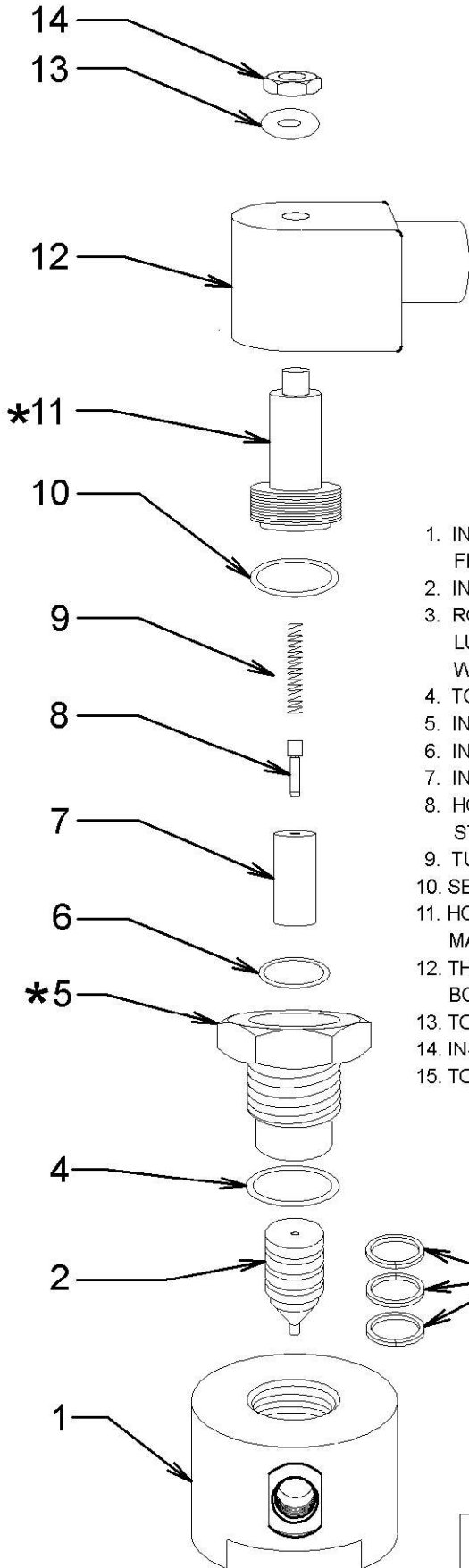


* Torque # 5 CYLINDER to 85 ft/lbs
 * Torque # 11 STEAM to 12.5 ft/lbs with ONE DROP OF #242 Loctite
 Torque Inlet and Outlet Fittings to 27ft/lbs

Field Assembly Repair

NUMBER	DESCRIPTION	PART No.
1	VALVE BODY	PRC-1-6
2	PISTON	MM-1-1
3	PISTON RINGS	MM-2-1
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



FIELD ASSEMBLY INSTRUCTION

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 A 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 ON 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.