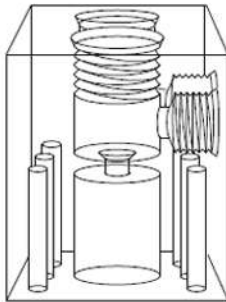
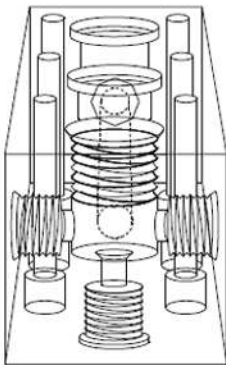
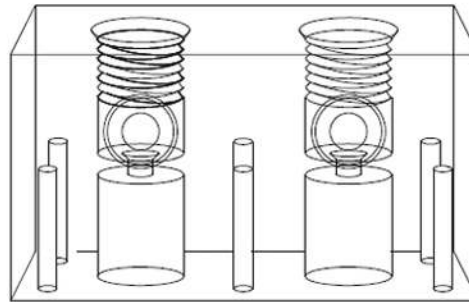


TGT-SV3-8 Valve Body Assembly

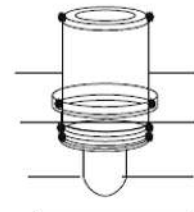
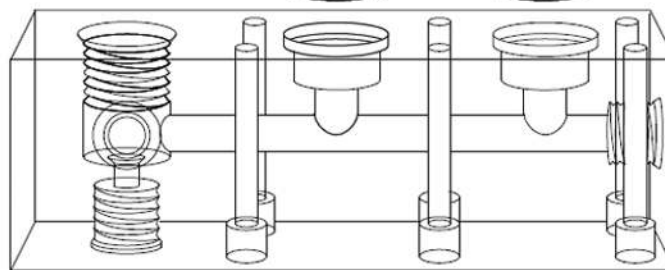
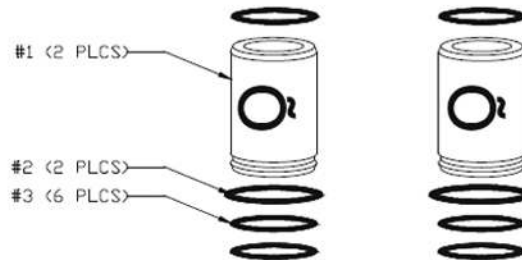
1. Clean and prep the two body halves.
2. Install the two upper & two lower o-rings (rings 2 & 3) using a small amount of lubrication.
3. Install o-ring #1 on check valve. Note: When installing check valve into lower body half be sure not to cut o-ring. Use small amount of lube on all o-rings.
4. Install check valve with arrow pointing at lower body.
5. Slide o-ring #4 over check valve and into o-ring gland in lower body.
6. Side the body halves together and install Allen head Torque Bolt® 25 Ft Lbs or 35 Newton meter.
7. Repeat Torque



End View

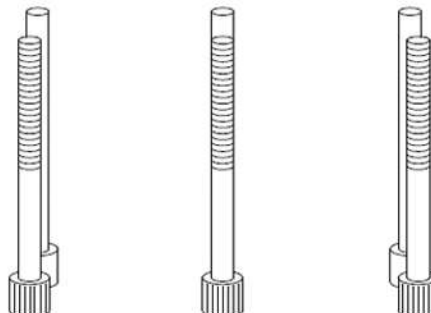
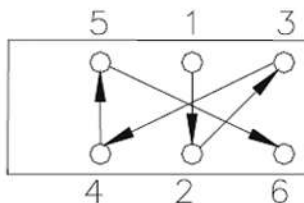


End View



Black dots indicate o-ring locations.

1	CHECK VALVE	VFP-2210D-3-5
2	O-RING	2-121-V75
3	O-RING	2-020-V90



FIELD ASSEMBLY REPAIR		
NO.	DESCRIPTION	PART NO.
1	VALVE BODY	PRC-1-6
2	PISTON	MM-1-1
3	PISTON RINGS	SC-688-584 GF-TFE
4	O-RING	SC-3-912-V90
*5	CYLINDER	PRC-1-1
6	O-RING	SC-2-016-V90
7	ARMATURE	PFG-1-1
8	PILOT NEEDLE	MM-3-1
9	PILOT SPRING	PFG-1-2
10	O-RING	SC-2-019-V90
*11	STEM	PFG-1-3
12	COIL	PFG-1-4
13	WASHER	PFG-1-5
14	NUT	PFG-1-6

* Torque #5 Cylinder to 85 ft/lbs

* Torque #11 Stem to 12.5 ft/lbs with Anti-Seize Lubricant
Torque Inlet and Outlet Fittings to 27 ft/lbs

FIELD ASSEMBLY INSTRUCTIONS

1. INSTALL PISTON RINGS ON TO THE PISTON;
ROTATE END GAPS 180 DEGREES FROM EACH OTHER.
2. INSTALL PISTON IN CYLINDER.
3. ROLL ON THE LARGE O-RING (#4). USE
MODERATE AMOUNT OF O-RING LUBRICATION
(TOO MUCH CAN CAUSE THE O-RING TO HYDRAULIC
OUT OF THE GLAND WHEN TORQUING THE CYLINDER.)
4. TORQUE THE CYLINDER (#5) TO 85 FOOT POUNDS.
5. INSTALL THE SMALL O-RING (#6) INTO THE RING
GLAND ON THE TOP OF THE CYLINDER.
6. INSTALL THE PILOT NEEDLE INTO THE
ARMATURE WITH THE RUBBER TIP FIRST.
7. INSTALL THE SPRING ON TOP OF PILOT NEEDLE.
8. HOLD THE ARMATURE ASSEMBLY WITH THE NEEDLE
DOWNWARD AND SLIDE THE STEM DOWN OVER THE
ARMATURE.
9. TURN THE STEM ASSEMBLY OVER WITH THE RUBBER
TIP UPWARD.
10. SET THE MIDDLE SIZED O-RING (#10) ON THE
TOP OF THE STEM ASSEMBLY.
11. HOLD THE STEM ASSEMBLY UPWARD AND TURN OVER
THE VALVE BODY ASSEMBLY, MAKING SURE THE
O-RING STAYS IN THE GLAND.
12. THREAD THE VALVE BODY ON TO THE STEM
ASSEMBLY UNTIL THE STEM IS BOTTOM OUT.
13. TORQUE THE STEM TO 12.5 FOOT POUNDS.
14. INSTALL THE VALVE BODY ASSEMBLY TO THE
COIL AND THREAD ON THE NUT.
15. TORQUE THE NUT SO THAT THE COIL CAN BE
TURNED BY HAND.

