Rephasing Cylinders

Overview & Principles of Rephasing

A **Rephasing Cylinder System** enables a pair (or multiple) cylinders to extend and retract in very near unison.

Rephasing is accomplished by using a rephasing passageway which is located at the position of full extension. Many design techniques accomplish this but in simplicity, the ***rephasing passageway*** allows a small amount of hydraulic fluid to bypass the cylinder piston in the fully extended position ultimately allowing the cylinders to rephase.

This feature allows the cylinders to be aligned during set up and ***rephased*** in the event of oil leakage/by-pass during usage or after service work.

A rephasing cylinder system will consist of a master cylinder and 1 or more slave cylinders. These cylinders operate evenly to raise and lower the implement to the desired working depth.

Bleeding Air & Rephasing Function

Rephasing cylinder lift systems should be ***rephased*** periodically to purge any air that may be ingested into the system over time and/or compensate for drift due to system leakage.

To rephase the system, with the cylinder fully extended, actuate the cylinder valve for 30 seconds, or 5-10 seconds if you rephase often.

In a new rephasing circuit, a much longer time of maintaining a fully extended sequence may be required to bleed excessive air out of the circuit and may have to be repeated several times.

⚠ **IMPORTANT:** *A rephasing cylinder circuit utilizes positive-displacement that effectively transfers power between cylinders, with the possibility of increasing internal pressures from cylinder to cylinder. Intensification occurs in hydraulic cylinders when there is pressure supplied to the full bore end of the hydraulic cylinder (extension) but the rod end (retraction) port becomes blocked or under excessive load. Pressure intensification may cause pressures to exceed the working pressure ratings of the cylinders themselves, or other components within the system. Safety awareness and caution should be taken to identify signs or causes of potential pressure build-up in the circuit.*

Troubleshooting

Series rephasing cylinder systems *(Master and Slave(s))* can exhibit undesirable behaviors such as ***creep*** *(drift or movement when the hydraulic cylinder is not in use)* or ***failing to stay synchronized*** *(not extending and retracting at the same rate).*

Below is a brief overview of some of the possible conditions that contribute to cylinder creep, drift or the series cylinder getting out of sync. Keep in mind that the cylinders are only part of the hydraulic circuit and there can be other contributing causes.

Cylinder rod measurement method:

Cylinder by-pass is a common field issue in series cylinder systems, and a systematic review is required to determine the problem.

- Extend the cylinders fully to the re-phasing position, then retract approximately 2+ inches away from the rephasing position.
- Immediately disconnect the hydraulics from tractor.
- Measure the length of the extended cylinder rod on each cylinder.
- Leave implement to stand for some an extended period of time, i.e. 3 hours.
- Re-measure length of rods again and compare before and after measurements.

  Please note: Variation can be expected if the implement is left over a time where the temperature change affects the hydraulics by contraction or expansion. Warm to cooler temperatures will cause the series cylinders to move. Make sure measurements are taken at similar temperatures.
- When the 'suspect' cylinder has been identified, disassembly must be carried out in a clean environment. The scoring of barrels and piston seals will usually indicate contamination of some type has entered the system.

Air in the system:

If one or all of the cylinders drift or the system is 'spongy' air is likely entrained in the system. Check for air bubbles going back to the tank or by removing the return line and catching oil in a clean container. With the rod clevises disconnected and the cylinders horizontal (ports at 12 o'clock) or vertical, hold in the re-phasing position until no aerated oil flows.

Please note: Check the reservoir levels when carrying out this exercise. Once the air has been pushed out of the system the reservoir can become low. This can introduce air into the system again.