

Single MODULATING VALVE

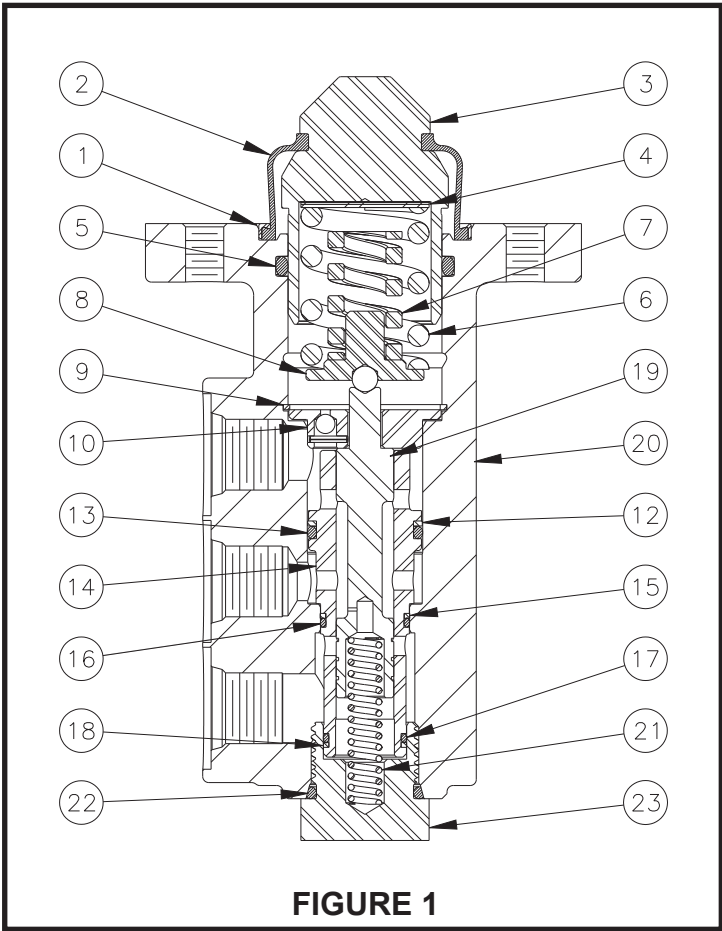


Service Instructions

TABLE 1 (Specifications)

Complete Unit Model Number	Valve Assembly Number	Repair Kit Number	Brake Pressure Setting	
			bar	(PSI)
06-464-942 (HO)	20-100-552	06-400-163	79.3 ± 3.5	(1150 ± 50)

HO - Mineral Base Hydraulic Oil



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DISASSEMBLY

(Refer to Figures 1 and 2)

NOTE

Spool (19) and sleeve (14) are manufactured as a matched set. Do not intermix spool (19) or sleeve (14) with other parts.

1. Prevent contamination to the brake valve and hydraulic system. Thoroughly clean brake valve and surrounding area of all dirt, grease, oil, etc. Remove the brake valve from the machine.
2. Remove ring (1) and boot (2) from housing (20).
3. Remove piston (3), shim(s) (4), springs (6 & 7), and retainer assembly (8) from housing (20). **NOTE: Be aware of the number of shim(s) being removed from housing.**
4. Remove o-ring (5) from housing (20) bore. **NOTE: Be careful not to scratch or mar housing bore.**
5. Remove retaining ring (9) and retainer assembly (10) from housing (20).
6. Remove spool and sleeve assembly (11) from housing (20). Separate spool (19) from sleeve (14). **NOTE: Be careful not to damage spool (19) or sleeve (14).**
7. Remove back-up rings (12, 15, & 18) and o-rings (13, 16, & 17) from sleeve (14).
8. Remove plug (23) and spring (21) from housing (20). Remove o-ring (22) from plug (23).

ASSEMBLY

(Refer to Figures 1 and 2)

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

1. Clean all parts thoroughly before assembling.
2. Install new o-rings (13, 16, & 17) and new back-up rings (12, 15, & 18) on sleeve (14).
3. Install spool (19) in sleeve (14). Note direction of spool (19).
4. Install spool and sleeve assembly (11) in housing (20). Be sure spool and sleeve assembly (11) seats properly in housing (20) bore.
5. Install new o-ring (22) on plug (23). Install spring (21) and plug (23) in housing (20). Torque plug (23) 54.2-67.8 N·m (40-50 lb·ft).
6. Install retainer assembly (10) and retaining ring (9) in housing (20).
7. Install new o-ring (5) in housing (20).
8. Install retainer assembly (8), springs (6 & 7), shim(s) (4), and piston (3) in housing (20). Be sure to install the same number of shim(s) as were removed.
9. Install new boot (2) and new ring (1) in housing (20).
10. Reinstall brake valve on the machine.

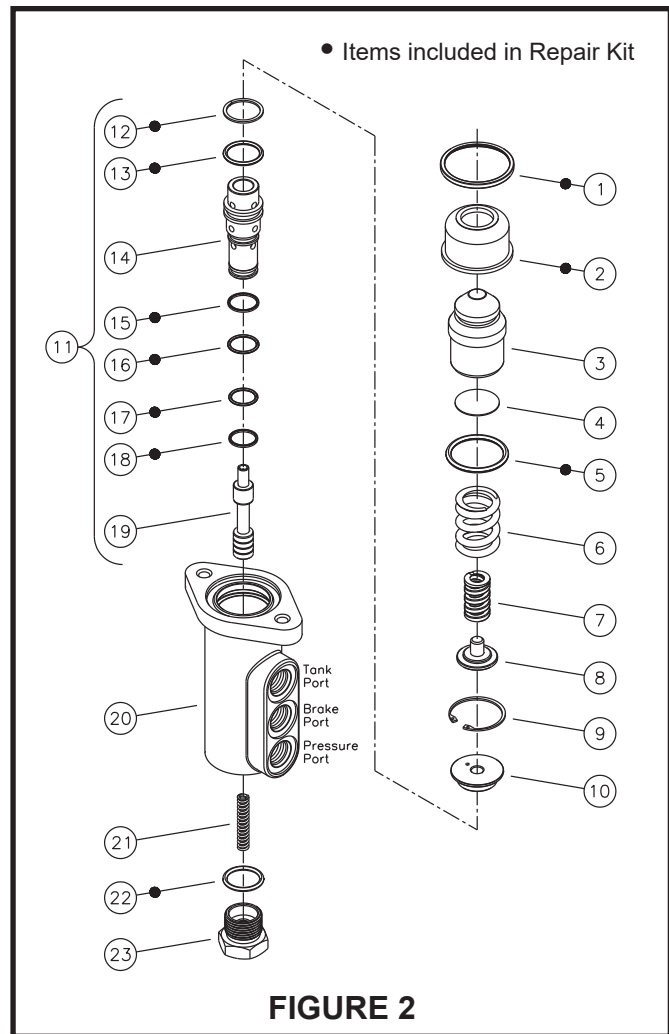


FIGURE 2