

Model Number	Repair Kit Number
03-463-208	06-400-302

# CHECK VALVE ASSEMBLY



## Service Instructions

### DISASSEMBLY

(Refer to Figures 1 and 2)

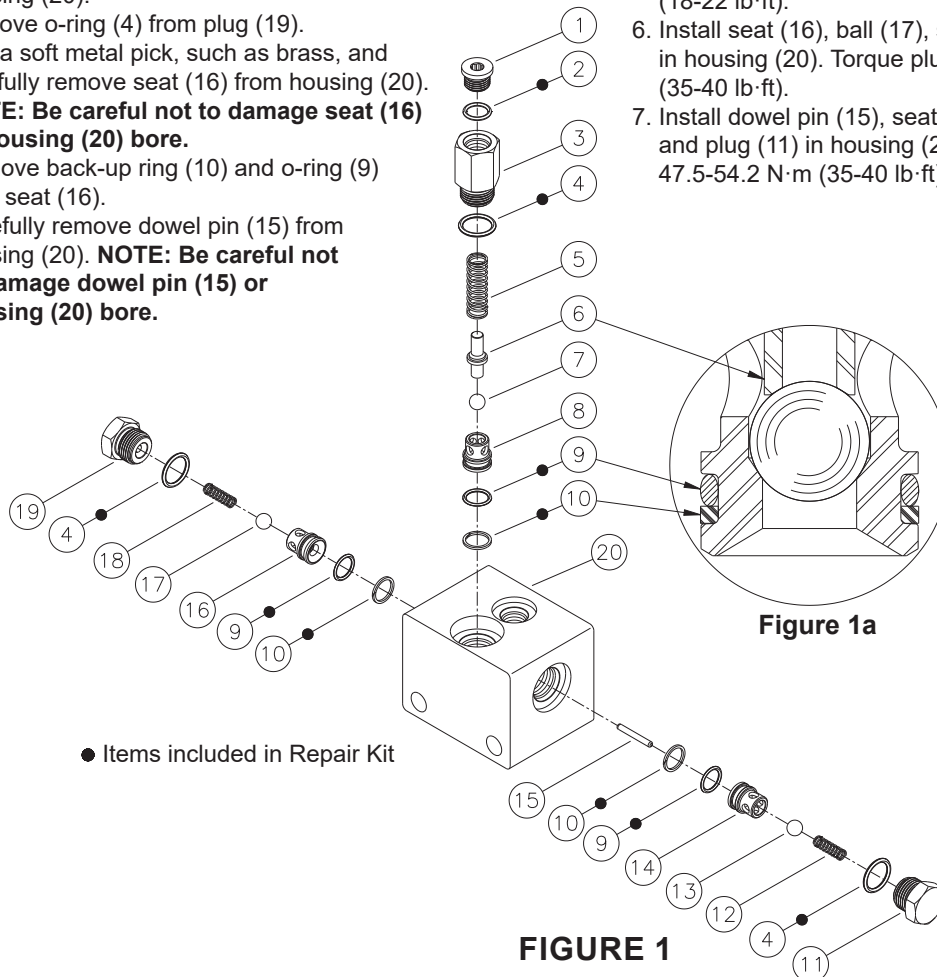
1. Remove plug (1) from plug (3). Remove o-ring (2) from plug (1).
2. Remove plug (3), spring (5), retainer (6), and ball (7) from housing (20).
3. Remove o-ring (4) from plug (3).
4. Use a soft metal pick, such as brass, and carefully remove seat (8) from housing (20). **NOTE: Be careful not to damage seat (8) or housing (20) bore.**
5. Remove back-up ring (10) and o-ring (9) from seat (8).
6. Remove plug (11), spring (12), and ball (13) from housing (20).
7. Remove o-ring (4) from plug (11).
8. Use a soft metal pick, such as brass, and carefully remove seat (14) from housing (20). **NOTE: Be careful not to damage seat (14) or housing (20) bore.**
9. Remove back-up ring (10) and o-ring (9) from seat (14).
10. Remove plug (19), spring (18) and ball (17) from housing (20).
11. Remove o-ring (4) from plug (19).
12. Use a soft metal pick, such as brass, and carefully remove seat (16) from housing (20). **NOTE: Be careful not to damage seat (16) or housing (20) bore.**
13. Remove back-up ring (10) and o-ring (9) from seat (16).
14. Carefully remove dowel pin (15) from housing (20). **NOTE: Be careful not to damage dowel pin (15) or housing (20) bore.**

### ASSEMBLY

(Refer to Figures 1 and 2)

WASH ALL PARTS THOROUGHLY WITH CLEAN SOLVENT AND ALLOW TO DRY. LUBRICATE ALL RUBBER COMPONENTS FROM REPAIR KIT WITH CLEAN TYPE FLUID USED IN THE SYSTEM. BE SURE THE ENTIRE ASSEMBLY PROCEDURE IS DONE USING CONTAMINATION FREE METHODS.

1. Install new o-rings (9) and new back-up rings (10) on seats (8, 14 & 16). Note order of o-ring and back-up ring. See Figure 2. **NOTE: Be careful not to damage seats.**
2. Install new o-rings (4) on plugs (3, 11 & 19).
3. Install new o-ring (2) on plug (1).
4. Install seat (8), ball (7), retainer (6), spring (5) and plug (3) in housing (20). Note, hole end of retainer faces ball. See Figure 1a. Torque plug (3) 47.5-54.2 N·m (35-40 lb·ft).
5. Install plug (1) in plug (3) and torque 24.4-29.8 N·m (18-22 lb·ft).
6. Install seat (16), ball (17), spring (18) and plug (19) in housing (20). Torque plug (19) 47.5-54.2 N·m (35-40 lb·ft).
7. Install dowel pin (15), seat (14), ball (13), spring (12), and plug (11) in housing (20). Torque plug (11) 47.5-54.2 N·m (35-40 lb·ft).



This publication is not subject to any update service. Information contained in this publication was in effect at the time the publication was approved for printing and is subject to change without notice or liability. ZF Off-Highway Solutions Minnesota Inc. reserves the right to revise the information presented or to discontinue the production of parts described at any time.

