

INVERTED SHUTTLE VALVE



Service Instructions

Model Number	Repair Kit Number
03-463-200	06-400-224

NOTE: If your product number is not listed, contact ZF Off-Highway Solutions Minnesota Inc. for information.

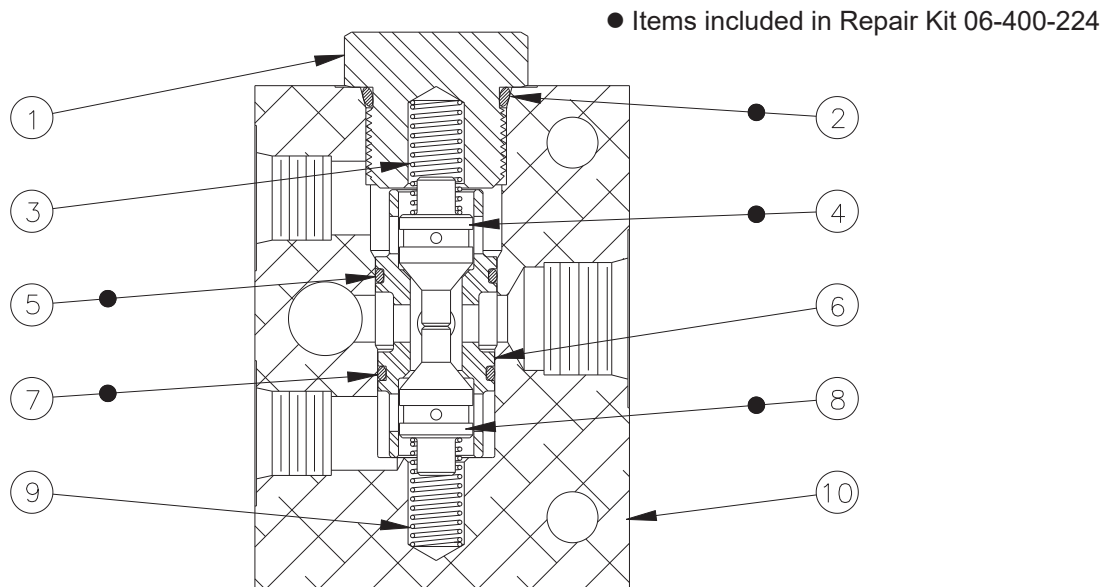
DISASSEMBLY

1. Remove end plug (1) from housing (10).
2. Remove o-ring (2) from end plug (1).
3. Remove spring (3) and poppet (4) from housing (10).
4. Using a brass hooked tool, carefully remove sleeve (6).
NOTE: Be careful not to scratch or mar sleeve (6) or housing (10) bore.
5. Remove o-rings (5 & 7) from sleeve (6).
6. Remove poppet (8) and spring (9) from housing (10).

ASSEMBLY

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

1. Clean all parts thoroughly before assembling.
2. Insert spring (9) into bottom of housing (10) bore. Center new poppet (8) in spring (9). Note direction of poppet (8).
3. Install new o-rings (5 & 7) on sleeve (6). Carefully insert sleeve (6) into housing (10) bore until it bottoms out.
4. Insert new poppet (4) into sleeve (6). Note direction of poppet (4).
5. Place spring (3) on end of poppet (4).
6. Install new o-ring (2) on end plug (1). Install end plug (1) in housing (10) and torque 40.7-67.8 N·m (30-50 lb·ft).



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