube
- D) M6 Service plug
- E) Warning tape

Warnings

- To make sure to use the correct repair kit, always read the permanent markings on the side of the tube before servicing.
- Failure to exhaust all gas pressure prior to disassembling could result in serious personal injury.
- Always wear safety glasses when servicing the gas spring.
- Only specially trained personnel with a good product knowledge should carry out the maintenance.
- Once the cover screw is removed, never lean directly over the valve.

Always direct the valve port away from yourself and others.

- Never use extreme force on the gas spring.
- Charged gas springs are under high internal pressure and should be protected against damage.
- Always use protective jaws when clamping the spring in a vice.
- To achieve maximum service life, keep the gas spring protected from dirt, drawing fluids, and grinding dust.

DISCHARGING INSTRUCTIONS

Discharging gas pressure

Warning!

Follow procedure thoroughly.

1. Remove Warning tape (E) below the upper C-groove to reveal M6 Service plug (D).

2. To open the Service Port slightly, unscrew M6 Service plug (D) no more than 1 (one) complete turn using a 3 mm Allen wrench to evacuate all gas pressure.

Be prepared for piston rod extension movement as a result of discharging.

Keep M6 Service plug (D) open. When the gas is discharged (no leakage through Service port), please proceed with discharging of lower chamber.

Note! Do not attempt to remove M6 Service plug (D), as it is under high internal pressure.

3. Clamp the gas spring in a vice (fitted with protective jaws). Expose the valve in the charge port by removing G 1/8" Cover screw (A) with a 5 mm Allen wrench.

4. Release the pressure by screwing the threaded end of the valve tool into the charge port until the valve needle opens.

Valve (B) must not be unscrewed until both upper and lower gas chambers are empty, allowing the piston rod to be pushed in and out using an appropriate T-handle.

As long as hand force is sufficient to push the piston in and out, the gas is considered discharged from the tube.

Only then should you unscrew the valve with the opposite end of the valve tool and remove the valve using the needle nose pliers.

Now M6 Service plug (D) can be removed and the gas spring dismounted.