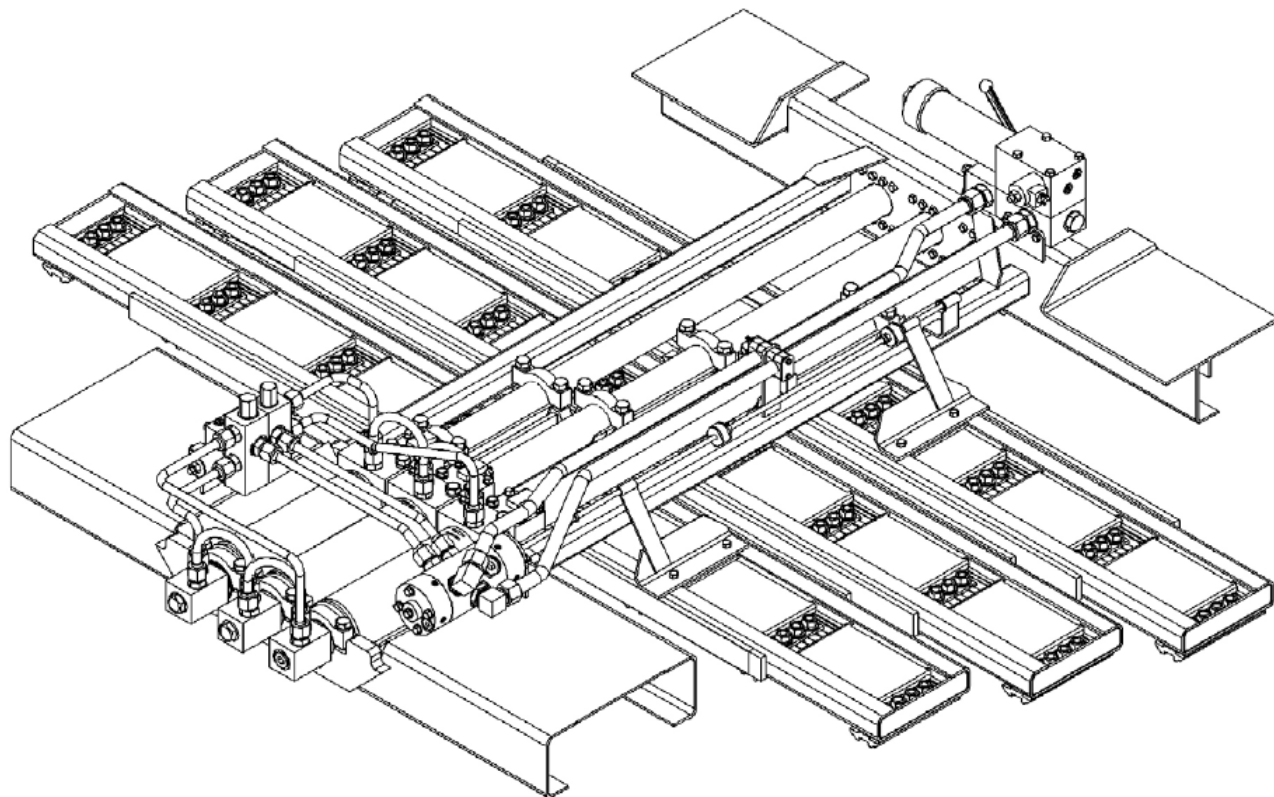


KEITH[®] WORKHORSE

UNLOADING SYSTEM



OWNER'S MANUAL

Version: English, 002, June 2008



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Table of Contents

| | | |
|-----|--|----|
| 1 | Introduction | 2 |
| 2 | Description of the <i>WALKING FLOOR</i> [®] system | 3 |
| | 2.1 Use of the <i>WALKING FLOOR</i> system | 3 |
| | 2.2 Operation of the <i>WALKING FLOOR</i> system | 3 |
| 3 | Technical specifications of the <i>WALKING FLOOR</i> Workhorse | 7 |
| | 3.1 Specifications of the hydraulic installation | 7 |
| 4 | Operation | 9 |
| | 4.1 Manual operation | 10 |
| | 4.2 Electric operation | 11 |
| | 4.2.1 Electrical control Load / Unload / On / Off..... | 13 |
| | 4.2.2 Electrical control On / Off..... | 14 |
| 5 | Components..... | 15 |
| | 5.1 The cylinder..... | 15 |
| | 5.2 The check valve..... | 16 |
| | 5.3 The switching valve..... | 16 |
| | 5.4 The on/off valve..... | 16 |
| | 5.5 The control valve..... | 17 |
| | 5.6 The hydraulic plumbing..... | 17 |
| | 5.7 Installation of floor slat with Kwik-Klamp [®] system | 18 |
| 6 | <i>WALKING FLOOR</i> Workhorse system maintenance..... | 19 |
| 7 | Solving problems..... | 20 |
| | 7.1 Emergency Provision..... | 22 |
| 8 | Warranty..... | 23 |
| 8.1 | Warranty conditions | 24 |
| | Registration card..... | 25 |

Introduction

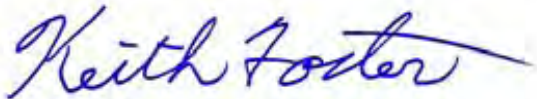
We at KEITH Mfg. Co. and KEITH *WALKING FLOOR* Europe, thank you for having chosen the KEITH® *WALKING FLOOR*® loading and unloading system. We are proud of the fact that we manufacture the simplest and most trouble-free loading and unloading system. With the KEITH *WALKING FLOOR* system you have the versatility of a flat floor, combined with the opportunity to load and unload practically any material you desire.

The following pages contain a description of the operation and the maintenance of your KEITH *WALKING FLOOR* system, a troubleshooting manual and working drawings of a number of the most important components of the system. Important information is also provided concerning the hydraulic installation on your vehicle. You must ensure that this hydraulic installation satisfies the stated requirements. We maintain a website at www.keithwalkingfloor.com which provides an up to date information resource from which manuals can be downloaded.

Make sure that you have read and understood the manual completely before you use the KEITH *WALKING FLOOR* system. If you have problems or require advice do not hesitate to contact us. It goes without saying that we will be pleased to help you!

Once again, thank you for choosing a KEITH *WALKING FLOOR* loading and unloading system.

Yours Faithfully,



Keith Foster
Founder
KEITH Mfg. Co.



Mark Foster
President
KEITH Mfg. Co.

All information in this document is offered in good faith and is believed to be reliable. The right to change or amend is hereby expressly reserved. The user is not discharged of ascertaining himself on the correctness of the information. KEITH *WALKING FLOOR* Europe is not responsible for any misinterpretation or errors.

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2. Description of the **WALKING FLOOR®** system

WARNING:



The large forces exerted by the floor when moving can result in damage to equipment which may result in serious injury or death. Always ensure that this manual has been read and fully understood by the operator. We advise that the operator keeps this manual with the vehicle at all times. Always ensure that 'best practice' is employed when using our systems. If in any doubt do **NOT** use this equipment and seek further assistance from your company's safety officer.

2.1 Use of the **WALKING FLOOR** system

The system is built up from a number of separate components. These components are assembled in such a way that they are only suitable for the conveying purpose described in the sales contract. Should you wish to convey other materials then please contact the supplier of your trailer.

2.2 Operation of the **WALKING FLOOR** system

The KEITH® **WALKING FLOOR** system can be used for loading and unloading most materials.

Moving the load with the system is based on the friction between the load and the floor. The floor consists of a number of *floor slats* placed side-by-side (the width of the floor determines the precise number of slats required).

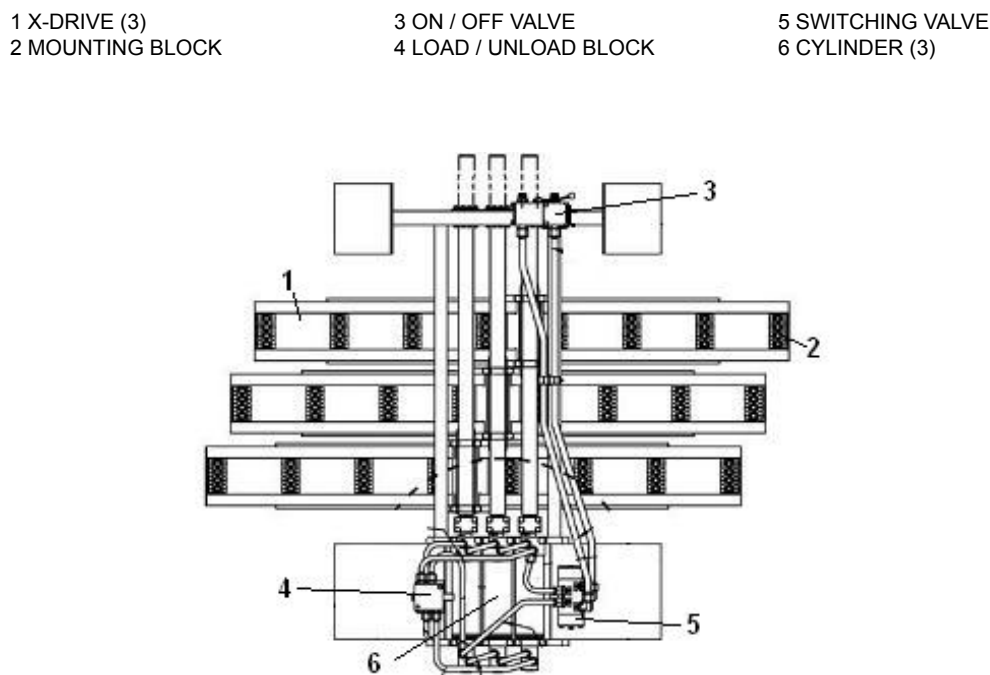
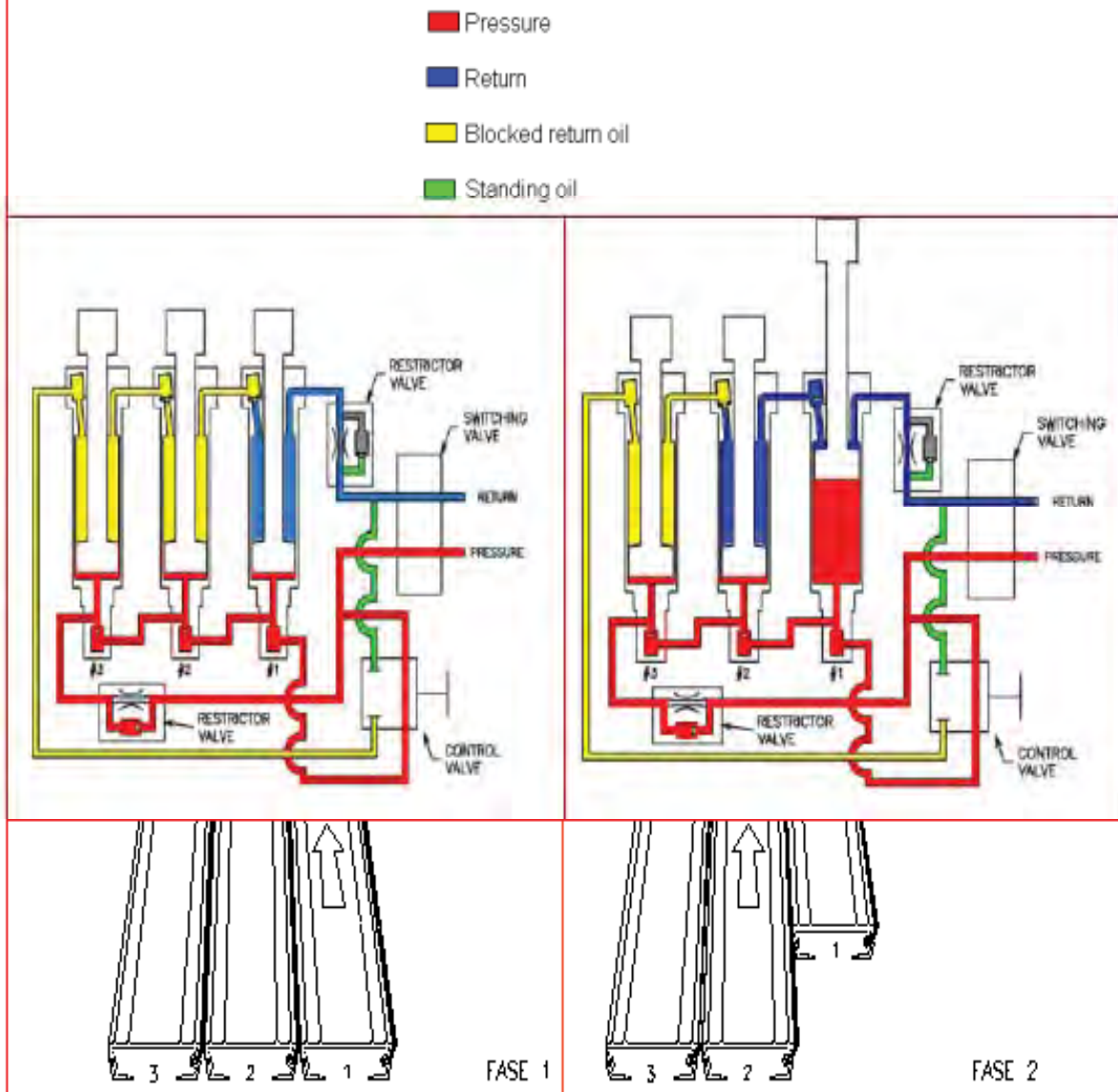


Figure 1.1: KEITH **WALKING FLOOR** *Workhorse drive-unit*

Three double-acting *hydraulic cylinders* move the floor slats in a cycle with four phases. The forces exerted by the cylinders are transferred to the slats by three *cross drives*. Each cross drive moves 1/3 of the total number of floor slats.

The floor slats slide over plastic *sliding bearings* that support both the upper part and the sides of the slat. Different floor slats, varying in width, surface area and material, have been developed to provide optimum operation with various types of load. The unloading cycle is composed of the following four phases, the loading cycle is the opposite. (Figure 1.2a and 1.2b).

KEITH® *Walking Floor*® Workhorse Oil flow diagram



- Phase 1:** Cylinder 1 (and slats #1) moves towards the front of the bunker. Because only 1/3 of the floor is moving, whereas 2/3 of the floor is not, the load will not move (the friction of this major floor area exceeds the friction force caused by the Walking Floor slats). At the end of its stroke, the cylinder actuates a check valve that allows the oil flow to start phase 2:
- Phase 2:** Cylinder 2 (and slats #2) moves towards the front of the bunker; again the load will not move. At the end of its stroke, the cylinder actuates a second check valve that allows the oil flow to start phase 3:

KEITH® *Walking Floor*® Workhorse Oil flow diagram

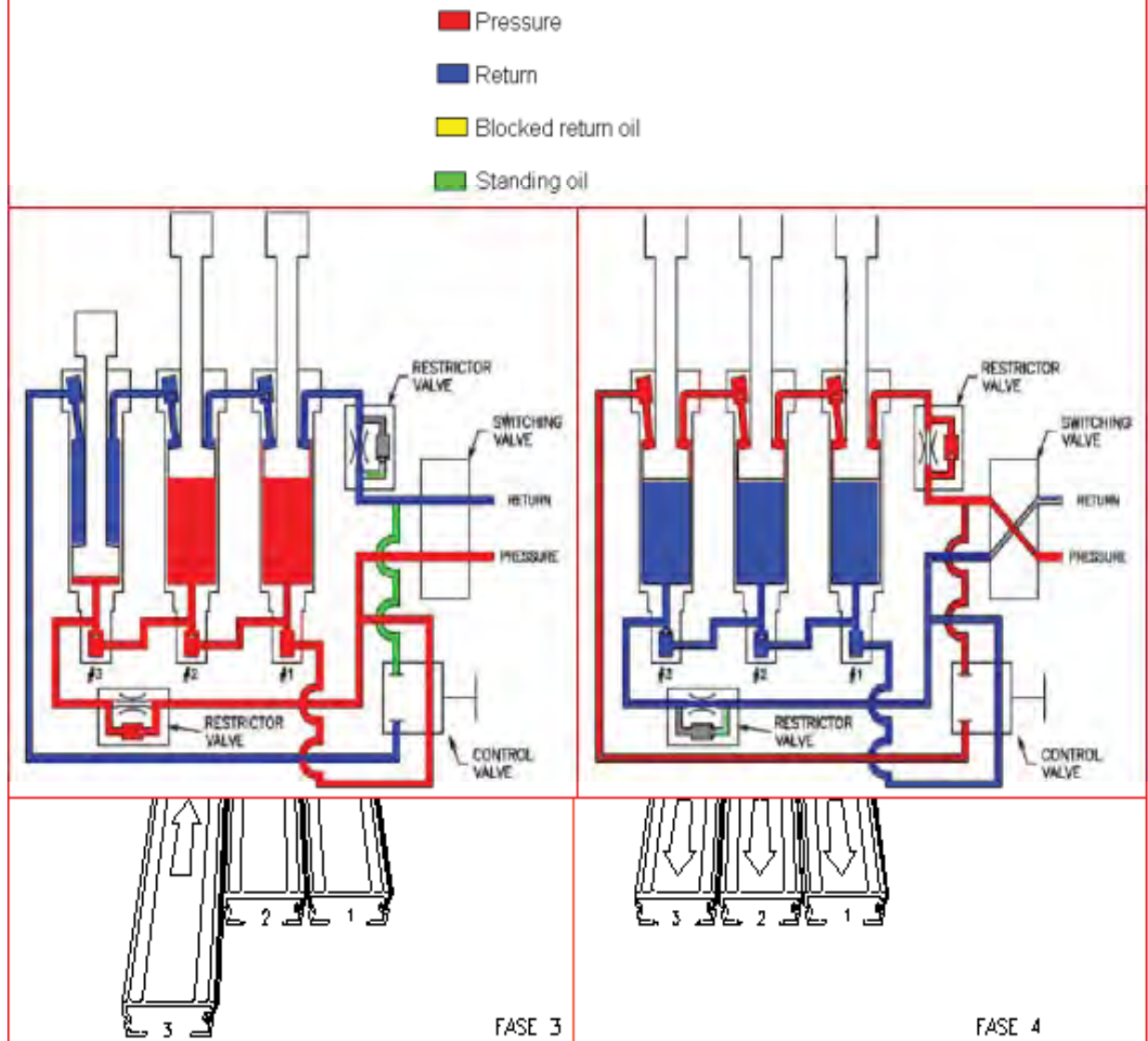


Figure 1.2b

- Phase 3:** Cylinder 3 (and slats #3) moves towards the front of the bunker; again the load remains still. At the end of the stroke, when all cylinders are lined up, an actuator attached to the cross drive mechanically switches the switching valve. The switching valve switches the pressure from the front end to the rear end of all cylinders, this starts phase 4:
- Phase 4:** Cylinder 1,2 and 3 (and all slats) move back towards the open side of the bunker. Because of the friction force between the floor and the load, the load will move over a distance equal to the stroke of the hydraulic cylinders. At the end of the stroke the switching valve switches the pressure to the rear end of all cylinders. The cycle is now completed and starts with phase 1 again.

The position of the two control valves (internal) determines the loading or the unloading cycle. A manual or electrical load- / off- / unload valve operates these valves.

The (un)loading time is determined by the speed of action of the cylinders, which depends on oil flow to the cylinders and the cylinder size. The force the cylinders transfer to the floor determines the maximum load, which can be (un)loaded. The cylinder force is dependent on the oil pressure and the cylinder size.

The pump determines both the flow and the maximum oil pressure, and therefore the (un)loading time and the weight, which can be handled. To protect the system, the pressure relief valve, set at 210 bar, limits the pressure.

NOTE:

- For faster (un)loading, the oil flow must be increased; pressure has no influence on (un)loading time.
- The system operating pressure is determined by the load resistance and not by the pressure relief valve setting of the pump.
- Conveying products for which the system has not been designed can cause damage to the system. We therefore advise you to contact your supplier about this first.

3. Specifications of the *WALKING FLOOR* Workhorse drive unit

| | | | |
|---------------|-----------------|---|-----------------------|
| Cylinders | 3 | | |
| | standard stroke | ∅ | 102 mm 200 mm. |
| Weight | | | 477 kg. |
| Capacity Pump | ∅ 102 mm | | 26.300 kg. at 140 bar |
| | max. | | 210 bar |
| | max. | | 110 l/min. |

3.1 Specifications of the hydraulic installation

Always consult the supplier of your drive unit to ensure you choose the correct hydraulic power unit. Figure 3.1 shows the components of the hydraulic installation in a hydraulic diagram.

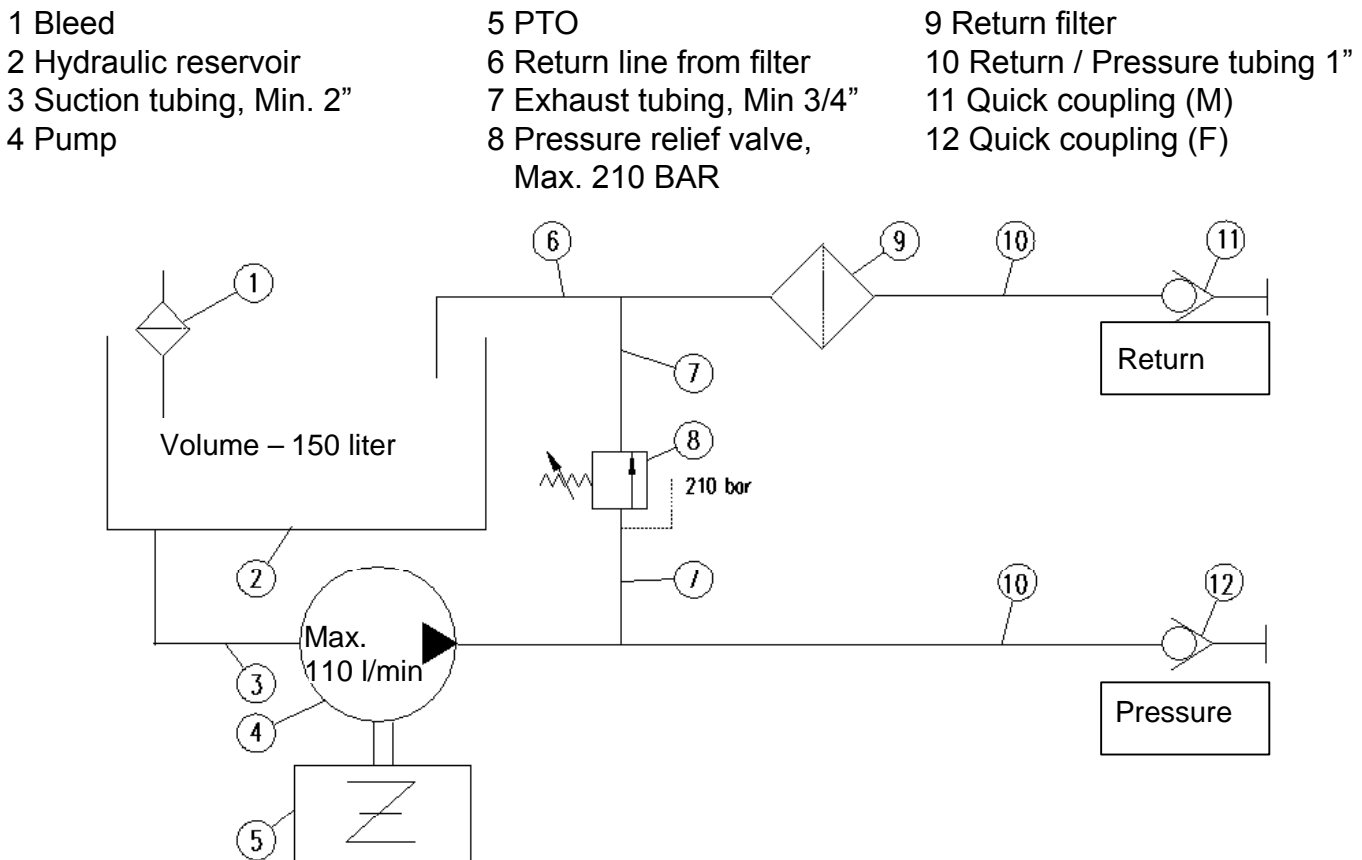


Figure 3.1 Hydraulic diagram

The hydraulic installation must meet the following requirements:

PUMP/ PTO: The quantity of oil that will be pumped in the system determines the loading and unloading time; the oil pressure determines the maximum total weight that can be handled.

The KEITH® *WALKING FLOOR*® Workhorse System is designed for a recommended maximum oil flow of 110 l/minute. And a recommended maximum speed of 2.6 m/min.

A high power take-off (PTO) ratio (greater than 1:1) reduces the size of the pump for a given rotational speed. This is generally the best alternative, technically as well as financially. Compare the performance of the motors in order to be certain that the motor can drive the pump. Also, check that the rotational speed of the motor will not be greatly reduced by the load. Compare the maximum permitted loading of the PTO with that of the pump.

OIL:

The hydraulic oil must be of high quality, suitable for a pressure of 210 bar. The ISO viscosity must be 46 (for example Chevron AW 46 hydraulic oil), while in cold conditions a viscosity of 32 must be used. Conditions of extreme cold demand hydraulic fluids of aviation quality.

RESERVOIR:

The volume of oil in the reservoir must be equal to or greater than the oil flow per minute. The reservoir must be filled to a level of 80-90%. Suction and return tubing must be placed so that cavitations will be prevented. The filler cap must have a bleed capability.

PRESSURE RELIEF VALVE:

The hydraulic installation must have a pressure relief valve that is adjusted to 210 bar. Ensure that the pressure relief valve is capable of sustaining the oil flow.

WARNING: The correct adjustment of the pressure relief valve is very important. If this is too low it is possible that the system will not load or unload; if it is too high, the system may be damaged.



Measures to follow:

FILTER:

The filter in the return tubing must have a degree of filtration of 10 microns. In conditions of extreme cold it is better to use filtration of 25 microns. Ensure that the nominal flow volume of the filter is the same as the maximum oil flow that can occur in the system.

HYDRAULIC PLUMBING:

All hoses must be suitable for a pressure of at least 300 bar.

Suction Plumbing: in order to prevent cavitations, the oil flow to the suction inlet of the pump must be unhindered. This requires suction tubing with a sufficient diameter (at least 2" or 50 mm) that is as short as possible (not more than 1.5 m), with out constrictions. Cavitations can also be caused by bends or elbows in the pipe work – a straight line is best. Ensure that the hose cannot collapse with the suction.

Pressure plumbing: the hose from the tractor to the trailer must be 1" or 25 mm.

Return plumbing: the hose from the trailer to the filter must also be 1" (25 mm). The hose from the return filter to the reservoir must be at least 1¼" (32 mm).

QUICK-COUPPLINGS:

| | |
|----------|--|
| Tractor: | Male on return (to the reservoir) female on pressure (from the pump) |
| Trailer: | female on return (from the "TANK" port on the filter block) male on pressure (to the "PUMP" port on the filter block) |

4. Operation

WARNING:



The large force exerted by the floor can result in damage to equipment and serious injury or death. Always ensure that this manual has been read and understood by the operator. Take the following precautionary measures:

- First open the doors before switching on the pump.
- Make sure that nobody is under the system when the pump is switched on.
- Ensure that during unloading no people or animals are in the immediate neighbourhood of the location where the load can end up. We suggest that no one should be within 5 m of the discharge danger zone.
- Ensure that there is always someone close to the emergency switch during loading and unloading.
- Always switch off the pump during maintenance or service activities.
- Always switch off the pump when the vehicle is being driven and when the system is not in use.

Two modes of operation are possible: *manual* and *electrical*; the person operating the system during loading or unloading must be able to see the place where the load will be placed.

GENERAL TIPS:

- Depending on the type of load, a part of it can remain on the floor after the unloading operation. This can be prevented by the use of a Cleensweep tarp system, a moving headboard or a piece of canvas, possibly attached to a moving headboard or attached to the front bulkhead with clips.
- In order to limit the effect of friction between the floor and the load, (so as to protect the load or the floor) a piece of canvas can be laid over the whole floor and fixed at the front to the moving headboard. With a simple arrangement it is possible to roll it up at the rear during unloading.
- The speed of the floor can be changed by changing the speed of the motor. Ensure that the maximum permitted pumping rate is not exceeded.
- Ensure that the material can be freely unloaded: do not push against the material stacked behind the floor.
- Take care that the load does not damage the front wall or headboard. The force exerted by the moving load can be considerable!
- In frosty conditions, stop the three cylinders at the beginning of the unloading movement. As soon as unloading starts, the floor slats will move together to the tail end of the trailer and will detach the load from the side walls.

4.1 Manual operation

Starting the floor operation:

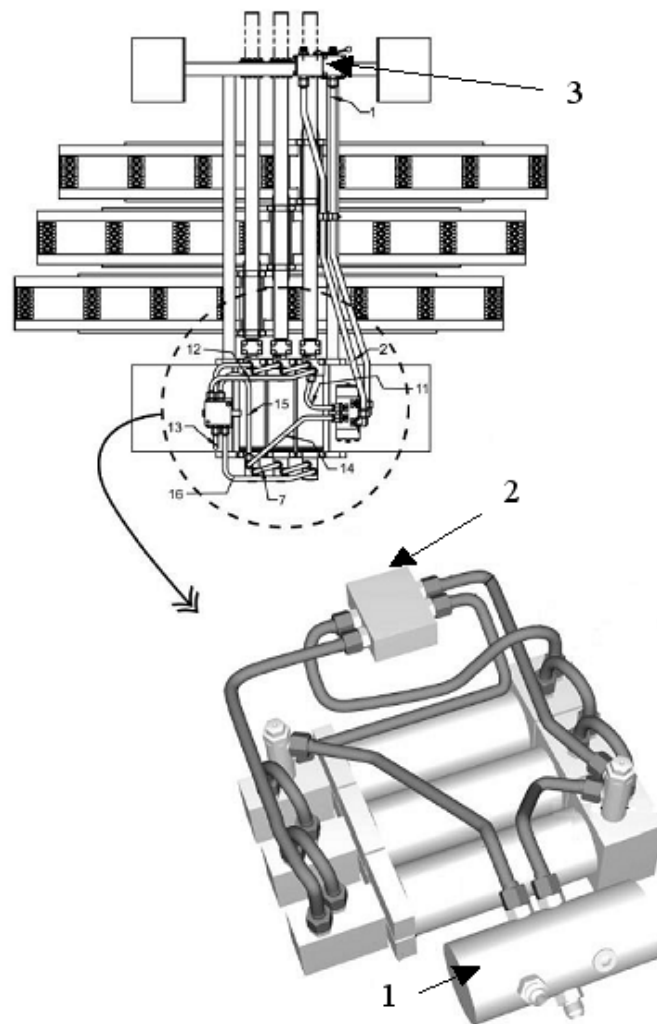
1. Open the trailer doors.
2. Attach the hydraulic quick couplings to one another.
3. Turn on the PTO and bring the engine to the desired number of revolutions (rpm).

Unloading / loading:

1. Select the desired operation to be performed by the system; unload / load.
2. Set the on/off handle in position; on. The floor will now begin to function.

Stopping:

1. Set the on/off handle in the position; off. The floor will now stop.



1. Switching valve
2. Manual Load/Unload valve
3. Manual On/Off valve

Figure 4.1: Manual operation

4.2 Electric operation

Starting the floor operation:

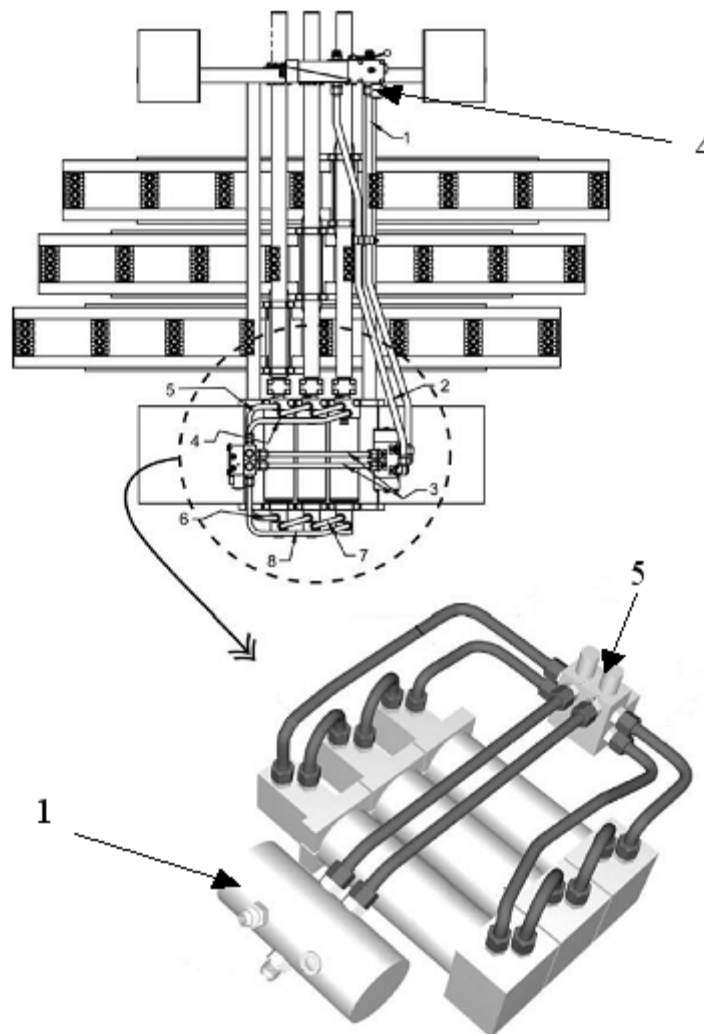
1. Open the trailer doors.
2. Attach the hydraulic quick couplings to one another.
3. Turn on the PTO and bring the engine to the desired number of revolutions (rpm).

Unloading / loading:

1. Set the control push button for the system in the desired position; unload / load.
 2. Set the on/off switch on the control box in the position; *on*
- The floor will now begin to function.

Stopping:

1. Set the on/off switch on the control box in the position; *off*



1. Switching valve
4. Electric On/Off valve
5. Electric Load/Unload valve

Figure 4.2: *Electric operation*

Emergency stop

The system with an optional KEITH® electrical controlbox is provided with an emergency stop push button. If a dangerous situation arises during the operation of the floor it can be stopped immediately with the emergency stop.

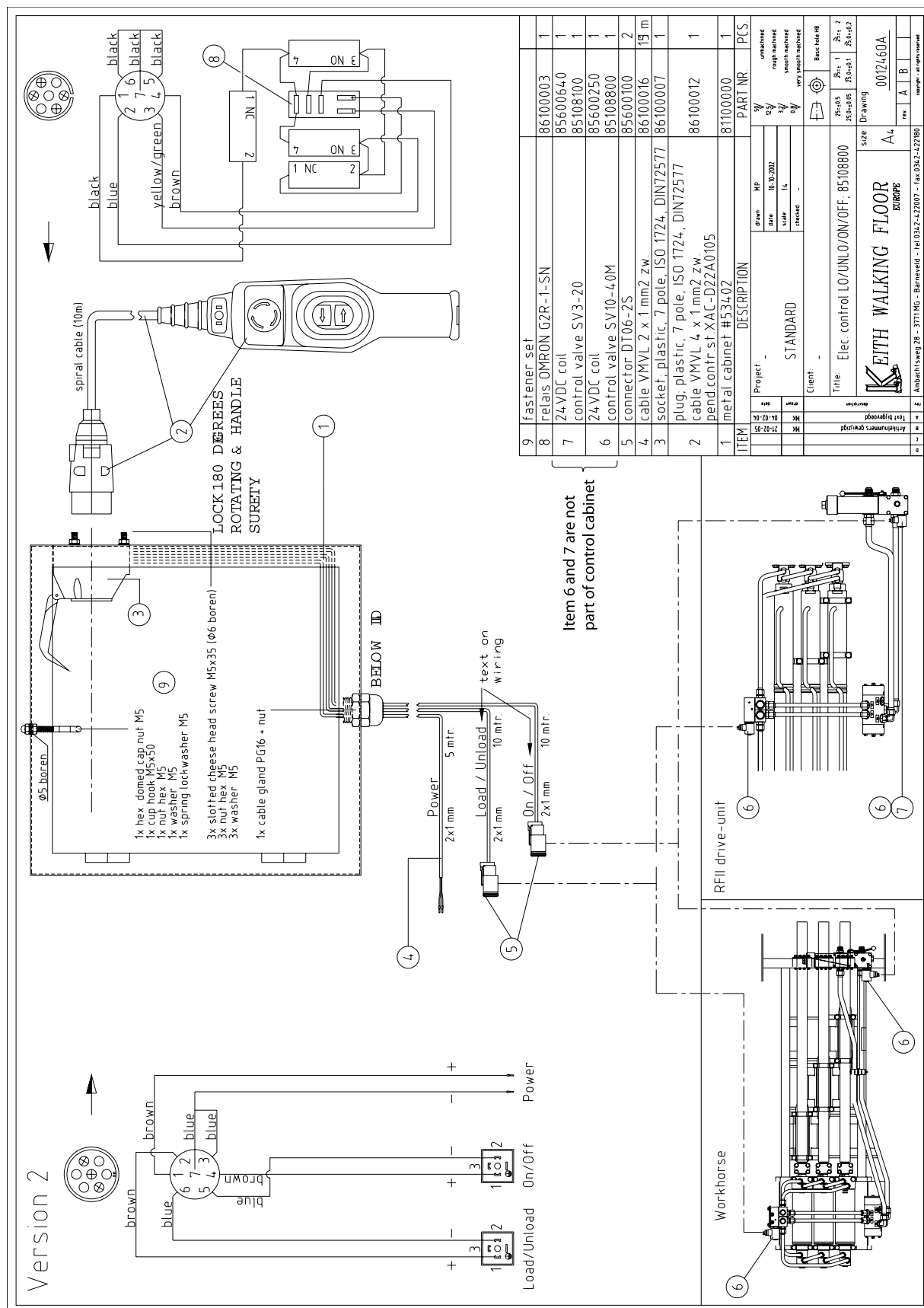
Manual operation in an emergency

In case of an interruption in the electrical power supply, the system can be switched on/ off manually. Operate the handle on the block between the pressure and return connection.

Switching off

1. Stop the floor
2. Switch the PTO off and uncouple the quick couplings, if necessary.

4.2.1 Electrical control Load / Unload / On / Off



4



5. Components



WARNING:

The large force and pressure caused by the hydraulic forces in the system can cause serious injuries. Always switch off the pump during maintenance or service work.

5.1 The cylinder

The three cylinders are the drive elements in the KEITH® *WALKING FLOOR*® system.

The cylinders are attached to the frame by a bolt construction. Each piston rod, or extension of the piston rods, are attached to a cross drive with two clamps.

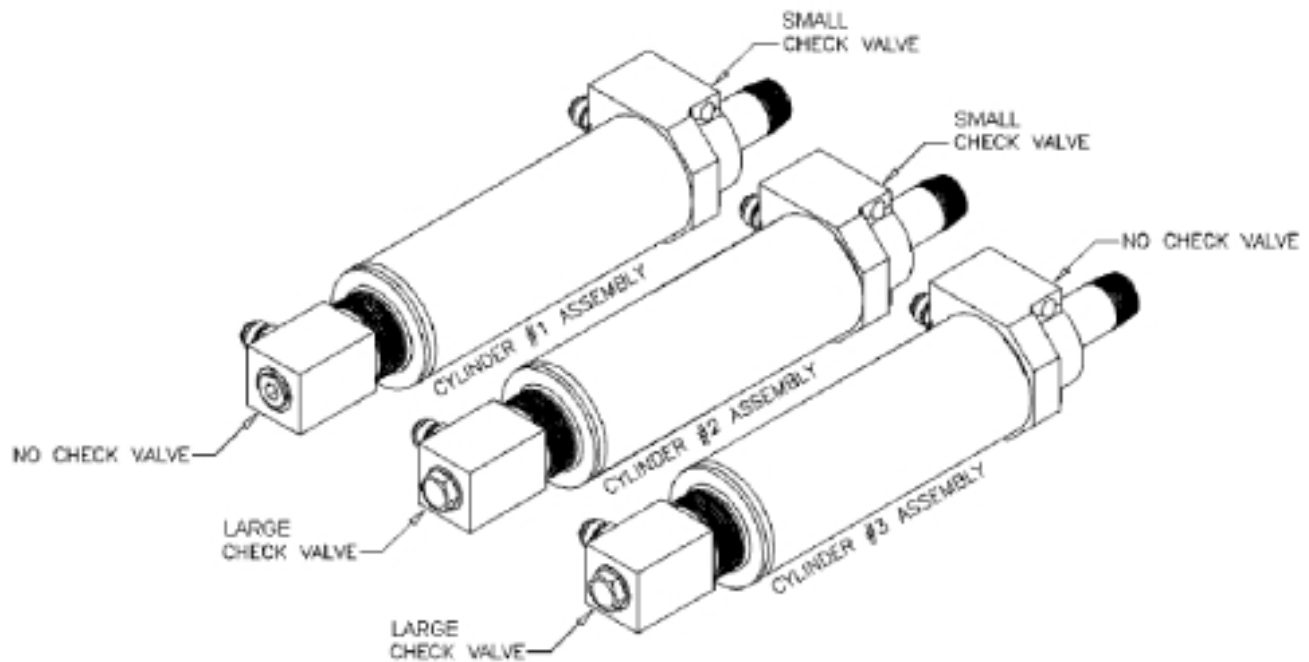


Figure 5.1: The Cylinder

The above figure shows the difference between the cylinder compilation.

For possible repair of a cylinder, in all cases a #2 cylinder will be supplied. Besides the replacement for a #2 cylinder, this cylinder can be modified for the purpose of a cylinder #1 or #3. For modification to cylinder 1, the plug, check valve and the spring at the end of the cylinder needs to be removed. When a cylinder #3 is needed, the check valve, the spring and plug needs to be removed at the front of the cylinder.

After replacement of a cylinder, followed by a full sequence of loading and/or unloading at full load:

Check the torque of the bolts with which the cylinder is attached to the frame - torque 170 Nm.

Check the torque of the bolts in the cylinder clamps - torque 170 Nm. Check the system for leaks.

5.2 The check valve

The four check valves are the sensors of the KEITH® *WALKING FLOOR*® system. The check valve detects when the cylinder has reached the end of its stroke and opens in order to allow the oil from the following cylinder to flow to the reservoir. The check valves are located at the front and rear of the cylinder in the heads on top of the cylinders. The valves are operated by the piston or piston rod inside the cylinders.

5.3 The switching valve

The only function of the switching valve is to change the pressure from one side of the cylinders to the other side. This ensures that the cylinders move in the opposite direction. The switching valve is mechanically operated at the end of the stroke of cylinder No.1 and cylinder No. 3.

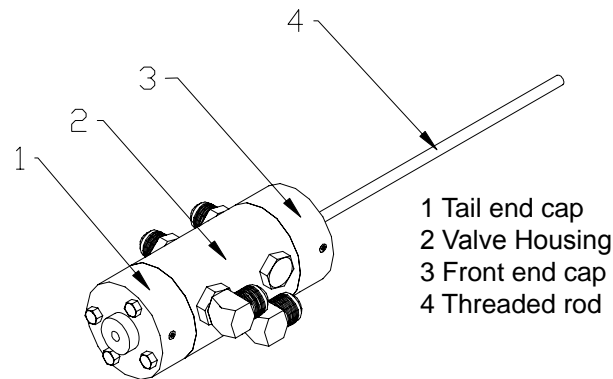
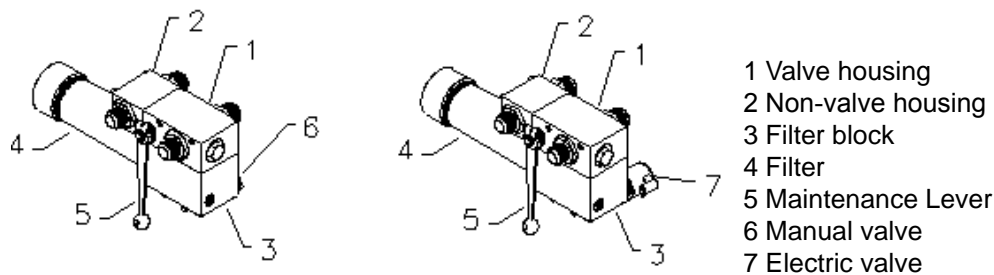


Figure 5.3: *The switching valve*

5.4 The On / Off Valve

The valve, manually and/ or electrically operated, sets the floor in operation. In the <OFF> position the oil flows via the valve directly back to the reservoir. The system will not operate if the pressure and return plumbing is not correctly connected.



Manual

Electric

Figure 5.4: *The On / Off valve*

5.5 The control valve

This valve, which is manually operated, determines the direction of movement of the system.

The valve has two positions:

- Fully Withdrawn ; unloading
- Fully Depressed; loading.

Before the floor system is started the correct direction must be set.

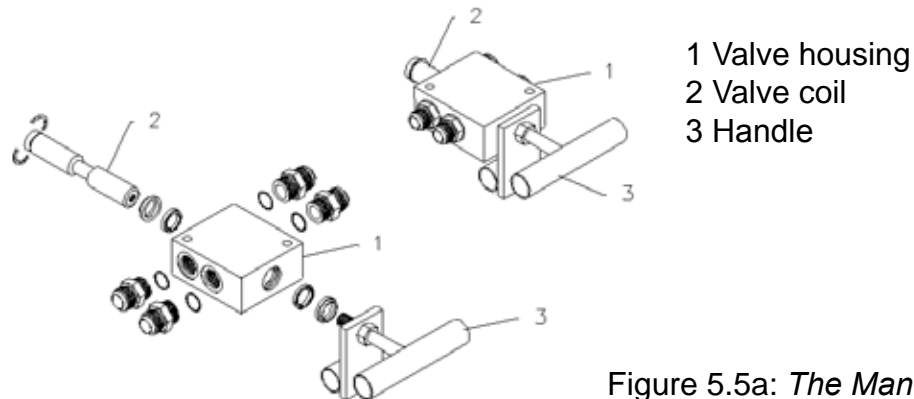


Figure 5.5a: *The Manual Control valve*

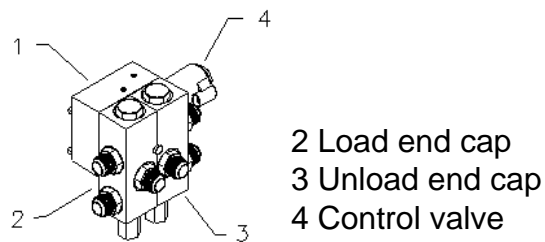


Figure 5.5b: *The Electric Control valve* 1 Pilot valve housing

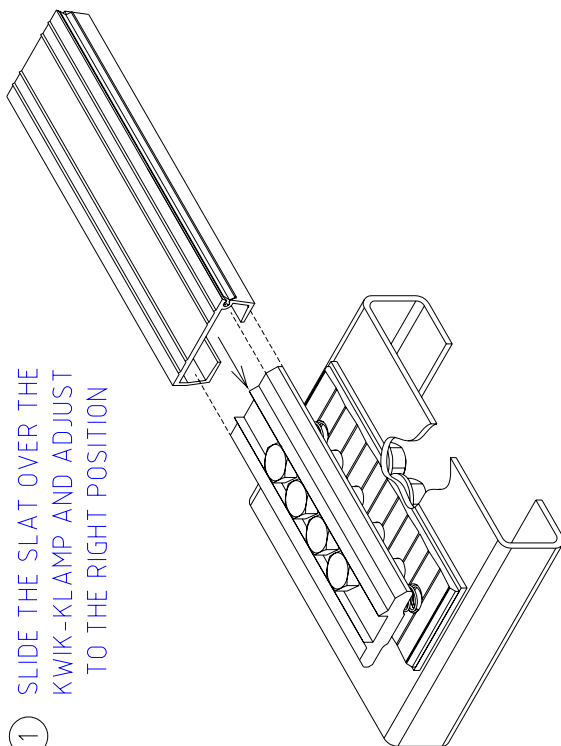
5.6 The hydraulic plumbing

All hydraulic plumbing is internally completely hollow. A considerable part of the hydraulic circuit is internal; the external plumbing for both manual and electrical operation are shown in respectively figures 4.1 and 4.2. Ensure, when work is being carried out on the system, that all couplings, covers and plugs make a good seal ("O" – ring or flat seal).

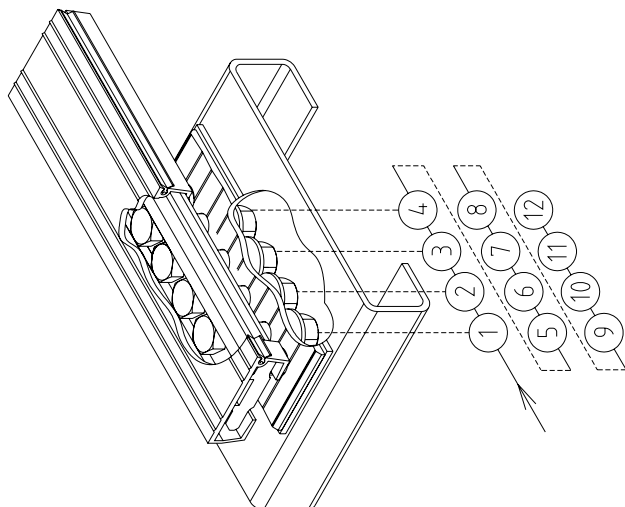
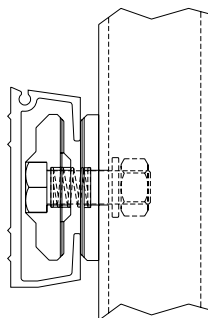
5.7 Installation of the floor slat with Kwik-Klamp® System

INSTALLATION OF SLATS WITH THE KWIK-KLAMP SYSTEM

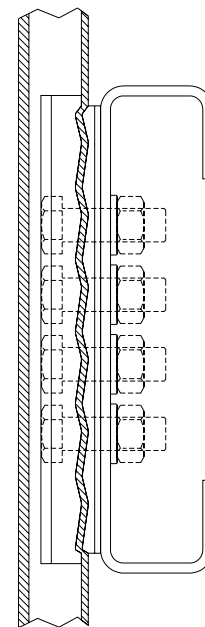
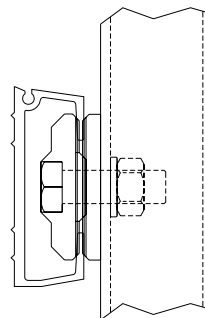
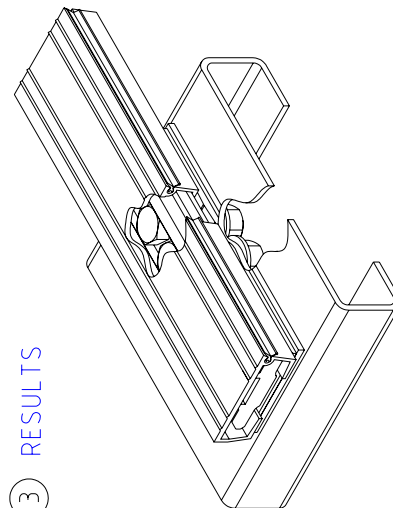
- 1 SLIDE THE SLAT OVER THE KWIK-KLAMP AND ADJUST TO THE RIGHT POSITION



- ② MOUNTING: EACH OF THE 4 BOLTS HAS TO BE TIGHTENED WITH A TORQUE OF 200 Nm, FROM 1 TO 12, THIS IS 3x EACH BOLT



- ### ③ RESULTS



| | | | |
|------------------------|----------|-----|----------|
| Project # | 00000000 | Rev | 00000000 |
| Sheet | 00000000 | Rev | 00000000 |
| Drawn | 00000000 | Rev | 00000000 |
| Check | 00000000 | Rev | 00000000 |
| Scale | 1:1 | Rev | 00000000 |
| Notes | - | | |
| Project Name | STANDARD | | |
| Client | - | | |
| Project Location | - | | |
| Project Description | - | | |
| Project Manager | - | | |
| Project Engineer | - | | |
| Project Architect | - | | |
| Project Designer | - | | |
| Project Draftsman | - | | |
| Project Checker | - | | |
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| Project Date | - | | |
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6. **WALKING FLOOR®** Workhorse system maintenance



WARNING: The large force and pressure can cause serious injuries. Always switch off the pump during maintenance or service work.

Two conditions that contribute to the life of the KEITH® *WALKING FLOOR* system are:

- Clean oil, free from contamination
- Correct torque for the bolts. The bolts of the cylinder clamps and of the floor profiles must be checked regularly.

The following maintenance must be carried out:

- after the system has been working for 6 hours;
- every half year or after every 150 operating hours whichever is sooner.

1. General inspection of the system and the floor.

Inspect the system for damage.

Check for oil leaks.

Check the system for smooth operation.

Check the temperature. No single part may be warmer than 70°C (it must be possible to touch all parts with the bare hand).

2. Change the oil filters:

- a. Filter in the return plumbing of the hydraulic installation. Optional:
- b. Filter in the pressure plumbing (FA 20ME MXW2-GDL20, 20 microns).
Unscrew the filter housing. Clean up any oil that has leaked. Fit a new filter.

3. Check the torque of the cylinder bolts.

- a. Cylinder clamps: Torque: 170 Nm.
- b. Bolts which connect the cylinder to the frame : 200 Nm

7. Dealing with problems



WARNING: The large force and pressure can cause serious injuries. Always switch off the pump during maintenance or service work. If you experience problems with the operation of your KEITH® *WALKING FLOOR*® system this section can help you to find a solution and to make small adjustments. Before you go further, first check whether one of the following most frequently encountered problems is applicable:

- oil* : is the reservoir full?
- pump* : does it pump the necessary quantity of oil at 210 bar?
- connections* : is the system connected as shown in the hydraulic diagram (fig. 3.1)?
- pressure relief valve* : is this adjusted to 210 bar?
- PTO* : is this switched on?
- quick couplings : are they properly connected?
- on/ off valve : is this on?
- electrical operation : is there sufficient voltage?
: is the emergency pushbutton pulled out?

*see the specification for the hydraulic installation (chapter 3).

IMPORTANT: When you perform welding on the system, the part on which welding is performed must be directly connected to earth. A pressure meter can be connected to the system.

PROBLEM A: The cycle begins, then the floor stops:

1. All cylinders move backward, then the system stops.

Cause #1: The switching valve is not switching correctly.

Solution: Check the adjustment. (Figure 7.1).

Cause #2: Insufficient pressure.

Solution: Check the pressure and the position of the pressure relief valve.

2. Cylinder 1 moves forward, cylinder 2 moves forward, cylinder 3 moves forward, then the system stops.

Cause: The switching valve is not switching correctly.

Solution: Check the adjustment. (Figure 7.1).

3. The floor functions perfectly without a load or with a light load, but not with a heavy load.

Cause #1: Insufficient pressure.

Solution: Check the pressure and the setting of the pressure relief valve.

Cause #2: The switching valve is not switching correctly.

Solution: Check the adjustment. (Figure 7.1).

N.B.: Cylinder 1 is the cylinder on the driver's side, for vehicles driving on the right.
Cylinder 1 is the cylinder on the passenger's side, for vehicles driving on the left.

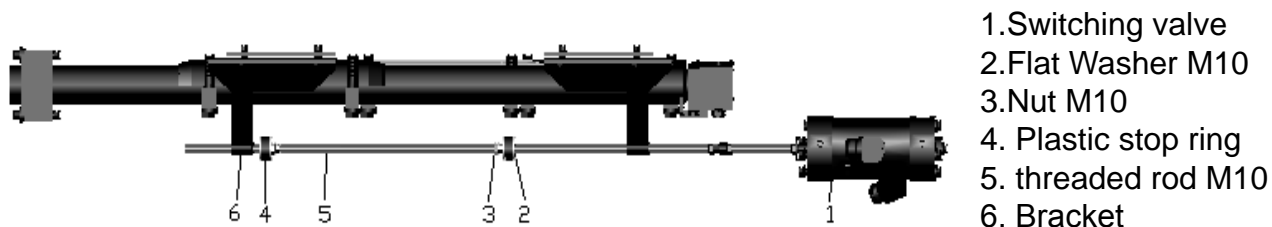


Figure 7.1 : Adjustment of the switching valve

PROBLEM B: Cycle runs incorrectly for unloading:

1. Cylinders 1 and 2 move together to the front.

Cause: The check valve on the front of cylinder 1 is not functioning correctly.

Solution: Repair the check valve.

2. Cylinders 2 and 3 move together to the front.

Cause: The check valve on the front of cylinder 2 is not functioning correctly.

Solution: Repair the check valve.

3. All cylinders move together to the front.

Cause #1: The load/unload valve is not functioning correctly.

Solution: Repair the load/unload valve.

Cause #2: The check valve on the front of cylinders 1 and 2 is not functioning correctly.

Solution: Repair the check valve.

PROBLEM C: The loading cycle runs incorrectly:

1. Cylinders 3 and 2 move together to the rear.

Cause : The check valve on the rear of cylinder 3 is not functioning correctly.

Solution: Repair the check valve.

2. Cylinders 2 and 1 move together to the rear.

Cause: The check valve on the rear of cylinder 2 is not functioning correctly.

Solution: Repair the check valve.

3. All cylinders move together to the rear.

Cause #1: The load/unload valve is not functioning correctly.

Solution: Repair the load/unload valve.

Cause #2: The check valve on the front of cylinders 2 and 3 is not functioning correctly.

Solution: Repair the check valve.

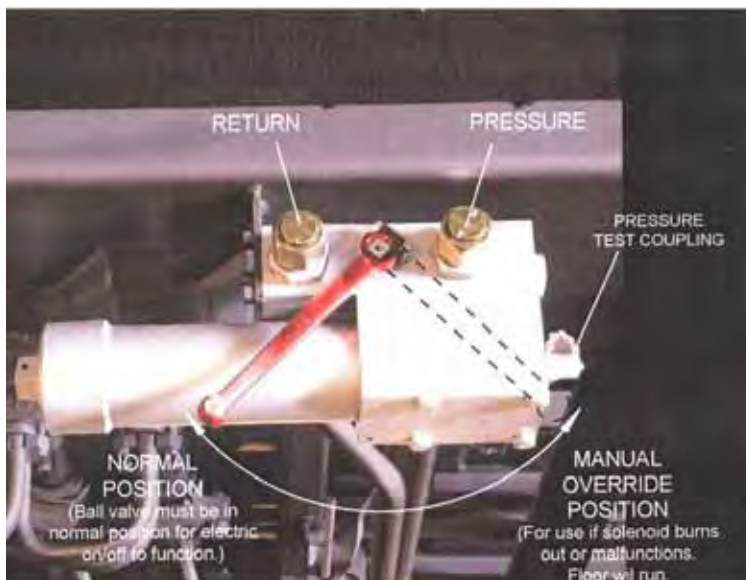
7.1 Emergency Provision

The Electric On / Off valve:

The on/ off valve, controlled electrically, starts and stops the operation of the floor. In the <OFF> position, the oil flows via the valve directly back to the oil reservoir. NOTE: the system will not work if the pressure- and return hydraulic piping are not correctly connected.

Situation: It is not possible to control the electric on/ off valve.

Solution: Place the red handle so it is pointing to the opposite direction of the system; in other words the manual override position (see figure 7.2). The oil shall now flow directly through the system. The Floor will start moving if the pump is switched on. The system will now unload. The floor can be switched into the loading direction by pressing and turning the red button of the coil of the electric control valve. By pressing and turning the red button to the right, the floor will unload again. This will only work when there is no electric power on the coil of the electric load / unload valve. If the red handle is placed in its normal position, meaning pointing toward the system, then the oil flow is blocked and the floor movement will stop.



The functioning of the handle



*The red button on the coil
Figure 7.2 : The electric on / off valve*

8. Warranty

KEITH Mfg. Co. hereby warrants,

- Only to the first owner of a new KEITH® *WALKING FLOOR*® unloader from the factory or selling distributorship that the product shall be free from defects in material and workman ship for a period of one year after delivery to the first registered owner.
- This warranty does not cover normal wear and tear and maintenance, and is not to be construed as a service contract.

Owners Obligation:

- To qualify for warranty coverage,
- A warranty card must be completed and on file at KEITH Mfg. Co. and,
- The equipment must be subject to normal use and service only.

Definition of Normal Use and Service:

Normal use and service means:

- The loading and/or unloading of uniformly distributed, non-corrosive material,
- Properly restrained and secured on properly maintained public roads, with gross vehicle weights not in excess of factory rated capacity.
- For stationary installations, normal use and service means the conveying of uniformly distributed, non-corrosive materials, with weights not in excess of factory rated capacity.

Sole and Exclusive Remedy:

If the product covered hereby fails to conform to the above stated warranty, KEITH Mfg. Co.'s sole liability under this warranty and the owner's sole and exclusive remedy is, Limited to repair or replacement of the defective part(s) at a facility authorized by KEITH Mfg. Co. This is the owner's sole and exclusive remedy for all contract claims, and All tort claims including those based on the strict liability in tort and negligence. Any defective part(s) must be shipped freight prepaid to the facility authorized by KEITH Mfg. Co.

Except As Expressly Set Forth Above, KEITH Mfg. Co. Makes No Warranties:

- Express, implied or statutory, specifically no warranties of fitness for a particular purpose or warranties of merchantability are made.
- Further, KEITH Mfg. Co. will not be liable for incidental damages or consequential damages such as, but not limited to:
- Loss of use of the product, damage to the product, towing expenses, attorney's fees and the liability you may have in respect to other reasons.

Tort Disclaimer:

•KEITH Mfg. Co. shall not have any liability in tort with respect to the products, including any liability based on strict liability in tort and negligence.

If This Warranty Violates Law:

•To the extent any provision of this warranty, contravenes the law of any jurisdiction, that provision shall be inapplicable in such jurisdiction and the remainder of the warranty shall not be affected thereby.

8.1 Warranty conditions

This guarantee applies to the free-of-charge provision of replacement components, provided;

- In the case of a malfunction KEITH *WALKING FLOOR* Europe must be informed first.
- The KEITH *WALKING FLOOR* system has been installed by your installer in accordance with our installation specifications.
- Our maintenance and operating instructions have been observed.

Not covered by the guarantee:

- Malfunctions of/caused by equipment supplied by third parties.
- Malfunctions of/caused by the use of contaminated and/or incorrect oil.
- Malfunctions of/caused by injudicious use.
- Malfunctions of/caused by repairs/additions carried out by third parties.
- Normal wear and tear of components and filter elements.
- Defects of electrical parts resulting from bad connections and/or incorrect voltages.
- Labor costs.

The guarantee will lapse if:

- The KEITH *WALKING FLOOR* system is used for material other than that for which the original was intended.
- The KEITH *WALKING FLOOR* system has not been installed correctly by your installer so that the operation of the system is negatively influenced.

Warranty registration card

USER DETAILS

NAME : _____

ADDRESS : _____

POSTAL CODE + PLACE : _____

COUNTRY: _____

TEL. : _____ FAX : _____

E-MAIL : _____

SYSTEM DATA

DATE OF PURCHASE : _____

MODEL / SERIAL NUMBER : _____

PURCHASED FROM : _____

LOAD : _____

HEREBY DECLARE THAT I HAVE READ AND AGREE TO THE GUARANTEE CONDITIONS
OF KEITH *WALKING FLOOR* EUROPE.

Place

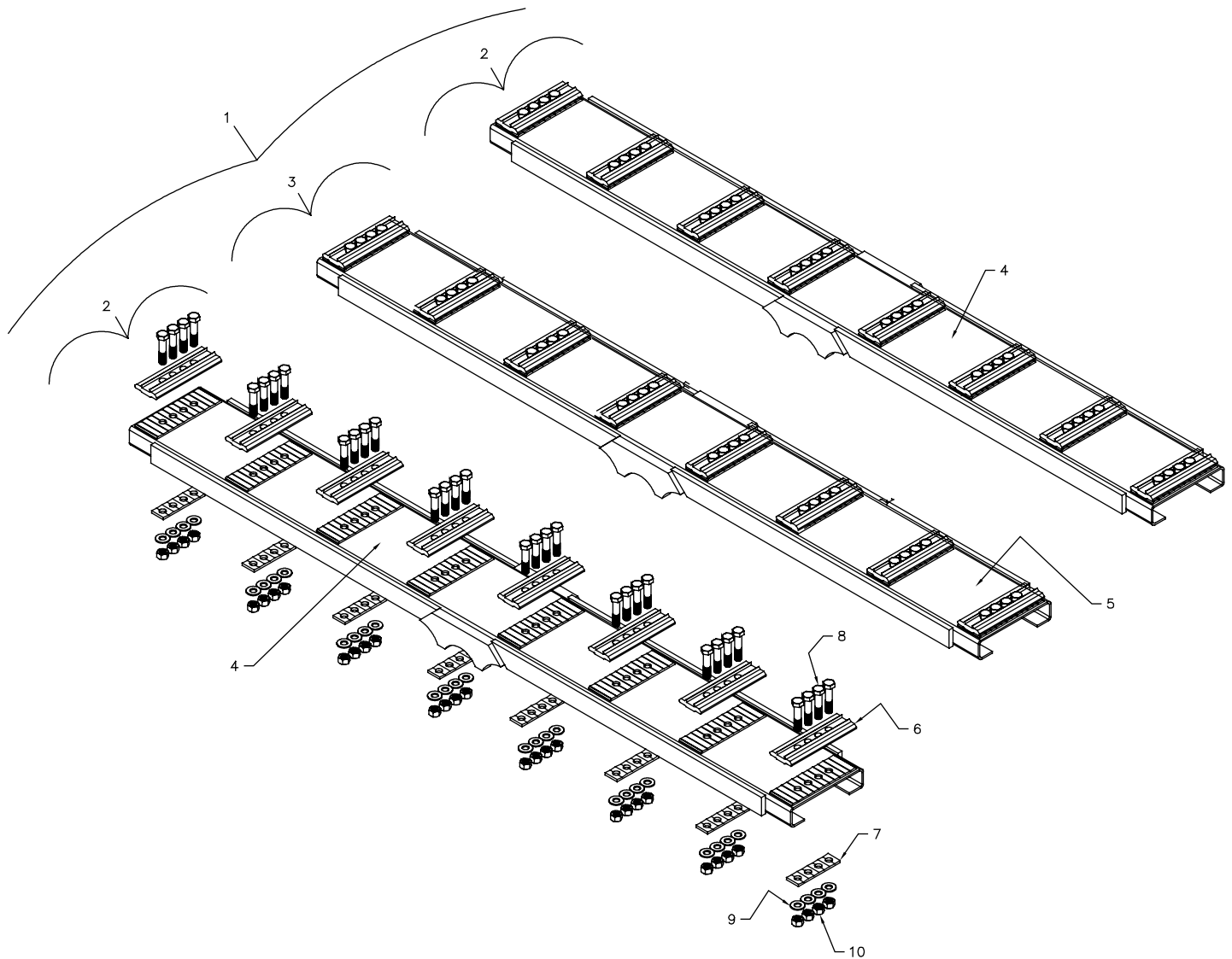
Date

Signature

N.B. IN ORDER TO SUBMIT A CLAIM UNDER THE GUARANTEE, THIS REGISTRATION
CARD MUST BE SENT TO KEITH *WALKING FLOOR* EUROPE WITHIN 10 DAYS OF
PURCHASE.

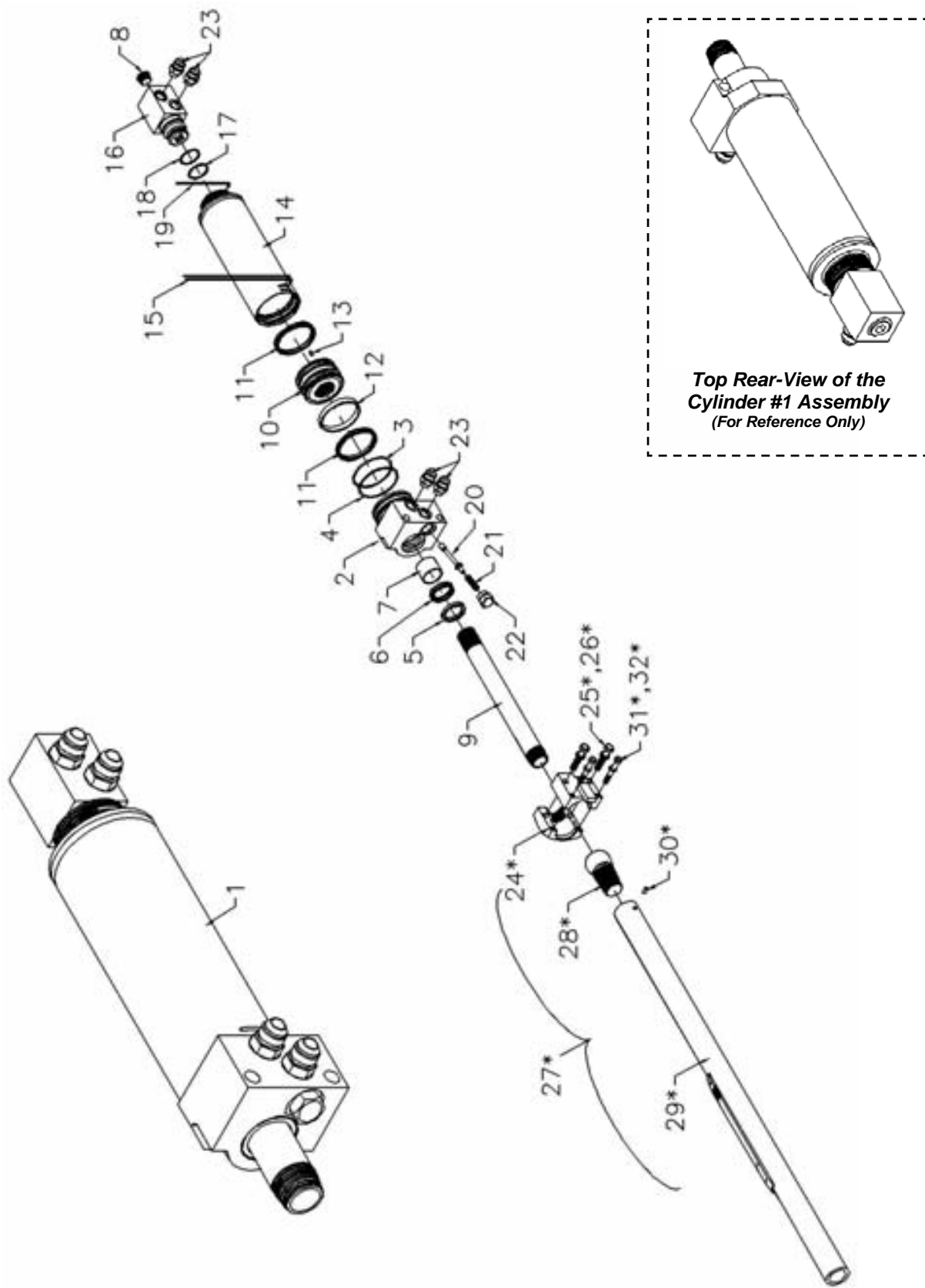
Send with sufficient postage to:

KEITH WALKING FLOOR EUROPE
AMBACHTSWEG 28
3771 MG BARNEVELD

**Notes:**

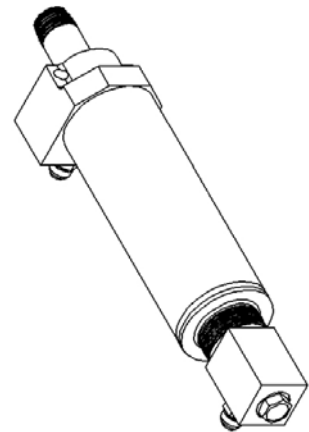
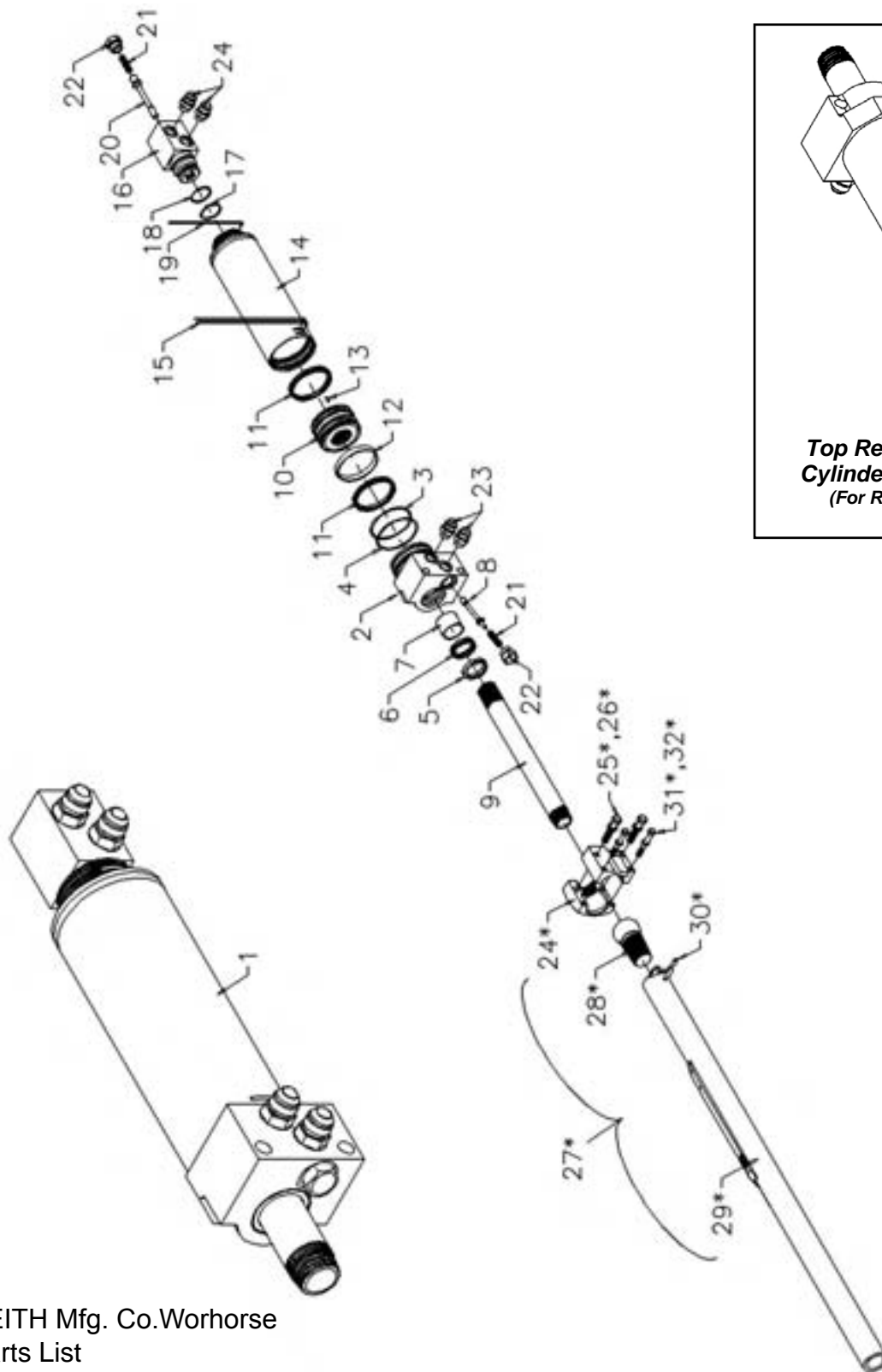
1. This view is an inverted bottom view of the Cross-Drive Assemblies.
2. Both #2 assemblies are identical, however one unit is rotated 180° as shown above.

| ID# | QUANTITY | DESCRIPTION | PART# |
|-----|----------|---|-----------------|
| | 1 | Workhorse Drive Conversion Kit to Electric On/Off w/ integrated Filter | 04839602 |
| - | - | Includes items 1-14 | - |
| 1 | 1 | Fairley Arlon Filter Block | 04436502 |
| 2 | 1 | Test Coupling SMK20-G1/4VC | 84904000 |
| 3 | 4 | 10mm x 110mm Hex Bolt | 87011500 |
| 4 | 1 | 6408-04 O-Ring Hex Plug | 84686500 |
| 5 | 1 | Solenoid Control Valve SV10-40 | 85108800 |
| 6 | 2 | 218 O-Ring | 84382800 |
| 7 | 2 | 112 O-Ring | 84376300 |
| 8 | 1 | On/Off Poppet | 04438401 |
| 9 | 1 | Spring #B-18273 | 84453400 |
| 10 | 1 | Fairley Arlon Filter Element #MXW2-GDL20 w/Spring 7 Rubber Seal | 84006520 |
| 11 | 2 | 147 O-Ring Backup | 84389047 |
| 12 | 2 | 147 O-Ring | 84378447 |
| 13 | 1 | Welded Filter Canister Assy. | 06151501 |



| ID# | QUANTITY | DESCRIPTION | PART # |
|-----|----------|---|-----------------|
| 1 | 1 | Workhorse Cylinder Assembly #1 | 04626101 |
| | | Includes items 2-23 | |
| 2 | 1 | 4" Aluminum Head w/Round Lock Wire | 04620801 |
| 3 | 1 | 240 O-Ring | 84385000 |
| 4 | 1 | 8-240 O-Ring Backup | 84393200 |
| 5 | 1 | 45mm Canned Rod Wiper | 84426600 |
| 6 | 1 | 45mm Rod Seal | 84354200 |
| 7 | 1 | 45mm Rod Wear Ring (1.5") | 84401200 |
| 8 | 1 | -12 O-Ring Socket Plug | 84687700 |
| 9 | 1 | 45mm Rod w/Tapered Grooves | 04936901 |
| 10 | 1 | 4" Steel Piston | 04581901 |
| 11 | 2 | 4" Piston Seal | 84352500 |
| 12 | 1 | 4" Piston Wear Ring (.5") | 84403800 |
| 13 | 1 | 3/16" x 1/2" Drive Lock Pin | 86650400 |
| 14 | 1 | 4" Barrel Weld Assembly | 04621001 |
| 15 | 2 | 1/8" Round Wire Lock | 04834401 |
| 16 | 1 | Check Valve Body Steel Head Mounted | 04581101 |
| 17 | 1 | 224 O-Ring | 84383700 |
| 18 | 1 | 8-224 O-Ring Backup | 84392160 |
| 19 | 1 | 1/8" Round Wire Lock | 04834401 |
| 20 | 1 | Check Valve Poppet 11/16" x 4-1/8" | 4537301 |
| 21 | 1 | .48" O.D. x .63" Wire x 2" Compression Spring | 84454730 |
| 22 | 1 | -12 O-Ring Hex Plug | 84686900 |
| 23 | 4 | -12 to -10 Straight Fitting | 84684900 |
| | | Items 24-32 Are Not Included With Cylinder Assembly | |
| 24 | 1 | Ball Socket w/ Tapered Grooves and Split Clamp Upper and Lower (metric) | 04936802 |
| 25 | 4 | 12mm x 60mm Hex Cap Screw | 87013100 |
| 26 | 4 | 1/2" Lock Washer | 86557000 |
| 27 | 1 | Cross-Drive Tube Assembly #1 | 04828501 |
| 31 | 2 | 10mm x 60mm Hex Cap Screw | 87008540 |
| 32 | 2 | 10mm Lock Washer | 86555000 |

Note: Cylinder #1 has a HEX plug (part ID #22) on the shaft end and a socket plug (Part ID #8) on the check valve end. Cylinder #1 can be identified by these features.



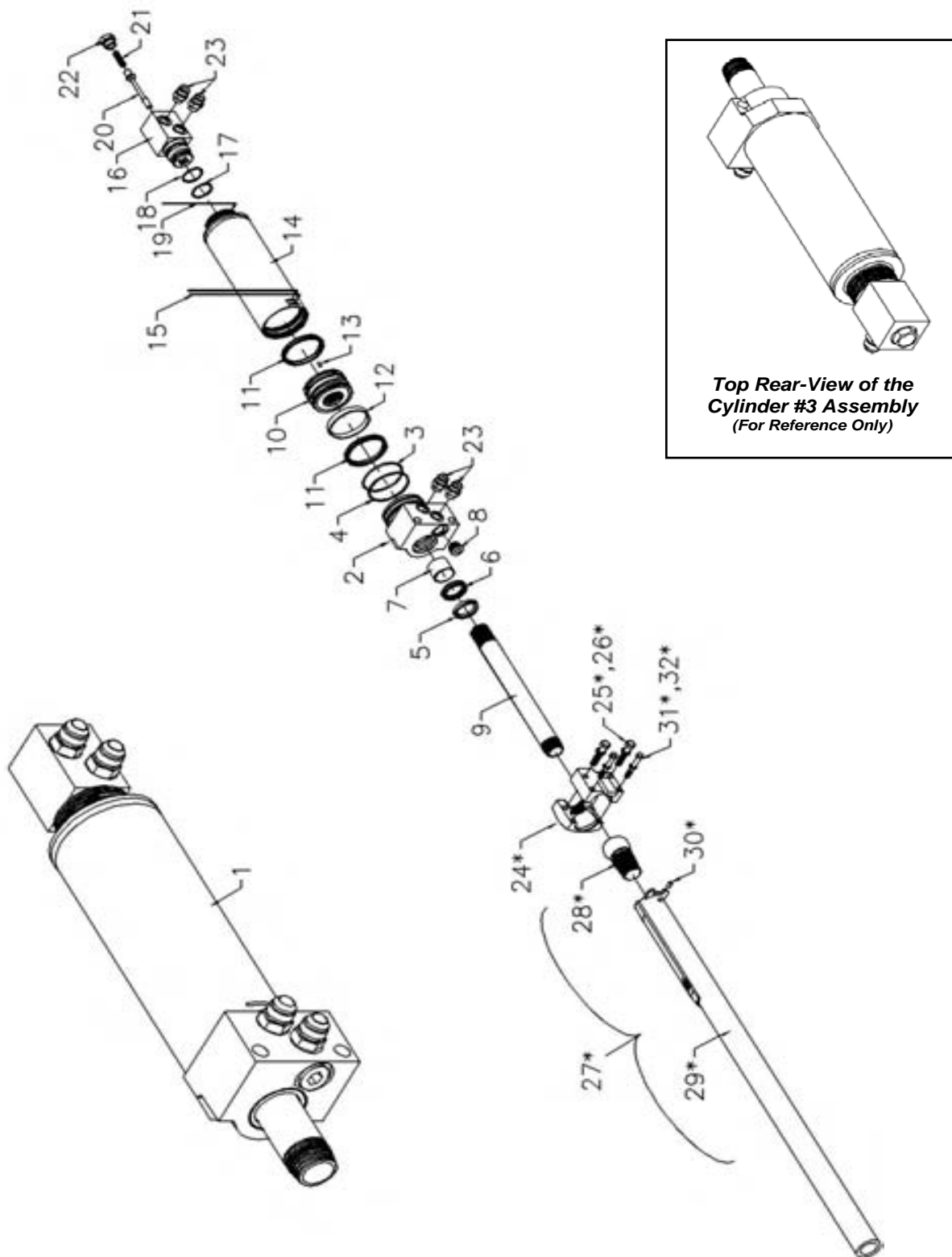
**Top Rear-View of the
Cylinder #2 Assembly
(For Reference Only)**

KEITH Mfg. Co.Worhorse Parts List

| ID# | QUANTITY | DESCRIPTION | PART |
|-----|----------|---|-----------------|
| 1 | 1 | Workhorse Cylinder Assembly #2 | 04626201 |
| | | Includes items 2-23 | |
| 2 | 1 | 4" Aluminum Head w/Round Lock Wire | 04620801 |
| 3 | 1 | 240 O-Ring | 84385000 |
| 4 | 1 | 8-240 O-Ring Backup | 84393200 |
| 5 | 1 | 45mm Canned Rod Wiper | 84426600 |
| 6 | 1 | 45mm Rod Seal | 84354200 |
| 7 | 1 | 45mm Rod Wear Ring (1.5") | 84401200 |
| 8 | 1 | Check Valve Poppet 11/16" x 4-1/8" | 04537301 |
| 9 | 1 | 45mm Rod w/Tapered Grooves | 04936901 |
| 10 | 1 | 4" Steel Piston | 04581901 |
| 11 | 2 | 4" Piston Seal | 84352500 |
| 12 | 1 | 4" Piston Wear Ring (.5") | 84403800 |
| 13 | 1 | 3/16" x 1/2" Drive Lock Pin | 86650400 |
| 14 | 1 | 4" Barrel Weld Assembly | 04621001 |
| 15 | 2 | 1/8" Round Wire Lock | 04834401 |
| 16 | 1 | Check Valve Body Steel Head Mounted | 04581101 |
| 17 | 1 | 224 O-Ring | 84383700 |
| 18 | 1 | 8-224 O-Ring Backup | 84392160 |
| 19 | 1 | 1/8" Round Wire Lock | 04834401 |
| 20 | 1 | Check Valve Poppet 13/16" x 5" | 4601901 |
| 21 | 1 | .48" O.D. x .63" Wire x 2" Compression Spring | 84454730 |
| 22 | 2 | -12 O-Ring Hex Plug | 84686900 |
| 23 | 4 | -12 to -10 Straight Fitting | 84684900 |
| | | Items 24-32 Are Not Included With Cylinder Assembly | |
| 24 | 1 | Ball Socket w/ Tapered Grooves and Split Clamp Upper and Lower (metric) | 04936802 |
| 25 | 4 | 12mm x 60mm Hex Cap Screw | 87013100 |
| 26 | 4 | 1/2" Lock Washer | 86557000 |
| 27 | 1 | Cross-Drive Tube Assembly #2 | 04828502 |
| 31 | 2 | 10mm x 60mm Hex Cap Screw | 87008540 |
| 32 | 2 | 10mm Lock Washer | 86555000 |

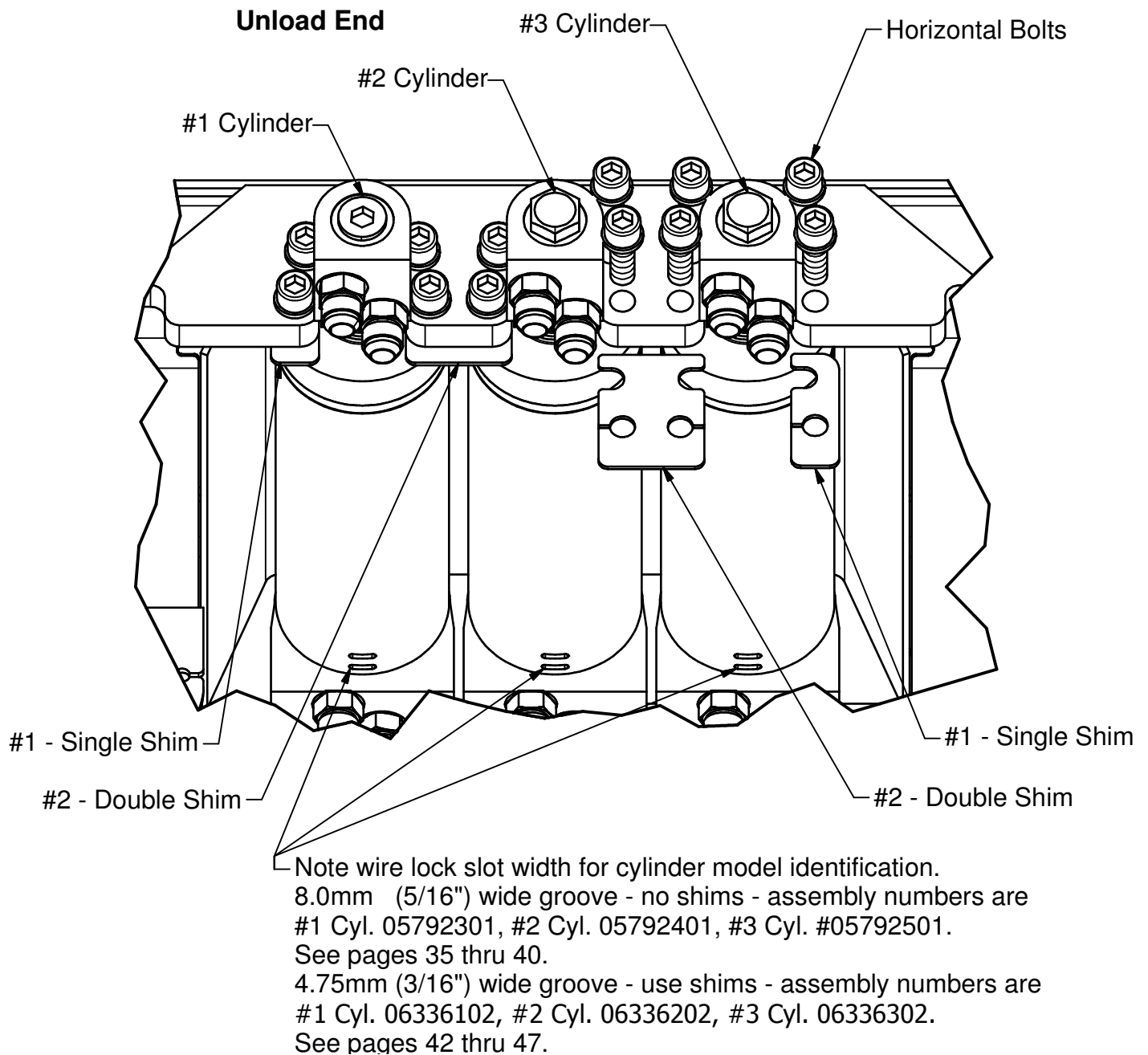
Note: Cylinder #2 has a HEX plug (Part ID #22) on the shaft end and a HEX plug (Part ID #22) on the check valve end. Cylinder #2 can be identified by these features.

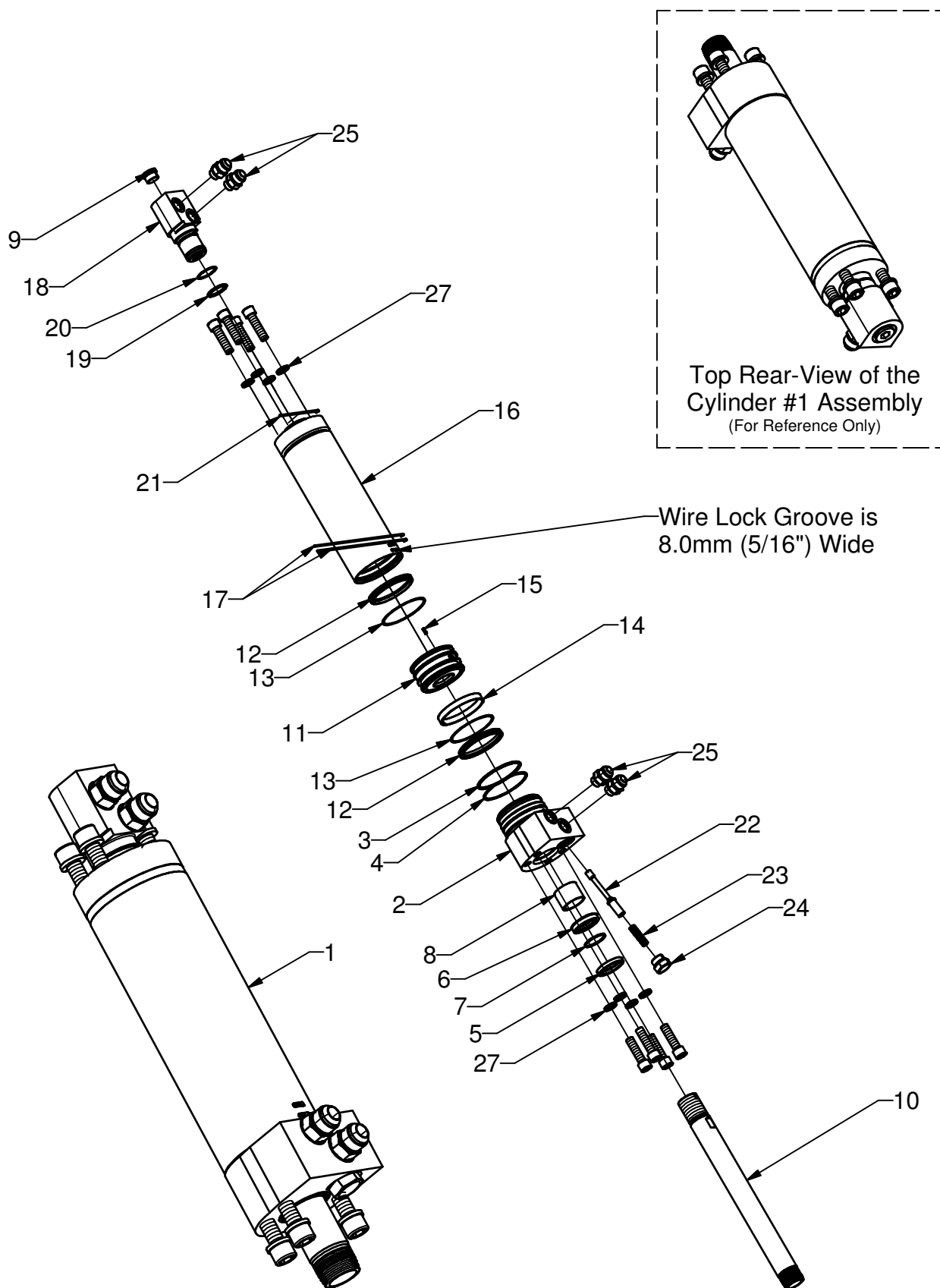
For parts and repair (unless otherwise noted), a #2 Cylinder will be shipped. To use this cylinder in the #1 position, remove the check valve (#20) and spring (#21) at the rear of the cylinder. To use the #2 Cylinder in the #3 position, remove the check valve (#8), spring (#21) at the front of the cylinder. (See Reference Diagram #01)



| ID# | QUANTITY | DESCRIPTION | PART # |
|-----|----------|---|-----------------|
| 1 | 1 | Workhorse Cylinder Assembly #3 | 04669101 |
| | | Includes items 2-23 | |
| 2 | 1 | 4" Aluminum Head w/Round Lock Wire | 04620801 |
| 3 | 1 | 240 O-Ring | 84385000 |
| 4 | 1 | 8-240 O-Ring Backup | 84393200 |
| 5 | 1 | 45mm Canned Rod Wiper | 84426600 |
| 6 | 1 | 45mm Rod Seal | 84354200 |
| 7 | 1 | 45mm Rod Wear Ring (1.5") | 84401200 |
| 8 | 1 | -12 O-Ring Socket Plug | 84687700 |
| 9 | 1 | 45mm Rod w/Tapered Grooves | 04936901 |
| 10 | 1 | 4" Steel Piston | 04581901 |
| 11 | 2 | 4" Piston Seal | 84352500 |
| 12 | 1 | 4" Piston Wear Ring (.5") | 84403800 |
| 13 | 1 | 3/16" x 1/2" Drive Lock Pin | 86650400 |
| 14 | 1 | 4" Barrel Weld Assembly | 04621001 |
| 15 | 2 | 1/8" Round Wire Lock | 04834401 |
| 16 | 1 | Check Valve Body Steel Head Mounted | 04581101 |
| 17 | 1 | 224 O-Ring | 84383700 |
| 18 | 1 | 8-224 O-Ring Backup | 84392160 |
| 19 | 1 | 1/8" Round Wire Lock | 04834401 |
| 20 | 1 | Check Valve Poppet 13/16" x 5" | 4601901 |
| 21 | 1 | .48" O.D. x .63" Wire x 2" Compression Spring | 84454730 |
| 22 | 1 | -12 O-Ring Hex Plug | 84686900 |
| 23 | 4 | -12 to -10 Straight Fitting | 84684900 |
| | | Items 24-32 Are Not Included With Cylinder Assembly | |
| 24 | 1 | Ball Socket w/ Tapered Grooves and Split Clamp Upper and Lower (metric) | 04936802 |
| 25 | 4 | 12mm x 60mm Hex Cap Screw | 87013100 |
| 26 | 4 | 1/2" Lock Washer | 86557000 |
| 27 | 1 | Cross-Drive Tube Assembly #3 | 04828503 |
| 31 | 2 | 10mm x 60mm Hex Cap Screw | 87008540 |
| 32 | 2 | 10mm Lock Washer | 86555000 |

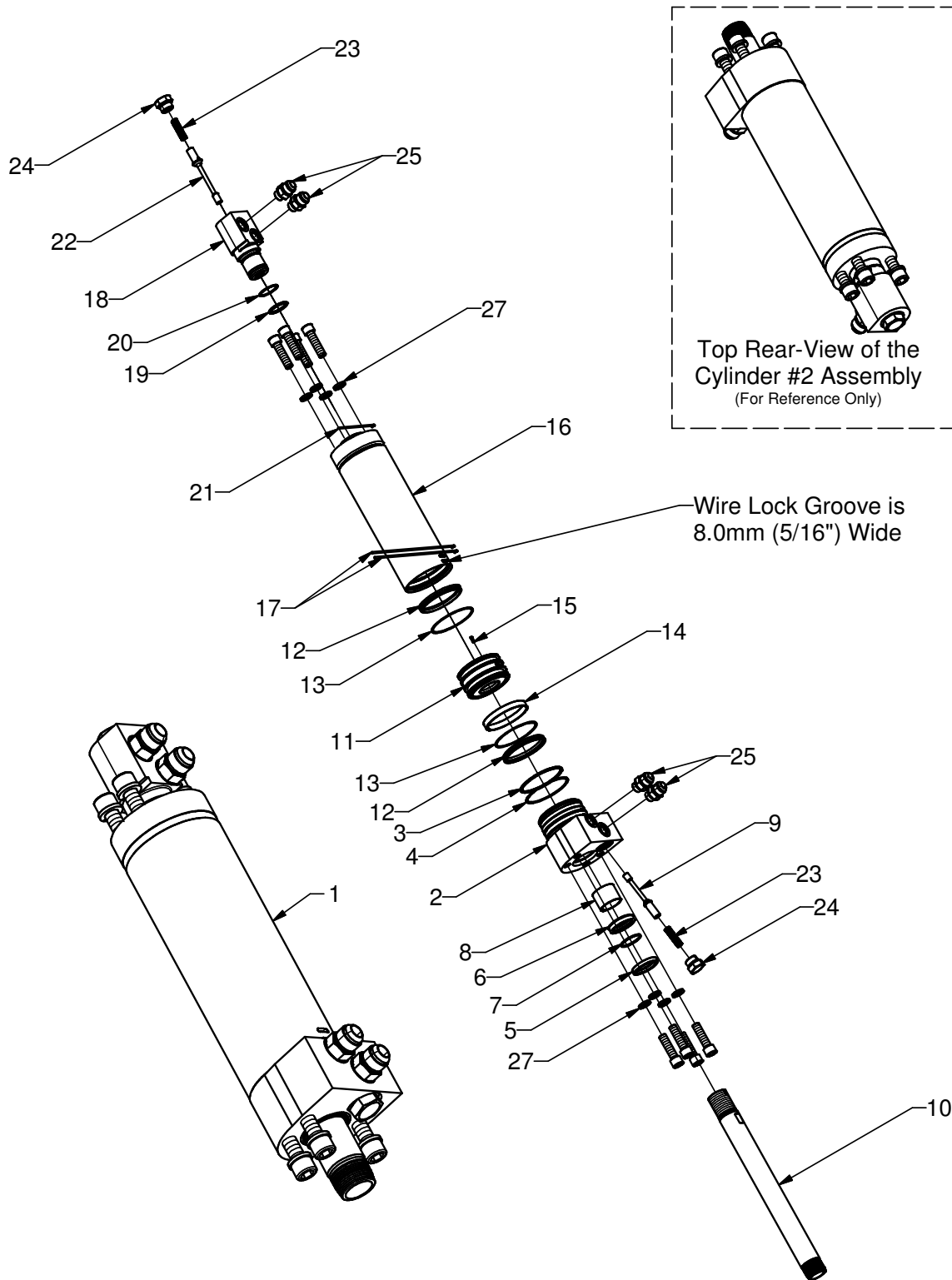
Note: Cylinder #3 has a socket plug (Part ID #8) on the shaft end and a HEX plug (Part ID #22) on the check valve end. Cylinder #3 can be identified by these features.





| PARTS LIST | | | |
|------------|----------|--|----------|
| ID # | QUANTITY | DESCRIPTION | PART # |
| 1 | 1 | Workhorse Cylinder #1 w/ Horizontal Bolts | 05792301 |
| | | includes items 2-25 | |
| 2 | 1 | 4" Aluminum Head w/Round Lock Wire & Horizontal Bolts | 05791302 |
| 3 | 1 | 240 O-Ring | 84385000 |
| 4 | 1 | 8-240 O-Ring Backup | 84393200 |
| 5 | 1 | 45mm Canned Rod Wiper | 84426600 |
| 6 | 1 | 45mm Rod Seal | 84354200 |
| 7 | 1 | 45mm Rod Seal Back-up | w/Seal |
| 8 | 2 | 45mm Rod Wear Ring (1.5") | 84401200 |
| 9 | 1 | -12 O-Ring Socket Plug | 84687700 |
| 10 | 1 | 45mm Rod w/Tapered Grooves | 05791501 |
| 11 | 1 | 4" Steel Piston | 04581901 |
| 12 | 2 | 4" Piston Seal | 84352500 |
| 13 | 2 | 4" Piston Seal Back-up | w/Seal |
| 14 | 1 | 4" Piston Wear Ring (.5") | 84403800 |
| 15 | 1 | 3/16" x 1/2" Drive Lock Pin | 86650400 |
| 16 | 1 | 4" Barrel Weld Assembly | 06184001 |
| 17 | 2 | 1/8" Barrel Round Wire Lock | 04834401 |
| 18 | 1 | Check Valve Body Steel Head Mounted w/Horizontal Bolts | 05791802 |
| 19 | 1 | 222 O-Ring | 84383500 |
| 20 | 1 | 8-222 O-Ring Backup | 84392160 |
| 21 | 1 | 1/8" Check Valve Round Wire Lock | 04834401 |
| 22 | 1 | Check Valve Poppet 11/16" x 4-1/8" | 04537301 |
| 23 | 1 | .48" O.D. x .063" Wire x 2" Compression Spring | 84454730 |
| 24 | 1 | -12 O-Ring Hex Plug | 84686900 |
| 25 | 4 | -12 to -10 Straight Fitting | 84684900 |
| | | Items 26-27 are not included in Cylinder Assembly | |
| 26 | 8 | M16 x 2 x 50mm Socket Head Cap Screw | 87012905 |
| 27 | 8 | M16 Lock Washer | 87078000 |

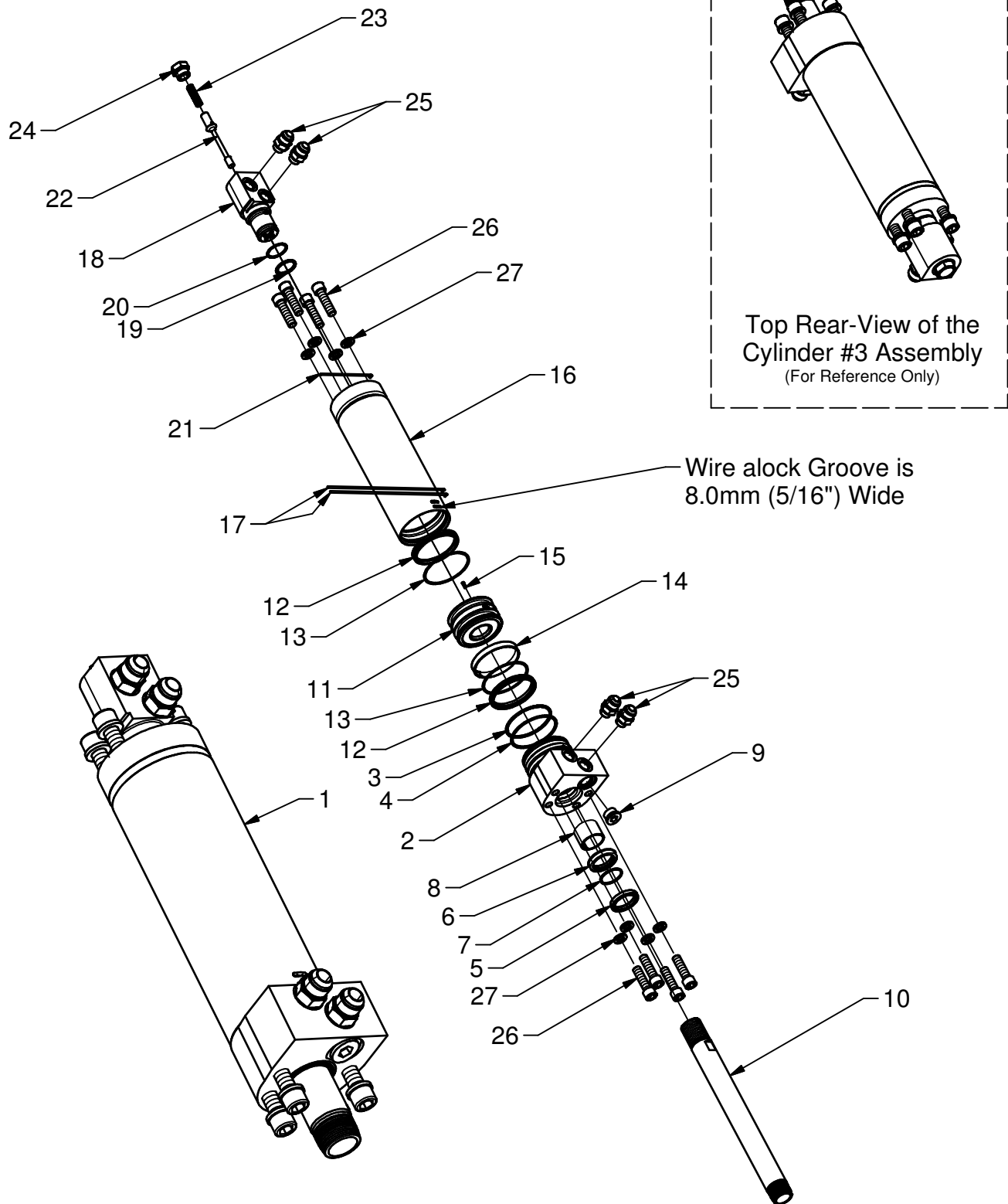
Note: Cylinder #1 has a Hex plug (Part ID #24) on the shaft end and a Socket plug (Part ID #9) on the check valve end. Cylinder #1 can be identified by these features.



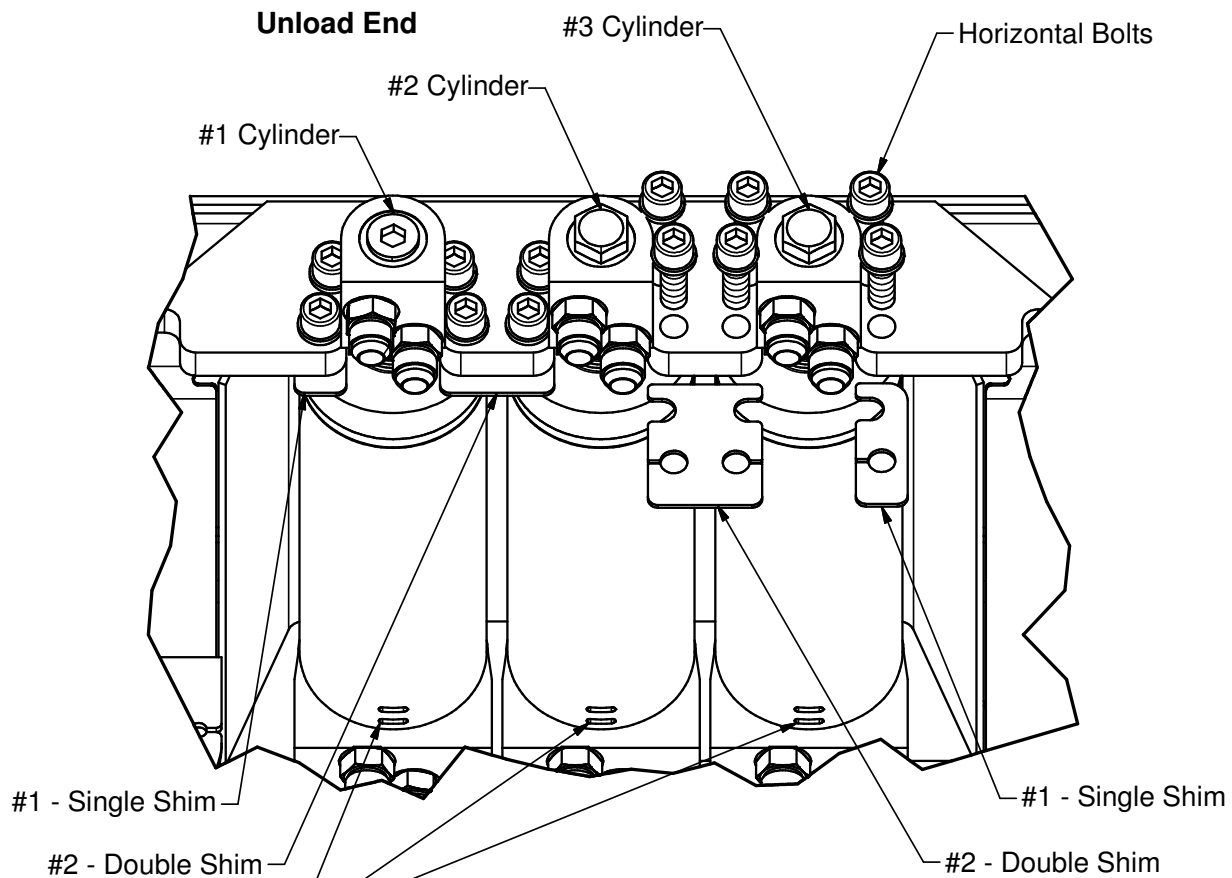
| PARTS LIST | | | |
|------------|----------|--|----------|
| ID # | QUANTITY | DESCRIPTION | PART # |
| 1 | 1 | Workhorse Cylinder #2 w/ Horizontal Bolts | 05792401 |
| | | includes items 2-25 | |
| 2 | 1 | 4" Aluminum Head w/Round Lock Wire & Horizontal Bolts | 05791302 |
| 3 | 1 | 240 O-Ring | 84385000 |
| 4 | 1 | 8-240 O-Ring Backup | 84393200 |
| 5 | 1 | 45mm Canned Rod Wiper | 84426600 |
| 6 | 1 | 45mm Rod Seal | 84354200 |
| 7 | 1 | 45mm Rod Seal Back-up | w/Seal |
| 8 | 2 | 45mm Rod Wear Ring (1.5") | 84401200 |
| 9 | 1 | Check Valve Poppet 11/16" x 4-1/8" | 04537301 |
| 10 | 1 | 45mm Rod w/Tapered Grooves | 05791501 |
| 11 | 1 | 4" Steel Piston | 04581901 |
| 12 | 2 | 4" Piston Seal | 84352500 |
| 13 | 2 | 4" Piston Seal Back-up | W/Seal |
| 14 | 1 | 4" Piston Wear Ring (.5") | 84403800 |
| 15 | 1 | 3/16" x 1/2" Drive Lock Pin | 86650400 |
| 16 | 1 | 4" Barrel Weld Assembly | 06184001 |
| 17 | 2 | 1/8" Round Wire Lock | 04834401 |
| 18 | 1 | Check Valve Body Steel Head Mounted w/Horizontal Bolts | 05791802 |
| 19 | 1 | 222 O-Ring | 84383500 |
| 20 | 1 | 8-222 O-Ring Backup | 84392160 |
| 21 | 1 | 1/8" Round Wire Lock | 04834401 |
| 22 | 1 | Check Valve Poppet 13/16" x 5" | 04601901 |
| 23 | 1 | .48" O.D. x .63" Wire x 2" Compression Spring | 84454730 |
| 24 | 1 | -12 O-Ring Hex Plug | 84686900 |
| 25 | 4 | -12 to -10 Straight Fitting | 84684900 |
| | | Items 26-27 are not included in Cylinder Assembly | |
| 26 | 8 | M16 x 2 x 50mm Socket Head Cap Screw | 87012905 |
| 27 | 8 | M16 Lock Washer | 87078000 |

Note: Cylinder #2 has A Hex plug (Part ID #24) on the shaft end and a Hex plug (Part ID #24) on the check valve end. Cylinder #2 can be identified by these features.

For parts and repair (unless otherwise noted), a #2 Cylinder will be shipped. To use this cylinder in the #1 position, remove the check valve (#22) and the spring (#23) at the rear of the cylinder. To use the #2 Cylinder in the #3 position, remove the check valve (#9), spring (#23), at the front of the cylinder. (See Reference Diagram #01)



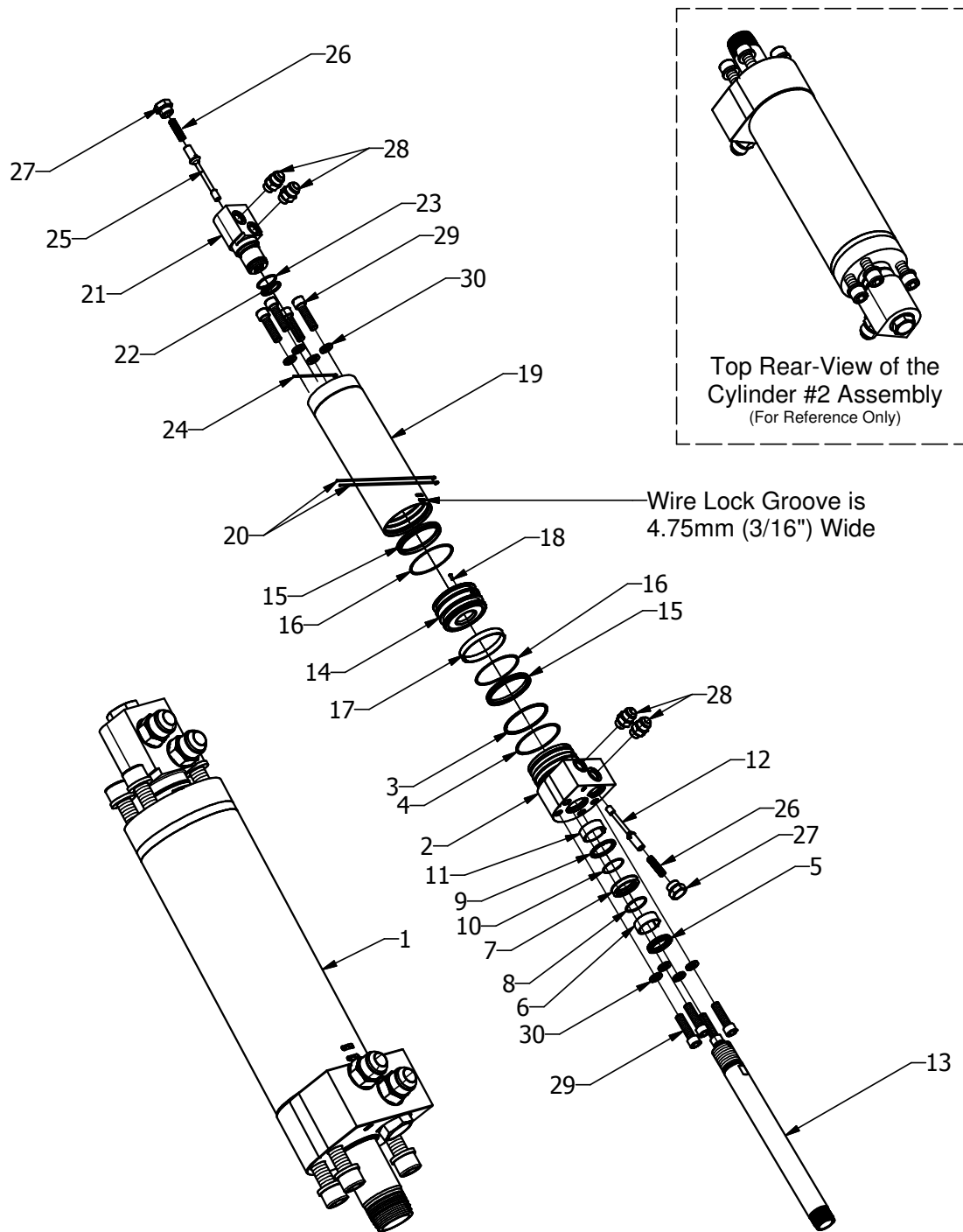
| ID # | QUANTITY | DESCRIPTION | PART # |
|------|----------|--|----------|
| 1 | 1 | Workhorse Cylinder #3 w/Horizontal Bolts | 05792501 |
| | | Includes items 2-23 | |
| 2 | 1 | 4" Aluminium Head w/Round Lock Wire & Horizontal Bolts | 05791302 |
| 3 | 1 | 240 O-Ring | 84385000 |
| 4 | 1 | 8-240 O-Ring Backup | 84393200 |
| 5 | 1 | 45mm Canned Rod Wiper | 84426600 |
| 6 | 1 | 45mm Rod Seal | 84354200 |
| 7 | 1 | 45mm Rod Seal Back-up | w/Seal |
| 8 | 2 | 45mm Rod Wear Ring (1.5") | 84401200 |
| 9 | 1 | -12 O-Ring Socket Plug | 84687700 |
| 10 | 1 | 45mm Rod w/Tapered Grooves | 05791501 |
| 11 | 1 | 4" Steel Piston | 04581901 |
| 12 | 2 | 4" Piston Seal | 84352500 |
| 13 | 2 | 4" Piston Seal Back-up | w/Seal |
| 14 | 1 | 4" Piston Wear Ring (.5") | 84403800 |
| 15 | 1 | 3/16" x 1/2" Drive Lock Pin | 86650400 |
| 16 | 1 | 4" Barrel Weld Assembly | 06184001 |
| 17 | 2 | 1/8" Round Wire Lock | 04834401 |
| 18 | 1 | Check Valve Body Steel Head Mounted w/Horizontal Bolts | 05791802 |
| 19 | 1 | 222 O-Ring | 84383500 |
| 20 | 1 | 8-222 O-Ring Backup | 84392160 |
| 21 | 1 | 1/8" Round Wire Lock | 04834401 |
| 22 | 1 | Check Valve Poppet 11/16" x 5" | 04601901 |
| 23 | 1 | .48" O.D. x .63" Wire x 2" Compression Spring | 84454730 |
| 24 | 1 | -12 O-Ring Hex Plug | 84686900 |
| 25 | 4 | -12 x -10 Straight Fitting | 84684900 |
| | | Items 24 & 25 are not included in Cylinder Assembly | |
| 26 | 8 | M16 x 2 50mm Socket Head Cap Screw | 87012905 |
| 27 | 8 | M16 Lock Washer | 87078000 |



Note wire lock slot width for cylinder model identification.
 8.0mm (5/16") wide groove - no shims - assembly numbers are
 #1 Cyl. 05792301, #2 Cyl. 05792401, #3 Cyl. #05792501.
 See pages 35 thru 40.
 4.75mm (3/16") wide groove - use shims - assembly numbers are
 #1 Cyl. 06336102, #2 Cyl. 06336202, #3 Cyl. 06336302.
 See pages 42 thru 47.

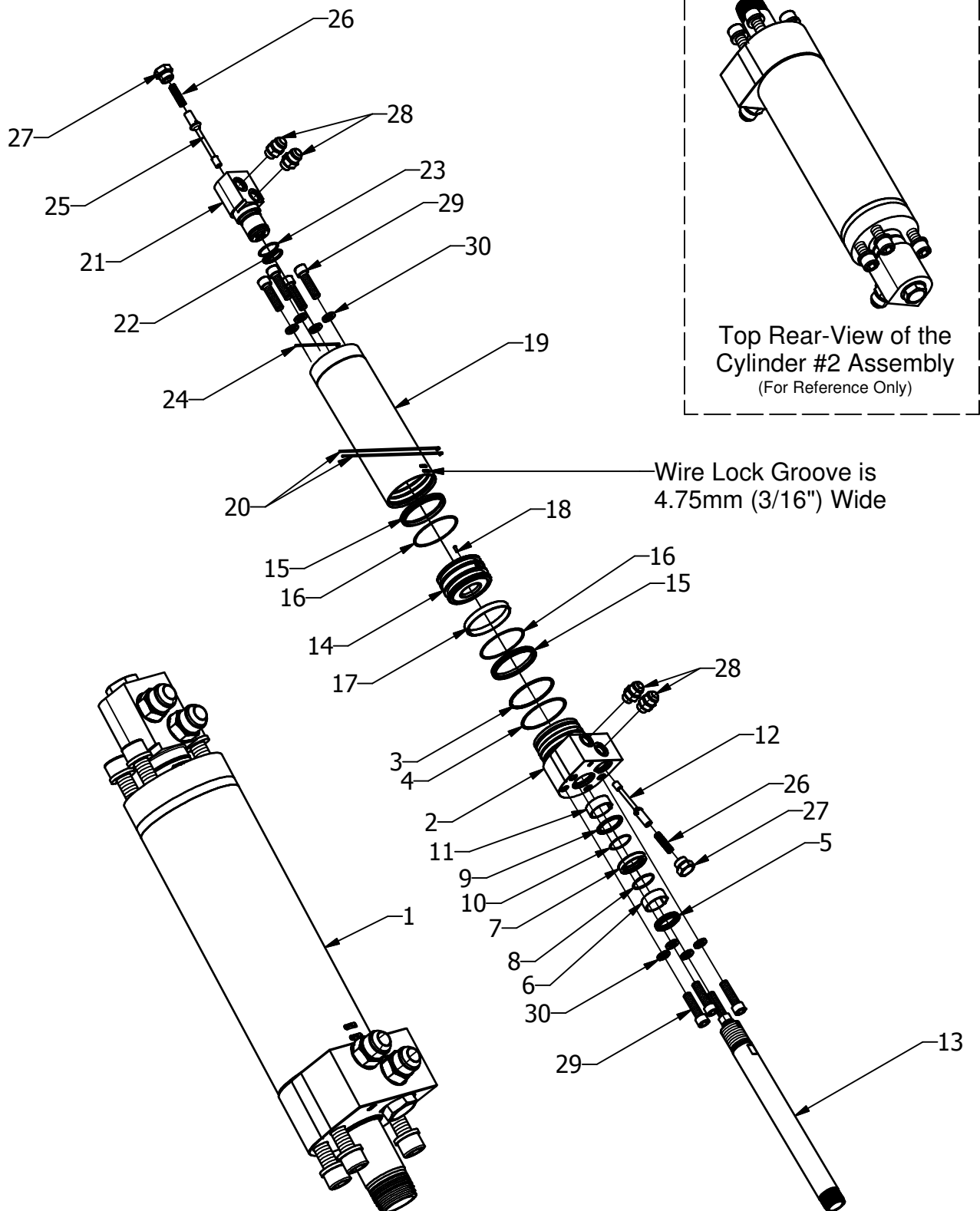
| SHIM PARTS LIST | | | | |
|-----------------|------|-------------|------------------------|----------|
| ID # | QTY. | DESCRIPTION | SIZE | PART # |
| 1 | 2 | Double Shim | 10 Gauge 3.4mm (.135") | 06260801 |
| 1 | 2 | Double Shim | 12 Gauge 2.7mm (.105") | 06260802 |
| 1 | 2 | Double Shim | 14 Gauge 1.9mm (.075") | 06260803 |
| 1 | 2 | Double Shim | 18 Gauge 1.2mm (.048") | 06260804 |
| 2 | 2 | Single Shim | 10 Gauge 3.4mm (.135") | 06260901 |
| 2 | 2 | Single Shim | 12 Gauge 2.7mm (.105") | 06260902 |
| 2 | 2 | Single Shim | 14 Gauge 1.9mm (.075") | 06260903 |
| 2 | 2 | Single Shim | 18 Gauge 1.2mm (.045") | 06260904 |

All 4 Shims must be the same size.



| Table | | | |
|-------|----------|---|-----------------|
| ID# | Quantity | Description | Part # |
| 1 | 1 | Workhorse II Cylinder Assembly #1 w/Horizontal Bolt w/ Shim | 06336102 |
| | | includes items 2-28 | |
| 2 | 1 | 4" Aluminum Head w/Horizontal Bolt | 06373102 |
| 3 | 1 | 240 "O"-Ring Buna 90 | 84385000 |
| 4 | 1 | 8-240 "O"-Ring Back-up | 84393200 |
| 5 | 1 | 45mm Rod Wiper | 84426605 |
| 6 | 1 | 45mm Rod PTFE Wear-Ring (Color Blue) | 84401205 |
| 7 | 1 | 45mm Seal | 84354200 |
| 8 | 1 | 45mm Seal Back-up | w/Seal |
| 9 | 1 | 45mm Buffer Seal | 84400201 |
| 10 | 1 | 45mm Buffer Seal Back-up | w/Buffer Seal |
| 11 | 1 | 45mm Wear-Ring (Color Gray) | 84401105 |
| 12 | 1 | -12 "O"-Ring Socket Plug | 84687700 |
| 13 | 1 | 45mm Rod w/Tapered Grooves | 05791501 |
| 14 | 1 | 4" Steel Piston | 04581901 |
| 15 | 2 | 4" Piston Seal | 84352500 |
| 16 | 2 | 4" Piston Seal Back-up | w/Seal |
| 17 | 1 | 4" Piston Wear-Ring (.5") | 84403800 |
| 18 | 1 | 3/16" x 1/2" Drive Lock Pin | 86650400 |
| 19 | 1 | 4" Barrel Weld Assembly | 06325901 |
| 20 | 2 | 1/8" Barrel Round Wire Lock | 04834401 |
| 21 | 1 | Check Valve Body Steel Head Mounted w/Horizontal Bolt | 05791802 |
| 22 | 1 | 222 "O"-Ring Buna 90 | 84383500 |
| 23 | 1 | 8-222 "O"-Ring Back-up | 84392140 |
| 24 | 1 | 1/8" Check Valve Round Wire Lock | 04834401 |
| 25 | 1 | Check Valve Poppet 11/16" x 4-1/8" | 04537301 |
| 26 | 1 | .48" O.D. x .063" Wire x 2" Compression Spring | 84454730 |
| 27 | 1 | -12 "O"-Ring Hex Plug | 84686900 |
| 28 | 1 | -12 to -10 Straight Fitting | 84684900 |
| | | items 29-30 Are not included with Cylinder Assembly | |
| 29 | 8 | M16 x 2 x 50mm Socket Head Cap Screw | 87012905 |
| 30 | 8 | M16 Lock Washer | 87078000 |

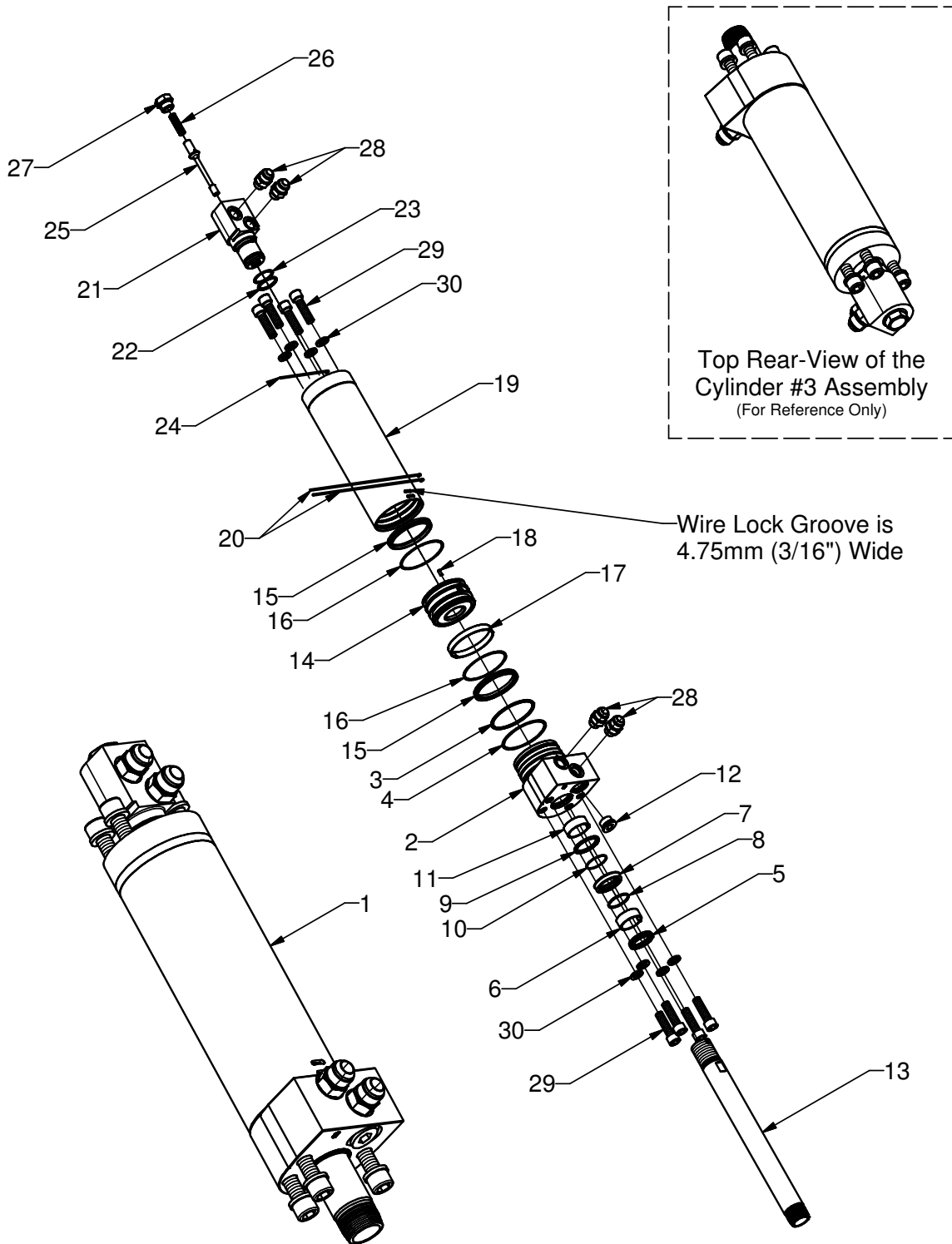
Note: Cylinder #1 has a Hex plug (Part ID #27) on the shaft end and a Socket plug (Part ID #12) on the check valve end. Cylinder #1 can be identified by these features.



| Workhorse II #2 Cylinder | | | |
|--------------------------|----------|--|-----------------|
| ID# | Quantity | Description | Part # |
| 1 | 1 | Workhorse II Cylinder Assembly w/Horizontal Bolt w/ Shim | 06336202 |
| | | includes items 2-28 | |
| 2 | 1 | 4" Aluminum Head w/Horizontal Bolt | 06373102 |
| 3 | 1 | 240 "O"-Ring Buna 90 | 84385000 |
| 4 | 1 | 8-240 "O"-Ring Back-up | 84393200 |
| 5 | 1 | 45mm Rod Wiper | 84426605 |
| 6 | 1 | 45mm Rod PTFE Wear-Ring (Color Blue) | 84401205 |
| 7 | 1 | 45mm Seal Rod | 84354200 |
| 8 | 1 | 45mm Seal Rod Back-up | w/Seal |
| 9 | 1 | 45mm Buffer Seal | 84400201 |
| 10 | 1 | 45mm Buffer Seal Back-up | w/Buffer Seal |
| 11 | 1 | 45mm Wear-Ring (Color Gray) | 84401105 |
| 12 | 1 | Check Valve Poppet 11/16" x 4-1/8" | 04537301 |
| 13 | 1 | 45mm Rod w/ Tapered Grooves | 05791501 |
| 14 | 1 | 4" Steel Piston | 04581901 |
| 15 | 2 | 4" Piston Seal | 84352500 |
| 16 | 2 | 4" Piston Seal Back-up | w/Seal |
| 17 | 1 | 4" Piston Wear-Ring (.5") | 84403800 |
| 18 | 1 | 3/16" x 1/2" Drive Lock Pin | 86650400 |
| 19 | 1 | 4" Barrel Weld Assembly | 04834401 |
| 20 | 2 | 1/8" Barrel Round Wire Lock | 04834401 |
| 21 | 1 | Check Valve Body Steel Head Mounted w/Horizontal Bolt | 05791802 |
| 22 | 1 | 222 "O"-Ring Buna 90 | 84383500 |
| 23 | 1 | 8-222 "O"-Ring Back-up | 84392140 |
| 24 | 1 | 1/8" Check Valve Round Wire Lock | 04834401 |
| 25 | 1 | Check Valve Poppet 13/16" x 5" | 04601901 |
| 26 | 2 | .48" O.D. x .063" Wire x 2" Compression Spring | 84454730 |
| 27 | 2 | -12 "O"-Ring Hex Plug | 84686900 |
| 28 | 4 | -12 to -10 Straight Fitting | 84684900 |
| | | Items 29-30 Are Not Included with Cylinder Assembly | |
| 29 | 8 | M16 x 2 50mm | 87012905 |
| 30 | 8 | M16 Lock Washer | 87078000 |

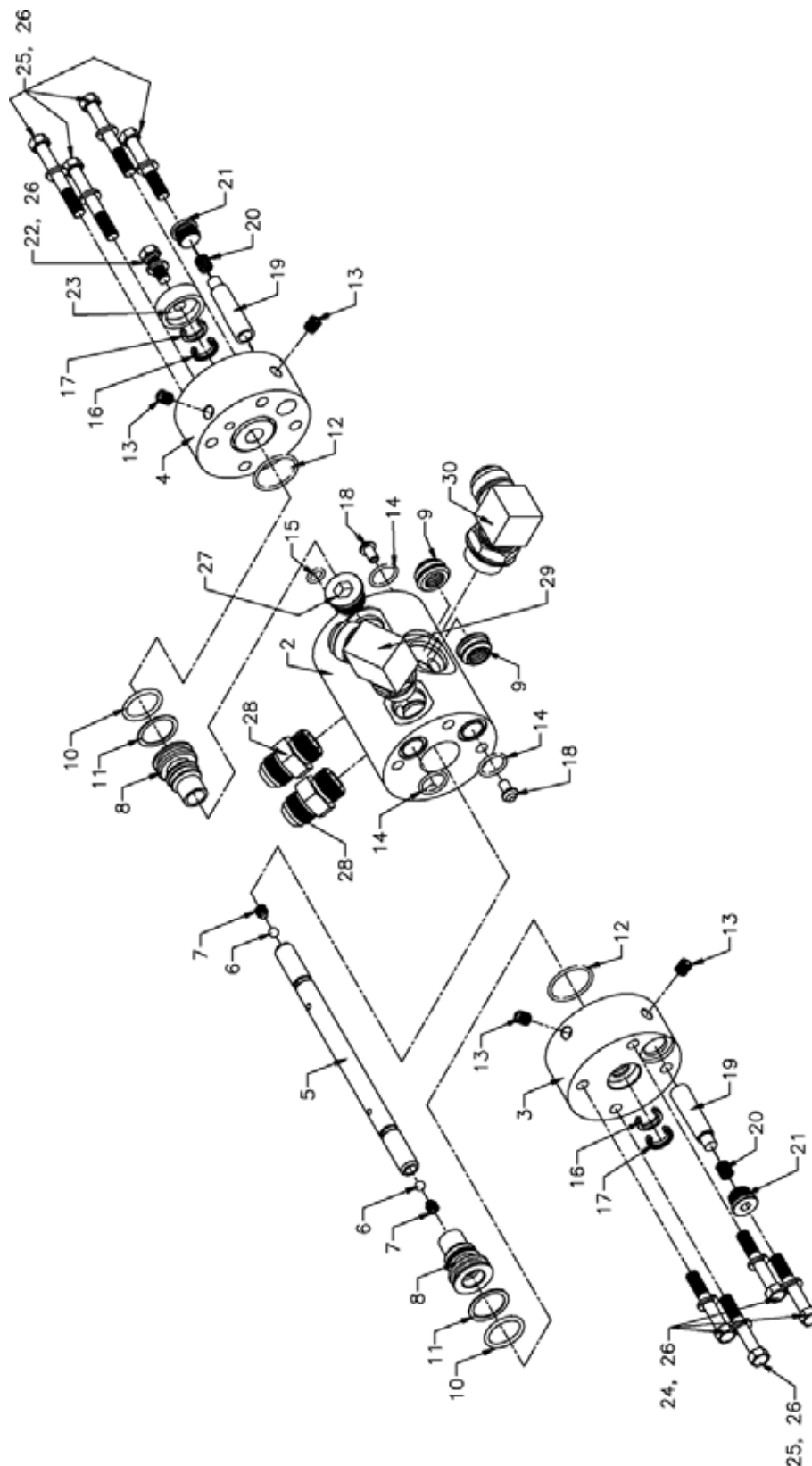
Note: Cylinder #2 has a Hex Plug (Part #27) on the shaft end and a Hex Plug (Part #27) on the check valve end. Cylinder #2 can be identified by these features.

For parts and repair (unless otherwise noted), a #2 Cylinder will be shipped. To use this cylinder in the #1 position, remove the check valve (#25) and spring (#26) at the rear of the cylinder. To use the #2 Cylinder in the #3 position, remove the check valve (#12), spring (#26) at the front of the cylinder. (See Reference Diagram #01).

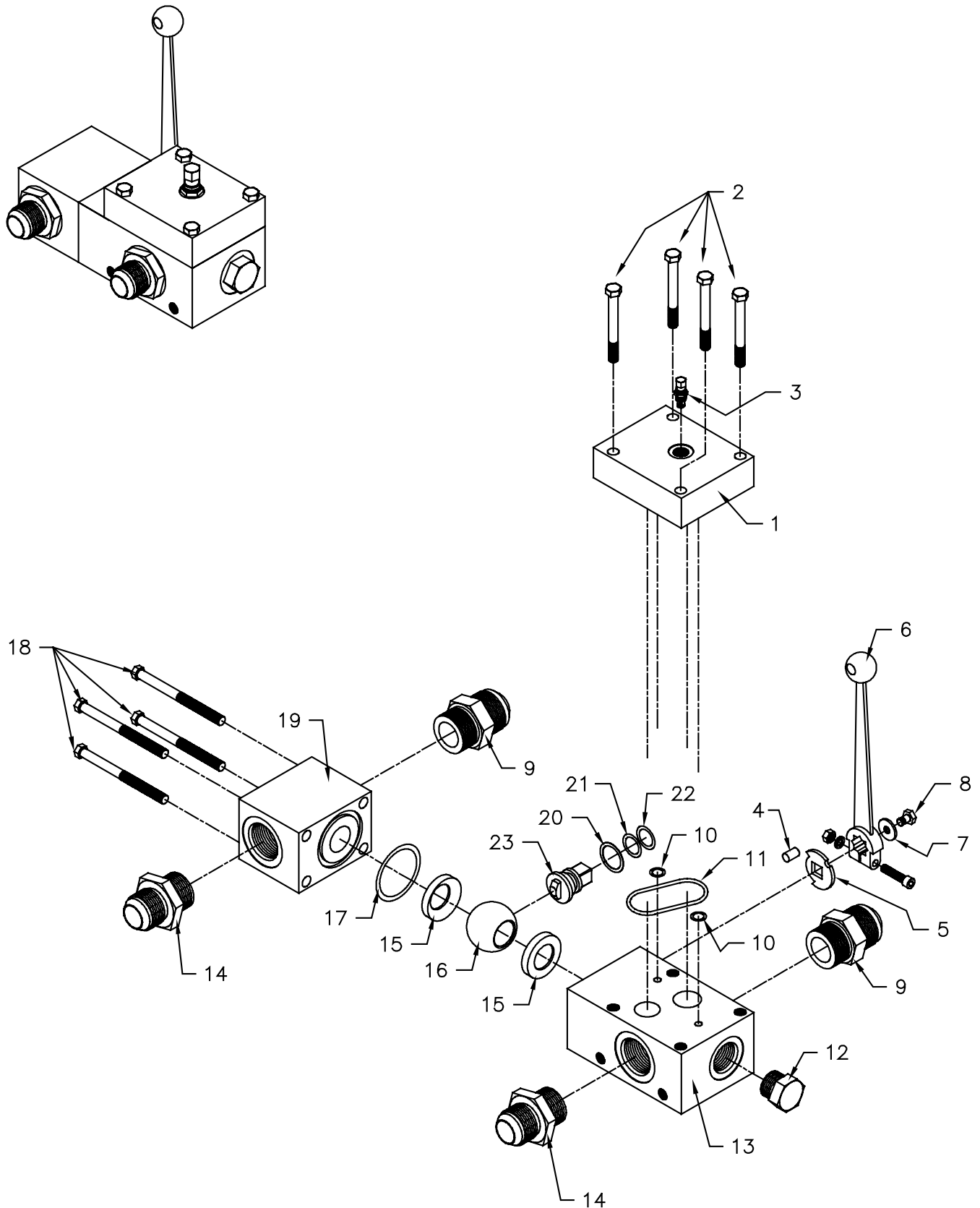


| Workhorse II #3 Cylinder | | | |
|--------------------------|----------|---|-----------------|
| ID# | Quantity | Description | Part # |
| 1 | 1 | Workhorse II Cylinder Assembly #3 w/Horizontal Bolt w/ Shim | 06336302 |
| | | includes items 2 - 28 | |
| 2 | 1 | 4" Aluminum Head w/ Horizontal Bolt | 06373102 |
| 3 | 1 | 240 "O"-Ring Buna 90 | 84385000 |
| 4 | 1 | 8-240 "O"-Ring Back-up | 84393200 |
| 5 | 1 | 45mm Wiper Rod | 84426605 |
| 6 | 1 | 45mm Rod PTFE Wear- Ring (Color Blue) | 84401205 |
| 7 | 1 | 45mm Seal Rod | 84354200 |
| 8 | 1 | 45mm Seal Rod Back-up | w/Seal |
| 9 | 1 | 45mm Buffer Seal | 84400201 |
| 10 | 1 | 45mm Buffer Seal Back-up | w/Buffer Seal |
| 11 | 1 | 45mm Wear-Ring (Color Gray) | 84401105 |
| 12 | 1 | -12 "O"-Ring Socket Plug | 84687700 |
| 13 | 1 | 45mm Rod w/Tapered Grooves | 05791501 |
| 14 | 1 | 4" Steel Piston | 04581901 |
| 15 | 2 | 4" Piston Seal | 84352500 |
| 16 | 2 | 4" Piston Seal Back-up | w/Seal |
| 17 | 1 | 4" Piston Wear-Ring (.5") | 84403800 |
| 18 | 1 | 3/16" x 1/2" Drive Lock Pin | 86650400 |
| 19 | 1 | 4" Barrel Weld Assembly | 06325901 |
| 20 | 2 | 1/8" Barrel Round Wire Lock | 04834401 |
| 21 | 1 | Check Valve Body Steel Head Mounted w/Horizontal Bolt | 05791802 |
| 22 | 1 | 222 "O"-Ring Buna 90 | 84383500 |
| 23 | 1 | 8-222 "O"-Ring Back-up | 84392140 |
| 24 | 1 | 1/8" Check Valve Round Wire Lock | 04834401 |
| 25 | 1 | Check Valve Poppet 13/16" x 5" | 04601901 |
| 26 | 1 | .48" O.D. x .063" Wire x 2" Compression Spring | 84454730 |
| 27 | 1 | -12 "O"-Ring Hex Plug | 84686900 |
| 28 | 4 | -12 to -10 Straight Fitting | 84684900 |
| | | Items 29-30 Are Not Included With Cylinder Assembly | |
| 29 | 8 | M16 x 2 x 50mm Socket Head Cap Screw | 87012905 |
| 30 | 8 | M16 Lock Washer | 87078000 |

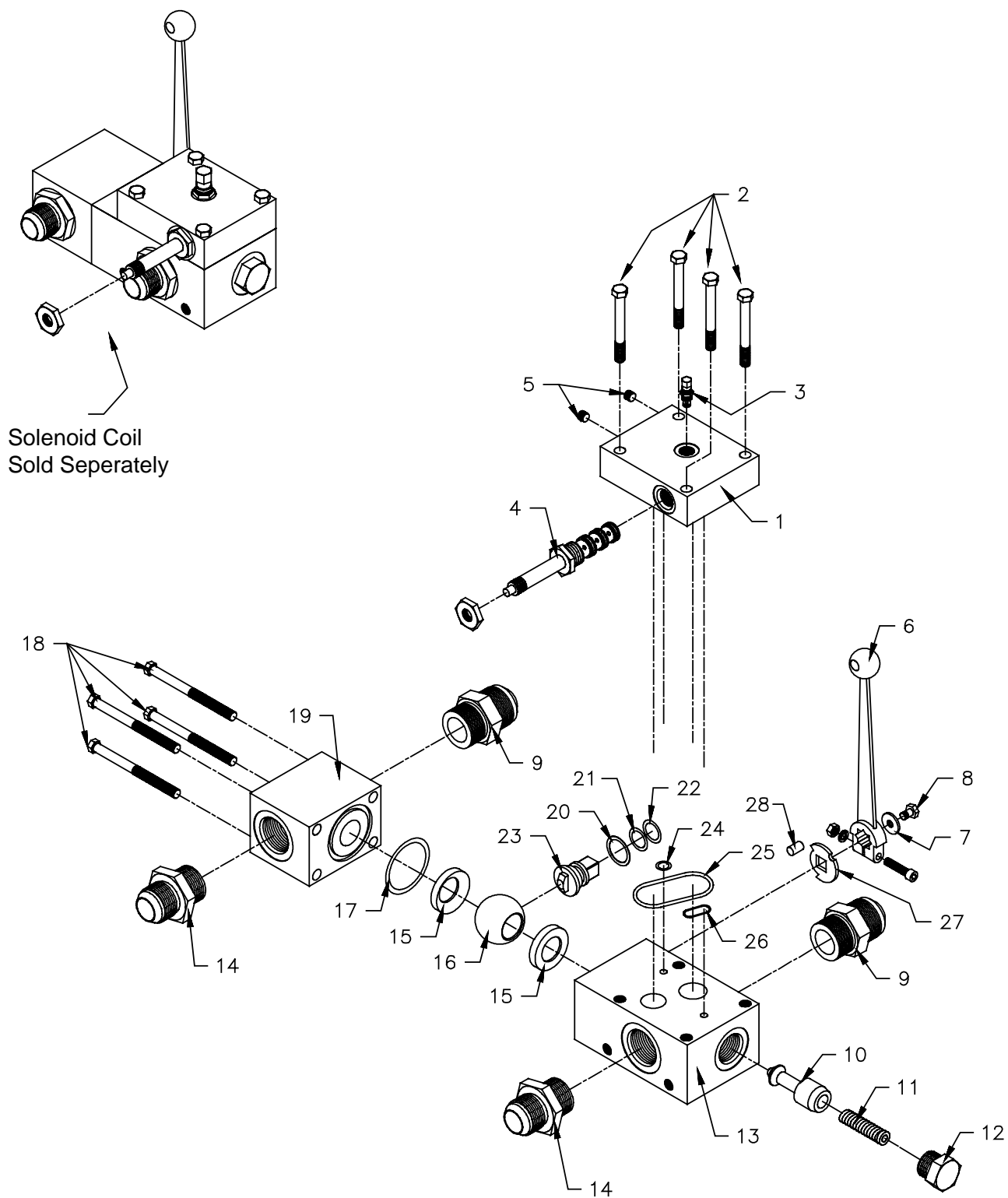
Note: Cylinder #3 has a Socket Plug (Part #12) on the shaft end and a HEX Plug (Part #27) on the check valve end. Cylinder #3 can be identified by these features.



| ID # | QUANTITY | DESCRIPTION | PART # |
|------|----------|--|----------------|
| 1 | 1 | Switching Valve Assembly METRIC | 4201502 |
| - | - | Includes items 1-34 | - |
| 2 | 1 | Body Switching Valve | 04504602 |
| 3 | 1 | End Cap Right Switching Valve | 04504701 |
| 4 | 1 | End Cap Left Switching Valve | 04504801 |
| 5 | 1 | Rod Control Switching Valve | 01335502 |
| 6 | 2 | Ball 5/16" Chrome Steel | 84800500 |
| 7 | 2 | Set Screw 10mm x 10mm Half Dog | 87008000 |
| 8 | 2 | Poppet Switching Valve | 03718901 |
| 9 | 2 | Ring Poppet Switching Valve | 03718801 |
| 10 | 2 | O-Ring 216 | 84382200 |
| 11 | 2 | O-Ring Backup 8-216 | 84391600 |
| 12 | 2 | O-Ring 126 | 84378200 |
| 13 | 2 | 1/8" Socket Pipe Plug | 84680780 |
| 14 | 3 | O-Ring 117 Urethane | 84377000 |
| 15 | 1 | O-Ring 111 | 84376200 |
| 16 | 2 | Seal Rod 5/8" | 84352200 |
| 17 | 2 | Woper Canned 5/8" Rod | 84427200 |
| 18 | 2 | Pilot Filter Seat | 04802701 |
| 19 | 2 | Filter Element CF0563-46 | 84012700 |
| 20 | 2 | Spring S157 | 84451750 |
| 21 | 2 | 6409-08 M O-Ring Socket Plug | 84687500 |
| 22 | 1 | Hex Bolt 10mm x 20mm | 87008470 |
| 23 | 1 | Cap Limit Switching Valve | 02552101 |
| 24 | 2 | Hex Bolt 10mm x 75mm | 87009750 |
| 25 | 5 | Hex Bolt 10mm x 65mm | 87009000 |
| 26 | 8 | Lock Washer 3/8" | 86555000 |
| 27 | 1 | 6408-H-12 O-Ring Socket Plug | 84687700 |
| 28 | 2 | 6400-12-12 Straight | 84685000 |
| 29 | 1 | 6801-16-12 90° Fitting | 84691700 |
| 30 | 1 | 6801-16-16 90° Fitting | 84691800 |
| 31 | 1 | 6801-12-12 90° Fitting | 84691500 |
| 32 | 1 | Socket Head Bolt 10mm x 65mm | 87009100 |
| 33 | 2 | 2404-4-2 Pipe Adaptor | 84673400 |



| ID# | QUANTITY | DESCRIPTION | PART NUMBER |
|-----|----------|--|-----------------|
| | 1 | Manual On/Off Ball Valve Assembly | 04840002 |
| | | Includes items 1-25 | |
| 1 | 1 | Manual Cover Plate On/Off Ball Valve | 04796402 |
| 2 | 4 | 10mm x 50mm Hex Bolt | 87008530 |
| 3 | 1 | Test Coupling SMK20-G1/4VC | 84904000 |
| 4 | 1 | 5/16" x 1/2" Dowel Pin | 86651500 |
| 5 | 1 | Spud Stop | 84802910 |
| 6 | 1 | Ball Valve Handle w/bolt, washer & nut | 84802900 |
| 7 | 1 | 6mm Flat Washer | 87075400 |
| 8 | 1 | 6mm x 10mm Hex Bolt | 87002450 |
| 9 | 2 | 2404-16-16 BSPP Straight Fitting | 84671400 |
| 10 | 2 | 112 O-Ring | 84376300 |
| 11 | 2 | 228 O-Ring | 84384000 |
| 12 | 1 | 6408-12 O-Ring Plug | 84686900 |
| 13 | 1 | Valve Housing | 04436602 |
| 14 | 2 | 6400-16-16 Straight Fitting | 84685400 |
| 15 | 2 | Ball Valve Seal Bushing | 04337301 |
| 16 | 1 | Ball Valve Ball | 04337101 |
| 17 | 1 | 225 O-Ring | 84383800 |
| 18 | 4 | 10mm x 100mm Hex Bolt | 87011000 |
| 19 | 1 | Non-Valve Housing | 04437902 |
| 20 | 1 | Spud Wear Washer | 04337601 |
| 21 | 1 | 208 O-Ring | 84379600 |
| 22 | 1 | 208 O-Ring Backup Teflon | 84390200 |
| 23 | 1 | Spud Shaft | 04438101 |
| 24 | 1 | 10mm x 90mm Hex Bolt | 87010500 |
| 25 | 3 | 10mm Lock Washer | 87076500 |

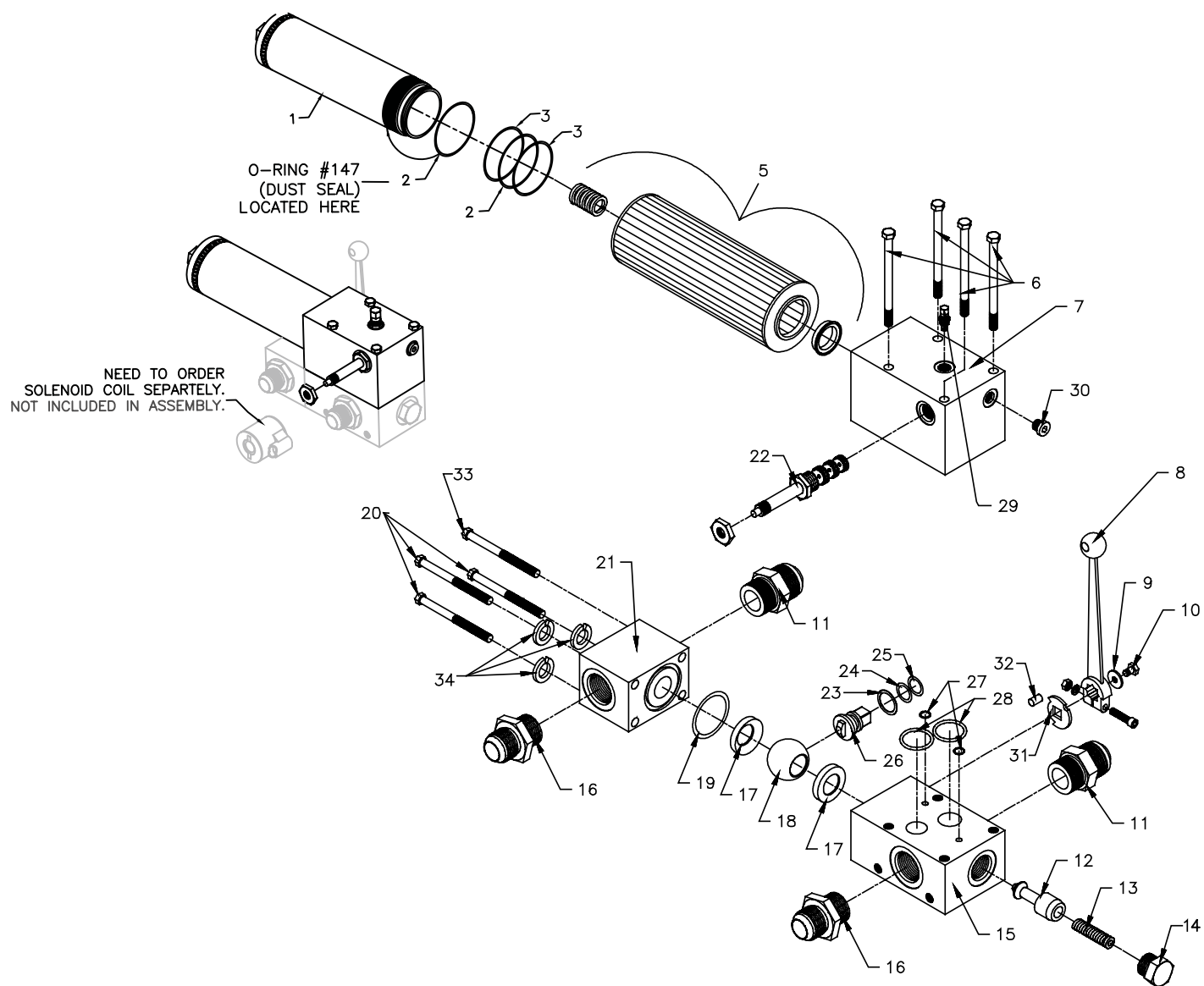


| ID# | QUANTITY | DESCRIPTION | PART |
|-----|----------|--|-----------------|
| | 1 | Pilot Operated / Manual On | 04718802 |
| | | Includes items 1-30 | |
| 1 | 1 | Electric Cover Plate On/Off Ball Valve | 04795702 |
| 2 | 4 | 10mm x 50mm Hex Bolt | 87008530 |
| 3 | 1 | Test Coupling SMK20-G1/4VC | 84904000 |
| 4 | 1 | Solenoid Control Valve SV10-40 | 85108800 |
| 5 | 2 | 1/16" NPT Pipe Plug | 84680770 |
| 6 | 1 | Ball Valve Handle w/bolt, washer & nut | 84802900 |
| 7 | 1 | 6mm Flat Washer | 87075400 |
| 8 | 1 | 6mm x 10mm Hex Bolt | 87002450 |
| 9 | 2 | 2404-16-16 BSPP Straight Fitting | 84671400 |
| 10 | 1 | On/Off Poppet | 04438401 |
| 11 | 1 | Spring #B-18273 | 84453400 |
| 12 | 1 | 6408-12 O-Ring Plug | 84686900 |
| 13 | 1 | Valve Housing | 04436602 |
| 14 | 2 | 6400-16-16 Straight Fitting | 84685400 |
| 15 | 2 | Ball Valve Seal Bushing | 04337301 |
| 16 | 1 | Ball Valve Ball | 04337101 |
| 17 | 1 | 225 O-Ring | 84383800 |
| 18 | 4 | 10mm x 100mm Hex Bolt | 87011000 |
| 19 | 1 | Non-Valve Housing | 04437902 |
| 20 | 1 | Spud Wear Washer | 04337601 |
| 21 | 1 | 208 O-Ring | 84379600 |
| 22 | 1 | 208 O-Ring Backup Teflon | 84390200 |
| 23 | 1 | Spud Shaft | 04438101 |
| 24 | 1 | 112 O-Ring | 84376300 |
| 25 | 2 | 228 O-Ring | 84384000 |
| 26 | 1 | 216 O-Ring | 84382200 |
| 27 | 1 | Spud Stop | 84802910 |
| 28 | 1 | 5/16" x 1/2" Dowel Pin | 86651500 |
| 29 | 3 | 10mm Lock Washer | 87076500 |
| 30 | 1 | 10mm x 90mm Hex Bolt | 87010500 |

Information for ordering solenoid Coil & Connectors:

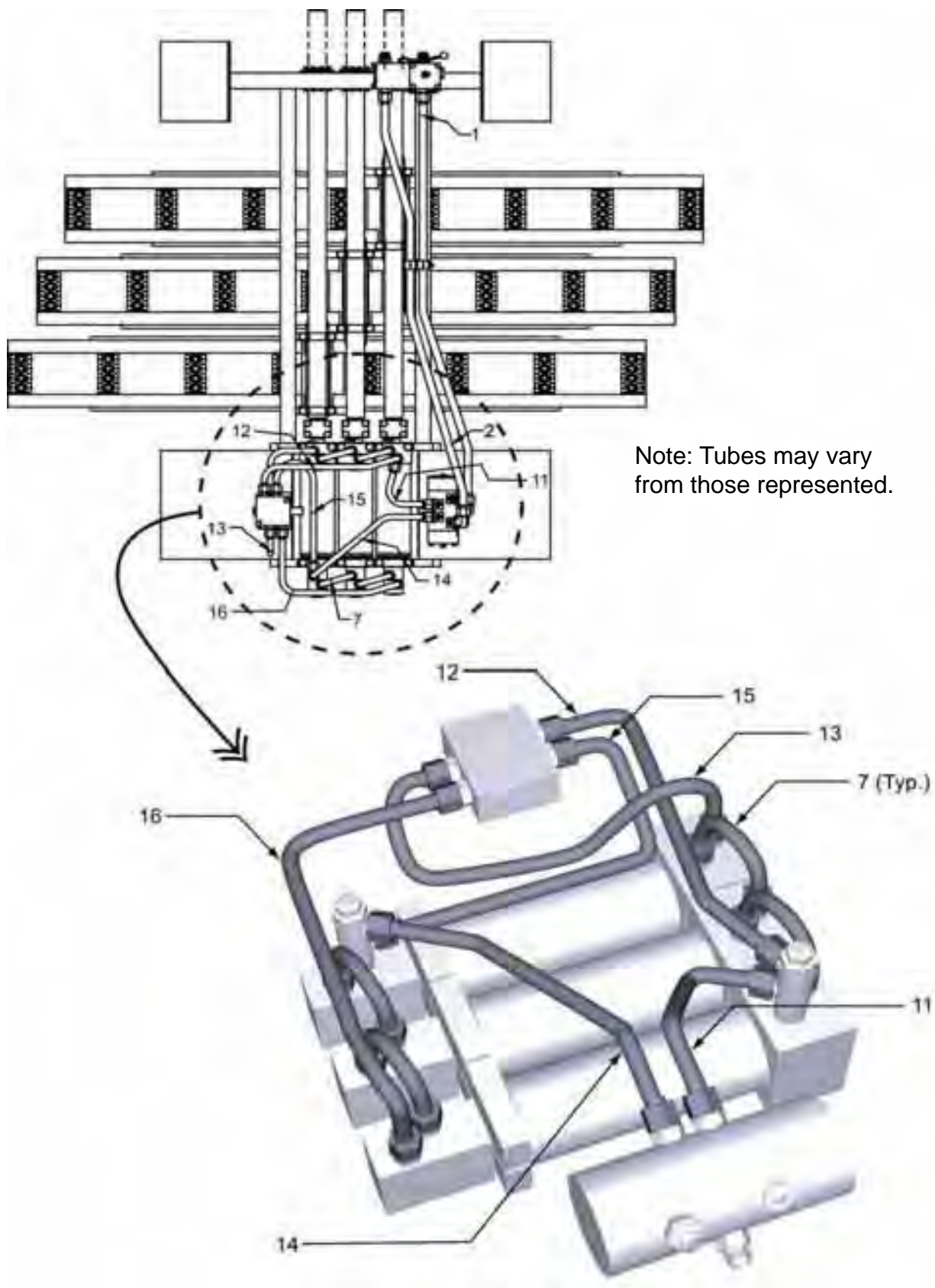
24 Volt Coil (HF 24 VCD 6353024)- Part #85602000

Din Connect (RR Din Plug RR00011039) - Part #85102790

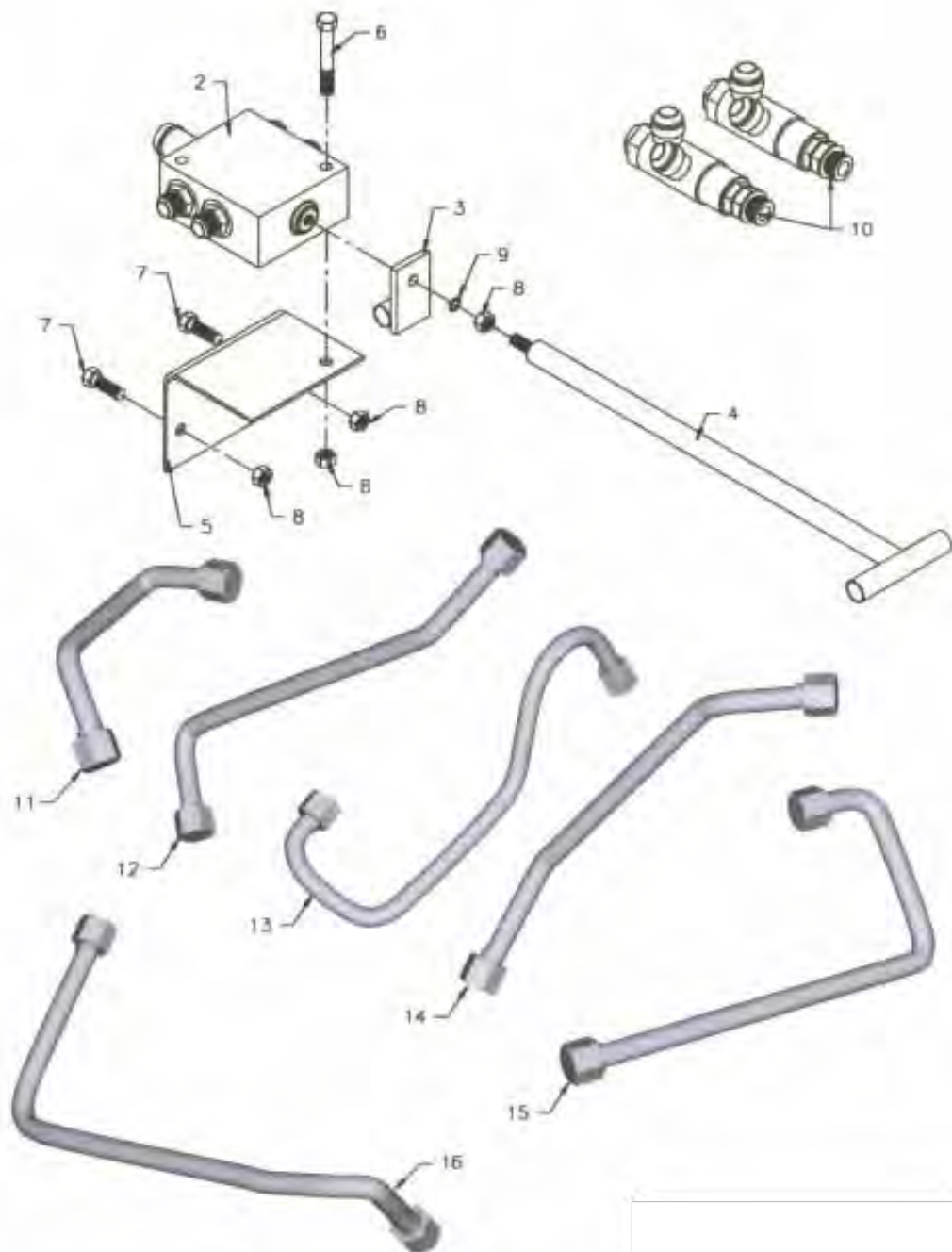


| ID# | QUANTITY | DESCRIPTION | PART |
|------------------|----------|---|-----------------|
| | 1 | Pilot Operated/Manual On/Off Fairley Arlon Filter Ball Valve | 04465802 |
| - | - | Includes items 1-34 | - |
| 1 ⁽¹⁾ | 1 | Threaded end Cap | 04426601 |
| 1 | 1 | Welded Filter Canister Assy. | 06151501 |
| 2 | 2 | 147 O-Ring | 84378447 |
| 3 | 2 | 147 O-Ring Backup | 84389047 |
| 4 ⁽¹⁾ | 1 | Threaded Barrel | 04426501 |
| 5 | 1 | Fairley Arlon Filter Element #MXW2-GDL20 w/Spring 7 Rubber Seal | 84006520 |
| 6 | 4 | 10mm x 110mm Hex Bolt | 87011500 |
| 7 | 1 | Fairley Arlon Filter Block | 04436501 |
| 8 | 1 | Ball Valve Handle w/bolt, washer & nut | 84802900 |
| 9 | 1 | 6mm Flat Washer | 87075400 |
| 10 | 1 | 6mm x 10mm Hex Bolt | 87002450 |
| 11 | 2 | 2404-16-16 BSPP Straight Fitting | 84671400 |
| 12 | 1 | On/Off Poppet | 04438401 |
| 13 | 1 | Spring #B-18273 | 84453400 |
| 14 | 1 | 6408-12 O-Ring Plug | 84686900 |
| 15 | 1 | Valve Housing | 04436602 |
| 16 | 2 | 6400-16-16 Straight Fitting | 84685400 |
| 17 | 2 | Ball Valve Seal Bushing | 04337301 |
| 18 | 1 | Ball Valve Ball | 04337101 |
| 19 | 1 | 225 O-Ring | 84383800 |
| 20 | 3 | 10mm x 100mm Hex Bolt | 87011000 |
| 21 | 1 | Non-Valve Housing | 04437902 |
| 22 | 1 | Solenoid Control Valve SV10-40 | 85108800 |
| 23 | 1 | Spud Wear Washer | 04337601 |
| 24 | 1 | 208 O-Ring | 84379600 |
| 25 | 1 | 208 O-Ring Backup Teflon | 84390200 |
| 26 | 1 | Spud Shaft | 04438101 |
| 27 | 2 | 112 O-Ring | 84376300 |
| 28 | 2 | 218 O-Ring | 84382800 |
| 29 | 1 | Test Coupling SMK20-G1/4VC | 84904000 |
| 30 | 1 | 6408-04 O-Ring Hex Plug | 84686500 |
| 31 | 1 | Spud Stop | 84802910 |
| 32 | 1 | 5/16" x 1/2" Dowel Pin | 86651500 |
| 33 | 1 | 10mm x 90mm Hex Bolt | 87010500 |
| 34 | 3 | 10mm Lock Washer | 87076500 |

(1) Not Shown. For use with previous models.

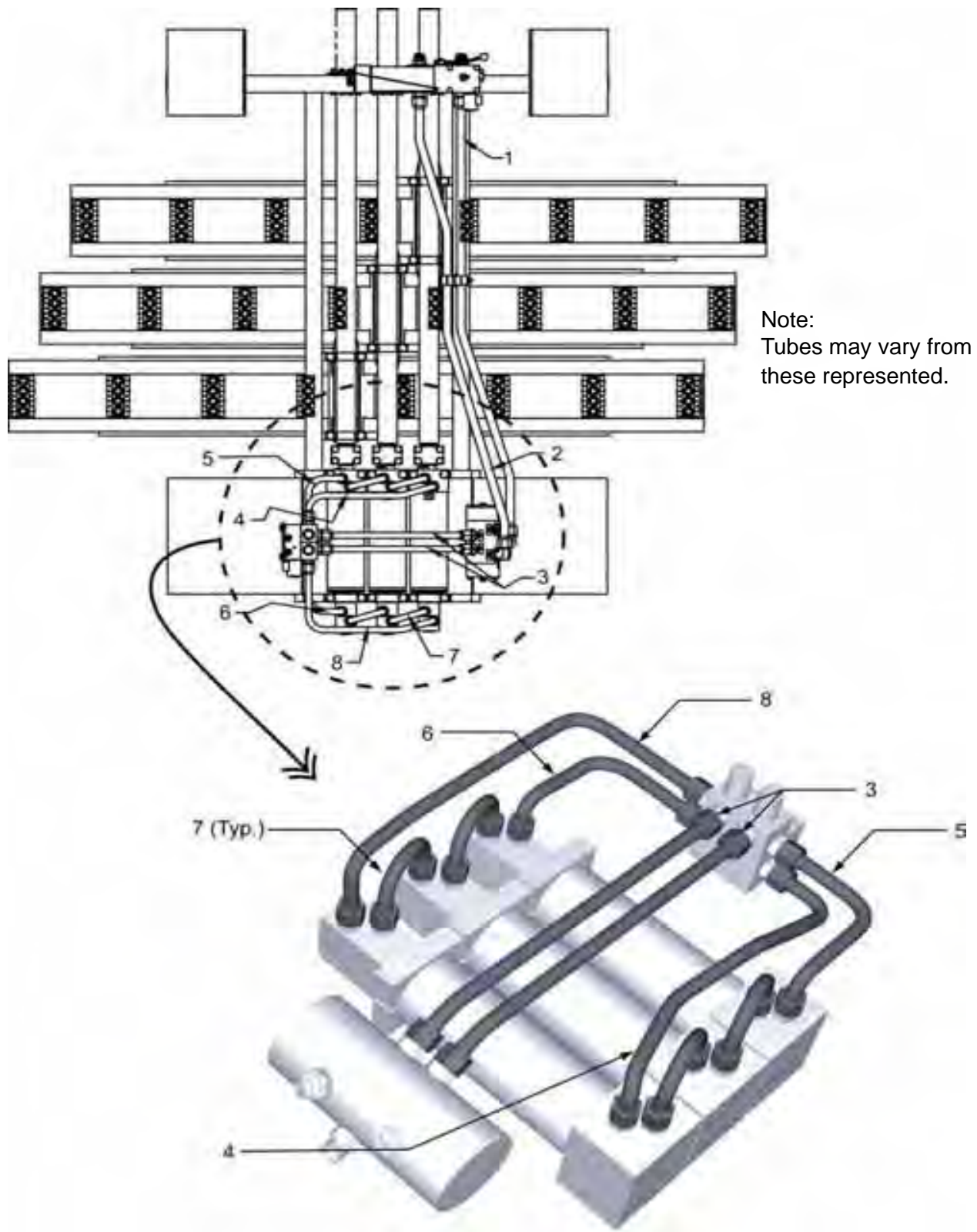


| ID# | QUANTITY | DESCRIPTION | PART # |
|-----|----------|--|----------|
| 1 | 1 | 1" Tube: Ball Valve to Switching Valve Pressure Tube | 04841201 |
| 2 | 1 | 1" Tube: Ball Valve to Switching Valve Return Tube | 04841301 |
| 7 | 4 | 3/4" Tube: Cylinder Cross-Over Tubes | 04840501 |
| 11 | 1 | 3/4" Tube: #1 Cylinder Unload End to Switching Valve | 04840601 |
| 12 | 1 | 3/4" Tube: #1 Cylinder Load End to Control Valve | 04840801 |
| 13 | 1 | 3/4" Tube: #3 Cylinder Load End to Control Valve | 04840901 |
| 14 | 1 | 3/4" Tube: #3 Cylinder Unload End to Switching Valve | 04841001 |
| 15 | 1 | 3/4" Tube: #3 Cylinder Unload End to Control Valve | 04840701 |
| 16 | 1 | 3/4" Tube: #1 Cylinder Unload End to Control Valve | 04840701 |

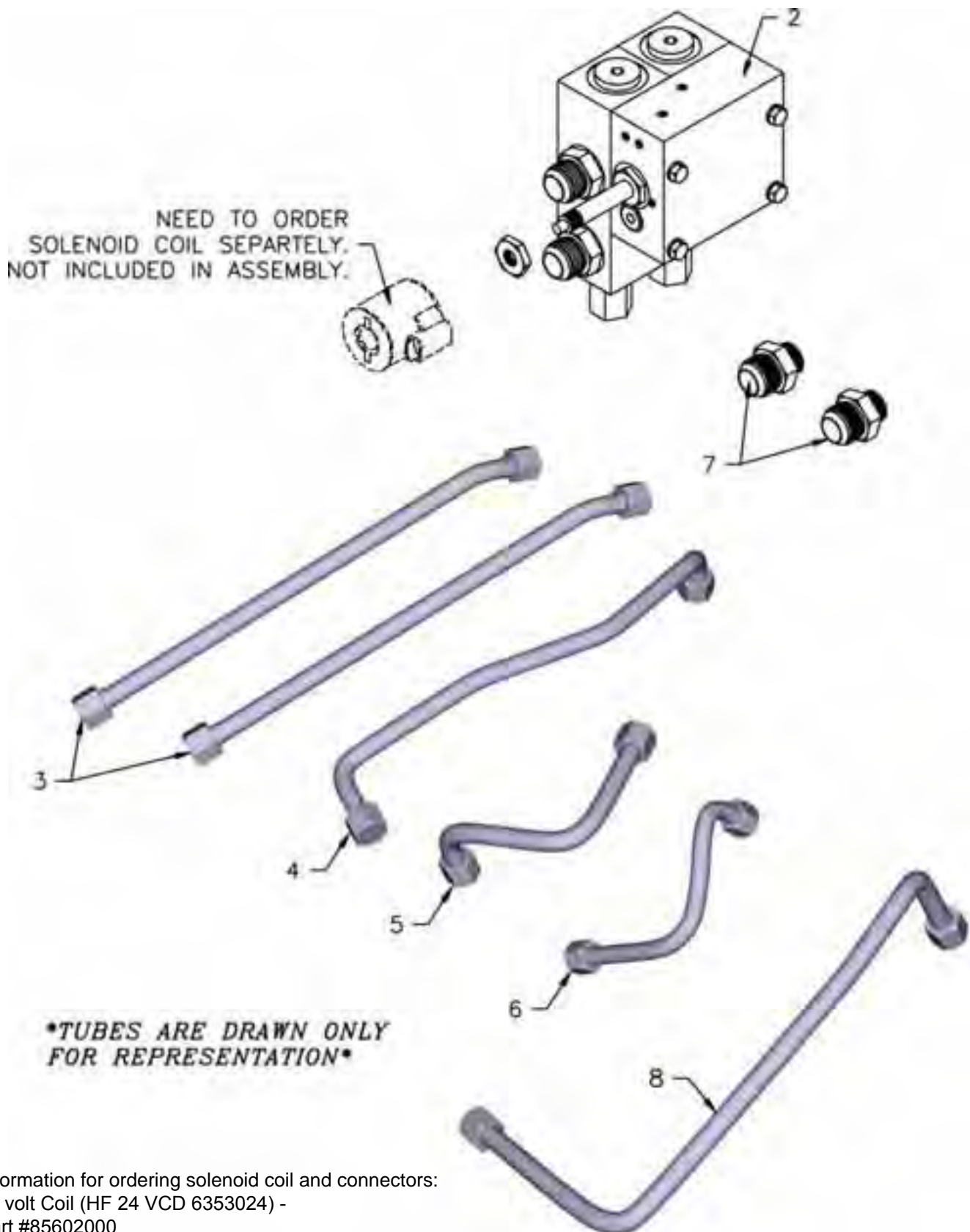


* Tubes are drawn only
for representation

| ID# | QUANTITY | DESCRIPTION | PART # |
|-----|----------|--|----------|
| 1 | 1 | Workhorse Drive Conversion Kit to Electric Load/Unload | 04839202 |
| - | - | Includes items 2-15 | - |
| 2 | 1 | Control Valve Manual Metric | 02552702 |
| 3 | 1 | Lock Bushing | 03215801 |
| 4 | 1 | Control Valve Long Handle | 04839002 |
| 5 | 1 | Control Valve Mount Plate Manual | 04838501 |
| 6 | 1 | 10mm x 70mm Hex Cap Screw | 87009500 |
| 7 | 2 | 10mm x 20mm Hex Cap Screw | 87008470 |
| 8 | 4 | 10mm Hex Nut | 87101500 |
| 9 | 1 | 10mm Lock Washer | 87076500 |
| 10 | 2 | Restrictor Valve | 04935701 |
| 11 | 1 | 3/4" Tube: #1 Cylinder Load End to Switching Valve | 04840601 |
| 12 | 1 | 3/4" Tube: #1 Cylinder Load End to Control Valve | 04840801 |
| 13 | 1 | 3/4" Tube: #3 Cylinder Load End to Control Valve | 04840901 |
| 14 | 1 | 3/4" Tube: #3 Cylinder Unload End to Switching Valve | 04841001 |
| 15 | 1 | 3/4" Tube: #3 Cylinder Unload End to Control Valve | 04841101 |
| 16 | 1 | 3/4" Tube: #1 Cylinder Unload End to Control Valve | 04840701 |

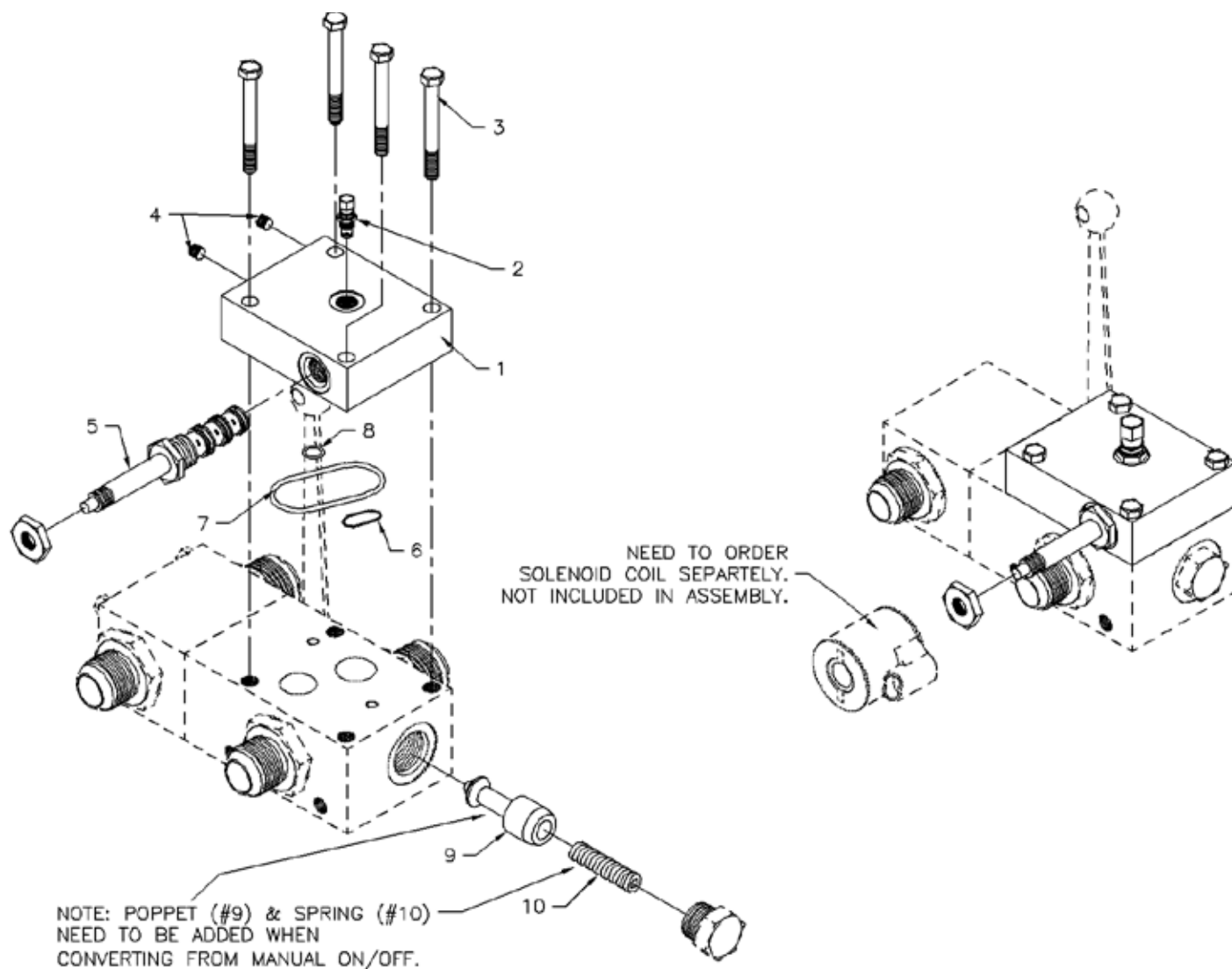


| ID# | QUANTITY | DESCRIPTION/ DESCRIPCION | PART # |
|-----|----------|--|----------|
| 1 | 1 | 1" Tube: Ball Valve to Switching Valve Pressure Tube | 04841201 |
| 2 | 1 | 1" Tube: Ball Valve to Switching Valve Return Tube | 04841301 |
| 3 | 2 | 3/4" Tube: Control Valve to Switching Valve | 04841401 |
| 4 | 1 | 3/4" Tube: #1 Cylinder Load End to Control Valve | 04841501 |
| 5 | 1 | 3/4" Tube: #3 Cylinder Load End to Control Valve | 04841601 |
| 6 | 1 | 3/4" Tube: #3 Cylinder Unload End to Control Valve | 04841701 |
| 7 | 4 | 3/4" Tube: Cylinder Cross-Over Tubes | 04840501 |
| 8 | 1 | 3/4" Tube: #1 Cylinder Unload End to Control Valve | 04840701 |



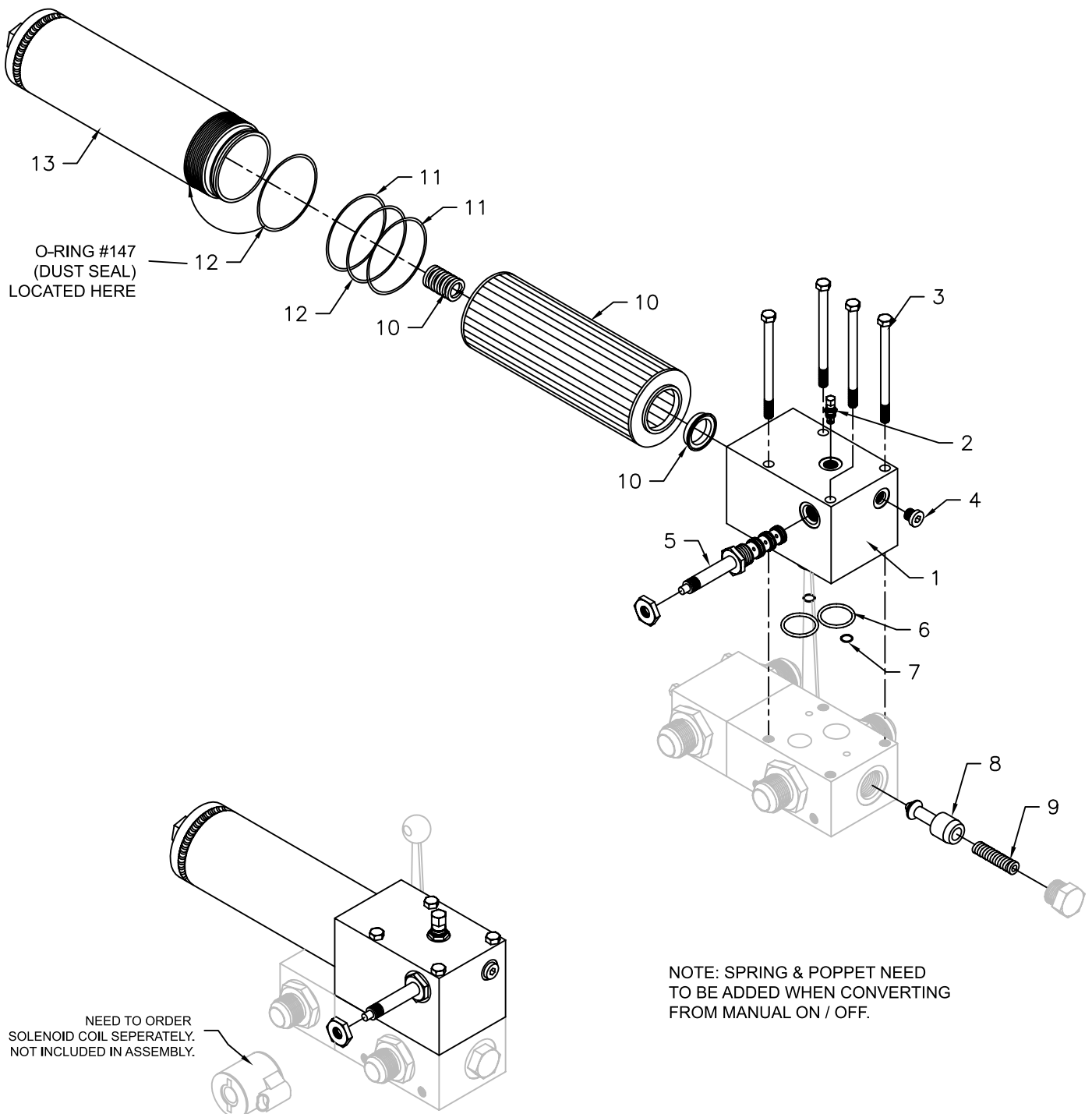
Information for ordering solenoid coil and connectors:
24 volt Coil (HF 24 VCD 6353024) -
Part #85602000
Din Connect (RR Din Plug RR00011039) - Part #85102790

| ID # | QUANTITY | DESCRIPTION | PART |
|------|----------|---|-----------------|
| 1 | 1 | Workhorse Drive Conversion Kit to Electric Load/Unload | 04839302 |
| - | - | Includes items 2-7 | - |
| 2 | 1 | Control Valve Modular 6-Port Metric | 04459401 |
| 3 | 2 | 3/4" Tube: Control Valve to Switching Valve | 04841401 |
| 4 | 1 | 3/4" Tube: #1 Cylinder load end to Control Valve | 04841501 |
| 5 | 1 | 3/4" Tube: #3 Cylinder load end to Control Valve | 04841601 |
| 6 | 1 | 3/4" Tube: #3 Cylinder unload end to Control Valve | 04841701 |
| 7 | 2 | Hydraulic Straight Fitting Male 37° JIC to Male O-Ring | 84684900 |
| 8 | 1 | 3/4" Tube: #1 Cylinder unload end to Control Valve | 04841701 |



Information For Ordering Solenoid Coil & Connectors: 24 Volt Coil (HF 24 VCD 6353024) – Part #8560200
Din Connect (RR Din Plug RR00011039) – Part #85102790

| ID# | QUANTITY | DESCRIPTION | PART # |
|-----|----------|--|-----------------|
| | 1 | Workhorse Drive Conversion Kit to Electric On/Off | 04839502 |
| - | - | Includes items 1-10 | - |
| 1 | 1 | Electric Cover Plate On/Off Ball Valve | 04795702 |
| 2 | 1 | Test Coupling SMK20-G1/4VC | 84904000 |
| 3 | 4 | 10mm x 50mm Hex Bolt | 87008530 |
| 4 | 2 | 1/16" NPT Pipe Plug | 84680770 |
| 5 | 1 | Solenoid Control Valve SV10-40 | 85108800 |
| 6 | 1 | 216 O-Ring | 84382200 |
| 7 | 1 | 228 O-Ring | 84384000 |
| 8 | 1 | 112 O-Ring | 84376300 |
| 9 | 1 | On/Off Poppet | 04438401 |
| 10 | 1 | Spring #B-18273 | 84453400 |



Information For Ordering Solenoid Coil & Connectors:
 24 Volt Coil (HF 24 VCD 6353024) - Part #85602000
 Din Connect (RR Din Plug RR00011039) - Part #85102790

| ID# | QUANTITY | DESCRIPTION | PART # |
|-----|----------|---|-----------------|
| | 1 | Workhorse Drive Conversion Kit to Electric On/Off w/ Integrated Filter | 04839602 |
| - | - | Includes items 1-14 | - |
| 1 | 1 | Fairley Arlon Filter Block | 04436502 |
| 2 | 1 | Test Coupling SMK20-G1/4VC | 84904000 |
| 3 | 4 | 10mm x 110mm Hex Bolt | 87011500 |
| 4 | 1 | 6408-04 O-Ring Hex Plug | 84686500 |
| 5 | 1 | Solenoid Control Valve SV10-40 | 85108800 |
| 6 | 2 | 218 O-Ring | 84382800 |
| 7 | 2 | 112 O-Ring | 84376300 |
| 8 | 1 | On/Off Poppet | 04438401 |
| 9 | 1 | Spring #B-18273 | 84453400 |
| 10 | 1 | Fairley Arlon Filter Element #MXW2-GDL20 w/Spring Rubber Seal | 84006520 |
| 11 | 2 | 147 O-Ring Backup | 84389047 |
| 12 | 2 | 147 O-Ring | 84378447 |
| 13 | 1 | Welded Filter Canister Assy. | 06151501 |