

# RELAY VALVE



## Service Instructions

### DISASSEMBLY

(Refer to Figure 1)

1. Remove end plug (1) and spring (3) from housing (6). Remove o-ring (2) from end plug (1).
2. Separate housings (6 & 9) by removing cap screws (4) and washers (5). Remove o-ring (8) from housings (6 & 9).
3. Carefully remove spool (7) from housing (6).  
**NOTE: Be careful not to damage spool or housing bore.**

#### CAUTION

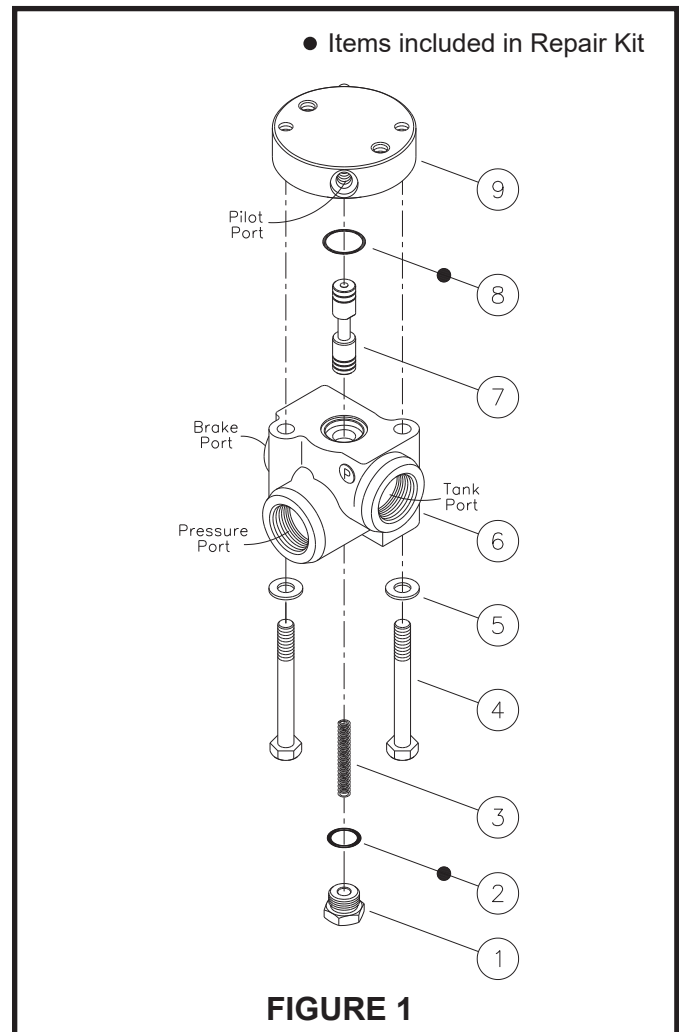
Do not intermix spools and housings. Spool (7) and housing (8) are manufactured as a matched set.

### ASSEMBLY

(Refer to Figure 1)

LUBRICATE ALL RUBBER COMPONENTS FROM THE REPAIR KIT WITH CLEAN TYPE FLUID USED IN THE SYSTEM.

1. Clean all parts thoroughly before assembling.
2. Lubricate spool (7) with clean system fluid and carefully slide into the top end of housing (6) bore. Note direction of spool (7). **NOTE: Spool must slide freely into bore. If either part is damaged, a new valve assembly may be required.**
3. Install new o-ring (8) in o-ring pocket on housing (6).
4. Reassemble housings (6 & 9) using cap screws (4) and washers (5). Use Loctite 242 on cap screws and torque 47.5-54.2 N·m (35-40 lb·ft).
5. Install new o-ring (2) on end plug (1).
6. Install spring (3) and end plug (1) in housing (6). Torque end plug (1) 47.5-54.2 N·m (35-40 lb·ft).



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