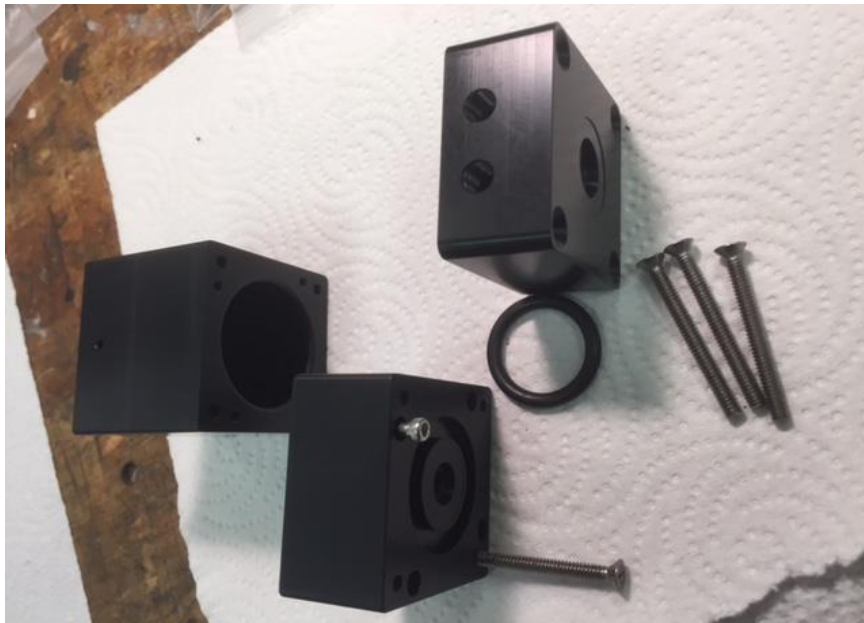


1. Collect PC1X comp parts, modified top manifold, 4 x 6-32 x 1.5" FHCS, LocTite Gasket Sealer #2, sand paper, acetone, #11, 6-32 tap, 0.11" transfer punch, 1/8" hole punch, 2 x 7" 1/8"

tubing, 1 x 7.5" 1/4" parflex, 2-211-70 oring.

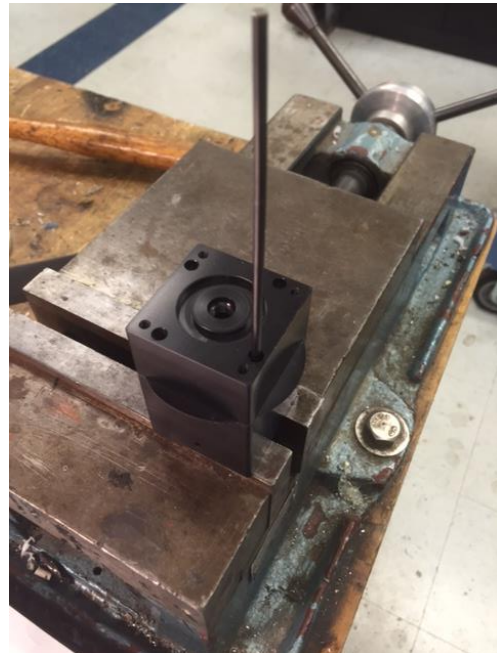
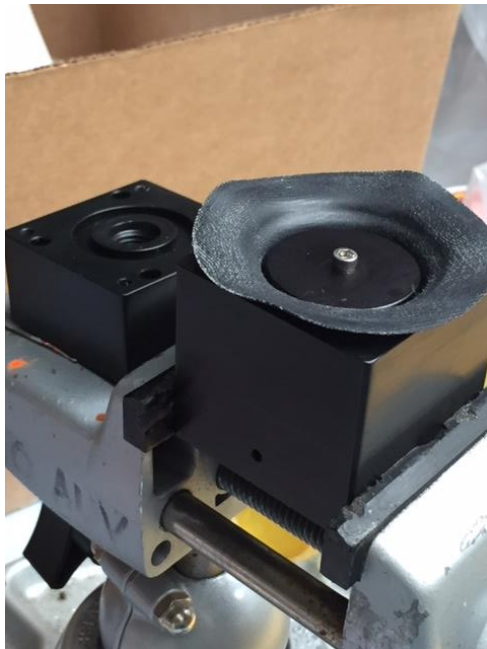


2. Use the #11 drill to ream guide pin hole in lower half section.
3. Roughen all surfaces to be bonded with Gasket Sealer. Course paper on plastic, med on rubber. Both flat surfaces of housing, both sides of diaphragm, piston top, cap underside.
4. Clean surfaces with acetone.
5. Punch a 1/8" hole in diaphragm top center.



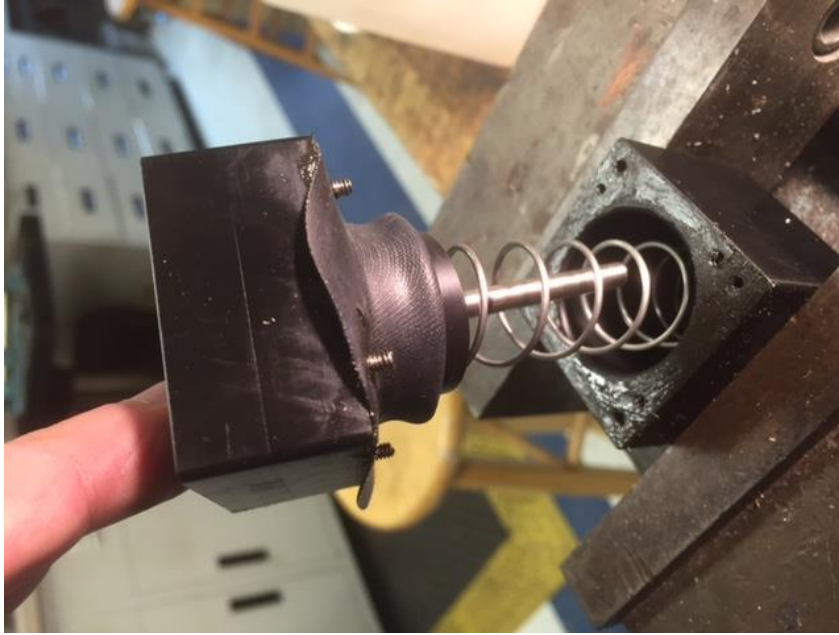
Apply a very thin layer of Gasket Sealer on piston top, diaphragm, cap underside surfaces to be bonded. Q tips help, Avoid radiused edges.

6. Assemble piston, diaphragm and cap with supplied 4-40 x 1/4" SHCScrew.
7. Clean any overflow from piston edges.
8. Screw piston guide into piston bottom, tighten gently.
9. Let dry for a few hours if possible. This ass'y will allow a better fitment and positioning of the punched holes in the diaphragm into the housing.
10. Dry fit the piston ass'y and both lower halves, carefully mark the location of the 4 remaining holes required. The corner holes in the lower half of comp are not used. Care is needed using the transfer punch to avoid damaging the existing tapped 4-40 holes. Piston ass'y is pushed 1/2 way down to position diaphragm at midtravel.



11. Punch the remaining 4 screw 1/8" holes in diaphragm.

12. Apply a very thin layer of Gasket Sealer as before on diaphragm, housing surfaces to be bonded. Q tips help, Avoid radiused edges.



13. Insert spring, assemble housing, piston ass'y, using supplied 4-40 SHCS as a guide. This isn't easy, spring is strong. A small clamp on the piston guide rod to hold it in the retracted position is very helpful.

14. Dry for 24 hours.

15. Trim excess rubber from outside of housing with a razor blade



16. Mid block, tap corner holes 5/8" deep with 6-32. If not done earlier.
17. Clean parts, grease oring, groove, install oring, assemble with 4 x 6-32 x 1.5" FHead



18. Finish ass'y .
19. Do a functional check by pumping in oil, should move smoothly from 4-7 psi for full travel. 1st fill may not be very smooth.
20. Leave filled for 24 hrs to leak check.