

POPPET SEAT SETTING PROCEDURE

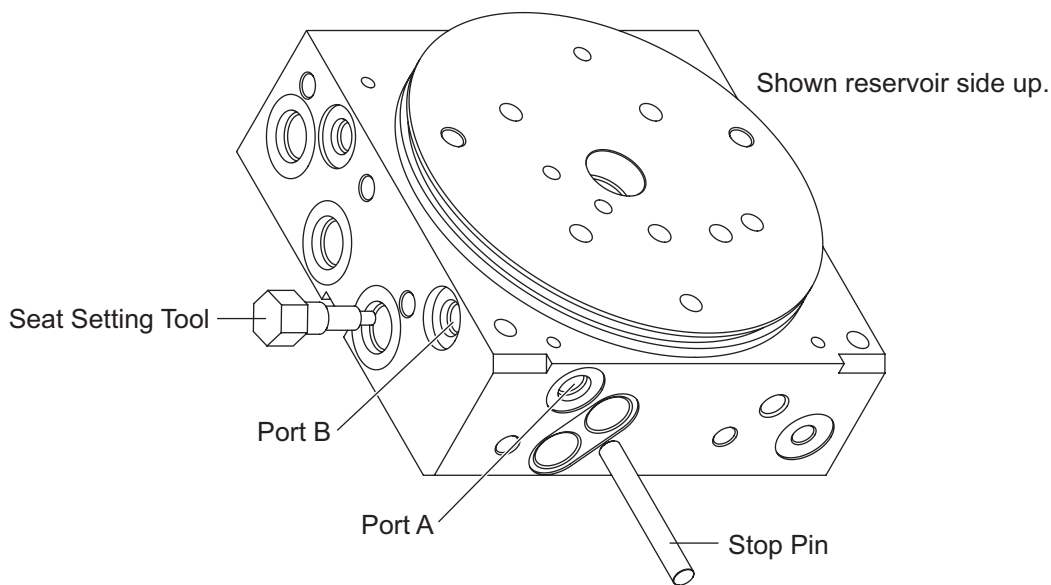
NOTE: Be certain that the hydraulic unit is free of pressurized fluid before beginning this procedure. Loosen plugs slowly to bleed out any residual pressure.

1. Remove boss plug, spring and poppet from port B.
2. Remove boss plug, spring and spool assembly from port A.
3. Insert the stop pin as deep into port A as it will go. Do not use force.
4. Install the seat setting tool into port B. Turn it in without a wrench until it stops.

5. While holding the stop pin in port A, rotate the pin while turning the seat setting tool into port B with a box wrench. When you feel the seat setting tool contact the stop pin, stop tightening.

NOTE: DO NOT OVER TIGHTEN. Once the seat setting tool interferes with the rotation of the stop pin, stop tightening. If you over tighten the seat setting tool against the stop pin, you could damage port A and set the poppet seat too deep, which would downgrade the performance of your hydraulic unit.

6. Assembly is opposite of disassembly. Tighten plugs to 55-65 in/lbs.



The company reserves the right under its product improvement policy to change construction or design details and furnish equipment when so altered without reference to illustrations or specifications used.