

Circle Turn Valve

Service Instructions

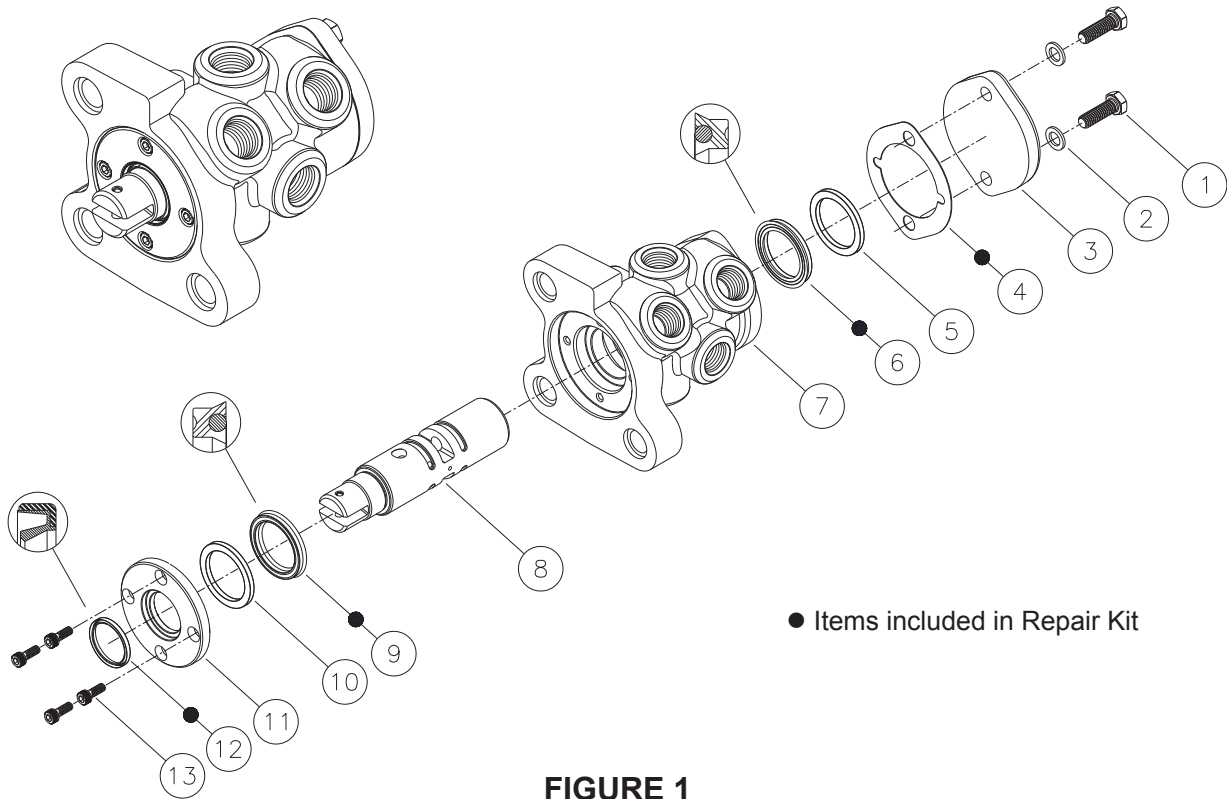


FIGURE 1

DISASSEMBLY

(Refer to Figure 1)

1. Refer to machine manufacture service manual to remove the circle turn valve from the machine.
2. Remove four socket head cap screws (13) attaching end cap (11) to housing (7).
3. Remove end cap (11) from spool (8) and housing (7).
4. Inspect seal (12) in end cap (11). If replacement is necessary remove with a screwdriver or some other bladed tool. **NOTE: Be careful not to damage seal surfaces on end cap (11).**
5. Remove spool (8), cup (9), and washer (10) as an assembly through open end of housing (7).
6. Remove cup (9) and washer (10) from spool (8).
7. Remove two cap screws (1) and two washers (2) attaching cover (3) and gasket (4) to housing (7).
8. Remove washer (5) and cup (6) from housing (7).

ASSEMBLY

(Refer to Figure 1)

WASH ALL PARTS WITH CLEAN SOLVENT AND DRY. LUBRICATE ALL RUBBER PARTS FROM REPAIR KIT WITH CLEAN SYSTEM FLUID PRIOR TO ASSEMBLY. BE SURE ENTIRE ASSEMBLY PROCEDURE IS DONE USING CONTAMINATION FREE METHODS.

1. Lubricate housing (7) bore and spool (8) with clean type fluid used in the system.

2. Install new cup (6) and washer (5) into housing (7). Note direction of cup (6).
3. Install new gasket (4) and cover (3) using two cap screws (1) and two washers (2). **NOTE: Apply two drops of Loctite #242 to threads.** Torque cap screws (1) 24.4-29.8 N·m (18-22 lb·ft).
4. Install spool (8) into housing (7) bore until contacting cup (6). **NOTE: Do not fully seat spool at this time.**
5. Install new cup (9) and washer (10) on spool (8) and seat in housing (7) counterbore using proper sleeve and arbor press if available. Otherwise carefully work outer lip of cup into housing counterbore until seated using a brass tool to compress lip. Note direction of cup (9).
6. Rotate spool (8) by hand and apply force until spool (8) bottoms against cover (3). **NOTE: Spool rotation and proper lubrication are important to avoid damage to cup (6).**
7. Install new seal (12) in end cap (11) if removed during disassembly. Note direction of seal (12). **NOTE: Be careful not to damage seal surfaces on end cap (11).**
8. Install end cap (11) over spool (8) and in housing (7) using four socket head cap screws (13). **NOTE: Apply two drops of Loctite #242 to threads.** Torque screws (13) 5.1-5.7 N·m (45-50 lb·in).
9. Reinstall circle turn valve on the machine according to machine manufacture service manual.