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INSTALLATION INSTRUCTIONS

1. Before shipment, all power units are flushed and cleaned to remove all contamination down to a 3micron particle size and a test run is performed.

If the cylinder lines were not flushed and cleaned at installation, it is **STRONGLY** recommended that the following procedures be performed prior to start-up.



CLEANLINESS IS VERY IMPORTANT THROUGHOUT THESE PROCEDURES.

2. A flushing block (Fife Part No. 27392-001) was shipped with the system. Disconnect the hydraulic lines from the Moog servo valve. Remove and replace the Moog servo valve with the flushing block reusing the existing seal plates. Torque the bolts evenly to 25 to 30 foot-pounds. Reconnect the hydraulic lines to the flushing block.
3. Disconnect the hydraulic lines from the cylinder. Connect the two line ends with a piece of clean flexible hose to form a loop.
4. Be sure the power unit reservoir is filled to the proper level. Turn on power unit. The circulating hydraulic fluid will flush the power unit passages, hydraulic lines, and fluid to a nominal level of 3 microns. The 3-micron absolute pressure filter in the power unit will collect the contamination.
5. Most contamination will be removed from the system in the first 15 minutes of flushing; however, continue to flush the system for one to two hours. If hydraulic fluid samples are taken and checked for cleanliness, the cleanliness level should be NAS 1638, Class 7, or ISO Standard 4406 16/13 or better. This level will ensure optimum life and performance.
6. When flushing is complete, replace the contaminated filter element. Replacement filter part numbers are listed below:

For Model E100 Power Units — P/N 21708-001
For All Other Power Units — P/N 21708-002

The filter elements are not reusable and should be discarded when replaced.

NOTE:

On units having a filter cap with a dirt level indicator, it is acceptable to leave the filter in until the indicator shows the filter is full. However, it is recommended that the filter be discarded after the power unit and system components have been further tested and are ready for operation. This will ensure that the power unit will be able to operate for an extended period of time before the filter will again have to be replaced.

7. Disconnect the hydraulic lines from the flushing block and replace it with the Moog servo valve. Again, torque the bolts evenly to 25 to 30 foot-pounds.



DO NOT OVERTIGHTEN THESE BOLTS. TORQUE OVER 50 FOOT-POUNDS MAY CAUSE HYDRAULIC SEEPAGE AROUND SEAL PLATES OR BINDING OF THE SPOOL IN THE VALVE BODY. INSUFFICIENT TORQUE CAN ALSO CAUSE HYDRAULIC SEEPAGE.

Reconnect the hydraulic lines to the Moog servo valve.

8. Remove the flexible hose from the cylinder end of the hydraulic lines and reconnect the lines to the cylinder.
9. Stroke the hydraulic cylinder to its limits in both directions by slowly turning the guide point adjustment (in the signal processor) back and forth between its extreme positions. Repeat this procedure five or ten times to ensure all air is purged from the hydraulic system. On installations where the cylinder is above the power unit by one foot or more, it may be necessary to slightly loosen a fitting on each cylinder line while it is under pressure. Allow a small quantity of fluid to drain from the line in order to evacuate the air. Any air in the hydraulic system contributes to instability of the control system. Therefore, the system must be completely purged of air. Check the fluid level in the reservoir and refill it as necessary. Tighten the fittings and make a final check for hydraulic leaks.
10. The system is now ready for functional component testing. Refer to Section 2 of the manual (Operating Instructions) for setup procedures.