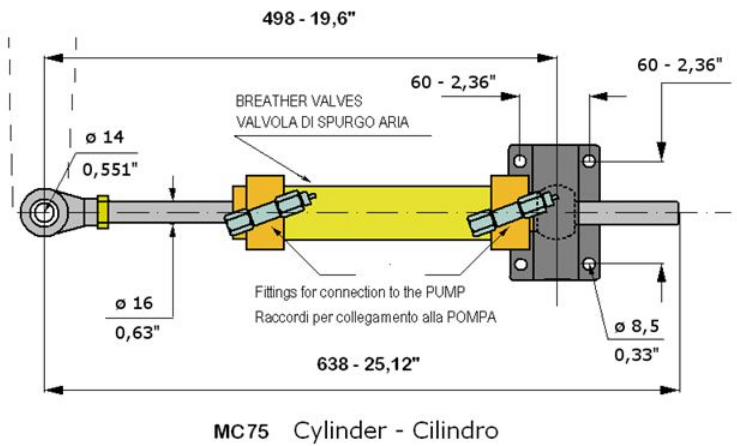
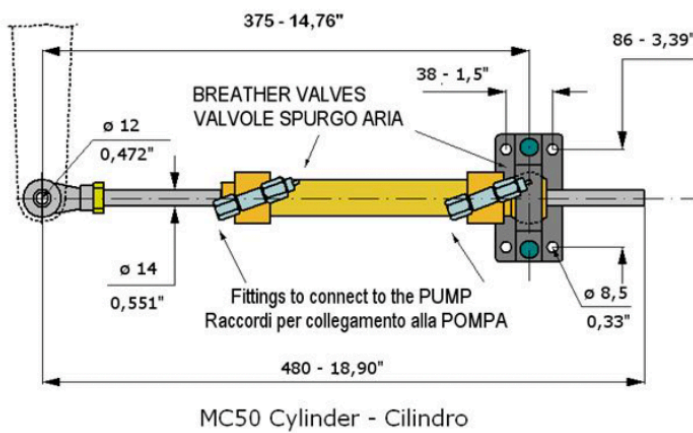


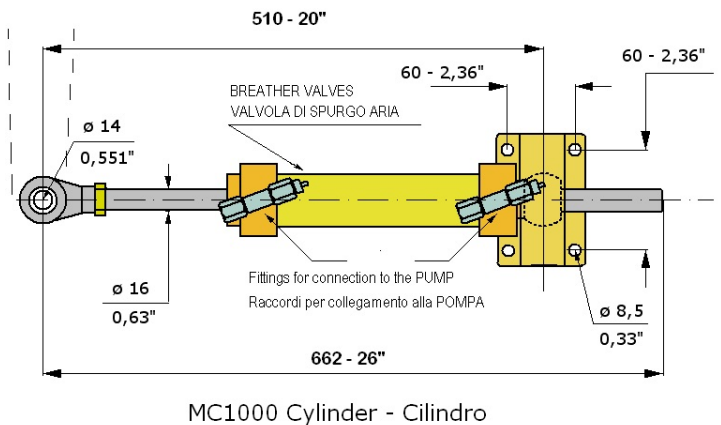
Hydrodrive Inboard Cylinder MC50/MC75/MC1000 Installation Guide



Installation Steps:

1. Preparation

- Ensure the engine or rudder system is centered.
- Clean all contact surfaces where the cylinder will be mounted.



2. Mounting the Cylinder

- Attach the rear end of the cylinder using the 4 mounting holes ($\phi 8.5$ mm) on the flange.
- Use marine-grade bolts and washers. Torque them to manufacturer specifications.
- Ensure the mounting surface is rigid and vibration-resistant.

3. Connecting the Rod End

- Align the cylinder rod end with the engine tiller arm or rudder tiller.
- Insert a bolt through the $\phi 14$ mm rod end and secure with a locknut.
- Apply marine-grade grease to the joint to allow smooth articulation.

4. Hydraulic Hose Connections

- Connect the hydraulic hoses to the fittings marked "For pump connection" on the cylinder.
- Use appropriate thread sealant on tapered threads.

- Ensure correct routing of hoses to avoid kinks or rubbing.
- Tighten fittings securely but do not over tighten.

5. Air Bleed Valves

- Open the breather valves (Valvola di spurgo aria) slightly during initial filling.
- These are used to vent trapped air from the system.
- Follow the bleeding procedure per pump manufacturer's instructions.

6. System Testing

- Fill the system with the correct hydraulic fluid (as per pump instructions).
- Turn the steering wheel side to side to purge air and check for smooth operation.
- Close breather valves once air is fully purged.
- Check for leaks at all connections.

7. Final Checks

- Re-torque all bolts after 1 hour of operation.
- Inspect hose routing and connections after sea trial.
- Re-grease mechanical joints as needed.