

SLAVE CYLINDER



Service Instructions

Model Number	Repair Kit Number	Model Number	Repair Kit Number	Model Number	Repair Kit Number
02-120-016 (BF)	02-100-001	02-120-028 (HO)	02-100-029	03-120-051 (BF)	02-100-014
02-120-017 (BF)	02-100-001	02-120-071 (BF)	02-100-016	03-120-069 (BF)	02-100-048
02-120-020 (HO)	02-100-029	02-120-117 (BF)	02-100-007	03-120-072 (HO)	02-100-049
02-120-021 (BF)	02-100-007	03-120-010 (HO)	02-100-028		
02-120-026 (BF)	02-100-007	03-120-017 (BF)	02-100-007		

BF = DOT 3, 4, 5, and 5.1 brake fluid HO = mineral base hydraulic oil

DISASSEMBLY

(Refer to Figure 1)

1. Remove push rod (1) and boot (2) from housing (8).
2. Remove retaining ring (3), piston (4), cup (5), spring (6) and stop (7) from housing (8). Note direction of cup (5).
NOTE: Be careful not to scratch or mar housing bore.
3. Remove plug (9) from housing (8) only if included in the repair kit. **NOTE: Not all models use plug (9).**
4. Remove bleeder screw (10) from housing (8) only if included in the repair kit. **NOTE: Some models use bleeder screw (10) in plug (9) port.**

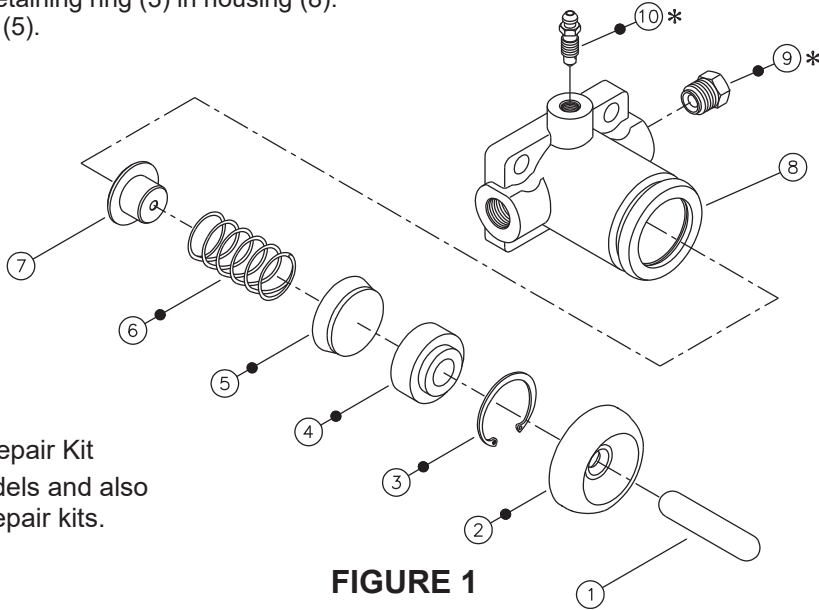
ASSEMBLY

(Refer to Figure 1)

LUBRICATE ALL RUBBER COMPONENTS FROM REPAIR KIT WITH CLEAN TYPE FLUID USED IN THE SYSTEM.

1. Clean all parts thoroughly with clean type fluid used in the system before assembling.
2. Install stop (7), new spring (6), new cup (5), new piston (4), and new retaining ring (3) in housing (8). Note direction of cup (5).

3. Install new plug (9) in housing (8) and torque 13.6-19.0 N·m (10-14 lb·ft). **NOTE: Not all models use plug (9) and not all repair kits include plug (9).**
4. Install new bleeder screw (10) in housing and torque 6.8-7.9 N·m (60-70 lb·in). **NOTE: Some models use bleeder screw (10) in plug (9) port. Not all repair kits include bleeder screw (10).**
5. Install new boot (2) and push rod (1) in housing (8).
6. Install the slave cylinder on the vehicle and connect the fluid lines. Bleed the system of air. Tighten fittings if leaks occur. Make several applications to be sure the slave cylinder is working properly. **NOTE: See form 81-600-001 instructions to bleed the slave cylinder. Refer to the vehicle manufacture specifications to bleed the vehicle brake system. All fittings must be inspected for leaks and tightened if leaks occur.**



- Items included in Repair Kit
- * Not used on all models and also not included in all repair kits.

FIGURE 1

Model Number	Repair Kit Number
03-120-034 (HO)	02-100-035
03-120-039 (BF)	02-100-032

BF = DOT 3, 4, 5, and 5.1 brake fluid
HO = mineral base hydraulic oil

● Items included in Repair Kit

DISASSEMBLY

(Refer to Figure 2)

1. Remove boot (1) from end cap (3) and piston/push rod assembly (5).
2. Unscrew end cap (3) and separate from body (8).
3. Remove piston/push rod assembly (5) and spring (4) from body (8).
4. Remove o-ring (7) and back-up ring (6) from piston/push rod assembly (5).
5. Remove seal (2) from end cap (3). Note direction of seal (2).

ASSEMBLY

(Refer to Figure 2)

LUBRICATE ALL RUBBER COMPONENTS FROM REPAIR KIT WITH CLEAN TYPE FLUID USED IN THE SYSTEM.

1. Clean all parts thoroughly with clean type fluid used in the system before assembling.
2. Install new back-up ring (6) and new o-ring (7) on piston/push rod assembly (5). Note order of back-up ring and o-ring.
3. Carefully install new seal (2) in end cap (3). Note the direction of seal (2).
4. Install end cap (3) over piston/push rod assembly (5) to body (8) and torque 47.5-54.2 N·m (35-40 lb·ft).
5. Install new boot (1).
6. Install the slave cylinder on the vehicle and connect the fluid lines. Bleed the system of air. Tighten fittings if leaks occur. Make several applications to be sure the slave cylinder is working properly. **NOTE: See form 81-600-001 instructions to bleed the slave cylinder. Refer to the vehicle manufacture specifications to bleed the vehicle brake system. All fittings must be inspected for leaks and tightened if leaks occur.**

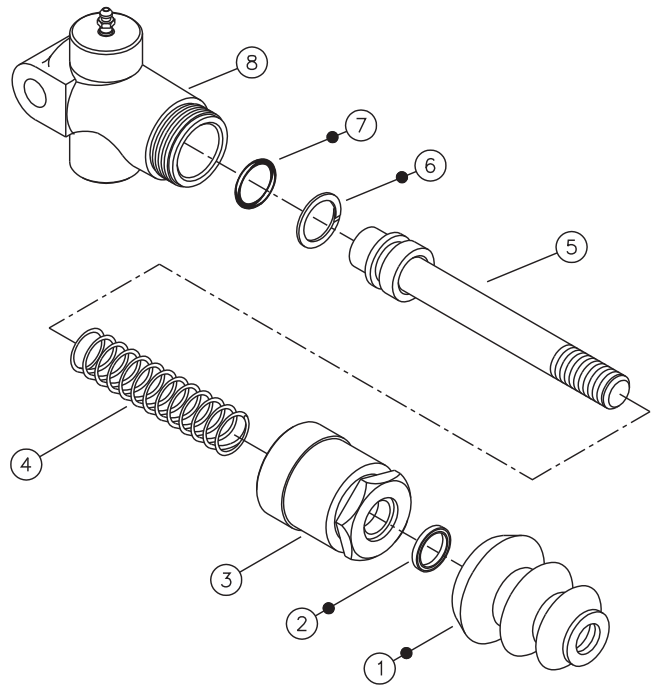


FIGURE 2

Model Number	Repair Kit Number
03-120-060 (HO)	02-100-035
03-120-061 (BF)	02-100-032

BF = DOT 3, 4, 5, and 5.1 brake fluid
HO = mineral base hydraulic oil

● Items included in Repair Kit

DISASSEMBLY

(Refer to Figure 3)

1. Remove boot (1) from end cap (3) and piston/push rod assembly (4).
2. Unscrew end cap (3) and separate from body (8).
3. Remove piston/push rod assembly (4) and spring (7) from body (8).
4. Remove o-ring (6) and back-up ring (5) from piston/push rod assembly (4).
5. Remove seal (2) from end cap (3). Note direction of seal (2).

ASSEMBLY

(Refer to Figure 3)

LUBRICATE ALL RUBBER COMPONENTS FROM REPAIR KIT WITH CLEAN TYPE FLUID USED IN THE SYSTEM.

1. Clean all parts thoroughly with clean type fluid used in the system before assembling.
2. Install new back-up ring (5) and new o-ring (6) on piston/push rod assembly (4). Note the order of back-up ring and o-ring.
3. Carefully install new seal (2) in end cap (3). Note the direction of seal (2).
4. Install end cap (3) over piston/push rod assembly (4) to body (8) and torque 47.5-54.2 N·m (35-40 lb·ft).
5. Install new boot (1).
6. Install the slave cylinder on the vehicle and connect the fluid lines. Bleed the system of air. Tighten fittings if leaks occur. Make several applications to be sure the slave cylinder is working properly. **NOTE: See form 81-600-001 instructions to bleed the slave cylinder. Refer to the vehicle manufacture specifications to bleed the vehicle brake system. All fittings must be inspected for leaks and tightened if leaks occur.**

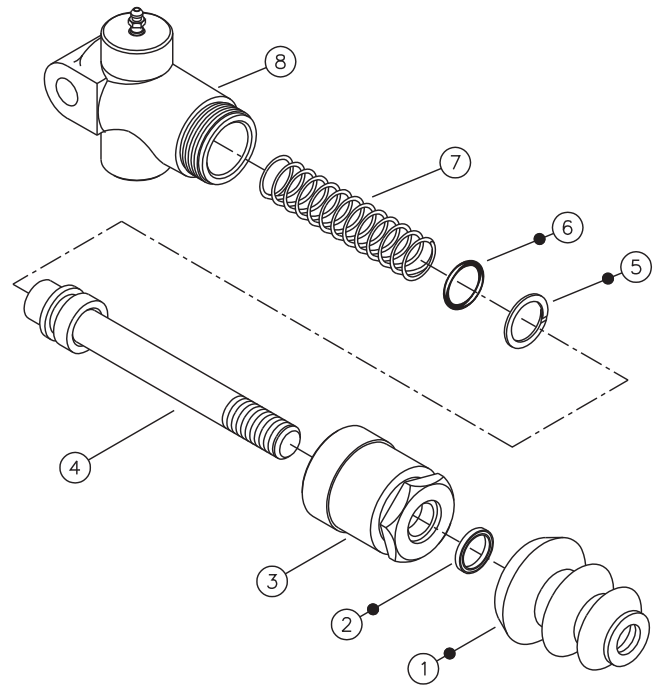


FIGURE 3

Model Number	Repair Kit Number
02-120-057 (BF)	02-100-018

BF = DOT 3, 4, 5, and 5.1 brake fluid

DISASSEMBLY

(Refer to Figure 4)

1. Remove nuts (1 & 17), retainer (16) and spring (15). Remove slave cylinder from vehicle.
2. Remove boot (2), retaining ring (3), washer (4), sleeve (5), springs (6 & 7), washer (8), push rod (9), piston (10), cup (11), retainer (12), and spring (13) from housing (14). Note direction of sleeve (5) and cup (11). **NOTE: Be careful not to scratch or mar housing bore.**
3. Remove bleeder screw (18) from housing (14).

ASSEMBLY

(Refer to Figure 4)

LUBRICATE ALL RUBBER COMPONENTS FROM REPAIR KIT WITH CLEAN TYPE FLUID USED IN THE SYSTEM.

1. Clean all parts thoroughly with clean type fluid used in the system before assembling.
2. Install spring (13), retainer (12), new cup (11), piston (10), push rod (9), new washer (8), new springs (7 & 6), sleeve (5), washer (4) and new retaining ring (3). Note the direction of cup (11) and sleeve (5).
3. Install new bleeder screw (18) in housing (14) and torque 6.8-7.9 N·m (60-70 lb·in).
4. Install new boot (2) on housing (14).
5. Install the slave cylinder on the vehicle and connect the fluid lines. Bleed the system of air. Tighten fittings if leaks occur. Make several applications to be sure the slave cylinder is working properly. **NOTE: See form 81-600-001 instructions to bleed the slave cylinder. Refer to the vehicle manufacture specifications to bleed the vehicle brake system. All fittings must be inspected for leaks and tightened if leaks occur.**

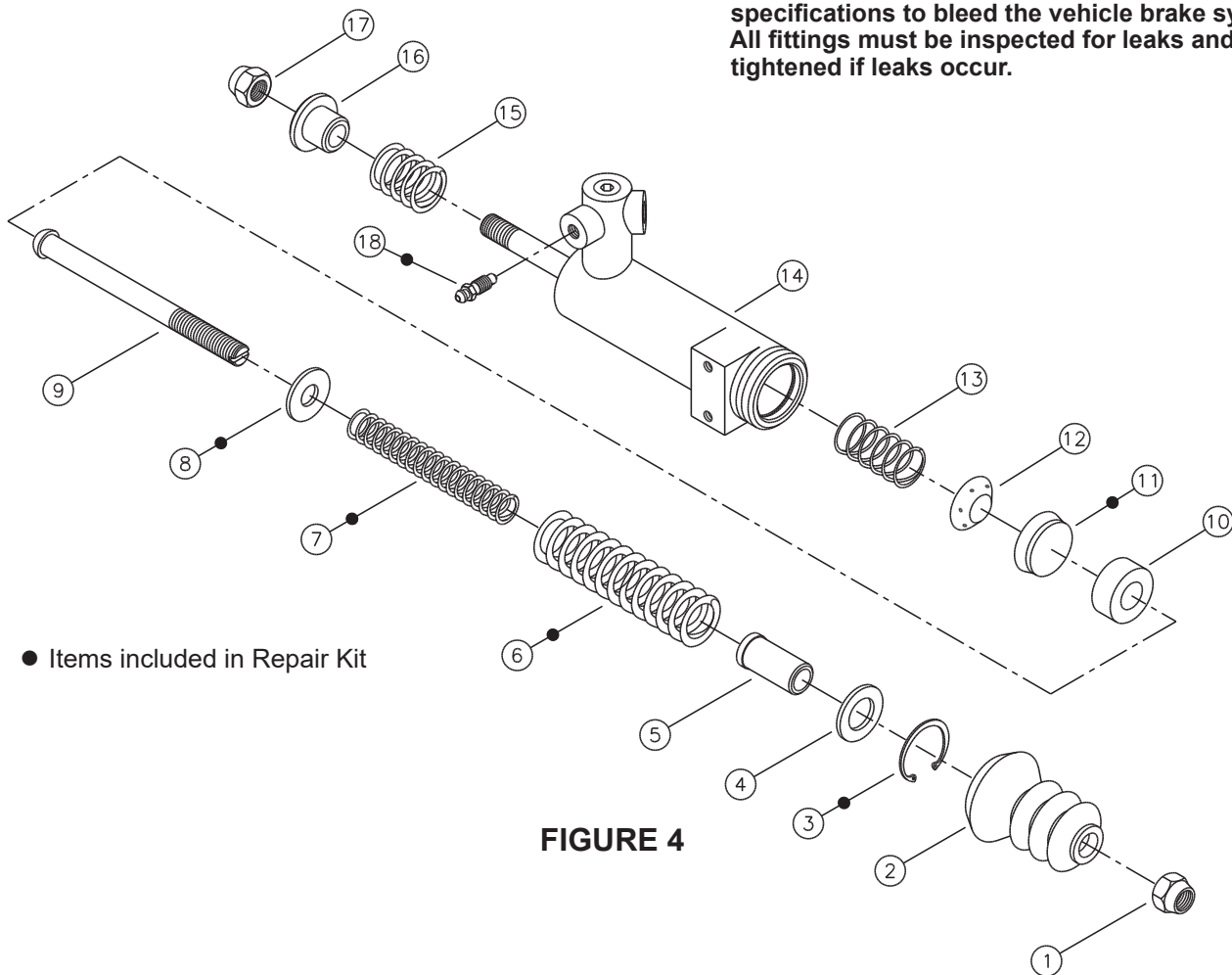


FIGURE 4

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