



## Diversified Metal Fabricators Service Bulletin SB 2039

<b>Title</b>	Roto 180 Swing Cylinder Replacement
<b>Document No.</b>	2039
<b>Issue Date</b>	3/28/03
<b>Units Affected</b>	Roto 180
<b>Purpose</b>	To provide a procedure for removal and replacement of Roto 180 Swing Cylinders.

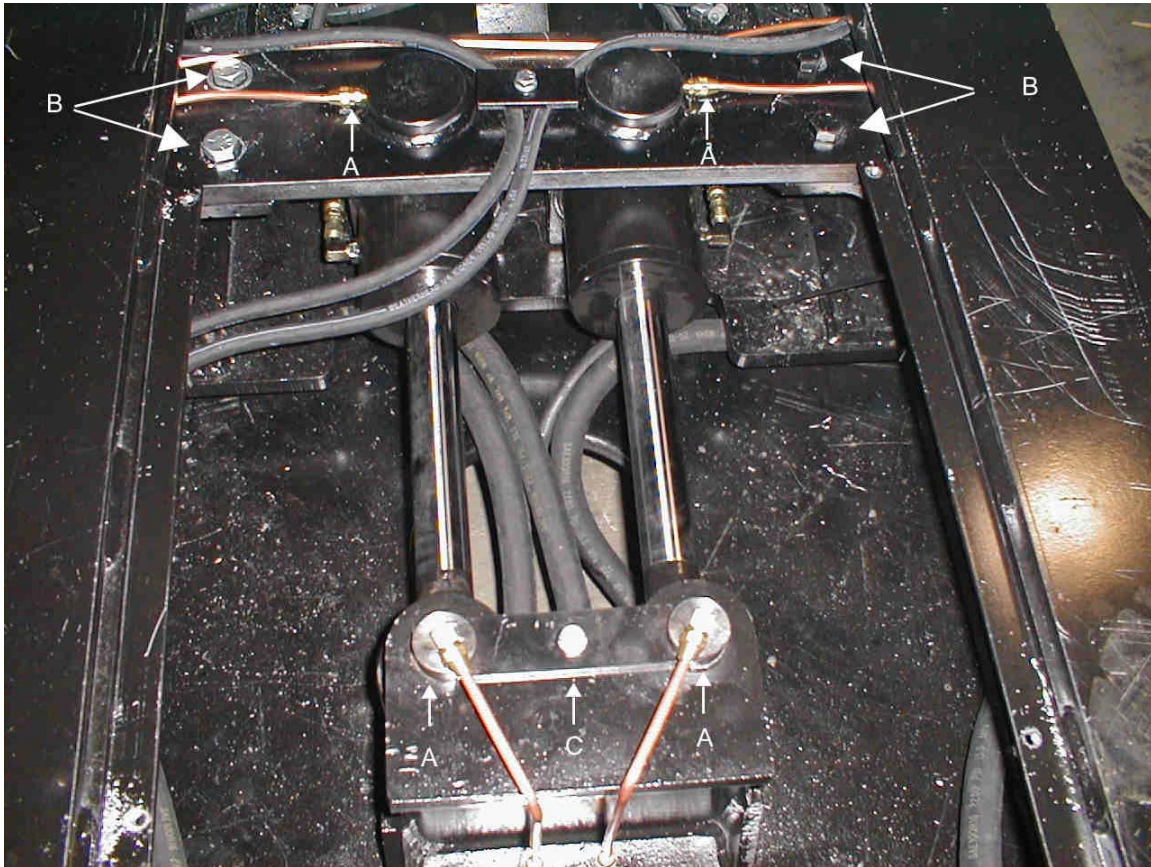
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### Procedure:

1. Remove the 8 bolts that secure the Roto cover plate to the subframe. Remove the cover.
2. Disconnect the compression fittings (labeled "A") of the 4 copper grease lines at the cylinder pivot points.
3. Remove the 4 cylinder bar bolts (labeled "B") and lift out the bar that secures the trunnion end of the cylinders in place.
4. Remove the bolt (labeled "C") that holds the pin retainer in place.
5. Remove the rod end pin for **\*ONE\*** of the cylinders and disconnect the 3 hydraulic hoses. **IMPORTANT:** Remove and replace the swing cylinders **\*ONE AT A TIME\*** to ensure that no hoses are crossed in the process.
6. Install the replacement cylinder, re-connect the hydraulic hoses and insert the rod-end pin.
7. Repeat steps 5 and 6 for the other swing cylinder.
8. Reassemble the rotary dump by performing steps 4 through 2 in reverse order.
9. Test dump body for proper rotational function and check level of hydraulic fluid in reservoir.
10. Replace Roto cover plate and secure with 8 bolts removed in step #1.



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DMF will replace defective parts under DMF's warranty terms. DMF will not cover parts that have been subjected to gross overloading or blatant abuse. DMF may require the return of affected parts to determine coverage.

### Diversified Metal Fabricators

Phone: (404) 875-1512

Email: [info@dmfatlanta.com](mailto:info@dmfatlanta.com)

Web: [www.dmfatlanta.com](http://www.dmfatlanta.com)