

1. Install O-ring seal (42) onto plug (40).



Illustration 2

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2. Install plug (40). Tighten plug (40) to a torque of 10 ± 1 N.m (89 ± 9 lb in).
3. Install O-ring seals (39) and (41) onto the valve body.



Illustration 3

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4. Install plug (38). Tighten plug (38) to a torque of 35 ± 4 N·m (26 ± 3 lb ft).
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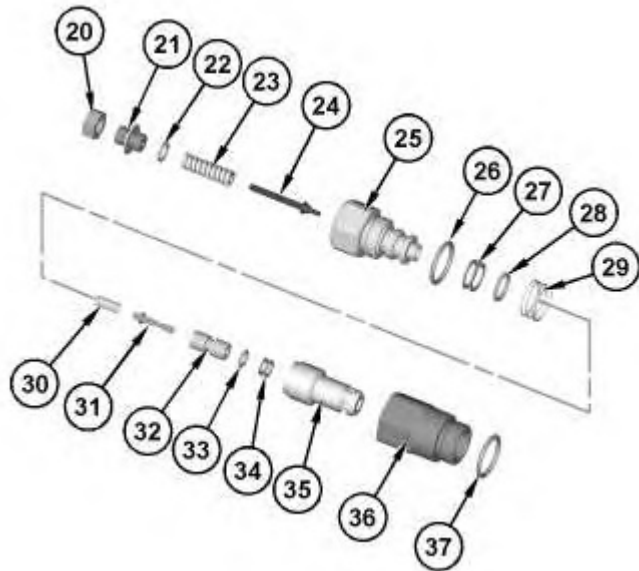


Illustration 4

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 **WARNING**

Improper assembly of parts that are spring loaded can cause bodily injury.

To prevent possible injury, follow the established assembly procedure and wear protective equipment.

5. Install O-ring seal (37) onto body (36).
6. Install O-ring seal (33) and backup rings (34) onto valve (32).
7. Install O-ring seal (26), backup rings (27), and O-ring seal (28) onto body (25).
8. Install O-ring seal (22) onto screw (21).
9. Install valve (35), valve (32), plunger (31), spring (30), spring (29), body (25), plunger (24), spring (23), screw (21), and nut (20) into body (36). Tighten body (25) to a torque of 101 ± 10 N.m (74 ± 7 lb ft). Tighten nut (20) to a torque of 19.6 ± 2.0 N.m (173.5 ± 17.7 lb in).



Illustration 5

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10. Install relief valve (19) into the valve body. Tighten relief valve (19) to a torque of $95 \pm 14 \text{ N}\cdot\text{m}$ ($70 \pm 10 \text{ lb ft}$).

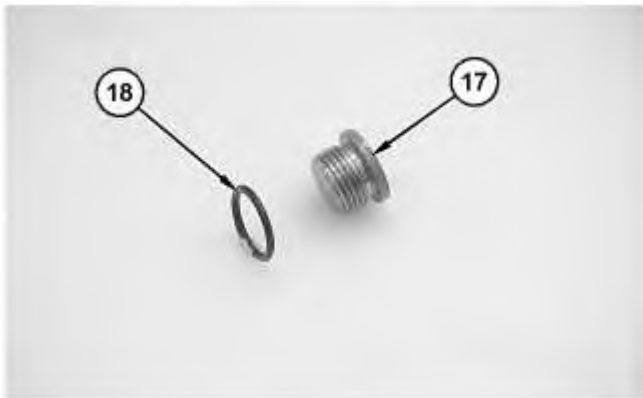


Illustration 6

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Illustration 7

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11. Install O-ring seal (18) onto plug (17).
12. Install plug (17). Tighten plug (17) to a torque of $40 \pm 7 \text{ N}\cdot\text{m}$ ($30 \pm 5 \text{ lb ft}$).

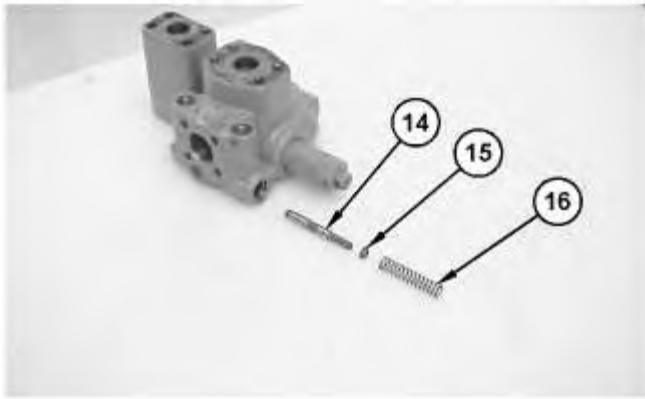


Illustration 8

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13. Install spool (14), guide (15), and spring (16) into the valve body.

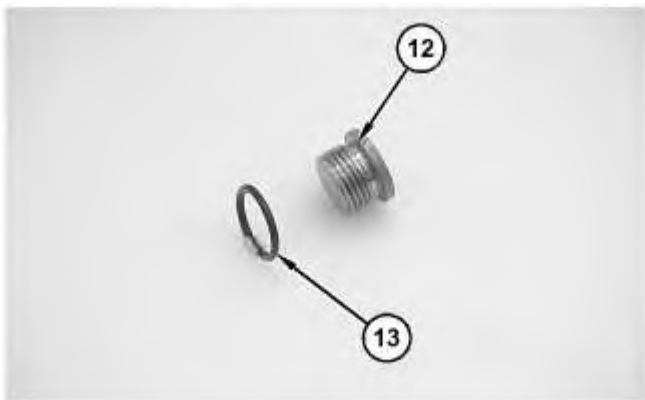


Illustration 9

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Illustration 10

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14. Install O-ring seal (13) onto plug (12).



WARNING

Improper assembly of parts that are spring loaded can cause bodily injury.

To prevent possible injury, follow the established assembly procedure and wear protective equipment.

15. Install plug (12). Tighten plug (12) to a torque of 50 ± 7 N·m (37 ± 5 lb ft).

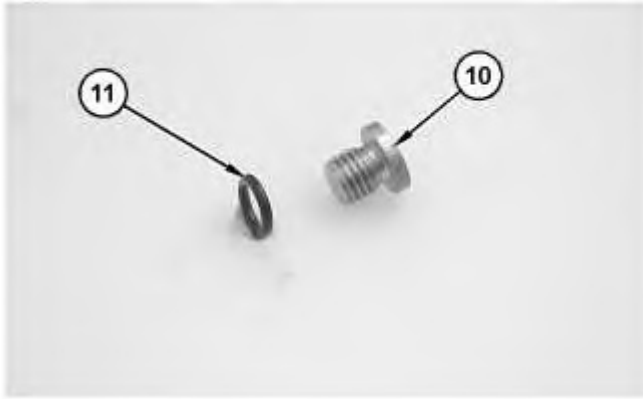


Illustration 11

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Illustration 12

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16. Install O-ring seal (11) onto plug (10).
17. Install plug (10). Tighten plug (10) to a torque of 10 ± 1 N.m (89 ± 9 lb in).
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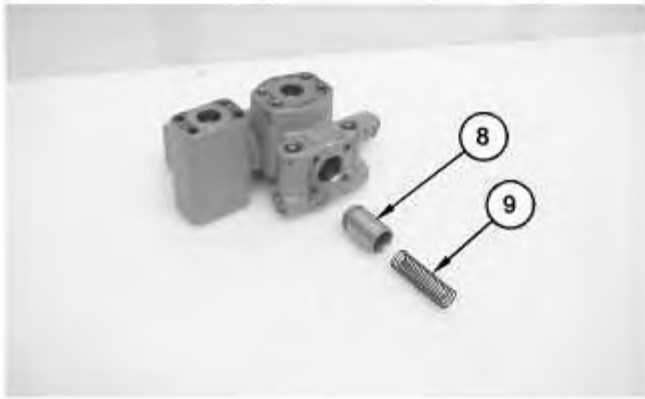


Illustration 13

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18. Install spool valve (8) and spring (9) into the valve body.

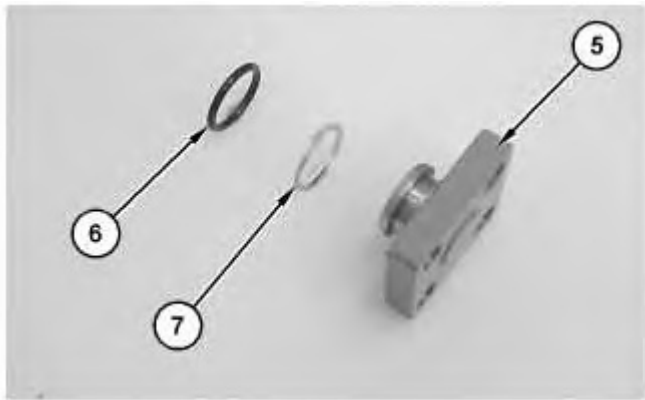


Illustration 14

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19. Lubricate backup ring (7) and O-ring seal (6) lightly with the lubricant that is being sealed. Install backup ring (7) and O-ring seal (6) onto cover (5).

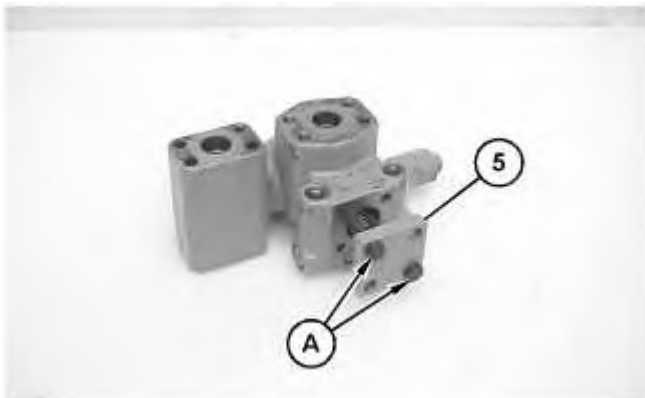


Illustration 15

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