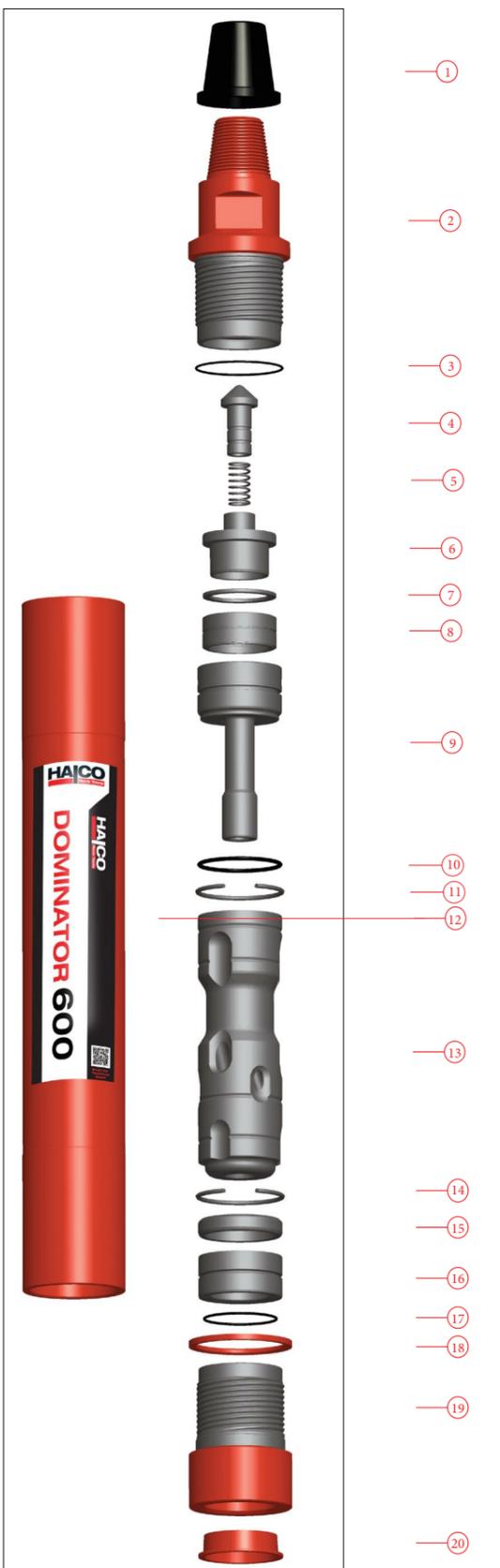


# DOMINATOR 600 MAINTENANCE SHEET - HOW TO ASSEMBLE



**A.** Before assembly ensure that all components are cleaned, greased and lubricated. Lay out components in the order of the illustration above for ease of identification.



**B.** Secure Cylinder (12) on a bench or suitable stripping equipment. The cylinder is not reversible and the bottom of the hammer is the cylinder end where the internal snap ring groove is nearest the cylinder threads, The top of the hammer is cylinder end with machined flats.



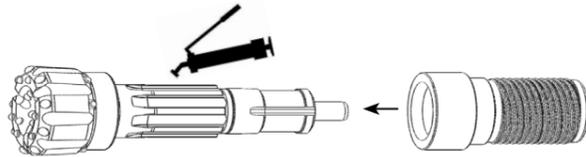
**C.** Insert Snap Ring (14) into bottom of Cylinder (12). Ensure that it sits in the snap ring groove.



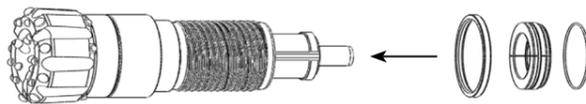
**D.** Insert Bottom Spacer (15) into bottom of Cylinder (12). Ensure it sits up against Snap Ring (14).



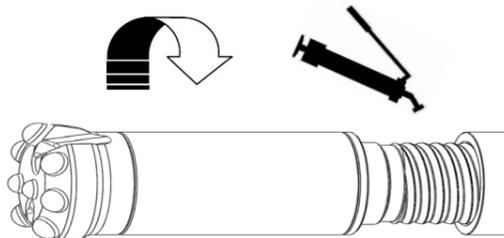
**E.** Grease Splines and fit Chuck (19).



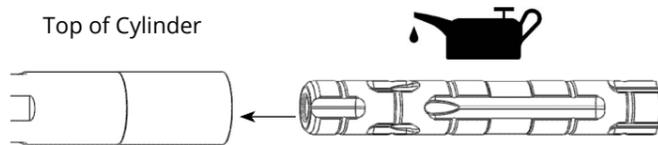
**F.** Fit Chuck Spacer (18) over Chuck (19). Fit 'O'Ring (17), ensure it sits in the 'O' Ring groove. Fit Bit Retaining Ring (16) onto Drill Bit.



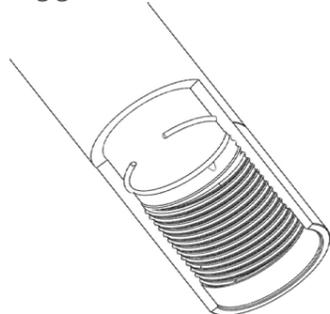
**G.** Grease threads and screw the Drill Bit, Chuck (15), Chuck Spacer (14) and Bit Retaining Ring (13) into the bottom of the Cylinder (12) until fully tightened.



**H.** Coat Piston (13) liberally with rock oil - minimum 200 centistroke and insert into the top of the Cylinder (12). Ensure that the Piston is inserted the right way around - as illustrated below.



**I.** Insert Snap Ring (11) into top of Cylinder (12). Ensure it sits in the snap ring groove.

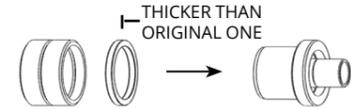


**J.** Fit 'O' Ring (10) onto Air Distributor (9) and inset into Cylinder (12) so that it sits against Snap Ring (11).

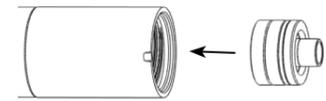


## SETTING CORRECT TOLERANCES

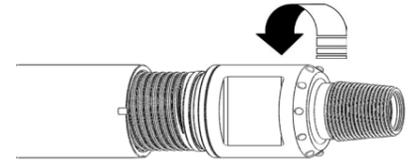
**K.** Fit a Shim (7), thicker than the one taken from the hammer, onto the N.R.V. Housing (6). Fit Compression Ring (8) onto N.R.V. Housing (6). Ensure it is assembled in the same sequence as originally fitted.



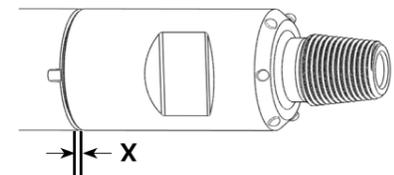
**L.** Insert N.R.V. Housing (6), Shim (7) and Compression Ring (8) into top of Cylinder (12).



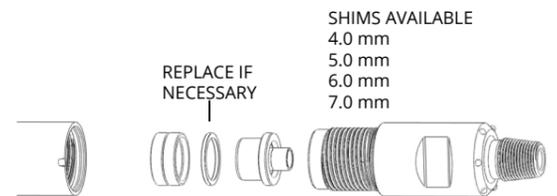
**M.** Screw Top Adaptor (2) into Cylinder (12) and hand tighten.



**N.** Measure make up gap 'X' between Cylinder (12) and Top Adaptor (2). Correct make up gap should be between 2.0mm - 3.0mm (0.079" - 0.157").

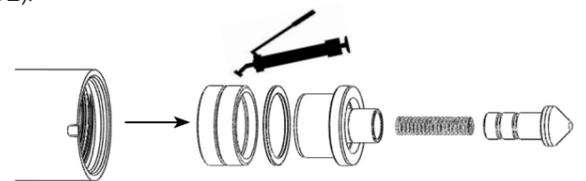


**O.** Unscrew and remove Top Adaptor (2), N.R.V. Housing (6), Shims (7) and Compression Spring (8). Replace shimming in order that the make up gap falls between the minimum and maximum figures.

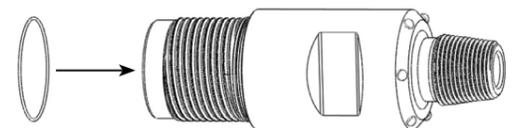


## FINAL ASSEMBLY

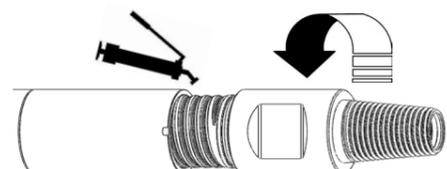
**P.** Fit N.R.V. Spring (5), N.R.V. (4), necessary Shims (7) and Compression Spring (8) onto N.R.V. Housing (6). Grease Compression Spring (8) and insert into top of Cylinder (12).



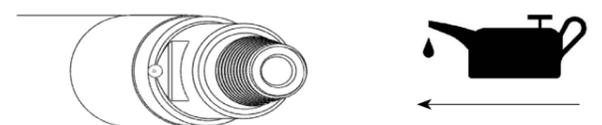
**Q.** Fit 'O' Ring (3) onto Top Adaptor (2). Ensure it sits in the 'O' Ring groove.



**R.** Grease threads and screw Top Adaptor (2) into Cylinder (12) until fully tightened.



**S.** Depress N.R.V (4) and pour 1/3 litre of air line oil into the hammer.



If you need further assistance, please call us on:  
(0)1422 399900 or email [salesuk@halcorocktools.com](mailto:salesuk@halcorocktools.com)

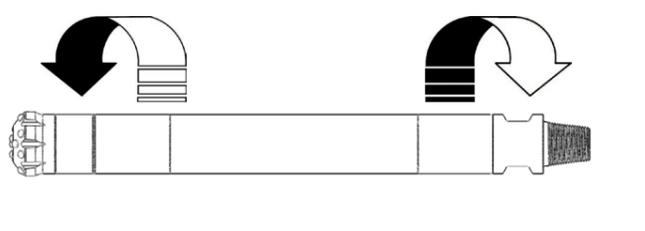
**HAJCO**  
Rock Tools

# DOMINATOR 600 MAINTENANCE SHEET - HOW TO DISMANTLE

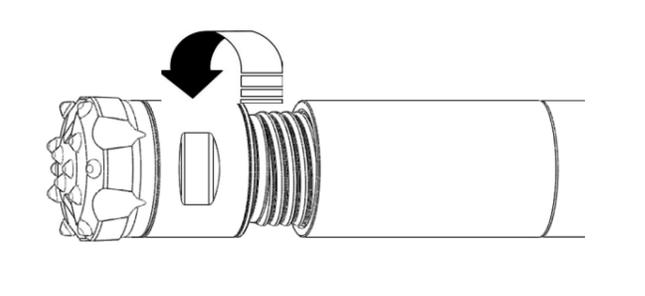


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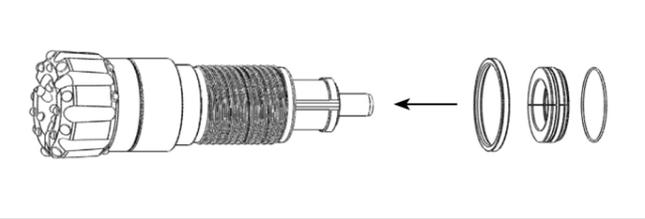
**B.** Break the top joint between Cylinder (12) and Top Adaptor (2) and bottom joint between Cylinder (12) and Chuck (19).



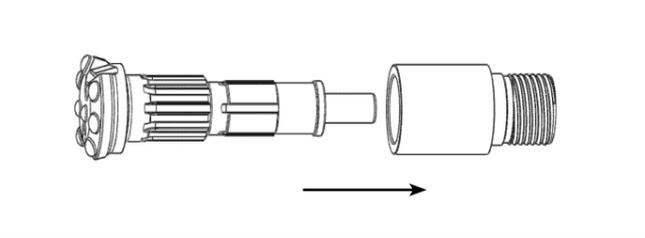
**C.** Unscrew and remove the Drill Bit, Chuck (19), Chuck Spacer (18) and Bit Retaining Ring (16) from Cylinder (12).



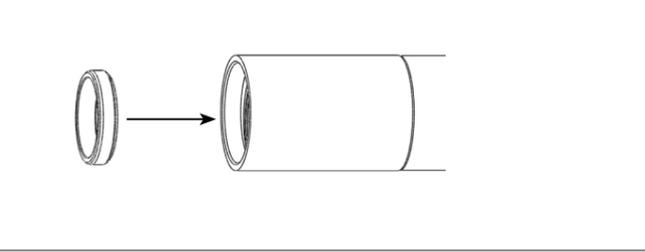
**D.** Remove Chuck Spacer (18) from the Chuck (19). Remove Bit Retaining Ring (16) from Drill Bit. Remove 'O' Ring (17) from Bit Retaining Ring (16).



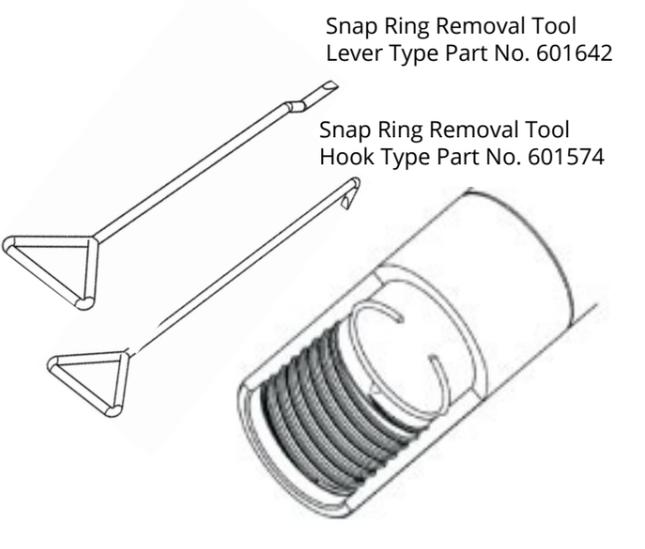
**E.** Remove the Chuck (19) from the Drill Bit.



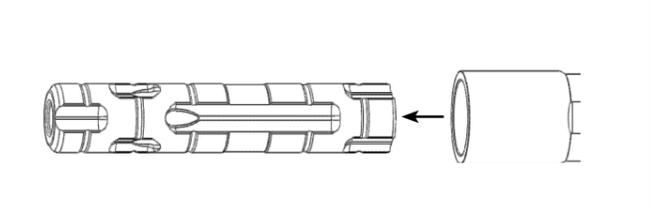
**F.** Remove Bottom Spacer (15) from Cylinder (12).



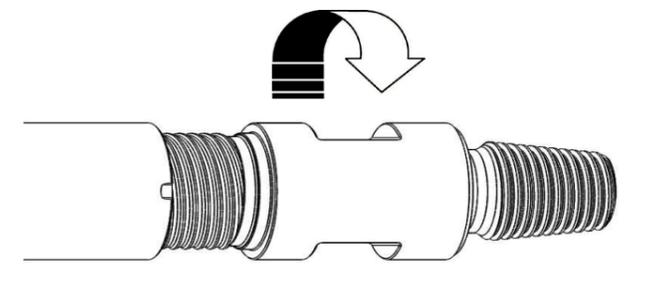
**G.** Remove Snap Ring (14) from the Cylinder (12) using the tools illustrated below.



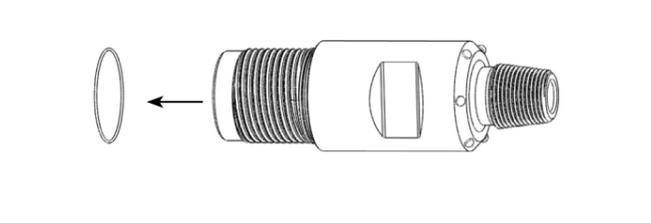
**H.** Remove Piston (13) from Cylinder (12).



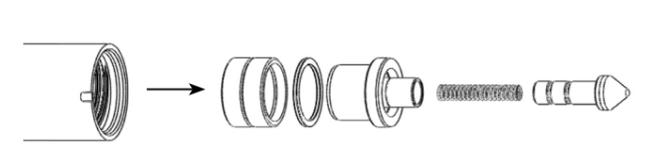
**I.** Unscrew and remove Top Adaptor (2) from the Cylinder (13).



**J.** Remove 'O' Ring (3) from the Top Adaptor (2).



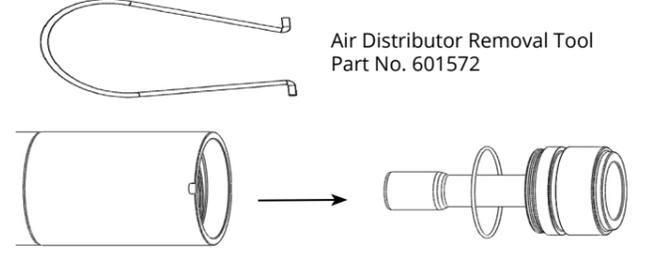
**K.** Remove N.R.V. Assembly (4-8) from Cylinder (12).



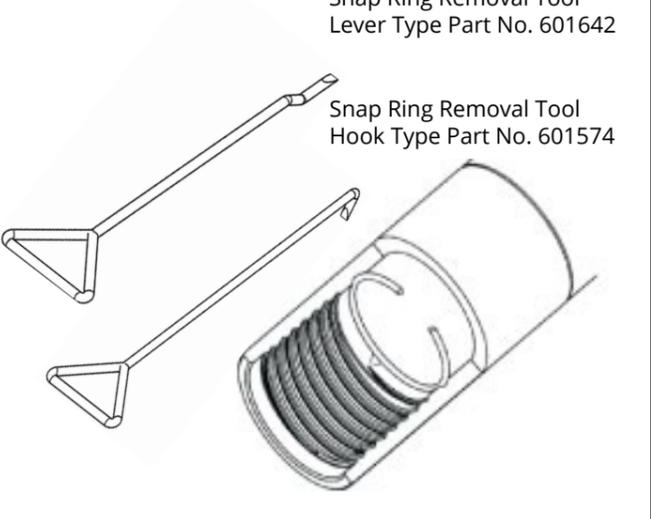
**NOTE!**  
Ensure that eye protection is worn when removing Compression Spring (8). Remove with great care as the component may spring apart without warning if dropped. If removed intact secure with wire or string before separating.



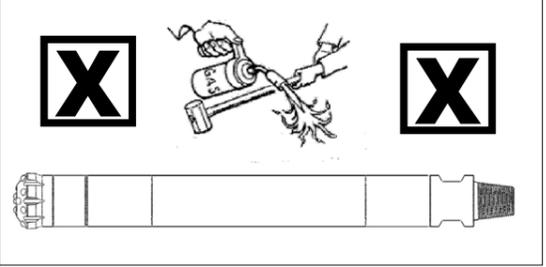
**L.** Remove Air Distributor (9) from Cylinder (12) using the tool illustrated below. Remove 'O' Ring (10) from Air Distributor (9).



**M.** Remove Snap Ring (11) from the Cylinder (12) using the tools illustrated below.



**DO NOT** apply heat or direct impact to the outside of the hammer as this usually damages the equipment.



**A.** When dismantling hammers it is essential that cylinders are clamped into the correct position, away from threads, which can be damaged.

