STANLEY®

TA54

HYDRAULIC TAMPER

⚠ WARNING

SERIOUS INJURY OR DEATH COULD RESULT FROM IMPROPER REPAIR OR SERVICE OF THIS TOOL.

REPAIRS AND/OR SERVICE TO THIS TOOL MUST ONLY BE DONE BY AN AUTHORIZED AND CERTIFIED DEALER.

SAFETY, OPERATION AND MAINTENANCE
SERVICE MANUAL

Stanley Hydraulic Tools
3810 SE Naef Road
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www.stanley-hydraulic-tools.com

OPS/SVCE USA
16826 12/2003 Ver 2

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SERVICING THE STANLEY TAMPER: This manual contains safety, operation, and routine maintenance instructions. Stanley Hydraulic Tools recommends that servicing of hydraulic tools, other than routine maintenance, must be performed by an authorized and certified dealer. Please read the following warning.

⚠ WARNING

SERIOUS INJURY OR DEATH COULD RESULT FROM THE IMPROPER REPAIR OR SERVICE OF THIS TOOL.

REPAIRS AND / OR SERVICE TO THIS TOOL MUST ONLY BE DONE BY AN AUTHORIZED AND CERTIFIED DEALER.

For the nearest authorized and certified dealer, call Stanley Hydraulic Tools at one of the numbers listed on the back of this manual and ask for a Customer Service Representative.

SAFETY SYMBOLS

Safety symbols and signal words, as shown below, are used to emphasize all operator, maintenance and repair actions which, if not strictly followed, could result in a life-threatening situation, bodily injury or damage to equipment.

This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

⚠ DANGER — **This safety alert and signal word indicate an imminently hazardous situation which, if not avoided, will result in death or serious injury.**

⚠ WARNING — **This safety alert and signal word indicate a potentially hazardous situation which, if not avoided, could result in death or serious injury.**

⚠ CAUTION — **This safety alert and signal word indicate a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.**

CAUTION — **This signal word indicates a potentially hazardous situation which, if not avoided, may result in property damage.**

NOTICE — **This signal word indicates a situation which, if not avoided, will result in damage to the equipment.**

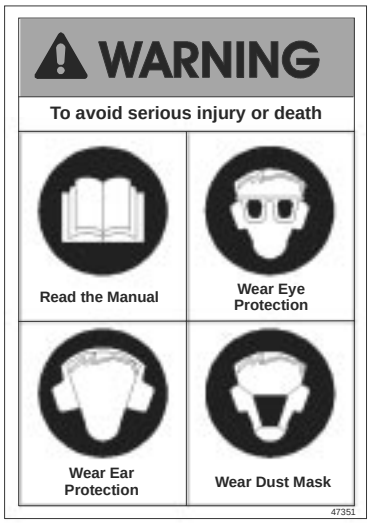
IMPORTANT — **This signal word indicates a situation which, if not avoided, may result in damage to the equipment.**

Always observe safety symbols. They are included for your safety and for the protection of the tool.

LOCAL SAFETY REGULATIONS

Enter any local safety regulations here. Keep these instructions in an area accessible to the operator and maintenance personnel.

SAFETY PRECAUTIONS



Tool operators and maintenance personnel must always comply with the safety precautions given in this manual and on the stickers and tags attached to the tool and hose.

These safety precautions are given for your safety. Review them carefully before operating the tool and before performing general maintenance or repairs.

Supervising personnel should develop additional precautions relating to the specific work area and local safety regulations. If so, place the added precautions in the space provided on page 4.

The TA54 Hydraulic Tamper will provide safe and dependable service if operated in accordance with the instructions given in this manual. Read and understand this manual and any stickers and tags attached to the tool and hoses before operation. Failure to do so could result in personal injury or equipment damage.

- Operator must start in a work area without bystanders. The operator must be familiar with all prohibited work areas such as excessive slopes and dangerous terrain conditions.
- Establish a training program for all operators to ensure safe operation.
- Do not operate the tool unless thoroughly trained or under the supervision of an instructor.
- Always wear safety equipment such as goggles, ear, head protection, and safety shoes at all times when operating the tool. Never wear loose clothing that can get entangled in the working parts of the tool.
- Do not inspect or clean the tool while the hydraulic power source is connected. Accidental engagement of the tool can cause serious injury.
- Supply hoses must have a minimum working pressure rating of 2500 psi/175 bar.
- Be sure all hose connections are tight.
- The hydraulic circuit control valve must be in the "OFF" position when coupling or uncoupling the tool. Wipe all couplers clean before connecting. Use only lint-free cloths. Failure to do so may result in damage to the quick couplers and cause overheating of the hydraulic system.
- Do not operate the tool at oil temperatures above 140°F/60°C. Operation at higher oil temperatures can cause operator discomfort and may damage the tool.
- Do not operate a damaged, improperly adjusted, or incompletely assembled tool.
- Know the location of buried or covered services before starting your work.
- To avoid personal injury or equipment damage, all tool repair, maintenance and service must only be performed by authorized and properly trained personnel.
- Do not exceed the rated limits of the tool or use the tool for applications beyond its design capacity.
- Always keep critical tool markings, such as lables and warning stickers legible.
- Always replace parts with replacement parts recommended by Stanley Hydraulic Tools.
- Without the use of of non-conductive accessories, this tool is not for use near energized lines. Failure to comply with this warning could result in serious personal injury.
- Do not overreach. Maintain proper footing and balanace at all times.
- Use care when handling the tamper. Do not carry the tool by the hoses.

TOOL STICKERS & TAGS

03783
GPM Decal

05152
Stanley Logo Decal

14908
Name Tag

STANLEY
Stanley Hydraulic tools
Division of the Stanley Works
3810 SE Naef Road
Milwaukie, OR 97267

05152

STANLEY
Stanley Hydraulic Tools
3810 SE Naef Road
Milwaukie, OR 97267 USA
Model No.
TA54

14908

CAUTION

3-9 GPM / 11-34 LPM
DO NOT EXCEED 2000 PSI / 140 BAR

DO NOT EXCEED SPECIFIED FLOW OR PRESSURE
USE CLOSED-CENTER TOOL ON CLOSED-CENTER SYSTEM. USE OPEN-CENTER TOOL ON OPEN-CENTER SYSTEM. CORRECTLY CONNECT HOSES TO TOOL "IN" AND "OUT" PORTS. IMPROPER HANDLING, USE OR OTHER MAINTENANCE OF TOOL COULD RESULT IN A LEAK, BURST OR OTHER TOOL FAILURE. CONTACT AT A LEAK OR BURST CAN CAUSE OIL INJECTION INTO THE BODY. FAILURE TO OBSERVE THESE PRECAUTIONS CAN RESULT IN SERIOUS PERSONAL INJURY.

03783

The safety tag (p/n 15875) at right is attached to the tool when shipped from the factory. Read and understand the safety instructions listed on this tag before removal. We suggest you retain this tag and attach it to the tool when not in use.

DANGER

1. FAILURE TO USE HYDRAULIC HOSE **LABELED AND CERTIFIED AS NON-CONDUCTIVE** WHEN USING HYDRAULIC TOOLS ON OR NEAR ELECTRICAL LINES MAY RESULT IN DEATH OR SERIOUS INJURY.

   BEFORE USING HOSE **LABELED AND CERTIFIED AS NON-CONDUCTIVE** ON OR NEAR ELECTRIC LINES BE SURE THE HOSE IS **MAINTAINED AS NON-CONDUCTIVE**. THE HOSE SHOULD BE REGULARLY TESTED FOR ELECTRIC CURRENT LEAKAGE IN ACCORDANCE WITH YOUR SAFETY DEPARTMENT INSTRUCTIONS.

2. A HYDRAULIC LEAK OR BURST MAY CAUSE OIL INJECTION INTO THE BODY OR CAUSE OTHER SEVERE PERSONAL INJURY.

   A **DO NOT** EXCEED SPECIFIED FLOW AND PRESSURE FOR THIS TOOL. EXCESS FLOW OR PRESSURE MAY CAUSE A LEAK OR BURST.

   B **DO NOT** EXCEED RATED WORKING PRESSURE OF HYDRAULIC HOSE USED WITH THIS TOOL. EXCESS PRESSURE MAY CAUSE A LEAK OR BURST.

   C CHECK TOOL HOSE COUPLERS AND CONNECTORS DAILY FOR LEAKS. **DO NOT** FEEL FOR LEAKS WITH YOUR HANDS. CONTACT WITH A LEAK MAY RESULT IN SEVERE PERSONAL INJURY.

IMPORTANT

READ OPERATION MANUAL AND SAFETY INSTRUCTIONS FOR THIS TOOL BEFORE USING IT.

USE ONLY PARTS AND REPAIR PROCEDURES APPROVED BY STANLEY AND DESCRIBED IN THE OPERATION MANUAL.

TAG TO BE REMOVED ONLY BY TOOL OPERATOR.

SEE OTHER SIDE

DANGER

D DO NOT LIFT OR CARRY TOOL BY THE HOSES. DO NOT ABUSE HOSE. DO NOT USE KINKED, TORN OR DAMAGED HOSE.

3. MAKE SURE HYDRAULIC HOSES ARE PROPERLY CONNECTED TO THE TOOL BEFORE PRESSURING SYSTEM. SYSTEM PRESSURE HOSE MUST ALWAYS BE CONNECTED TO TOOL "IN" PORT. SYSTEM RETURN HOSE MUST ALWAYS BE CONNECTED TO TOOL "OUT" PORT. REVERSING CONNECTIONS MAY CAUSE REVERSE TOOL OPERATION WHICH CAN RESULT IN SEVERE PERSONAL INJURY.

4. DO NOT CONNECT OPEN-CENTER TOOLS TO CLOSED-CENTER HYDRAULIC SYSTEMS. THIS MAY RESULT IN LOSS OF OTHER HYDRAULIC FUNCTIONS POWERED BY THE SAME SYSTEM AND/OR SEVERE PERSONAL INJURY.

5. BYSTANDERS MAY BE INJURED IN YOUR WORK AREA. KEEP BYSTANDERS CLEAR OF YOUR WORK AREA.

6. WEAR HEARING, EYE, FOOT, HAND AND HEAD PROTECTION.

7. TO AVOID PERSONAL INJURY OR EQUIPMENT DAMAGE, ALL TOOL REPAIR MAINTENANCE AND SERVICE MUST ONLY BE PERFORMED BY AUTHORIZED AND PROPERLY TRAINED PERSONNEL.

IMPORTANT

READ OPERATION MANUAL AND SAFETY INSTRUCTIONS FOR THIS TOOL BEFORE USING IT.

USE ONLY PARTS AND REPAIR PROCEDURES APPROVED BY STANLEY AND DESCRIBED IN THE OPERATION MANUAL.

TAG TO BE REMOVED ONLY BY TOOL OPERATOR.

SEE OTHER SIDE

SAFETY TAG P/N 15875 (shown smaller then actual size)

HYDRAULIC HOSE REQUIREMENTS

HOSE TYPES

Hydraulic hose types authorized for use with Stanley Hydraulic Tools are as follows:

❶ Certified non-conductive

❷ Wire-braided (conductive)

❸ Fabric-braided (not certified or labeled non-conductive)

Hose ❶ listed above is the only hose authorized for use near electrical conductors.

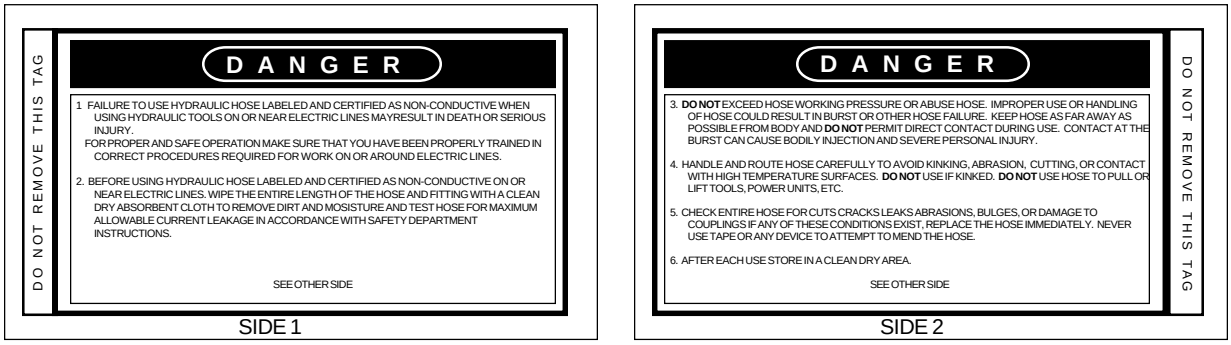
Hoses ❷ and ❸ listed above are **conductive** and **must never** be used near electrical conductors.

HOSE SAFETY TAGS

To help ensure your safety, the following DANGER tags are attached to all hose purchased from Stanley Hydraulic Tools. DO NOT REMOVE THESE TAGS.

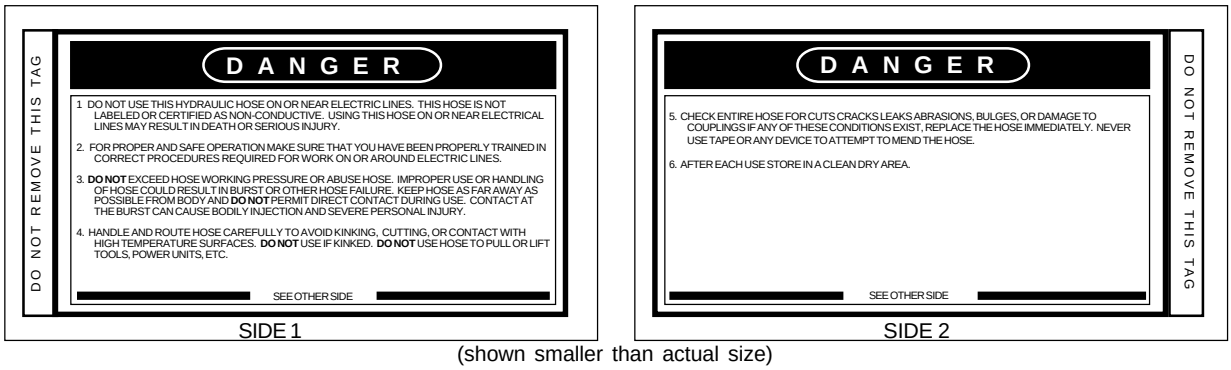
If the information on a tag is illegible because of wear or damage, replace the tag immediately. A new tag may be obtained from your Stanley Distributor.

THE TAG SHOWN BELOW IS ATTACHED TO "CERTIFIED NON-CONDUCTIVE" HOSE



(shown smaller than actual size)

THE TAG SHOWN BELOW IS ATTACHED TO "CONDUCTIVE" HOSE.



(shown smaller than actual size)

HOSE PRESSURE RATING

The rated working pressure of the hydraulic hose **must be equal to or higher than** the relief valve setting on the hydraulic system.

HTMA REQUIREMENTS

Hydraulic System Requirements	Tool Category C 20Lpm at 138bar BHTMA CATEGORY **Type I**	D 30Lpm at 138bar BHTMA CATEGORY **Type II**	E 40Lpm at 138bar EHTMA CATEGORY	**Type III**
Flow rate Tool Operating Pressure *(at the power supply outlet)*	4-6gpm (15-23 lpm) 2000 psi (138 bar)	7-9gpm (26-34 lpm) 2000 psi (138 bar)	10.5-11.6 gpm (36-44 lpm) 2000 psi (138 bar)	11-13 gpm (42-49 lpm) 2000 psi (138 bar)
System relief valve setting *(at the power supply outlet)*	2100-2250 psi (145-155 bar)	2100-2250 psi (145-155 bar)	2100-2250 psi (145-155 bar)	2100-2250 psi (145-155 bar)
Maximum back pressure *(at tool end of the return hose)*	200 psi (14 bar)	200 psi (14 bar)	200 psi (14 bar)	200 psi (14 bar)
Measured at a max. fluid viscosity of: *(at min. operating temperature)*	400 ssu* (82 centistokes)	400 ssu* (82 centistokes)	400 ssu* (82 centistokes)	400 ssu* (82 centistokes)
Temperature Sufficient heat rejection capacity to limit max. fluid temperature to: *(at max. expected ambient temperature)*	140° F (60° C)	140° F (60° C)	140° F (60° C)	140° F (60° C)
Min. cooling capacity at a temperature difference of between ambient and fluid temps	3 hp (2.24 kW) 40° F (22° C)	5 hp (3.73 kW) 40° F (22° C)	6 hp (4.47 kW) 40° F (22° C)	7 hp (5.22 kW) 40° F (22° C)
NOTE: Do not operate the tool at oil temperatures above 140°F (60° C). Operation at higher temperatures can cause operator discomfort at the tool.				
Filter Min. full-flow filtration Sized for flow of at least: *(For cold temp. startup and max. dirt-holding capacity)*	25 microns 18 gpm (68 lpm)	25 microns 30 gpm (114 lpm)	25 microns 35 gpm (132 lpm)	25 microns 40 gpm (151 lpm)
Hydraulic fluid Petroleum based *(premium grade, anti-wear, non-conductive)* Viscosity *(at min. and max. operating temps)*	100-400 ssu* (20-82 centistokes)	100-400 ssu* (20-82 centistokes)	100-400 ssu* (20-82 centistokes)	100-400 ssu* (20-82 centistokes)
NOTE: When choosing hydraulic fluid, the expected oil temperature extremes that will be experienced in service determine the most suitable temperature viscosity characteristics. Hydraulic fluids with a viscosity index over 140 will meet the requirements over a wide range of operating temperatures.				

NOTE: These are general hydraulic system requirements. See tool Specification page for tool specific requirements.

OPERATION

PREOPERATION PROCEDURES

PREPARATION FOR INITIAL USE

The tool, as shipped, has no special unpacking or assembly requirements prior to usage. Inspection to assure the tool was not damaged in shipping and does not contain packing debris is all that is required.

CHECK HYDRAULIC POWER SOURCE

1. Using a calibrated flowmeter and pressure gauge, check that the hydraulic power source develops a flow of 3-9 gpm/ 11-34 lpm at 1000-2000 psi/70-140 bar.

2. Make certain the hydraulic power source is equipped with a relief valve set to open at 2250 psi/155 bar maximum.

3. Check that the hydraulic circuit matches the tool for open-center (OC) operation.

CHECK TOOL

1. Make sure all tool accessories are correctly installed. Failure to install tool accessories properly can result in damage to the tool or personal injury.

2. There should be no signs of leaks.

3. The tool should be clean, with all fittings and fasteners tight.

CHECK TRIGGER MECHANISM

1. Check that the trigger operates smoothly and is free to travel between the "ON" and "OFF" positions.

OPERATING PROCEDURES

1. Observe all safety precautions.

2. Place the tamper on the surface to be compacted.

3. Squeeze the trigger to start the tamper.

⚠ WARNING

The tamper will rise quickly when first turned on. Do not stand over or place any part of your body on top of the tamper. Wear safety shoes.

NOTE:
Partially depressing the trigger allows the tool to operate at a slow speed, making it easy to start the tamper on the surface to compacted.

4. Guide the tamper using both hands. One on the On/Off valve trigger and the other at the tapered section at the end of the handle tube.

5. When back-filling a deep hole, compact (tamp) the back-fill after a maximum of 6 inches/15 cm of material is added to the hole. This will ensure maximum compaction of the filled hole and minimize any setting that may occur.

COLD WEATHER OPERATION

If the tool is to be used during cold weather, preheat the hydraulic fluid at low engine speed. When using the normally recommended fluids, fluid temperature should be at or above 50° F/10° C (400 ssu/82 centistokes) before use.

STORAGE

1. Disconnect the tool from the hydraulic power source.

2. Remove the tool bit and spray the chuck area with WD-40™ inside and out.

3. Wipe clean and store in a clean, dry place.

EQUIPMENT PROTECTION & CARE

NOTICE

In addition to the Safety Precautions in this manual, observe the following for equipment protection and care.

- Make sure all couplers are wiped clean before connection.
- The hydraulic circuit control valve must be in the “OFF” position when coupling or uncoupling hydraulic tools. Failure to do so may result in damage to the quick couples and cause overheating of the hydraulic system.
- Always store the tool in a clean dry space, safe from damage or pilferage.
- Make sure the circuit PRESSURE hose (with male quick disconnect) is connected to the “IN” port. The circuit RETURN hose (with female quick disconnect) is connected to the opposite port. Do not reverse circuit flow. This can cause damage to internal seals.
- Always replace hoses, couplings and other parts with replacement parts recommended by Stanley Hydraulic Tools. Supply hoses must have a minimum working pressure rating of 2500 psi/172 bar.
- Do not exceed the rated flow (see Specifications) in this manual for correct flow rate and model number. Rapid failure of the internal seals may result.
- Always keep critical tool markings, such as warning stickers and tags legible.
- Tool repair should be performed by experienced personnel only.
- Make certain that the recommended relief valves are installed in the pressure side of the system.
- Do not use the tool for applications for which it was not intended.

TROUBLESHOOTING

Tool does not run.	Power unit not functioning.	Check power unit for proper flow and pressure 3-9gpm/11-34 lpm at 1000-2000 psi/70-140 bar.
	Couplers or hoses blocked.	Remove restriction.
	Presssure and return line hoses reversed at ports.	Be sure hoses are connected to their proper ports.
	Mechanical failure.	Have inspected and repaired by authorized dealer.
	Backpressure too high.	Check hydraulic system for excessive backpressure over 250 psi/17 bar measure at the end of the tool operating hoses.
Tool does not compact effectively.	Power unit not functioning.	Check power unit for proper flow and pressure 7-9gpm/26-34 lpm, 1500 psi/103 bar.
	Couplers or hose blocked.	Remove restriction.
	Backpressure too high.	Check hydraulic system for excessive backpressure over 250 psi/17 bar measure at the end of the tool operating hoses.
	Fluid too hot (above 140°F / 60°C) Fluid too cold (below 60°F / 15.5°C)	Provide cooler to maintain proper oil temperature. Bypass cooler to warm up oil, or provide cooler to maintain proper temperature.
	Tamper shoe too large for soil conditions.	Use smaller shoe for back-filling operations (p/n 01849).
Tool operates slow.	Low oil flow from power unit.	Check power source for proper flow.
	High backpressure.	Check hydraulic system for excessive backpressure and correct as required.
	Couplers or hoses blocked.	Remove restrictions.
	Fluid too hot (above 140°F / 60°C) Fluid too cold (below 60°F / 15.5°C)	Provide cooler to maintain proper oil temperature. Bypass cooler to warm up oil, or provide cooler to maintain proper temperature.

TROUBLESHOOTING

Tamper gets hot.	Hot oil going through tool	Check power unit. Be sure flow rate is not too high causing excess oil to go through the relief valve. Provide cooler to maintain proper oil temperature (100-130°F/38-54°C). Eliminate flow control devices. Do Not Exceed Recommended Flow.
Oil leakage on pison rod	Lower piston seal failure.	Replace seal and wiper, piston and nose as required.
Oil leakage around trigger.	Valve spool seal failure.	Replace seals.
Oil leakage around spool end caps.	O-Ring failure.	Replace O-Rings.
Piston extends but does not retract (reciprocate).	Presure and return reversed.	Correct the proper flow direction at power unit or tool.
	Tool not assembled correctly.	Review service instructions for proper assembly or contact an authorized Stanley Hydraulic Tools distributor. Also check the following: 1. Flow sleeve lined up correctly with locating pin. 2. Oil tubes reveresed at On/Off valve. 3. Front sleeve in correctly. 4. Thrust bridge washer in correctly.
	Backpressure too high	Check hydraulic system for excessive backpressure over 250 psi/17 bar measure at the end of the tool operating hoses.

SPECIFICATIONS

Oil Flow Range ..... 3-9 gpm/11-34 lpm
Pressure Range ..... 1000-2000 psi/70-140 Bar
Length ..... See Below
Weight ..... 25 lbs/11.3 kg
Porting ..... 1/2 in. SAE O-Ring Port or 3/8 Pipe Hose Ends
Couplers ..... HTMA/EHTMA Flush Face Type Male & Female
System Type ..... HTMA Type I and Type II

Handle Length	No Valve	Valve in Handle	Mid-Valve
3 Foot	66 inches/167 cm	55 inches/139 cm	
System Type	O.C./C.C.	O.C./C.C.	O.C

ACCESSORIES

Description **Part No.**

Kidney Shoe 00833
Round Shoe, 6-inch Diameter 00840
Rectangular Shoe 01070
Square Shoe, 8-inch x 8-inch 01081
Square Shoe, 6-inch x 6-inch 08252
8 Ft Hose (2 required) 35784
45° Elbow -8 SAE Male x -8 JIC Male 350000
In-Line Valve Assembly O.C./C.C. 38632

SERVICE TOOLS

Tamper Sleeve Tool 01120
Sleeve Installation Wrench 01949
O-Ring Tool Kit 04337

SERVICE

PRIOR TO DISASSEMBLY

Clean exterior of tool.

Obtain Seal Kit, (Part Number 02030), for no-valve models, or (Part Number 02032), for valve-in-handle models, so you can replace all seals exposed during disassembly. Note orientation of seals before removing them. Install new seals in the same way.

NOTE:
Refer to Parts List Illustration for location of parts.

TO REMOVE THE HANDLE ASSEMBLY

1. Place the tamper in a vise with soft jaws, clamping on the large flat faces of block and tube assembly with the handle assembly to the right and the trigger on the valve-in-handle models in the up position.

2. No-valve Models.

a. Remove the four oval head capscrews securing the hose guides to the handle and remove the guides.

b. Remove the four 5/16-18 x 1-1/4 inch/32 mm long capscrews and washers securing the handle tube to the lower assembly and separate assemblies.

c. Remove the hose assembly from two fittings on the lower assembly and pull hose out of the handle assembly.

3. Valve-in-handle Models.

a. On mid-valve models, remove the four flat head screws securing the valve body to the handle tube and pull the valve body away from the handle assembly.

On mid-valve models remove the eight capscrews securing the upper handle tube to the valve body and hose guides. Slide the upper handle tube off to access the upper hose assemblies.

b. On end-valve models, place a wrench across the flat portion of the on-off valve body, slide the protective cover off of the retaining nut and loosen the nut with a 2-1/8 inch wrench.

Pull the valve body away from the handle assembly.

c. On all models, remove the four 5/16-18 x 1-1/4 inch/32 cm long capscrews and washers securing the handle assembly to the lower assembly and slide the handle off over the tubes or hoses.

d. Remove the oil tubes or hoses and fittings as required.

TO DISASSEMBLE THE VALVE ASSEMBLY

1. On mid-valve models, remove the button head machine screw from the end of the on-off spool. Drive the 5/32 x 1 inch/4 mm x 25 mm roll pin from valve body assembly and pull the valve spool with the trigger attached out of the spool bore. Drive out the 1/8 x 7/8 inch/3 mm x 22 mm roll pin to remove the spool from the trigger. Slide the spring off of the spool.

Carefully remove the a-rings from the valve spool bore using o-ring service tools.

2. On end-valve models, drive the two 5/32 inch/4 mm diameter roll pins out of the trigger. Then remove the trigger, spring and valve spool from the valve body.

Carefully remove the a-rings from the valve spool bore before using o-ring service tools.

TO DISASSEMBLE THE LOWER ASSEMBLY (VIEW A)

1. Remove the 7/16-20 x 1-1/2 inch/38 mm long capscrew and lockwasher securing the tamper shoe to the piston. Tap on the top of the tamper shoe with a soft face hammer to remove it from the piston taper.

If the tamper shoe is not removed easily as above, thread the retaining screw three fourths of the way in and tap on its head with a hammer while pulling on the shoe.

2. Loosen the jam nut and unscrew the nose from the block and tube assembly.

3. Remove the rod wiper and felt washer from the lower end of the nose.

4. Remove the rod seal from the nose by first removing the retaining ring.

5. Remove the cushion and two o-rings from the opposite end of the nose. Always install new seals and o-rings during assembly.

6. Pull the piston from the block and tube assembly. The front sleeve and thrust bridge washer can be removed with the piston.

7. Remove the back sleeve and oil tube from the block and tube assembly by using service tool, (Part Number 01120), or a length of 3/8-16 Redi-Bolt threaded into the end of the oil tube.

NOTE:
Remove the flow sleeve by placing a hooked tool into the 5/16-inch holes in the lower end of the sleeve. Be careful not to damage the bore.

8. Remove the reversing spool by removing the two end caps.

NOTE:
The insert pressed into the block and tube assembly for the forward/reverse spool is not serviceable. It should be tight in its bore with the slot on either end perpendicular to the block and tube center line.

TAMPER REASSEMBLY

PRIOR TO REASSEMBLY

Clean all parts with a degreasing solvent.

Inspect all parts for obvious wear and damage.

Ensure that all seals exposed during disassembly are replaced. Refer to the parts list at the back of this manual for the applicable repair and seal kit.

Apply clean grease or o-ring lubricant to all parts during reassembly.

Refer to the parts list at the back of this manual for parts location.

REASSEMBLY

LOWER ASSEMBLY

1. Install one of the end caps (with o-ring) on the block and tube assembly, then install the reversing spool. Install the remaining end cap and o-ring. Tighten the end caps securely.

NOTE:
The spool should move freely in its bore without binding.

2. Place the block and tube assembly in a bench vise with soft jaws and clamp on the large flat faces of the block.

3. If the flow sleeve is still in position on the roll pin in the bottom of the block and tube assembly bore, proceed to step (6). If the flow sleeve has shifted position or has been removed, it must be repositioned using service tool, (Part Number 01949), Sleeve Installation Wrench.

4. Insert the flow sleeve into the block and tube assembly slotted end first. Note position of the doweling hole in the end of the flow sleeve and the pin in the bottom of the block and tube bore. Align these features as the flow sleeve is inserted.

5. Place the projection on the end of service tool, (Part Number 01949), Sleeve Installation Wrench in the slot on the end of the face of the flow sleeve. Push the flow sleeve into place, rotating back and forth as required to align the pin, until the groove in the installation wrench is flush with the end of the block and tube assembly.

IMPORTANT

Do not force the flow sleeve into place or attempt further assembly without the flow sleeve in the proper position.

6. Insert the oil tube (small end first) into the counterbored end of the back sleeve. Loosely thread, (Part Number 01120), Tamper Sleeve Tool into the oil tube thread. Place a new o-ring into the groove on the end face of the oil tube and retained with grease. Replace the two oil control seals in the grooves of the back sleeve (grooves with multiple holes).

7. Slide this entire assembly into the flow sleeve, and remove the Tamper Sleeve Tool by pushing firmly as you rotate it counterclockwise.

8. Insert the piston (tapered end first) into large end of the front sleeve. (The four grooves on the front sleeve 0.0. are towards the large end of the piston.)

Insert this assembly into the flow sleeve using your fingers to push the front sleeve into place. (The hollow end of Part Number 01120 Tamper Sleeve Tool may be used to push the front sleeve into place.)

9. Install the bridge, washer (beveled side out) over the piston and against the front sleeve and flow sleeve faces.

10. Replace the seals in the nose as follows:

a. Press the rod seal (lip side in) into the lower end of the nose. Make sure the seal is positioned against the inner shoulder of the nose.

b. Install the seal washer in the nose. Push it firmly against the rod seal.

c. Secure the rod seal and seal washer in place by installing the spirolox retaining ring.

d. Install the felt washer in the nose, then install the rod wiper (lip side out). The edge of the wiper must be flush with the end of the nose.

e. Install the 1/8 x 1 inch/3 mm x 25 mm 1.0. o-ring and cushion, chamfered/notched side out, into the counter-bore on the threaded end.

f. Install the 1/16 x 1-3/4 inch/1.5 mm x 44.5 mm I.D. o-ring in the outside groove of the nose.

11. Install the nose, as assembled above, over the piston and screw into the block and tube assembly and tighten securely.

12. Replace the jam nut and tighten securely.

13. Install the tamper shoe on the piston rod and secure with the 7/16-20 x 1-1/2 inch/38 mm long capscrew.

VALVE ASSEMBLY

1. Mid-valve Tampers.

a. Replace the o-rings within the spool bore.

b. Attach the valve spool to the trigger using a 1/8 x 7/8 inch/3 mm x 22 mm roll pin.

c. Place the valve spring over the valve spool and lubricate its O.D.

d. Push the valve spool through the trigger side of the valve body bore, and secure the trigger to the valve body with a 5/32 inch diameter x 1 inch/4 mm x 25 mm roll pin through the trigger pivot.

e. Depress the trigger and place a small drop of #242 Loctite on the thread of the button head machine screw and tighten securely into the valve spool.

IMPORTANT

Do not allow Loctite on the outside diameter of the valve spool.

2. Valve-in-handle Tampers.

a. Replace the o-rings within the spool bore.

b. Insert the valve spool assembly (small end first) through the valve body, from the side opposite the trigger.

c. Place the valve spring on the valve spool projecting through the trigger side, followed by the trigger.

d. Align the trigger with the corresponding holes in the valve body using a 1/8 inch or 5/32 inch/3 mm or 4 mm diameter punch, and drive the 5/32 inch/4 mm diameter roll pins into place.

HANDLE ASSEMBLY, OIL TUBES AND VALVE ASSEMBLY

1. No-Valve Tampers.

a. Insert the hose assembly through the tube end of the handle assembly, female fittings first.

b. Attach the hose assembly to the fittings on the block and tube assembly, attaching the hose painted red to the port marked “IN”.

c. Attach the handle assembly to the block and tube assembly with four 5/16-18 x 1-1/4 inch/32 mm long capscrews and washer.

d. Install hose guides and secure with the four oval head screws.

2. Mid-valve Tampers.

a. Insert plain ends of oil tubes into the tube fittings on the block and tube assembly and secure.

b. Install the handle assembly over the oil tubes and secure to the block and tube assembly with four 5/16-18 x 1-1/4 inch/32 mm long capscrews and lockwashers.

c. Place rubber tube retainer over the oil tubes. Make sure the tubes are not twisted.

d. Install new a-rings in the oil tube ports of the valve body.

e. Insert the valve assembly into the handle assembly making sure the oil tubes slide into the valve body ports.

NOTE:
The oil tube port opposite the trigger should connect the tube marked "IN" at the block and tube assembly.

f. Secure the valve assembly to handle assembly with the two 1/4-20 and two 5/16-18 flat head screws using #242 Loctite to secure the threads.

3. Valve-in-handle Tamper.

a. Insert the plain ends of the oil tubes into the tube fittings on the block and tube assembly.

b. Install the handle assembly over the oil tubes and secure to the block and tube assembly with four 5/16-18 x 1-1/4 inch/32 mm long capscrews and lockwashers.

c. Install new a-rings in the oil tube ports of the body.

d. Push the on-off valve assembly over the oil tubes until mating with the handle tube flare.

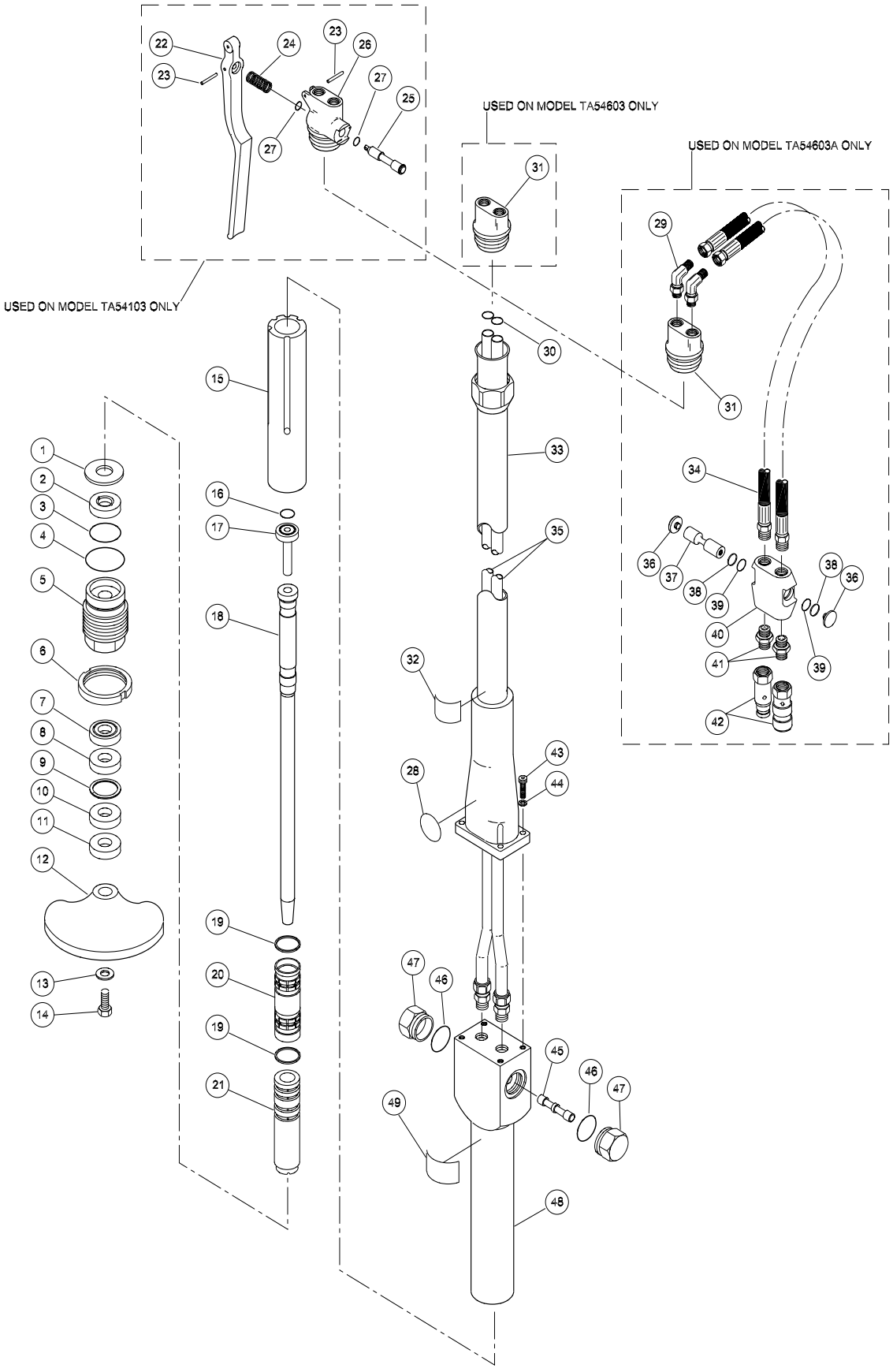
NOTE:
The pressure oil tube is located on the side opposite the trigger and should correspond to the "IN" port on the block and tube assembly.

e. Apply #242 Loctite to the valve body threads. Place a wrench across the flat area of the valve body and tighten the tube nut to 200 Ib ft/270 Nm with a 2-1/8 inch wrench. Slide the plastic cover in place over the tube nut.

IMPORTANT

Do not allow the valve body to rotate relative to the tamper lower assembly. This will avoid twisting the oil tubes inside the handle assembly.

PARTS ILLUSTRATION



PARTS LIST

ITEM	QTY	PART NO.	DESCRIPTION
1	1	01038	Thrust Bridge Washer
2	1	00823	Cushion
3	1	00834	O-ring
4	1	01262	O-ring
5	1	14883	Nose
6	1	01795	Jam Nut
7	1	14891	Seal
8	1	14884	Seal Washer
9	1	04902	Retaining Ring, Spirolox
10	1	08434	Felt Washer
11	1	15016	Rod Wiper
12	1	00833	Shoe
13	1	00825	Lockwasher
14	1	00845	Capscrew
15	1	01036	Flow Sleeve
16	1	00940	O-ring
17	1	00806	Oil Tube
18	1	14886	Piston
19	2	29690	Oil Control Seal
20	1	00927	Back Sleeve
21	1	01037	Front Sleeve
22	1	04525	Trigger (model TA54103 only)
23	1	00114	Roll Pin (model TA54103 only)
24	1	04097	Spring (model TA54103 only)
25	1	04480	Valve Spool (model TA54103 only)
26	1	04897	Valve Body Assy (model TA54103 only)
27	2	07627	O-ring
28	1	14908	Name Tag
29	2	350000	45° Elbow (model TA54603A only)
30	2	00175	O-ring
31	1	35036	Hose Block (models TA54603 & TA54603A only)
32	1	05152	Sticker, Stanley Logo
33	1	07737	Handle Assy (incl Jam Nut)
34	2	35784	Hose Assy (models TA54603A only)
35	2	07738	Oil Tube
36	2	01003	Button (model TA54603A only)
37	1	38631	Valve Spool (model TA54603A only)
38	2	13568	Back-up Ring (model TA54603A only)
39	2	13567	O-Ring (model TA54603A only)
		38632	In-line Valve Assy (incl items 36-40) (model TA54603A only)
40	1	38629	Valve Body Assy (model TA54603A only)
41	2	00936	Adapter (modelsTA54603A only)
42	1	24069	Coupler Set (model TA54603A only)
43	4	00144	Capscrew
44	4	00145	Lockwasher
45	1	00819	Reversing Spool
46	2	06533	O-ring
47	2	14882	End Cap
		14885	**Lower Tamper Assy (Incld items 1-11, 15-21, & 46-48)**
48	1	34684	Block & Valve Spool Housing
49	1	03783	Sticker, GPM

Seal Kit Part No. 02030
No Valve Model

Seal Kit Part No. 02032
Valve In Handle Model

ITEM NO.	PART NO.	QTY	DESCRIPTION
3	07245	1	Rod Seal
4	01262	1	O-Ring
7	14891	1	Seal
10	08434	1	Felt Washer
11	15016	1	Rod Wiper
16	00940	1	O-Ring
19	29690	2	Oil Control Seal
27	07627	2	O-Ring
30	00175	2	O-Ring
46	06533	2	O-Ring

WARRANTY

Stanley Hydraulic Tools (hereinafter called “Stanley”), subject to the exceptions contained below, warrants new hydraulic tools for a period of one year from the date of sale to the first retail purchaser, or for a period of 2 years from the shipping date from Stanley, whichever period expires first, to be free of defects in material and/or workmanship at the time of delivery, and will, at its option, repair or replace any tool or part of a tool, or new part, which is found upon examination by a Stanley authorized service outlet or by Stanley’s factory in Milwaukie, Oregon to be DEFECTIVE IN MATERIAL AND/OR WORKMANSHIP.

EXCEPTIONS FROM WARRANTY

NEW PARTS: New parts which are obtained individually are warranted, subject to the exceptions herein, to be free of defects in material and/or workmanship at the time of delivery and for a period of 6 months after the date of first usage. Seals and diaphragms are warranted to be free of defects in material and/or workmanship at the time of delivery and for a period of 6 months after the date of first usage or 2 years after the date of delivery, whichever period expires first. Warranty for new parts is limited to replacement of defective parts only. Labor is not covered.

FREIGHT COSTS: Freight costs to return parts to Stanley, if requested by Stanley for the purpose of evaluating a warranty claim for warranty credit, are covered under this policy if the claimed part or parts are approved for warranty credit. Freight costs for any part or parts which are not approved for warranty credit will be the responsibility of the individual.

SEALS & DIAPHRAGMS: Seals and diaphragms installed in new tools are warranted to be free of defects in material and/or workmanship for a period of 6 months after the date of first usage, or for a period of 2 years from the shipping date from Stanley, whichever period expires first.

CUTTING ACCESSORIES: Cutting accessories such as breaker tool bits are warranted to be free of defects in material and or workmanship at the time of delivery only.

ITEMS PRODUCED BY OTHER MANUFACTURERS: Components which are not manufactured by Stanley and are warranted by their respective manufacturers.

a. Costs incurred to remove a Stanley manufactured component in order to service an item manufactured by other manufacturers.

ALTERATIONS & MODIFICATIONS: Alterations or modifications to any tool or part. All obligations under this warranty shall be terminated if the new tool or part is altered or modified in any way.

NORMAL WEAR: any failure or performance deficiency attributable to normal wear and tear such as tool bushings, retaining pins, wear plates, bumpers, retaining rings and plugs, rubber bushings, recoil springs, etc.

INCIDENTAL/CONSEQUENTIAL DAMAGES: To the fullest extent permitted by applicable law, in no event will STANLEY be liable for any incidental, consequential or special damages and/or expenses.

FREIGHT DAMAGE: Damage caused by improper storage or freight handling.

LOSS TIME: Loss of operating time to the user while the tool(s) is out of service.

IMPROPER OPERATION: Any failure or performance deficiency attributable to a failure to follow the guidelines and/or procedures as outlined in the tool’s operation and maintenance manual.

MAINTENANCE: Any failure or performance deficiency attributable to not maintaining the tool(s) in good operating condition as outlined in the Operation and Maintenance Manual.

HYDRAULIC PRESSURE & FLOW, HEAT, TYPE OF FLUID: Any failure or performance deficiency attributable to excess hydraulic pressure, excess hydraulic back-pressure, excess hydraulic flow, excessive heat, or incorrect hydraulic fluid.

REPAIRS OR ALTERATIONS: Any failure or performance deficiency attributable to repairs by anyone which in Stanley’s sole judgement caused or contributed to the failure or deficiency.

MIS-APPLICATION: Any failure or performance deficiency attributable to mis-application. “Mis-application” is defined as usage of products for which they were not originally intended or usage of products in such a matter which exposes them to abuse or accident, without first obtaining the written consent of Stanley. PERMISSION TO APPLY ANY PRODUCT FOR WHICH IT WAS NOT ORIGINALLY INTENDED CAN ONLY BE OBTAINED FROM STANLEY ENGINEERING.

WARRANTY REGISTRATION: STANLEY ASSUMES NO LIABILITY FOR WARRANTY CLAIMS SUBMITTED FOR WHICH NO TOOL REGISTRATION IS ON RECORD. In the event a warranty claim is submitted and no tool registration is on record, no warranty credit will be issued without first receiving documentation which proves the sale of the tool or the tools’ first date of usage. The term “DOCUMENTATION” as used in this paragraph is defined as a bill of sale, or letter of intent from the first retail customer. A WARRANTY REGISTRATION FORM THAT IS NOT ALSO ON RECORD WITH STANLEY WILL NOT BE ACCEPTED AS “DOCUMENTATION”.

NO ADDITIONAL WARRANTIES OR REPRESENTATIONS

This limited warranty and the obligation of Stanley thereunder is in lieu of all other warranties, expressed or implied including merchantability or fitness for a particular purpose except for that provided herein. There is no other warranty. This warranty gives the purchaser specific legal rights and other rights may be available which might vary depending upon applicable law.

STANLEY®

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