

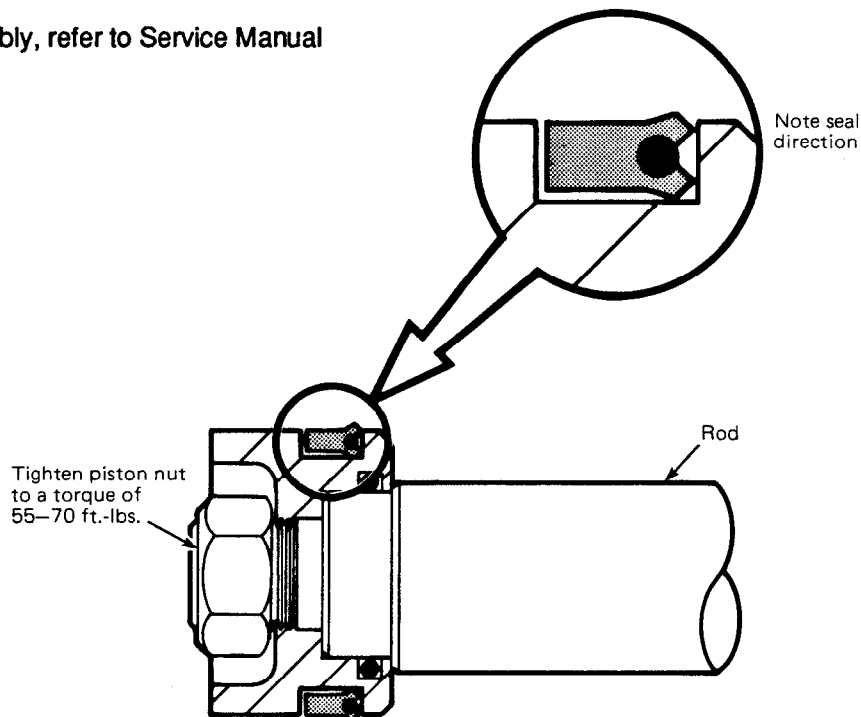


# Technical Bulletin

## 20D Carton Clamp Piston Seal Conversion Kit 558255 for Low Pressure Clamping Applications

This sheet provides instructions for the installation of Piston Conversion Kit 558255. This piston seal arrangement is well suited for applications requiring low clamp pressures such as handling appliances, tissue, etc.

1. Remove the cylinders from the clamp and disassemble according to Service Manual 670487.
2. Install the seals to the new piston. Note the seal direction shown in the illustration.
3. Install the piston to the rod. Install the piston nut and tighten to a torque of 55-70 ft.-lbs.
4. For further assembly, refer to Service Manual 670487.



**NOTE:** This information should not be interpreted as the basis for warranty claims unless so designated.  
Part No. 681443

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