



H-80, H-100, H-200 Series Helms (2-Line Systems) Air Purge Instructions Using HF-35 Purge Kit

NOTE: USE HYNAUTIC STEERING FLUID MCO-06.

NOTE: For Dual Station Systems, purge lower helm first.

NOTE: See Special Procedure for UNBALANCED CYLINDERS

1. Set up Helm as shown in Figure 1. Connect tube at cylinder. **DO NOT** invert bottle at this time.
2. Unscrew 9/16" **brass hex nuts** on each side of helm (Figure 2) and back out by hand until they stop. **DO NOT** loosen aluminum main caps.
3. Loosen Bleed Fittings on cylinder approximately 1/2 turn.
4. Invert fluid container and allow helm to fill for 20 to 30 seconds. Slowly turn wheel 5 times in each direction.
5. Turn wheel clockwise a few revolutions, then quickly turn counterclockwise for a quarter turn, then back clockwise. Air "burping" from the helm should diminish, and air bubbles will be seen in the clear tubing at the cylinder.
6. When "burping" has stopped, and no bubbles are visible in clear tube at Cylinder while turning wheel, right the fluid container. Leave fill tube attached.
7. Close Bleed Fittings at Cylinder. **DO NOT OVER TIGHTEN!**

NOTE

Before proceeding, determine if cylinder is **UNBALANCED** (K-11, K-12, K-13, K-14), meaning the shaft extends from only one side. If so, turn wheel until shaft is **FULLY RETRACTED**. Continue to next step.

8. Hold fluid container lower than Helm and allow fluid to drain back into container.
9. Disconnect tube and adapter and reinstall Filler Plug in Helm.
10. Tighten brass nuts on sides of Helm.
11. If dual station system, repeat steps 1-10 at upper station.
12. Check fluid level after several hours operation. When Helm is **NOT** hard over, fluid level should be slightly lower than fill hole. (If **UNBALANCED** cylinder, shaft must be **FULLY RETRACTED** when checking fluid level.)

For Fluid, Purge Kits, or Service Parts, contact your local supplier

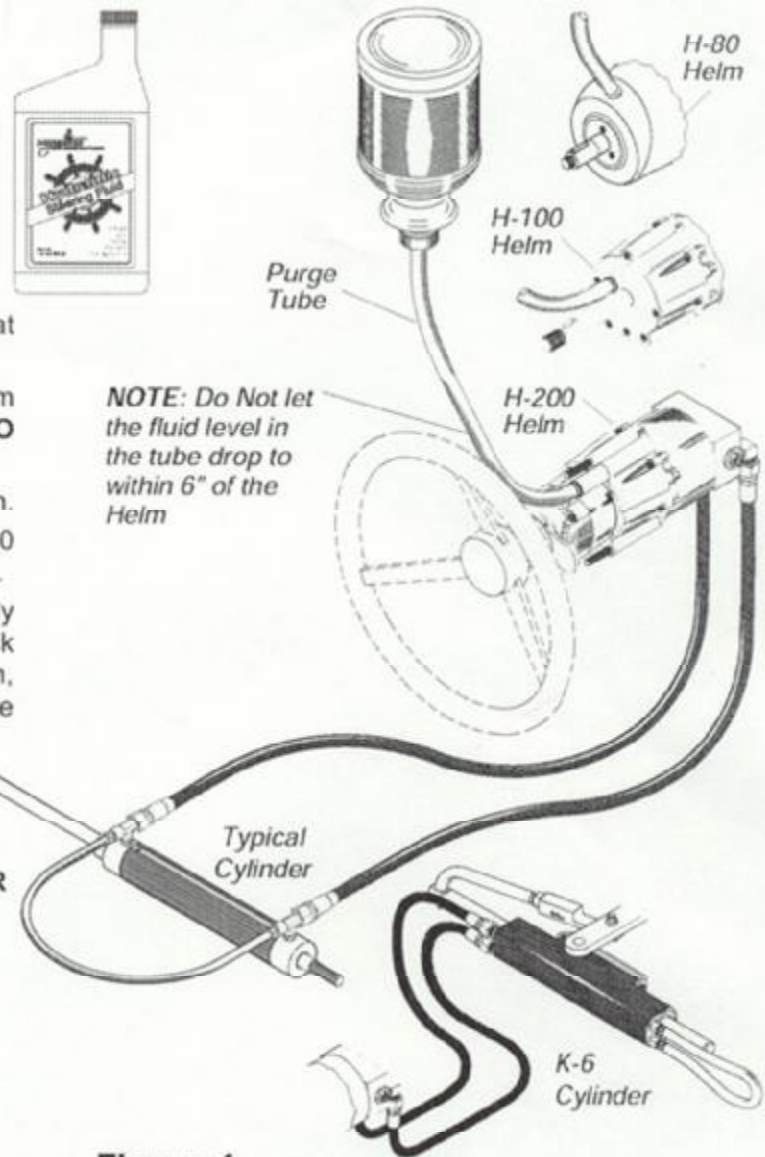


Figure 1

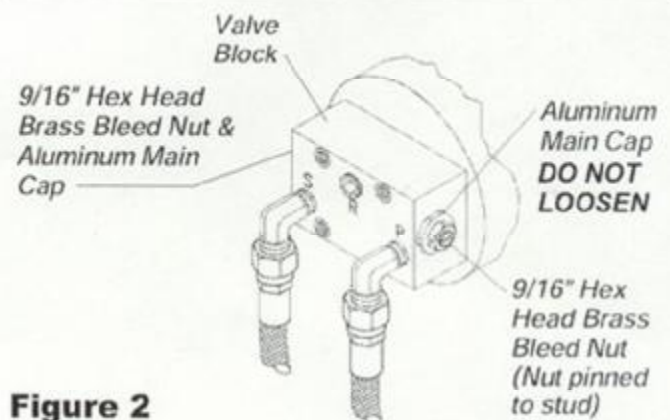


Figure 2