

3 STONE ROTARY CYLINDER HONE KIT



CONTENTS			
1	Rotary Cylinder Hone		3 320 Finishing Grit Stones
1	Cylinder Hone Extension		9 Cotter Pins
3	080 Course Grit Stones		1 Hex Key
3	220 Medium Grit Stones		1 Storage Pouch

APPLICABLE TO -

ERCOUPE 415-C, CD, D, E, G, F-1, F-1A, Alon A2, A2-A and early M10 aircraft that are equipped with either the Hayes welded or Erco forged trailing link MLG assemblies that incorporate liquid filled oleo struts.

MAIN LANDING GEAR OLEO MAINTENANCE –

The introduction of this cylinder barrel hone kit makes available an effective tool to **recondition** the interior running surface of the oleo cylinder barrel.

This cylinder hone kit is intended to be used each time the MLG oleo struts are disassembled for routine seal replacement or when upgrading to our popular **STC SA01247CH MLG Oleo Restoration Kit**, and results in increased seal effectiveness and service life.

The cleaning and resurfacing process can be accomplished with or without removing the Taxi Stack end fitting and Donuts.

The kit is furnished with 3 sets of honing stones to be used as conditions dictate.

Course 080 grit
Medium 220 grit
Finishing 320 grit

SUGGESTED RECONDITIONING PROCESS -

**** Keep the stones generously lubricated with DOT 3 automotive brake fluid ****

1. Clean and degrease the cylinder barrel interior surface.
2. Inspect the cylinder barrel interior surface to determine its current condition. Begin honing at 80 grit for severe imperfections, 220 grit for moderately rough surface or 320 grit for a reasonably smooth surface needing a cleanup.
3. Continue honing until a reasonably smooth surface is achieved.
4. Deburr and smooth the open end of the cylinder barrel prior to reassembly to avoid damaging the new seal as it is inserted.
5. Clean the interior of the cylinder barrel and insert the generously lubricated replacement seal and piston assembly using -
Cup Seal - DOT 3 Automotive Brake Fluid
O Ring Seal - RED, Mil Spec 5606 Hydraulic Fluid
6. Reassemble and service.